

COLD DRAWN SEAMLESS TUBING ASTM A519 AISI 1018 OR 1026**1. SCOPE**

This specification covers Cold Drawn Seamless Round Tubing per ASTM A519 AISI 1018 or 1026 stress relieved.

2. DESIGNATION

C.D. Seamless Tubing ASTM A519
AISI 1018 or 1026 SR (stress relieved)

3. RELATED STANDARDS**3.1 REFERENCE STANDARDS**

ASTM A519 - Specification for Seamless Carbon and Alloy Steel Mechanical Tubing
86507735 (FNHA-3-A-002.00) - Standard Bend Radii

3.2 This standard replaces the following company standard:

New Holland (Partial) 2.50.3

4. REQUIREMENTSPhysical Properties

Minimum Yield Strength* 60,000 PSI
Minimum Tensile Strength* 70,000 PSI
Elongation 5% Minimum

minimums are not guaranteed per specification

5. TOLERANCES

5.1 The normal specification is by O.D. and wall thickness. Alternate specifications are by I.D. and wall thickness, or by O.D. and I.D. Tolerances are listed in Tables 1 and 2.

5.2 Length tolerances for cut length are listed in Table 3.

NOTE: Cold drawn seamless tubing is usually the highest cost round tubing. Consult with purchasing to determine the most economical tubing use.

ALL	H	TH	115052	08-00	NAME	STD A519-1018 RD TUB		
ALL	G	TH	114396	02-00				
ALL	F	RLF	110229	JUL 97	 NEW HOLLAND	ENGINEERING SPECIFICATION		
ALL	E	TH	109326	970226				
ALL	D	TH	108086	960731				
ALL	C	TH	107053	951019				
ALL	B	RE	104739	950123				
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TABLE 1 - DIAMETER TOLERANCES

OD SIZE in.	WALL % OF OD	TOLERANCE			
		OD in.		ID in.	
		OVER	UNDER	OVER	UNDER
Up thru 0.499	All	.004	.000		
.500 thru 1.699	All	.005	.000	.000	.005
1.700 thru 2.099	All	.006	.000	.000	.006
2.100 thru 2.499	All	.007	.000	.000	.007
2.500 thru 2.899	All	.008	.000	.000	.008-
2.900 thru 3.299	All	.009	.000	.000	.009
3.300 thru 3.699	All	.009	.000	.000	.010
3.700 thru 4.099	All	.011	.000	.000	.011
4.100 thru 4.499	All	.012	.000	.000	.012
4.500 thru 4.899	All	.013	.000	.000	.013
4.900 thru 5.299	All	.014	.000	.000	.014
5.300 thru 5.549	All	.015	.000	.000	.015
5.500 thru 5.999	Under 6	.010	.010	.010	.010
	6 thru 7.5	.009	.009	.009	.009
	Over 7.5	.018	.000	.009	.009
6.000 thru 6.499	Under 6	.013	.013	.013	.013
	6 thru 7.5	.010	.010	.010	.010
	Over 7.5	.020	.000	.010	.010
6.500 thru 6.999	Under 6	.015	.015	.015	.015
	6 thru 7.5	.012	.012	.012	.012
	Over 7.5	.023	.000	.012	.012
7.000 thru 7.499	Under 6	.018	.018	.018	0.18
	6 thru 7.5	.013	.013	.013	.013
	Over 7	.026	.000	.013	.013

TABLE 2 - WALL THICKNESS TOLERANCES

WALL THICKNESS PERCENT OF OD	MAX PERCENT OVER AND UNDER NORMAL	
	ID Under .500 in.	ID .500 in. and Over
Under 10	10	7.5
10 to 25	10	6



NAME

STD A519-1018 RD TUB

ENGINEERING SPECIFICATION

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2OF
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PART NUMBER

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