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British Standard Specification for
**Seamless and welded steel tubes
for automobile, mechanical and
general engineering purposes**

**Part 5. Specific requirements for electric resistance welded
and induction welded steel tubes**

Tubes en acier soudés et sans soudure pour l'automobile, la mécanique et la technique générale
Partie 5. Tubes en acier soudés par résistance et par induction. Caractéristiques particulières

Nahtlose und geschweißte Stahlrohre für den Kraftfahrzeugbau, Maschinenbau
und für allgemeine technische Zwecke

Teil 5. Besondere Anforderungen an widerstandsgeschweißte und induktionsgeschweißte Stahlrohre

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Foreword

This British Standard has been prepared under the direction of the Iron and Steel Standards Committee. It is a combined standard superseding BS 980 : 1950, BS 1775 : 1964 and BS 3014 : 1958 which are withdrawn.

In BS 6323, manufacturing processes have been aligned with current procedures, and processes no longer used, i.e. oxy-acetylene welding and hydraulic lap welding, have been deleted. Terminology relating to the designation of certain manufacturing processes has been updated, i.e. SAW replaces EFW, and CFS replaces CDS. Additionally, in combining the standards, steel grades have been rationalized and aligned, with delivery conditions now being clearly designated by letter codes.

This standard is published in eight separate Parts as follows:

Part 1. General requirements

- Part 2. Specific requirements for hot finished welded steel tubes
- Part 3. Specific requirements for hot finished seamless steel tubes
- Part 4. Specific requirements for cold finished seamless steel tubes
- Part 5. Specific requirements for electric resistance welded and induction welded steel tubes
- Part 6. Specific requirements for cold finished electric resistance welded and induction welded steel tubes
- Part 7. Specific requirements for submerged arc welded steel tubes
- Part 8. Specific requirements for longitudinally welded stainless steel tubes

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Amendment No. 1
published and effective from 30 June 1986
to BS 6323 : Part 5 : 1982

**Specification for seamless and welded steel tubes for
 automobile, mechanical and general engineering
 purposes**

**Part 5. Specific requirements for electric resistance
 welded and induction welded steel tubes**

Revised text

AMD 5141
 June 1986

Clause 1. Scope

In note 1, line 3, delete 'and BS 4848 : Part 2' and substitute ', BS 4848 : Part 2 and BS 6363'.

AMD 5141
 June 1986

Clause 9.1 General

In line 3, after '9.2', insert 'except for rectangular section tubes exempted by 9.2,'.

AMD 5141
 June 1986

Clause 9.2 Flattening test

Delete the existing clause entirely and substitute the following.

'9.2 Flattening test. The distance between the platens, or in the case of flattening by hammer blows the distance between the outside surfaces, shall not be greater than the percentage of the original outside diameter as shown in table 4. For non-circular tubes the percentage of the original outside dimension before flattening shall be used. The weld shall be placed at 90° to the direction of flattening.

This test shall not be a requirement for rectangular section tubes where the ratio of the major to the minor dimensions is greater than 2.'

AMD 5141
 June 1986

Table 7. Dimensions: imperial size range in common usage for electric resistance welded and induction welded tubes

Delete main headings and substitute the following.

Outside	Mass per unit length (in kg/m and lb/ft)
diameter	Thickness

Against outside diameter 28.58 mm, in column 10 for thickness 1.5 mm, delete '0.100' and substitute '1.00'.

AMD 5141
 June 1986

Publications referred to

Delete the references to BS 980, BS 1775 and BS 3014, and the associated footnote. After the entry for BS 6323 : Part 1, insert the following new entry.

'BS 6363 Specification for welded cold formed steel structural hollow sections'.



Amendment No. 2
published and effective from 30 June 1989
to BS 6323 : Part 5 : 1982

Specification for seamless and welded steel tubes for
automobile, mechanical and general engineering purposes
Part 5. Specific requirements for electric resistance
welded and induction welded steel tubes

Revised text

AMD 6024
June 1989

Title

In the title on the front cover and on page 1, delete 'and induction welded' and substitute '(including induction welded)'.

Delete the translations on the front cover and substitute the following.

Tubes en acier soudés et sans soudure pour l'automobile, la mécanique et la technique générale
Partie 5. Tubes en acier soudés par résistance (y inclus par induction). Caractéristiques particulières

Nahtlose und geschweißte Stahlrohre für den Kraftfahrzeugbau, Maschinenbau und für allgemeine
technische Zwecke
Teil 5. Besondere Anforderungen an widerstandsgeschweißte (einschließlich induktionsgeschweißter)
Stahlrohre

AMD 6024
June 1989

Contents

Delete lines 2 and 3 of the entries for tables 6 and 7 and substitute 'usage for electric resistance welded (including induction welded) tubes' in both cases.

AMD 6024
June 1989

Foreword

In lines 11 and 13 of paragraph 3, delete 'and induction welded' and substitute '(including induction welded)'.

AMD 6024
June 1989

Clause 1. Scope (as amended by Amendment No. 1)

In line 3, delete 'and induction welded' and substitute '(including induction welded)'.

AMD 6024
June 1989

Clause 8.2 Thickness

After item (b) insert the following.

'The minimum thickness in the weld area shall be not less than that permitted in the body of the tube.'

