

eurocylinder systems AG
 Auenstrasse 21
 D-99510 Apolda

Quality requirements for seamless steeltubes

Material 34CrMo4 DIN 17204

Chemical composition		min	max
C		0,3	0,37
Mn		0,5	0,8
Si		0,15	0,35
P			0,02
S			0,01
S + P			0,025
V+Nb+Ti+Zr			0,15
Cr		0,9	1,2
Mo		0,15	0,3
Grossman index		0,39	0,42

$(0,54 \times C) \times (0,7 \times Si+1) \times (3,3333 \times Mn+1) \times (2,16 \times Cr+1) \times (0,363 \times Ni+1) \times (3,0 \times Mo+1) \times (0,365 \times Cu+1)$

Mechanical properties Re (Mpa)

diameter	< 114	min 800
	> 114	min 675

Inspections for minimum wall thickness according EN 10246-13
 for longitudinal imperfections according EN 10246-5 or EN10246-7

Surfaces no overlapping, rough contours, sharp edges

Measurement tolerances			
wall thicknes		0 ... 15 %	cold drawn
		0 ... 30 %	hot rolled
ext. Diameter		-0,5 ... +0,5 %	cold drawn
		-1 ... +1 %	hot rolled
roundness		min 1,5 %	from mean diameter
straigtness		max 2mm per m	