



LAL BABA SEAMLESS TUBES



with a  
seamless  
today

Lal Baba Seamless Tubes Pvt. Ltd. (LBST) is a leading manufacturer of Cold Drawn Carbon Steel Seamless Tubes with an installed output capacity of 36000 Metric Tonnes per annum.

We are ISO 9001, ISO 14001 & TS 16949 certified, along with approvals from IBR, BIS, Indian Railways, BHEL, L&T, EIL, Mecon, IOC, Mangalore Refinery Ltd., Madras Fertilizers etc.

Our tubes find use in myriad industries like Mining, Oil & Gas, Automobiles, Cranes, Hydraulics, Boilers, Power Plant, Cooling Tower, Railways, Nuclear Power Stations and Chemicals etc.

# the journey begins...



To ensure this rich product portfolio, we have invested significantly in a 700,000 square feet plant, with state-of-the-art machinery.

We are committed in entirety to the rolling out of pipes that conform precisely to all internationally set norms of perfection, with a coherent focus on quality. Adding to that, the company prides its versatility and guarantees the production of pipes to suit individual customer's explicit needs. All products manufactured at Lal Baba Seamless Tubes undergo unfaltering inspection at various levels, commencing with the foremost step, to the final dispatch. To ascertain that only the best products reach the clients, Third Party Inspections by BV, SGS, RITES, LLOYDS etc. are also done regularly as per customer's direction.

Apart from having a firm quality control system in place, Lal Baba Seamless Tubes Pvt. Ltd. also pays strict attention to the timely delivery of its products. Our location at the heart of a strategic port town of Haldia, ensures that our global logistic reach is at its optimum.

# Global Presence

Apart from catering to various top notch domestic clients like SAIL, BHEL, Tata Steel, Indian Railway, Garden Reach Shipbuilders Ltd., Hindustan Shipyard Ltd, Maruti Suzuki, ISRO, Indian Navy, Godrej, L&T, NTPC and many more, our regular exporting countries are USA, Germany, UK, France, Belgium, Spain, Netherlands, UAE, Sri Lanka, Bangladesh etc.



## Features of Cold Drawn Seamless Tubes



- ✓ Tubes made without weld or joints
- ✓ Can withstand very high pressure
- ✓ Very strong in nature, does not crack or break
- ✓ Recommended by all safety legislations in the world as a superior product for transportation of gas, fuel, pressure etc.
- ✓ Can be bended upto 180° degrees without any cracks or leaks

# Infrastructure



## **BARREL TYPE CROSS ROLL PIERCING PROCESS**

This is a modified version of the Original Mannesmann's Cross Rolling Process and is implemented at the Lal Baba Seamless Tubes, Haldia plant.

## **COLD DRAWN SYSTEM (CDS)**

The principal reasons behind cold drawing are:

- Achievement of closer wall thickness and diameter tolerance
- Improvement in surface finish
- To enhance servicibility
- No premature failure
- Suitable for critical forming, such as 180° bends
- Enhancement of mechanical properties of the tube
- Expansion of product mix towards the lower end of the OD and wall thickness scales

## **BRIGHT ANNEALING FURNACE**

Electrically operated roller hearth bright annealing furnace is the latest in type which produces bright surface with surface finish to the extent of mRa2, by using Co atmosphere.



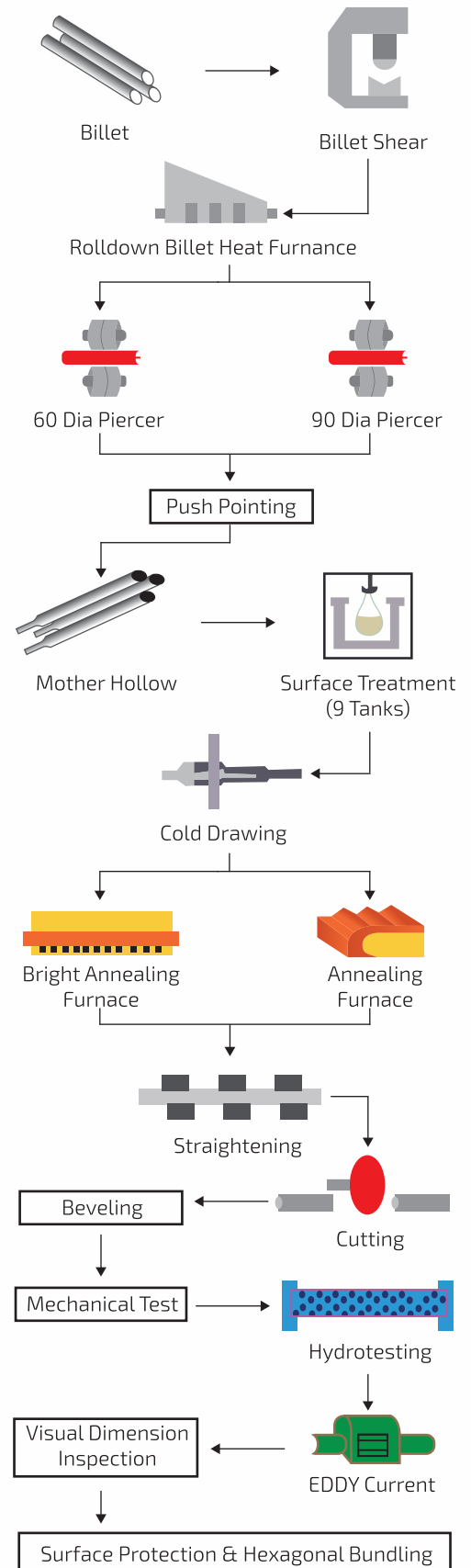
# Testing Facilities

We, at Lal Baba Seamless Tubes Pvt. Ltd. are committed to achieve a reputation for quality seamless tubes at competitive price by introducing latest technologies. Some of the testing equipments used in our facilities are given below :

- Spectrometer for chemical analysis
- Brinell Hardness Tester
- Universal Tensile Testing Machine
- Hydro Tester
- Eddy Current Tester



# Process



# Product Program

Products	Dimensional Range	Standards of Fabrication									
<ul style="list-style-type: none"> <li>■ Heat Exchanger Tubes</li> <li>■ Superheater Tubes</li> <li>■ Condenser Tubes</li> <li>■ Boiler Tubes</li> <li>■ Pneumatic Tubes</li> <li>■ Automotive Component Tubes</li> <li>■ Hydraulic Tubes</li> <li>■ Special Alloyed Tubes</li> </ul>	<table border="1"> <thead> <tr> <th></th> <th>Min (mm)</th> <th>Max (mm)</th> </tr> </thead> <tbody> <tr> <td>OD</td> <td>10.1</td> <td>114.3</td> </tr> <tr> <td>WT</td> <td>0.9</td> <td>13.0</td> </tr> </tbody> </table>		Min (mm)	Max (mm)	OD	10.1	114.3	WT	0.9	13.0	<p>LBST can manufacture the tubes as per standards of various countries, the most common being ASTM, DIN, EN, IS, BIS, BS. In addition to these norms we can manufacture tubes as per customer's specific demands like stricter tolerances, heat treatment condition, surface finishes.</p>
		Min (mm)	Max (mm)								
OD	10.1	114.3									
WT	0.9	13.0									

## Applications & Specifications



### Hydrocarbon Process

ASTM : A -53, A-333, A334, A-335  
 BS : 3602 (Pt-I)



### Automotive Industry

ASTM : A-519  
 SAE : 1010, 1012, 1020, 1040, 1518, 4130  
 DIN : 2391, 1629  
 BS : 980, 6323 (Pt-V)  
 IS : 3601, 3074



### Boiler & Heat Exchanger

ASTM : A-106, A-178, A-179, A-192,  
 A-209, A-210, A-213, A-214  
 BS : 3059 (Pt-I & Pt-II)  
 EN 10216 (Pt-I & Pt-III)  
 3602 (Pt-I)  
 IS : 1914, 2416, 11714, 4923  
 DIN : 17175



### Mechanical, Structural & General Engineering

ASTM : A-500, A-501, A-519  
 DIN : 1629, 1630, 2319  
 BS : 980, 1775, 3601, 6323  
 IS : 1161, 3601, 9295  
 EN : 10305-1, 10305-4, 10216-1,  
 10216-2



### Railways

IS : 1239 (Pt-I), 1161  
 BS : 980



### Hydraulic Cylinder

SAE : 1026, 1518  
 IS : 6631  
 DIN : 1629

# ASTM Schedule Size

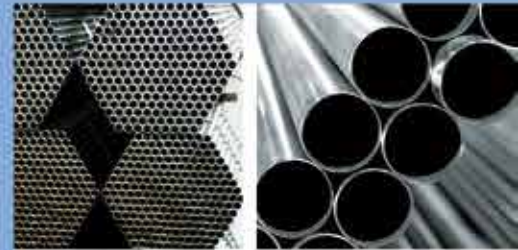
Nominal Bore Inch.	Outside Diameter		Wall Thickness MM	Schedule	Class	Weight (kg)	
	Inch	MM				Per Meter	Per Foot
1/8	0.405	10.30	1.7	40	Std	0.36	0.11
		10.30	2.4	80	xs	0.47	0.14
1/4	0.54	13.70	2.2	40	Std	0.62	0.19
		13.70	3.0	80	xs	0.79	0.24
3/8	0.675	17.10	2.3	40	Std	0.84	0.26
		17.10	3.2	80	xs	1.10	0.33
1/2	0.84	21.30	2.87	40	Std	1.30	0.40
		21.30	3.73	80	xs	1.62	0.49
		21.30	4.78	160	-	1.95	0.59
		21.30	7.50	-	xxs	2.55	0.78
3/4	1.05	26.70	2.87	40	Std	1.69	0.51
		26.70	3.91	80	xs	2.20	0.67
		26.70	5.56	160	-	2.90	0.88
		26.70	7.80	-	xxs	3.64	1.11
1	1.315	33.40	3.38	40	Std	2.50	0.76
		33.40	4.55	80	xs	3.24	0.98
		33.40	6.35	160	-	4.24	1.29
		33.40	9.10	-	xxs	5.45	1.66
1.1/4	1.66	42.20	3.56	40	Std	3.39	1.03
		42.20	4.85	80	xs	4.47	1.36
		42.20	6.35	160	-	5.61	1.71
		42.20	9.70	-	xxs	7.77	2.36
1.1/2	1.9	48.30	3.68	40	Std	4.05	1.23
		48.30	5.08	80	xs	5.41	1.65
		48.30	7.14	160	-	7.25	2.20
		48.30	10.20	-	xxs	9.58	2.91
2	2.375	60.30	3.91	40	Std	5.44	1.65
		60.30	5.54	80	xs	7.48	2.28
		60.30	8.74	160	-	11.11	3.38
		60.30	11.10	-	xxs	13.47	4.10
2.1/2	2.875	73.00	5.16	40	Std	8.63	2.63
		73.00	7.01	80	xs	11.41	3.47
		73.00	9.53	160	-	14.92	4.54
		73.00	14.00	-	xxs	20.37	6.20
3	3.5	88.90	4.80	-	-	9.95	3.03
		88.90	5.49	40	Std	11.29	3.43
		88.90	7.62	80	xs	15.27	4.65
		88.90	11.13	160	-	21.35	6.49
		88.90	15.20	-	xxs	27.63	8.40
3.1/2	4	101.60	4.80	-	-	11.46	3.48
		101.60	5.74	40	Std	13.57	4.13
		101.60	8.08	80	xs	18.63	5.67
4	4.5	114.30	4.00	-	-	10.88	3.31
		114.30	4.80	-	-	12.96	3.94
5"	5.563	141.3	6.55	40	-	21.76	6.62
		141.3	9.53	80	-	30.93	9.4
6"	6.625	168.3	7.11	40	-	28.23	8.59
		168.3	10.97	80	-	42.52	12.93
8"	8.625	219.1	8.18	40	-	42.49	12.92
		219.1	12.7	80	-	64.58	19.64





Mechanical Properties

V	Yield Strength		Tensile Strength		% Elongation (G.L. 50 mm WT 8 mm) e (min.)
	Min.		Min.		
Max	PSI	MPa	PSI	MPa	
<b>PRESSURE VESSEL TUBES</b>					
0.08	30,000	205	48,000	330	e=625000 A02/U09
0.08	35,000	240	60,000	415	
0.08	30,000	205	48,000	330	35L / 25T
0.08	35,000	240	60,000	415	30L / 16.5T
0.08	40,000	275	70,000	485	30L / 16.5T
-	30,000	205	55,000	380	35
-	35,000	240	60,000	415	30
<b>CONDENSERS/HYDRAULIC/PNEUMATIC POWER SYSTEMS</b>					
0.02		235		340	25
0.02		355		490	22
		195		320	27
		235		360	25
0.02					
-	NBK : 215 / GBK : -		NBK : 340 / GBK : 315		NBK : 470
-	NBK : 255 / GBK : -		NBK : 440 / GBK : 390		NBK : 570
-	NBK : 355 / GBK : -		NBK : 490 / GBK : 490		NBK : 630
-	As per Customer requirements				
-					
-					
-					
-					
-					
-					
-					
<b>CONDENSER TUBES</b>					
-	26,000	180	47,000	325	35
-	26,000	180	47,000	325	35
-	37,000	255	60,000	415	30
-	40,000	275	70,000	485	30
-	30,000	205	60,000	415	30
-	32,000	220	60,000	415	30
-	30,000	205	60,000	415	30
-	30,000	205	60,000	415	30
-	32,000	220	60,000	415	30
-	30,000	205	60,000	415	30
-	28,000	195	46,000	320	69,500
-	40,000	275	71,000	490	93,000
-	WT≤16mm = 235 / WT>16mm = 225		350		-
-	WT≤16mm = 355 / WT>16mm = 345		-		Long 21 / Trans 19
-	WT≤16mm = 235 / WT>16mm = 225		360		480
-	WT≤16mm = 255 / WT>16mm = 245		410		530
-	-	-	46,500	320	-
-	30,500	210	48,000	330	-
-	35,000	240	59,500	410	-
-	45,000	310	64,500	445	-



# ASTM Size Range

NB		OD	WALL THICKNESS															
Inch	mm	mm	1.45	2.41	3.02	3.2	4.78	5.54	5.56	6.35	7.01	7.14	7.62	8.08	8.56	9.53	10.97	12.7
1/8	6	10.3																
1/4	8	13.7			Sch 80													
3/8	10	17.1				Sch 80												
1/2	15	21.3					Sch 160											
3/4	20	26.7							Sch 160									
1	25	33.4								Sch 160								
1 1/4	32	42.2								Sch 160								
1 1/2	40	48.3									Sch 160							
2	50	60.3						Sch 80										
2 1/2	65	73									Sch 80							
3	80	88.9										Sch 80						
3 1/2	90	101.6											Sch 80					
4	100	114.3												Sch 80				
5	125	141.3																
6		168.3																
8	200	219.1																

Our Clientele



# Quality Policy & Certifications

We, at Lal Baba Seamless Tubes Pvt. Ltd. are committed to achieve a reputation for quality seamless tubes at competitive price by introducing latest technologies, deploying trained personnel along with adequate resources in all respect, striving at continual improvement.

We are also committed to fulfill the need and expectation of the customers through active participation at all level of employees and fostering a spirit of pride amongst them.



ISO 9001 : 2008



ISO 14001 : 2004



BIS Licence



EIL Certified



TS 16949 : 2009





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