



Finarvedi is the holding company of the Arvedi Group, whose “core business” comprises steelmaking activities with volumes of over 1.5 million tpy of high quality products for the most demanding markets.

The Arvedi Group, founded in 1964 by Giovanni Arvedi, employs more than 1,600 people and has a consolidated turnover of approximately 1 billion Euros.

Four manufacturing plants, located in Northern Italy and operating in three specific sectors, form the steel-

making nucleus of the Arvedi Group. Acciaieria Arvedi SpA (Cremona) is the first example in Europe of a mini-mill for hot rolled carbon steel flat products.

Arvedi Tubi Acciaio SpA (Cremona) and Ilta Inox SpA (Robecco d'Oglio - Cremona) operate in the area of carbon steel and stainless steel tube production.

Arinox SpA (Sestri Levante - Genoa), manufactures precision stainless steel strip.

All the Arvedi Group companies,

thanks to their production, organizational and logistical structures, have acquired a leading role in the industrial panorama both at an Italian and international level. In fact, a considerable share of production (on average over 40% with peaks of up to 80%) is destined for foreign markets.

Finarvedi SpA

Carbon steel

Stainless steel

Acciaieria Arvedi SpA

Arvedi Tubi Acciaio SpA

iltainox SpA

Arinox SpA



*Hot rolled pickled
and galvanized
carbon steel coils*

*Black, galvanized
and coated carbon
steel welded tubes*

*Stainless steel
welded tubes*

*Cold rolling of
stainless steel
precision strip*

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Arvedi





Aerial view of the factory in Robecco d'Oglio (Cremona)



High quality welded stainless steel tubes



Ilta Inox was founded in 1963 and is considered today as one of the most important European producers in the market of welded stainless steel tubes.

Over the past forty years, Ilta Inox has acquired a firm market position, targeting its main production in the most demanding **industrial sectors such as power generation, chemical, pharmaceutical and food industry.**

With a turnover of 300 million Euros (80% represented by export sales) the company, located in Robecco d'Oglio, is considered as one of the world leaders in its field.

Their large number of welding lines equipped with the **most qualified welding technology** (TIG, Laser), their modern system of heat treatment and their numerous finishing lines, allow Ilta Inox to satisfy even the most stringent market demands, thanks to the high quality of its products which are recognized and certified by the most important international testing organizations.

As proof of its high production standards and in anticipation of European norms, **Ilta Inox has recently obtained the ISO 14001 environmental certification.**



Partial view of the coil stock

Coil slitting line

A production path which originates from the accurate control of the quality of the steel

Raw material comes only from suppliers who are ISO 9000 certified.

Before transforming the steel, Ilta Inox carries out a 100% check on incoming material using a portable spectrometer, in order to guarantee the conformance and characteristics of the steels which will be used in production.

A further laboratory analysis completes this stage of inspection and verifies the exact chemical composition of the steel to be used.

Versatility and a wide production range are aided by a large warehouse which allows Ilta Inox to maintain a constant stock of the many different types of steel in the various different thicknesses required in the market.

The first stage of the manufacturing process is the slitting of the coil, which Ilta Inox carries out in-house, on coil up to 30 tons.

This enables Ilta Inox to optimize the feeding of the production lines, thus enhancing the competitiveness of the final product.



The welding

The result of ongoing investment provides Iltia with the advantage of state-of-the-art welding technology.

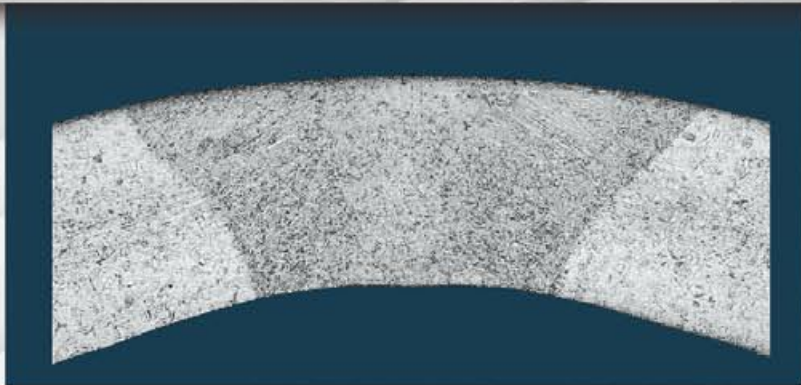
The **TIG/Plasma** method uses electricity to obtain fusion.

The **Laser welding method** uses a ray of light accurately focused which leads to the fusion of the edges.

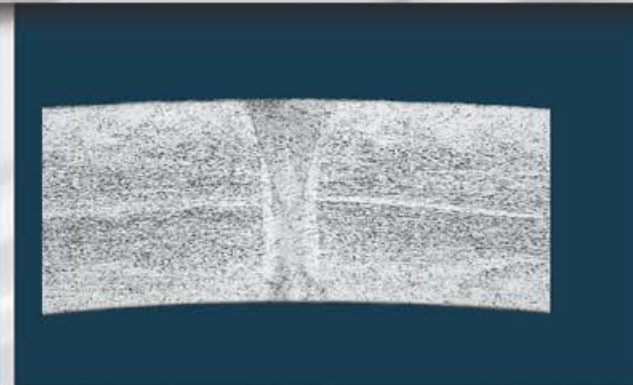
TIG welding



Laser welding



TIG Micrograph



Laser Micrograph

The micrograph

The heat-affected zone following TIG welding is wider when compared with Laser welding, however still maintains good mechanical and corrosion-resistance properties.

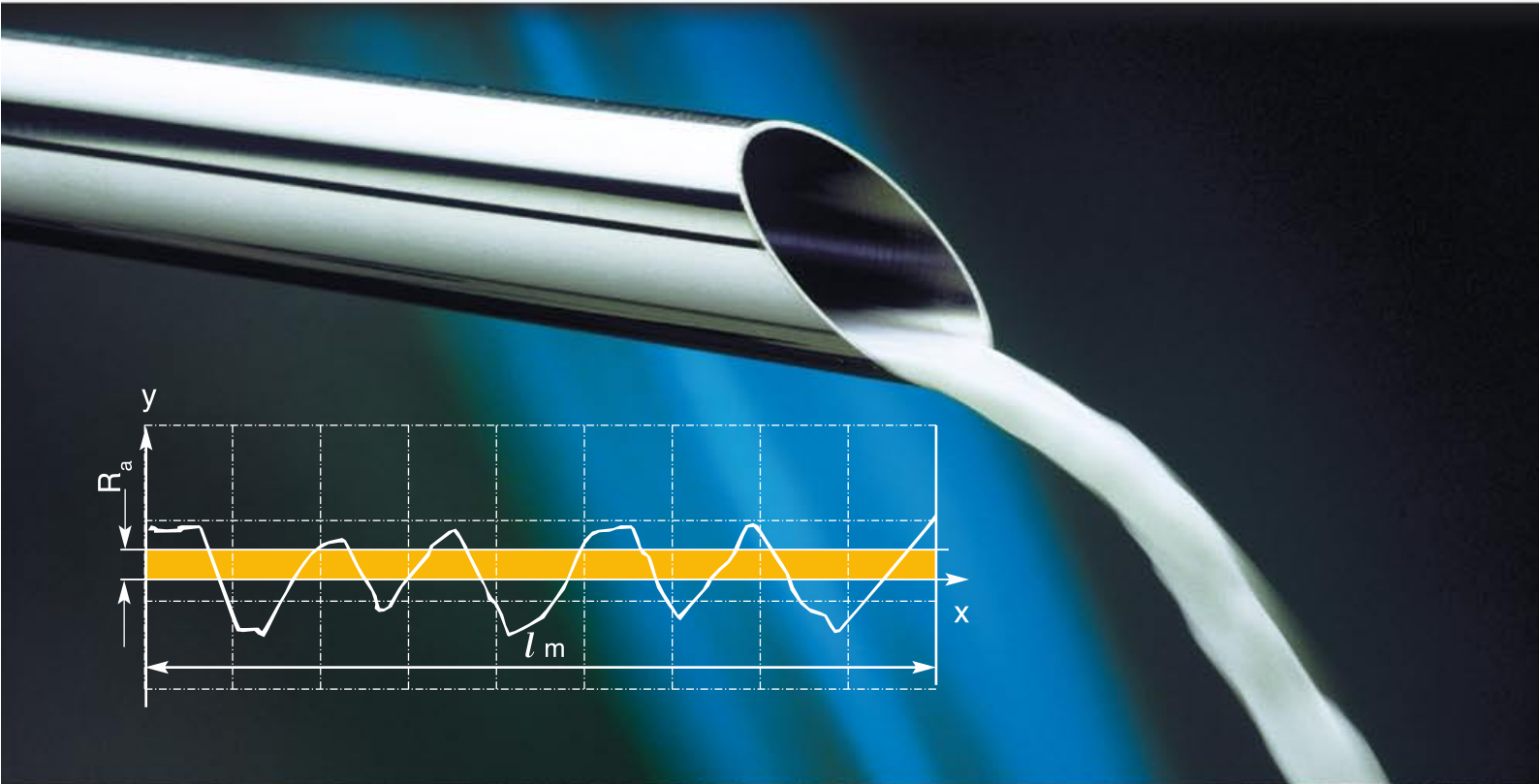
Being narrower than other traditional welding methods, laser welding guarantees, without any doubt, better mechanical and corrosion-resistant characteristics.



Preventing corrosion

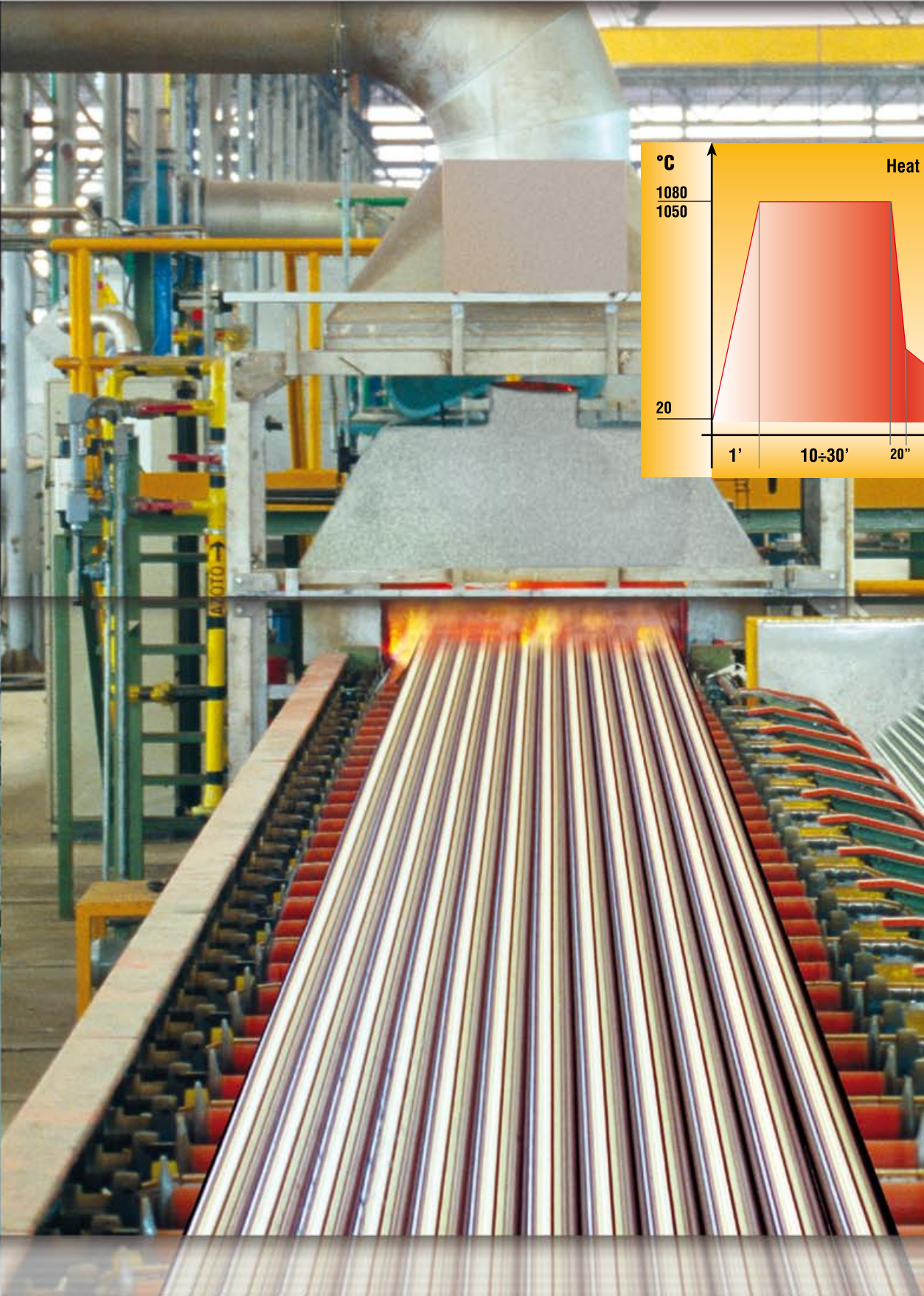
Corrosion and an incorrect roughness on the internal surface of the tube could represent a problem for a producer of stainless steel tubes for the food industry.

In Iltta Inox every trace of ferrous and oxidizing contamination, which could be detrimental to corrosion resistance, is removed by a process of pickling in a bath of acid solution. Iltta Inox is able to pickle tubes in lengths of up to 18 metres.



Heat treatment

The heat treatment process, which has the purpose of both eliminating the work hardening effect caused by cold working, and of homogenizing the structure of the welded area (whilst also enhancing the corrosion resistance) is carried out between 1040° and 1100°C in a controlled atmosphere (Bright annealing). The different stages of heat treatment, i.e. the duration and the speed of the tube flow, are constantly monitored in order to achieve a correct solubilization.



On-line controls

The tubes produced by Ita Inox constantly undergo a dimensional check (Laser O.D. Checking), as well as continuous destructive tests in order to evaluate the integrity of the weld area. The control of mechanical characteristics is carried out with modern laboratory equipment.



Flaring test



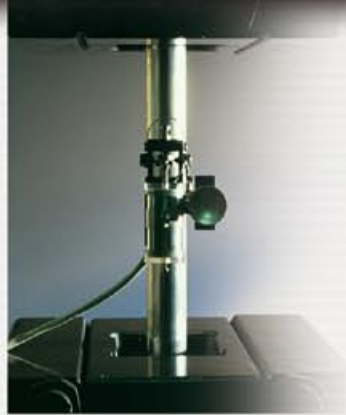
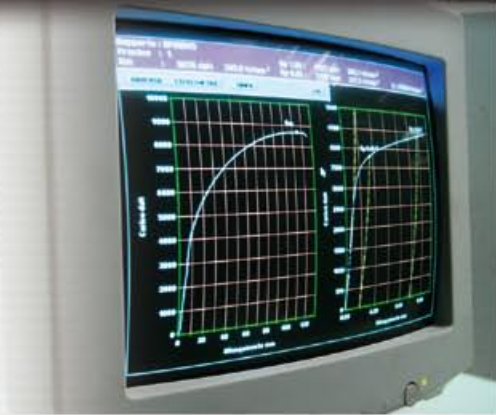
Flattening test



Reverse bending test



Expansion test



Tensile test

Non-destructive controls off-line

In order to guarantee the integrity of the whole tube wall, 100% of our production is off-line Eddy Current tested.

This control is carried out after tube straightening by certified operators and with the use of equipment which is regularly calibrated and certified by Ita's in-house laboratory or by an external agency, according to the EN 10246-3 norm.



Finishing

On request tubes can be supplied:
Polished G180-G240-G320-G400
Or mirror polished

Cut with tolerances
on the length up to $-0/+1$ mm







Left above: Welding lines

In the middle: New warehouse of round tubes

Right above: View of welding lines

Table of steel grades

Steel Name	Steel Number	Chemical composition									
		C %	Ni %	Cr %	Mo %	Mn %	Si %	P %	S %	N %	Ti %
4301	X5 CrNi 18-10	≤ 0,07	8,00 - 10,50	17,00 - 19,50	-	≤ 2	≤ 1	≤ 0,045	≤ 0,015	≤ 0,11	-
4306	X2 CrNi 19-11	≤ 0,03	10,00 - 12,00	18,00 - 20,00	-	≤ 2	≤ 1	≤ 0,045	≤ 0,015	≤ 0,11	-
4307	X2 CrNi 18-9	≤ 0,03	8,00 - 10,00	17,50 - 19,50	-	≤ 2	≤ 1	≤ 0,045	≤ 0,015	≤ 0,11	-
4541	X6 CrNiTi 18-10	≤ 0,08	9,00 - 12,00	17,00 - 19,00	-	≤ 2	≤ 1	≤ 0,045	≤ 0,015	-	5xCmin to 0,70
4401	X5 CrNiMo 17-12-2	≤ 0,07	10,00 - 13,00	16,50 - 18,50	2,00 to 2,50	≤ 2	≤ 1	≤ 0,045	≤ 0,015	≤ 0,11	-
4404	X2 CrNiMo 17-12-2	≤ 0,03	10,00 - 13,00	16,50 - 18,50	2,00 to 2,50	≤ 2	≤ 1	≤ 0,045	≤ 0,015	≤ 0,11	-
4571	X6 CrNiMoTi 17-12-2	≤ 0,08	10,50 - 13,50	16,50 - 18,50	2,00 to 2,50	≤ 2	≤ 1	≤ 0,045	≤ 0,015	-	5xCmin to 0,70
4435	X2 CrNiMo 18-14-3	≤ 0,03	12,50 - 15,00	17,00 - 19,00	2,50 to 3,00	≤ 2	≤ 1	≤ 0,045	≤ 0,015	≤ 0,11	-
4432	X2 CrNiMo 17-12-3	≤ 0,03	10,50 - 13,00	16,50 - 18,50	2,50 to 3,00	≤ 2	≤ 1	≤ 0,045	≤ 0,015	≤ 0,11	-
4845	X8 CrNi 25-21	≤ 0,10	19,00 - 22,00	24,00 - 26,00	-	≤ 2	≤ 1,5	≤ 0,045	≤ 0,030	≤ 0,11	-
4462	X2 CrNiMoN 22-5-3	≤ 0,030	4,50 - 6,50	21,00 - 23,00	2,50 to 3,50	≤ 2	≤ 1,0	≤ 0,035	≤ 0,015	≥ 0,10 to 0,22	-
4828	X15 CrNiSi 20-12	≤ 0,20	11,00 - 13,00	19,00 - 21,00	-	≤ 2	1,5 - 2,5	≤ 0,045	≤ 0,030	≤ 0,11	-
(According to Euronorm EN 10088-2)											

Production norms
ASTM A249 - A269 - A270 - A312 - A554 - A778 - A789 - A790
DIN 17455 - 17457 - 11850
NFA 49147 - 49247 - 49249 - 49647
EN 10217/7 - 10312 - 10296/2
Executions
Welded
Brushed
Pickled
Bright Annealed up to O.d. 114,3 mm
Annealed and Pickled up to O.d. 219,1 mm
Polished Grit 180-Grit 400
Inside Polished
Mirror Polished

Tolerances on length
Commercial length: 6000 mm +/- 30mm
Fix length: from 500 mm up to 18000mm with a tolerance up to -0/+1mm
Tolerance on straightness: 2mm/mt
Tolerance on perpendicularity of the cut: +/- 1°
Tolerance on quantity: +/- 10%

Production flow

Coil slitting

Welding

Straightening

Eddy Current Test

Pickling

Straightening

Bright Annealing

Pickling

Bright annealing

Straightening

Equivalent steel grades

AISI	DIN	AFNOR	GHOST
304	1.4301	Z7 CN 18 - 9	08 Kh 18N 10
304L	1.4306	Z3 CN 18 - 10	03 Kn 18N 11
304L	1.4307	Z3 CN 19 - 9	-
321	1.4541	Z6 CNT 18 - 10	08 Kh 18N 10 T
316	1.4401	Z7 CND 17 - 11 - 02	08 Kh 18N 10T
316L	1.4404	Z3 CND 17 - 12 - 02	03 Kn 17N 14 M2
316TI	1.4571	Z6 CNDT 17 - 12	08 Kn 17N 13 M2T
316SL	1.4435	Z3 CND 18 - 14 - 03	03 Kn 16N 15 M3
316L	1.4432	Z3 CND 17 - 13 - 03	-
310S	1.4845	Z8 CN 25 - 20	10 Kn 23N 18
31803	1.4462	Z3 CND 22 - 05Az	-
309	1.4828	Z17 CNS 20 - 12	20 Kn 23N 13

Tolerances on dimension EN ISO 1127				
Outside Diameter mm	Tolerance on O.D.		Tolerance on thickness	
	Tolerance class	Allowed Deviation	Tolerance class	Allowed Deviation
D ≤ 168,3	D3	+/- 0,75% min +/- 0,30 mm	T3	+/- 10% min +/- 0,20 mm
	D4 ^a	+/- 0,5% min +/- 0,10 mm		
D > 168,3	D2	+/- 1,0% min +/- 0,50 mm		

a: By request D4 tolerance

According to EN 10217-7

Packing



**BRUSHED OR NOT
PICKLED TUBE**
W0: from hot or
cold rolled

Eddy Current
Test



Packing



PICKLED TUBE
W1: from hot rolled
W2: from cold rolled

Straightening



Eddy
Current Test



Packing



**BRIGHT ANNEALED
AND PICKLED TUBE**
W1A: from hot rolled
W2A: from cold rolled

Eddy Current
Test



Packing



BRIGHT ANNEALED TUBE
W1R: from hot rolled
W2R: from cold rolled

Metric dimensions Theoretical weight in kg/mtr.

Outside Diameter mm	Thickness mm														
	0,8	1	1,2	1,5	1,6	2	2,3	2,5	2,6	3	3,2	3,6	4	5	6
10	0,184	0,225	0,264	0,319	-	-	-	-	-	-	-	-	-	-	-
12	0,224	0,275	0,325	0,394	-	-	-	-	-	-	-	-	-	-	-
13	0,244	0,300	0,355	0,432	-	-	-	-	-	-	-	-	-	-	-
14	0,264	0,326	0,385	0,470	-	-	-	-	-	-	-	-	-	-	-
15	0,284	0,351	0,415	0,507	-	-	-	-	-	-	-	-	-	-	-
16	0,304	0,376	0,445	0,545	0,577	0,701	-	-	-	-	-	-	-	-	-
17	0,325	0,401	0,475	0,582	0,617	0,751	-	-	-	-	-	-	-	-	-
17,2	0,329	0,406	0,481	0,590	0,625	0,761	0,858	-	-	-	-	-	-	-	-
18	0,345	0,426	0,505	0,620	0,657	0,801	-	-	-	-	-	-	-	-	-
19	0,365	0,451	0,535	0,657	0,697	0,851	-	-	-	-	-	-	-	-	-
19,05	0,366	0,452	0,536	0,659	0,699	0,854	-	-	-	-	-	-	-	-	-
20	0,385	0,476	0,565	0,695	0,737	0,901	-	-	-	-	-	-	-	-	-
21,3	0,411	0,508	0,604	0,744	0,789	0,967	1,094	1,177	1,217	-	-	-	-	-	-
22	0,425	0,526	0,625	0,770	0,817	1,002	-	-	-	-	-	-	-	-	-
23	0,445	0,551	0,655	0,808	0,857	1,052	-	-	-	-	-	-	-	-	-
24	0,465	0,576	0,685	0,845	0,897	1,102	-	-	-	-	-	-	-	-	-
25	0,485	0,601	0,715	0,883	0,937	1,152	1,307	1,409	1,458	-	-	-	-	-	-
25,4	0,493	0,611	0,727	0,898	0,954	1,172	1,330	1,434	1,484	-	-	-	-	-	-
26,9	0,523	0,649	0,772	0,954	1,014	1,247	1,417	1,527	1,582	1,795	-	-	-	-	-
28	0,545	0,676	0,805	0,995	1,058	1,302	1,480	1,596	1,654	-	-	-	-	-	-
29	0,565	0,701	0,835	1,033	1,098	1,352	1,538	1,659	1,719	-	-	-	-	-	-
30	0,585	0,726	0,865	1,070	1,138	1,402	1,595	1,722	1,784	2,028	-	-	-	-	-
31,8	0,621	0,771	0,919	1,138	1,210	1,492	1,699	1,834	1,901	2,163	-	-	-	-	-
32	0,625	0,776	0,925	1,146	1,218	1,502	1,710	1,847	1,914	2,178	-	-	-	-	-
33	0,645	0,801	0,956	1,183	1,258	1,552	1,768	1,909	1,979	2,254	2,388	-	-	-	-
33,7	0,659	0,819	0,977	1,209	1,286	1,588	1,808	1,953	2,025	2,306	2,444	-	-	-	-
34	0,665	0,826	0,986	1,221	1,298	1,603	1,826	1,972	2,044	2,329	2,468	-	-	-	-
35	0,685	0,851	1,016	1,258	1,338	1,653	1,883	2,035	2,109	2,404	2,548	-	-	-	-
38	0,745	0,926	1,106	1,371	1,458	1,803	2,056	2,222	2,305	2,629	2,788	-	-	-	-
40	0,785	0,977	1,166	1,446	1,538	1,903	2,171	2,348	2,435	2,779	2,949	-	-	-	-
41	0,805	1,002	1,196	1,484	1,579	1,953	2,229	2,410	2,500	2,855	3,029	-	-	-	-
42	0,825	1,027	1,226	1,521	1,619	2,003	2,286	2,473	2,565	2,930	3,109	-	-	-	-
42,4	0,833	1,037	1,238	1,536	1,635	2,023	2,309	2,498	2,591	2,960	3,141	3,498	-	-	-
43	0,845	1,052	1,256	1,559	1,659	2,053	2,344	2,535	2,630	3,005	3,189	3,552	-	-	-
44,5	0,875	1,089	1,301	1,615	1,719	2,128	2,430	2,629	2,728	3,117	3,309	3,687	-	-	-
45	0,885	1,102	1,316	1,634	1,739	2,153	2,459	2,661	2,760	3,155	3,349	3,732	-	-	-
48,3	0,952	1,184	1,415	1,758	1,871	2,319	2,649	2,867	2,975	3,403	3,614	4,029	-	-	-
50	0,986	1,227	1,466	1,822	1,939	2,404	2,747	2,974	3,086	3,531	3,750	4,183	-	-	-
50,8	1,002	1,247	1,490	1,852	1,971	2,444	2,793	3,024	3,138	3,591	3,814	4,255	-	-	-
51	-	1,252	1,496	1,859	1,979	2,454	2,805	3,036	3,151	3,606	3,830	4,273	-	-	-
52	-	1,277	1,526	1,897	2,019	2,504	2,862	3,099	3,216	3,681	3,910	4,363	-	-	-
53	-	1,302	1,556	1,934	2,059	2,554	2,920	3,161	3,281	3,756	3,990	4,453	-	-	-
54	-	1,327	1,587	1,972	2,099	2,604	2,978	3,224	3,346	3,831	4,071	4,543	-	-	-
57	-	1,402	1,677	2,085	2,220	2,754	3,150	3,412	3,542	4,056	4,311	4,814	-	-	-
60,3	-	1,485	1,776	2,209	2,352	2,920	3,340	3,618	3,757	4,304	4,575	5,111	-	-	-
63,5	-	1,872	2,329	2,480	3,080	3,525	3,819	3,965	4,545	4,832	5,400	-	-	-	-
	0,8	1	1,2	1,5	1,6	2	2,3	2,5	2,6	3	3,2	3,6	4	5	6

Outside Diameter mm	Thickness mm														
	1	1,2	1,5	1,6	2	2,3	2,5	2,6	3	3,2	3,6	4	5	6	8
70	1,728	2,067	2,573	2,740	3,405	3,899	4,226	4,388	5,033	5,353	5,986	-	-	-	-
73	-	2,157	2,686	2,861	3,556	4,072	4,413	4,583	5,258	5,593	6,256	-	-	-	-
76,1	-	2,251	2,802	2,985	3,711	4,250	4,607	4,785	5,491	5,841	6,535	7,222	-	-	-
80	-	2,368	2,948	3,141	3,906	4,475	4,852	5,039	5,784	6,154	6,887	7,612	-	-	-
83	-	2,458	3,061	3,261	4,056	4,648	5,039	5,234	6,010	6,394	7,157	7,913	-	-	-
84	-	2,488	3,099	3,301	4,107	4,705	5,102	5,299	6,085	6,474	7,248	8,013	-	-	-
85	-	2,518	3,136	3,341	4,157	4,763	5,165	5,365	6,160	6,554	7,338	8,113	-	-	-
88,9	-	2,635	3,283	3,498	4,352	4,987	5,409	5,618	6,453	6,867	7,689	8,504	-	-	-
101,6	-	3,016	3,760	4,006	4,988	5,719	6,204	6,445	7,407	7,885	8,834	9,776	-	-	-
104	-	3,088	3,850	4,103	5,108	5,857	6,354	6,602	7,587	8,077	9,050	10,016	-	-	-
108	-	3,209	4,000	4,263	5,308	6,087	6,604	6,862	7,888	8,397	9,411	10,417	-	-	-
114,3	-	3,398	4,237	4,515	5,624	6,450	6,999	7,272	8,361	8,902	9,979	11,048	-	-	-
127	-	-	4,714	5,024	6,260	7,182	7,794	8,099	9,315	9,920	11,124	12,320	15,274	-	-
128	-	-	4,751	5,064	6,310	7,239	7,856	8,164	9,390	10,000	11,214	12,420	15,400	-	-
129	-	-	4,789	5,104	6,360	7,297	7,919	8,229	9,465	10,080	11,304	12,520	15,525	-	-
133	-	-	4,939	-	6,560	7,527	8,169	8,490	9,766	10,401	11,665	12,921	16,026	-	-
139,7	-	-	5,191	5,533	6,896	7,913	8,589	8,926	10,269	10,937	12,269	13,592	16,864	20,087	-
152,4	-	-	5,668	6,042	7,532	8,645	9,384	9,753	11,223	11,955	13,413	14,864	18,454	21,995	-
153	-	-	5,690	6,066	7,562	8,679	9,421	9,792	11,268	12,003	13,468	14,924	18,530	22,085	-
154	-	-	5,728	6,106	7,612	8,737	9,484	9,857	11,343	12,083	13,558	15,024	18,655	22,236	-
156	-	-	5,803	6,186	7,712	8,852	9,609	9,987	11,493	12,244	13,738	15,224	18,905	22,536	-
159	-	-	5,916	6,306	7,863	9,025	9,797	10,182	11,719	12,484	14,008	15,525	19,281	22,987	-
168,3	-	5,021	6,265	6,679	8,328	9,560	10,379	10,788	12,417	13,229	14,847	16,456	20,445	24,384	-
203	-	-	7,568	-	10,066	11,559	12,551	13,047	15,024	16,010	17,975	19,932	24,790	29,597	-
204	-	-	-	-	10,116	11,616	12,614	13,112	15,099	16,090	18,065	20,032	24,915	29,748	-
205	-	-	-	-	10,166	11,674	12,677	13,177	15,174	16,170	18,155	20,132	25,040	29,898	-
206	-	-	-	-	10,216	11,731	12,739	13,242	15,249	16,250	18,245	20,232	25,165	30,048	-
219,1	-	-	8,173	-	10,872	12,486	13,559	14,095	16,233	17,300	19,426	21,544	26,805	32,016	-
253	-	-	9,446	-	12,570	14,438	15,681	16,302	18,780	20,016	22,482	24,940	31,050	37,109	-
254	-	-	-	-	12,620	14,496	15,744	16,367	18,855	20,096	22,572	25,040	31,175	37,260	-
255	-	-	-	-	12,670	14,553	15,807	16,432	18,930	20,176	22,662	25,140	31,300	37,410	-
256	-	-	-	-	12,720	14,611	15,869	16,497	19,005	20,256	22,752	25,240	31,425	37,560	-
273	-	-	-	-	13,572	15,590	16,933	17,604	20,282	21,619	24,285	26,943	33,554	40,114	-
304	-	-	-	-	15,124	17,376	18,874	19,622	22,611	24,103	27,079	30,048	37,435	44,772	-
305	-	-	-	-	15,174	17,433	18,937	19,687	22,686	24,183	27,169	30,148	37,560	44,922	-
306	-	-	-	-	15,224	17,491	18,999	19,753	22,761	24,263	27,260	30,248	37,685	45,072	-
323,9	-	-	-	-	16,121	18,522	20,120	20,918	24,106	25,697	28,873	32,041	39,926	47,761	-
353	-	-	-	-	17,578	20,198	21,941	22,812	26,292	28,029	31,496	34,956	43,570	52,133	-
354	-	-	-	-	17,628	20,255	22,004	22,878	26,367	28,109	31,586	35,056	43,695	52,284	-
355,6	-	-	-	-	17,708	20,347	22,104	22,982	26,487	28,237	31,731	35,216	43,895	52,524	-
406,4	-	-	-	-	20,252	23,273	25,284	26,289	30,303	32,308	36,310	40,304	50,255	60,156	-
457	-	-	-	-	-	-	-	-	34,104	-	-	45,372	56,590	67,758	89,944
506	-	-	-	-	-	-	-	-	37,785	-	-	50,280	62,725	75,120	99,759
508	-	-	-	-	-	-	-	-	37,936	-	-	50,481	63,976	75,420	100,160
609,6	-	-	-	-	-	-	-	-	45,568	-	-	60,657	75,696	90,685	120,513
711	-	-	-	-	-	-	-	-	-	-	-	-	-	-	140,825
	1	1,2	1,5	1,6	2	2,3	2,5	2,6	3	3,2	3,6	4	5	6	8



Standard gauge dimensions

ASTM A 249 / A 269 / A 789 / A 790 / A 270

Theoretical weight in kg/mtr.
Tubes can be heat treated up to diameter 219,1 mm.

		Thickness mm											
Outside Diameter		BWG 20	BWG 19	BWG 18	BWG 16	BWG 14	BWG 12	BWG 11	BWG 10	BWG 9	BWG 8	BWG 7	BWG 6
Inches	mm	0,88 mm	1,06 mm	1,24 mm	1,65 mm	2,11 mm	2,77 mm	3,05 mm	3,40 mm	3,76 mm	4,19 mm	4,57 mm	5,16 mm
		Kg/meter	Kg/meter	Kg/meter	Kg/meter	Kg/meter	Kg/meter	Kg/meter	Kg/meter	Kg/meter	Kg/meter	Kg/meter	Kg/meter
1/2"	12,7	0,260	0,309	0,356	0,457	-	-	-	-	-	-	-	-
5/8"	15,88	0,331	0,393	0,455	0,588	-	-	-	-	-	-	-	-
3/4"	19,05	0,400	0,477	0,553	0,719	0,895	-	-	-	-	-	-	-
1"	25,4	0,540	0,646	0,750	0,981	1,231	-	-	-	-	-	-	-
1 1/4"	31,8	-	0,816	0,949	1,246	1,569	2,014	2,196	-	-	-	-	-
1 3/8"	34,9	-	0,898	1,045	1,374	1,732	2,229	2,432	-	-	-	-	-
1 1/2"	38,1	-	0,983	1,144	1,506	1,902	2,451	2,677	-	-	-	-	-
1 3/4"	44,5	-	1,153	1,343	1,770	2,240	2,894	3,166	-	-	-	-	-
2"	50,8	-	1,320	1,539	2,031	2,573	3,331	3,647	4,035	-	-	-	-
2 1/8"	53,9	-	-	1,635	2,159	2,736	3,546	3,884	4,299	-	-	-	-
2 3/8"	60,3	-	-	1,834	2,423	3,074	3,990	4,372	4,844	-	-	-	-
2 1/2"	63,5	-	-	1,933	2,555	3,244	4,212	4,617	5,117	-	-	-	-
2 3/4"	69,9	-	-	2,132	2,820	3,582	4,656	5,105	5,662	-	-	-	-
2 7/8"	73	-	-	2,228	2,948	3,745	4,871	5,342	5,925	-	-	-	-
3"	76,2	-	-	2,327	3,080	3,915	5,093	5,587	6,198	6,820	-	-	-
3 1/2"	88,9	-	-	-	3,605	4,585	5,974	6,557	7,279	8,016	-	-	-
4"	101,6	-	-	-	4,130	5,256	6,855	7,526	8,360	9,212	10,220	-	-
4 1/2"	114,3	-	-	-	4,654	5,927	7,736	8,496	9,442	10,407	11,552	-	-
5"	127	-	-	-	5,179	6,598	8,617	9,466	10,523	11,603	12,885	14,010	15,743
6"	152,4	-	-	-	6,228	7,940	10,378	11,406	12,685	13,995	15,550	16,917	19,024
8"	203,2	-	-	-	-	10,624	13,902	15,286	17,010	18,777	20,880	22,730	25,588
10"	254	-	-	-	-	13,308	17,426	19,166	21,335	23,560	26,209	28,543	32,152
12"	304,8	-	-	-	-	15,992	20,949	23,045	25,660	28,343	31,539	34,356	38,715
14"	355,6	-	-	-	-	18,676	24,473	26,925	29,985	33,126	36,869	40,169	45,279
16"	406,4	-	-	-	-	21,360	27,996	30,805	34,310	37,909	42,199	45,983	51,843
		BWG 20	BWG 19	BWG 18	BWG 16	BWG 14	BWG 12	BWG 11	BWG 10	BWG 9	BWG 8	BWG 7	BWG 6



ANSI standard dimensions

ASTM A 312 / ASTM A 778 / ASTM A 554

Theoretical weight kg/mtr.

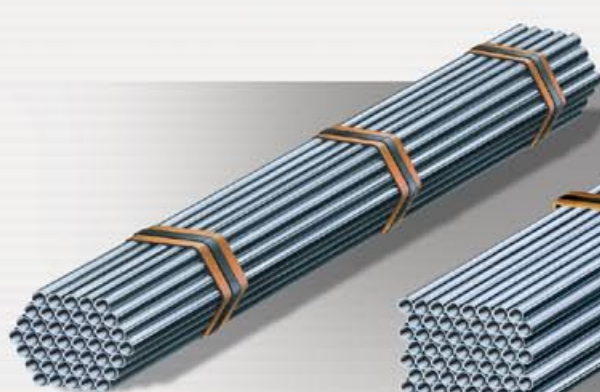
Outside Diameter		Sch.5 S		Sch.10 S		Sch.10		Sch.20		Sch.40 S	
Inches	mm	Thick.	Kg/meter	Thick.	Kg/meter	Thick.	Kg/meter	Thick.	Kg/meter	Thick.	Kg/meter
3/8"	17,2	-	-	1,65	0,642	-	-	-	-	2,31	0,861
1/2"	21,34	1,65	0,814	2,11	1,016	-	-	-	-	2,77	1,288
3/4"	26,67	1,65	1,034	2,11	1,298	-	-	-	-	2,87	1,710
1"	33,4	1,65	1,312	2,77	2,125	-	-	-	-	3,38	2,541
1 1/4"	42,16	1,65	1,674	2,77	2,732	-	-	-	-	3,56	3,441
1 1/2"	48,26	1,65	1,926	2,77	3,155	-	-	-	-	3,68	4,108
2"	60,33	1,65	2,424	2,77	3,990	-	-	-	-	3,91	5,524
2 1/2"	73,05	2,11	3,748	3,05	5,346	-	-	-	-	-	-
3"	88,9	2,11	4,585	3,05	6,557	-	-	-	-	5,49	11,466
3 1/2"	101,6	2,11	5,256	3,05	7,526	-	-	-	-	-	-
4"	114,3	2,11	5,927	3,05	8,496	-	-	-	-	6,02	16,322
5"	141,3	2,77	9,609	3,40	11,740	-	-	-	-	-	-
6"	168,3	2,77	11,481	3,40	14,039	-	-	-	-	-	-
8"	219,1	2,77	15,005	3,76	20,274	-	-	6,35	33,828	-	-
10"	273	3,40	22,953	4,19	28,203	-	-	6,35	42,414	-	-
12"	323,9	3,96	31,725	4,57	36,542	-	-	6,35	50,492	-	-
14"	355,6	3,96	34,868	4,78	41,990	6,35	55,532	-	-	-	-
16"	406,4	3,96	39,905	4,78	48,070	6,35	63,610	-	-	-	-
18"	457,2	4,19	47,529	4,78	54,151	6,35	71,687	-	-	-	-
20"	508	4,78	60,231	5,54	69,702	6,35	79,764	-	-	-	-
22"	558,8	-	-	-	-	6,35	87,842	-	-	-	-
24"	609,6	5,54	83,796	6,35	95,919	6,35	95,919	-	-	-	-
26"	660,4	-	-	-	-	7,92	129,398	-	-	-	-
28"	711,2	-	-	-	-	7,92	139,472	-	-	-	-

Standard packing

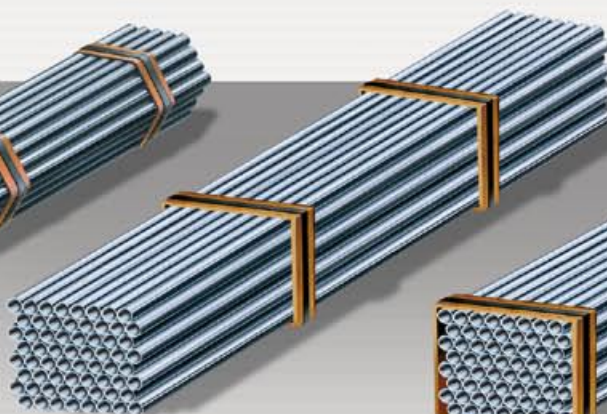
Outside Diameter	Metres	Type
from 10 to 20 mm	1014	exagonal bundle A
from 21,3 to 26,9 mm	762	exagonal bundle A
from 28 to 35 mm	546	exagonal bundle A
from 38 to 54 mm	366	exagonal bundle A
from 60,3 to 76,1 mm	222	exagonal bundle A
from 83 to 114,3 mm	114	exagonal bundle A
from 127 to 141,3 mm	108	bundle with wooden frames B
from 152 to 219,1 mm	84	bundle with wooden frames B
from 252 to 273 mm	42	bundle with wooden frames B
from 304 to 406,4 mm	30	bundle with wooden frames B
from 457 to 609,6 mm	12	bundle with wooden frames B
from 660,4 to 711 mm	6	bundle with wooden frames B

Packing

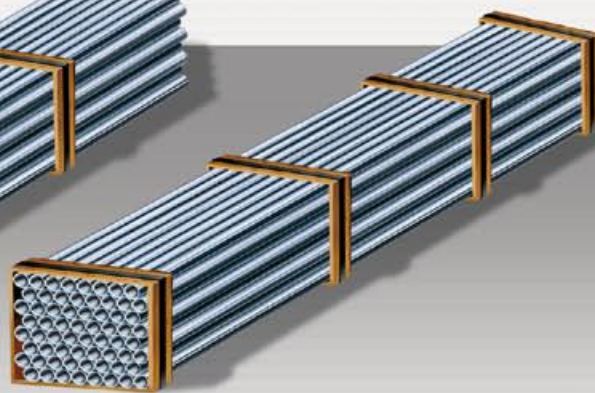
Our tubes are normally supplied with an "A" or "B" packing (≥ 127 O.D.). On request other kinds of packing are available



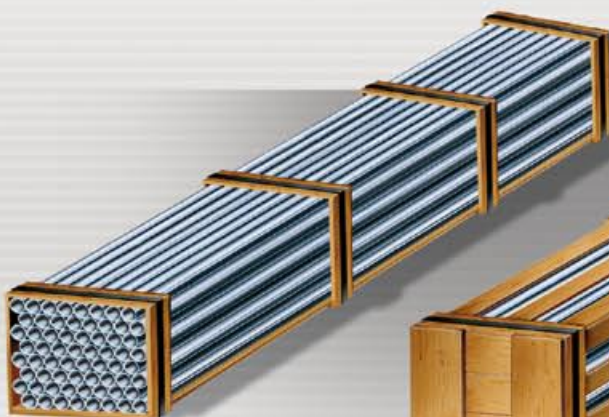
A - bundle
standard



B - bundle
standard



C - bundle
on request



C2 - bundle
on request



D - crate
on request



F - case
on request



Quality. Since 1963 our key-concept

Ilta Inox has been certified according to the **ISO 9002:1994** standard since 1994 and according to **ISO 9001:2000** since 2000, and maintains a developing and constantly updated system of quality management.

This continuous evolution and the respect for the demands of our clients, has stimulated us in the achievement of important goals such as gaining the European product certification **AD 2000-Merkblatt-TRD 100 97/23/EC (PED)**.

The satisfaction of our clients through the continuous improvement of processes, product and service is our target.

Certifications, approvals and licences for specific types of products have been awarded by the most important international institutions.

ISO 14001 Certification confirms that the care for the environment is one of the ultimate goals for ILTA.

Quality System Certifications

Type of certification	Date of first issue	Agency
ISO 9001: 2000	25/03/1994	DNV
TÜV AD 2000 Merkblatt WO/TRD 100	11/04/1979	TÜV

Licences, approvals and product certifications

Type of approval	Application field
DIN-DVGW (since 1999)	Welded stainless steel tubes for gas and potable water transportation
RINA (since 1979)	Tubes for naval use
Lloyds Register (since 2002)	Tubes for naval use
TÜV directive for Pressure vessels	Tubes for pressure vessels
TÜV AD 2000 W2/W10 (since 1979)	Tubes for pressure vessels and boilers; cryogenic equipment

The environment: a certified passion

ISO 14001 certification given to
Acciaieria Arvedi, Arvedi Tubi Acciaio and
Ilta Inox guarantees the respect of those
principles and procedures where the protection
of the environment is an essential value.
This result has been conquered by
means of investments in installations,
staff's training and the
awareness that man makes
the quality of the
environment.

Acciaieria Arvedi



Arvedi Tubi Acciaio



iltainox



ISO 14001

The Istituto Italiano di
Garanzia della Qualità and
the company Det Norske
Veritas Italy have certified
the systems of environment
management of Acciaieria
Arvedi, Arvedi Tubi Acciaio
and Ilta Inox planned
according to ISO 14001.

Arvedi





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