

H8

### Cylinder tubes inside skived and roller burnished

**Outside diameter - OD**  
Ø60 - 245 mm

**Inside diameter - ID**  
Ø50 - 200 mm

**Outside tolerance - OD**  
according to EN 10305-1 / EN 10305-2

**Inside tolerance - ID**  
ISO H8

**Roundness - ID**  
within the limits of diameter tolerances

**Surface roughness - ID**  
Ra: max. 0.30 µm

**Standard indicative length**  
5000 - 8000 mm  
other, on request

**Straightness local deviation**  
max. 1 mm / 1000 mm

**Straightness total deviation**  
max. 3.5 mm for tubes with length up to 6000 mm for tubes with length more than 6000 mm, for each meter over this length, the tolerance increases by 0.5 mm

#### Chemical composition - in % by weight

Steel grade	C	Si	Mn	P	S	Cr	Mo	Ni	V	Cu	N
E355	max. 0.22	max. 0.55	max. 1.60	max. 0.025	max. 0.025	-	-	-	-	-	-

#### Mechanical properties

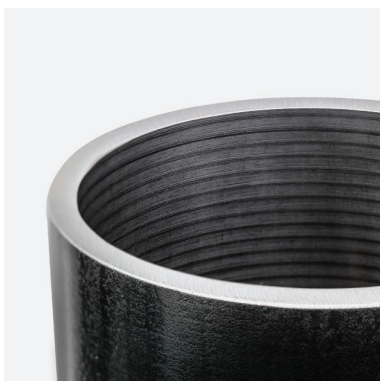
Steel grade	Tensile strength	Yield point	Elongation (longitudinal)	Impact energy <sup>(1)</sup> (longitudinal direction)	Hardness <sup>(2)</sup> Brinell
	R <sub>m</sub> N/mm <sup>2</sup>	R <sub>p0.2</sub> N/mm <sup>2</sup>	A <sub>5</sub> %	KV <sub>2</sub> J	N/mm <sup>2</sup>
E355+SR	min. 580	min. 450	min. 10	min. 27J / -20°C	min. 175

SR = stress-relieved, C = cold drawn  
(1) On request

(2) The hardness values is for information only  
(3) The Yield Point value is for information only

#### Standard dimensions range

Inside diameter mm	50	50.8	55	60	63	63.5	65	70	75	76.2	80	82.55	85	88.9	90	100	101.6	105	110	114.3	115	120	125	127	130	135	140	150	160	170	180	200				
Wall thickness mm	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5	6.5	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35	6.35			
6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6			
7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5			
10	10	10	10	10	8.5	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10		
12.5	12.5	12.5	12.5	10	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5		
15	15	15	15	12.5	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15		
13								17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5	17.5		
13.5																																				
20																	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20		
22.5																																				
25																																				



The skiving and roller burnishing production technique refers to a process consisting in micro-finishing metallic internal tube surfaces. The resulted effect is a mirror surface finish with technical roughness advantages.

#### Dimensional tolerance table

Inside diameter - ID mm	ISO H8 µm
50 < Ø ≤ 80	0 / +46
80 < Ø ≤ 120	0 / +54
120 < Ø ≤ 180	0 / +63
180 < Ø ≤ 200	0 / +72