

U-Bend Tubes for Heat Exchanger Specification

Materials:

304/L, 316L, 321/H, 310S, S31803, S32205, etc

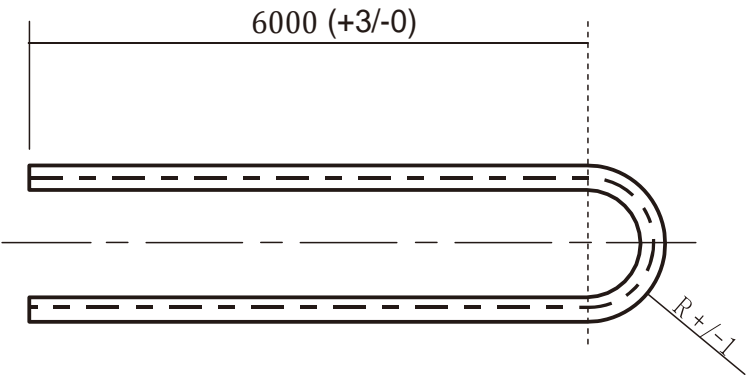
Size Range:

O.D.: 15.88mm---38.1mm

W. T.: 0. 89mm--- 3.77mm

Max. Developed Length: 27000mm

( We can ship up to 20 meter in Straight Length. )



Technical Details:

- a. All U-tube wall thinning at the bend to be <17% of original tube wall thickness.
- b. All U-tube ovality at the bend to be <10% of original tube outside diameter.
- c. After bending, solution annealing shall be carried out for those items, bend radius < 5D. The heating shall be done by electric resistance heating in a protective atmosphere and followed by rapid quenching.
- d. Scale formed during the heat treatment shall be removed by pickling or polishing inside and outside surfaces.
- e. All U-tube bends to be supplied with correct leg lengths, cut square and de-burred.
- f. After bending, solution annealing and pickling, all U-tube shall be hydrotested.
- g. On completion and final inspection, all U-tubes to be tagged with row number and packed in steel structure with plywood.

Row No.	Bend Radius	Qty	Developed Length
R1	51	32	12160
R2	83	32	12259
R3	114	32	12359
R4	146	32	12459
R5	178	29	12559
R6	210	32	12658
R7	241	32	12758
R8	273	32	12858
R9	305	32	12958
R10	337	32	13057
R11	368	32	13157
R12	400	29	13257
R13	432	32	13357
R14	464	30	13457
R15	495	28	13556
R16	527	26	13656
R17	559	24	13756
R18	591	20	13855
R19	622	14	13955
R20	654	10	14055

TOTAL:562