

HINDUSTAR



ERW Black & Galvanised Pipes

HUTCH

INDIA



IS : 3601



IS : 1161



IS : 4923



IS : 1239



About Us


Hutch India Private Limited located at Surat, Gujarat in Western India, is an amalgamation of innovation, technology and human proficiency. With the best resources in the industry we cater to all the growing needs and demands of the market. We have started this factory in the western region to cater to the clients and also give benefit of increasing logistics cost to our clients. We are engaged in manufacturing of Black and Galvanised Steel Pipes/Tubes in the size ranging from 15mm to 100mm in the Light, Medium and Heavy classes as well as Corresponding RHS and SHS Tubes. The pipes are made from the Highest Quality of Raw materials with the help of most advanced ERW technology and are subjected to strict Quality Control at every stage of production. The unit is equipped with the most modern technology to ensure the highest standards. Its products confirm to National/International Standard. It is Licensee of the Bureau of Indian Standards and is registered with DGS&D (Directorate General of Supplies and Disposals)

The group has vast experience over 20 years, in various dimensions and diversified interests, with multiple products-from Steel Pipes such as GI Pipes, MS Pipes, Galvanised Pipes in Both Round and SHS as well as RHS Category.

HUTCH, a name in the pipe industry, is playing a pivotal role, in the development of the country and its products are being used for the purpose of Agriculture, Industries, Water and Sanitary Fittings, Gas Line, Power and Electrification & Tubular Polls. The Products are being manufactured with the single motive of highest satisfaction to our customers/ users and full value for their money. Our brands are no doubt the first choice of all the architects, agriculturists, builders, engineers' and fabricators in the industry.

An ISO: 9001 certified company spread over 1,50,000 sq. ft., engaged in the manufacturing of ERW Black and HOT DIPPED Galvanised Pipes/Tubes ranging from 15mm to 100mm in the Light, Medium and Heavy classes conforming to

- IS: 1239 (part-I) 2004 for Water Lines,
 - IS – 1161 for Structural Grades and
 - IS – 3601 for General Engineering Purposes,
 - IS – 4923 for RHS and SHS Pipes
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The image shows a stack of metal tubes, likely ERW (Electric Resistance Welded) tubes, arranged in a grid pattern. The tubes are dark in color, possibly black or dark grey, and are shown from a perspective that creates a sense of depth. A solid red horizontal bar is positioned at the top of the image, and another solid red horizontal bar is positioned at the bottom. The text is centered over the stack of tubes.

**ERW BLACK &
GALVANISED (GI)
ROUND TUBES**

Mild Steel (MS) Black Pipes

Outside Diameter : 1/2" – 4" inches

Thickness Range : 0.7 mm – 8.0 mm

Length : 3.0 meter – 12.0 meter

APPLICATION

- Liquid Transmission
- Idlers
- Mech. and General Engineering
- Structural
- Water and Sewage
- Water Wells
- Fire Protection
- Fencing & Many more...

PRODUCTION STANDARDS

- IS:1239(Part-I)/2004, BS:1387-1990
- IS:3601-1984
- IS:1161-1998

TEST PERFORMED

- Hydrostatic Test
- Eddy Current Test
- Flattening/Flaring Test/Bend Test
- Chemical Analysis
- Other Tests as Required by the Standard

FINISHING OPERATIONS

- Plain end
- Threaded and coupled
- Grooved
- Cut lengths

SURFACE PROTECTION

- Black (self coloured uncoated)
- Outside protective coating oil/varnish
- Hot Dip Galvanised
- Pre Galvanised

NOTE: For details please ref. specification sheet.

Mild Steel (MS) pipes are widely used across industries because it easy to weld and forge them for their various uses. These pipes are also known as black pipe as they're not galvanised or have any coating on them. Hutch India Private Limited is one of the largest MS Pipe manufacturers in India.

Galvanised (GI) Steel Tubes

Galvanized steel pipes, manufactured by Hutch India Private limited, are covered by a layer of zinc. Galvanized steel pipes and tubes are mostly used in structural applications. Galvanized steel pipes and tubes are available in various size and shapes based on the customer's requirements.

- Steel tubes that undergo the hot-dipped galvanised process.
- Pre-manufactured steel tubes dipped in molten zinc provide excellent corrosion resistance.
- Range includes products from 1/2" – 4" inches outer diameter.
- Used in underground piping, overground piping, power, refineries, scaffolding, engineering structural, scientific experiments and fire-fighting systems.

Pipes and tubing made of galvanised steel has long been one of the most used building materials in the world. For decades, designers, builders and consumers seeking long-term structural performance in the harshest of outdoor applications have turned to zinc-coated steel pipes. Zinc-coated galvanised steel pipes and tube resist the attack of wind, water and road salts.

Galvanised Steel are those steel that has been covered with a layer of zinc metal. During galvanising, steel is immersed in a molten zinc bath, ensuring a tough, uniform barrier coating. Zinc's natural corrosion resistance provides long-term protection, even in outdoor environments. Apart from preventing water corrosion, it is equally effective in dry, indoor environments.

These GI pipes are cheap, light in weight and easy to handle & transport & easy to join.

Product Range

HUTCH INDIA offers steel tubes and pipes as per following national standards.

Indian Standards

IS : 1239 (part-1) / 2004 (Light, Medium & Heavy Series)
Black & Galvanized plain end, screwed and socketed, 15mm to 150mm

IS: 1239



TECHNICAL DATA OF BLACK & GALVANIZED PIPES								
SPECIFICATION IS : 1239 (PART - 1)2004 - DIN 2439, DIN 2440, DIN 2441 (EQUIVALENT BS : 1387 : 1985/en 10255 : 2004*/en 10240 : 1998/DIN 2444)								
NB and Series	Outside Diameter		Wall Thickness		Nominal Weight			
	Min	Max	MM	SWG	Black Pipes		Galvanized Pipes	
					Plain end		Screwed & Socketed	
MM	MM	MM	SWG	Kg/M	Meters/Tonne	Kg/M	Meters/Tonne	
15 L M H	21.0	21.4	2.0	14	0.95	1052	0.96	1046
	21.0	21.8	2.6	12	1.21	826	1.22	820
	21.0	21.8	3.2	10	1.44	694	1.45	690
20 L M H	26.4	26.9	2.3	13	1.38	725	1.39	719
	26.5	27.3	2.6	12	1.56	641	1.57	637
	26.5	27.3	3.2	10	1.87	535	1.88	532
25 L M H	33.2	33.8	2.6	12	1.98	505	2.00	500
	33.3	34.2	3.2	10	2.41	415	2.43	411.5
	33.3	34.2	4.0	8	2.96	341	2.95	339
32 L M H	41.9	42.5	2.6	12	2.54	394	2.57	389
	42.0	42.9	3.2	10	3.10	322	3.13	319
	42.0	42.9	4.0	8	3.79	264	3.82	262
40 L M H	47.8	48.4	2.9	11	3.23	310	3.27	306
	47.8	48.8	3.2	10	3.56	281	3.60	278
	47.9	48.8	4.0	8	4.37	229	4.41	227
50 L M H	59.6	60.2	2.9	11	4.08	245	4.15	241
	59.7	60.8	3.6	9	5.03	199	5.10	196
	59.7	60.8	4.5	7	6.19	161	6.26	160
65 L M H	75.2	76.0	3.2	10	5.74	175	5.83	171.5
	75.3	76.6	3.6	9	6.42	156	6.54	153
	75.3	76.6	4.5	7	7.93	126	8.05	124
80 L M H	87.6	88.7	3.2	10	6.72	149	6.89	145
	88.0	89.5	4.0	8	8.36	120	8.53	117
	88.0	89.5	4.8	6	9.90	101	10.10	96
100 L M H	113.0	113.9	3.6	9	9.75	102	10.00	100
	113.1	115.0	4.5	7	12.20	82	12.50	80
	113.1	115.0	5.4	5	14.50	69	14.80	67.5
125 L M H	138.5	140.8	4.8	6	15.90	63	16.40	61
	138.5	140.8	5.4	5	17.90	56	18.40	54
150 L M H	163.9	165.5	4.8	6	18.90	53	19.50	51
	163.9	166.5	5.4	5	21.30	47	21.90	46

Thickness & Mass are applicable for Black & Galvanized Steel Tubes as per clause 8. 1. 1 of IS : 1239 (part-1) 2004

A Thickness	Tolerance	B Weight	Tolerance	Length Tolerance
1. Light Tubes	+ not limited- 8%	1. Single Tube (Light Series)	+10%-8%	Unless otherwise specified 4 to 7 mtrs. can also be supplied in fix lengths. ±5cm
2. Medium and Heavy Tubes	+ not limited- 10%	2. Single Tube (Medium and Heavy Series)	± 10%	
		3. For quantities per load of tonnes minimum (Light Series)	±7.5%-5%	
		4. For quantities per load of 10 tonnes minimum (medium and Heavy Series)	±7.5%	

TECHNICAL DATA OF IS : 3601 1984 TUBES FOR MECHANICAL & GENERAL ENGG. PURPOSES



Size N.B		Approx O.D. (MM)	Thickness (MM)	Wt. Kg/Mtr.	Meter per Ton	Size N.B.		Approx O.D. (MM)	Thickness (MM)	Wt. (MM)	Meters per Ton
MM	In					MM	Inch				
15	1/2"	21.3	1.8	0.866	1155	50	2"	60.3	2.3	3.290	304
			2.0	0.952	1050				2.6	3.700	270
			2.6	1.200	833				2.9	4.110	243
			3.2	1.430	699				3.2	4.510	222
			4.0	1.710	585						
20	3/4"	26.9	1.8	1.110	901				3.6	5.030	199
			2.0	1.230	813				4.0	5.550	180
			2.6	1.400	714				4.5	6.190	162
			3.2	1.560	641				5.0	6.820	147
			4.0	1.870	535				5.6	7.550	133
			2.260	442				6.3	8.390	119	
25	1"	33.7	2.0	1.560	641	65	2.5"	76.1	2.6	5.240	191
			2.3	1.780	562				2.9	5.750	174
			2.6	1.990	503				3.2	6.440	155
			3.2	2.410	415				3.6	7.110	141
			4.0	2.930	341				4.5	7.950	126
			4.5	3.240	309			5.0	8.770	114	
32	1.25"	42.4	2.3	2.270	441	80	3"	88.9	5.4	9.420	106
			2.6	2.550	392				6.3	10.800	93
			3.2	3.090	324				7.1	12.100	83
			3.6	3.440	291				2.9	6.15	163
			4.0	3.790	264				3.2	6.76	148
			5.0	4.610	217				4.0	8.38	119
			5.4	4.930	203				5.0	10.3	97
40	1.5"	48.3	2.3	2.610	383				5.4	11.1	90
			2.6	2.930	341				5.6	11.5	87
			2.9	3.250	308				6.3	12.8	78
			3.2	3.560	281				8.0	16.0	63
			4.0	4.370	229						
			4.9	5.230	191						
			5.0	5.340	187						
			5.6	5.900	170						
			5.9	6.160	162						

Note: Sizes and Thickness other than listed above can be supplied on order basis.

STEEL TUBES FOR STRUCTURAL PURPOSES CONFORMING TO IS : 1161 : 1998



N.B.	Series	Outside Diameter	Thickness	Nominal Weight		Calculated Nominal Weight	
				Black Tube		Galvanized Tubes	
				Plain End		Plain End	
		MM	MM	Kg/M	Meters/Tonne	Kg/M	Meters/Tonne
15	L	21.30	2.00	0.947	1058	1.00	1003
	M		2.60	1.21	826	1.26	794
	H		3.20	1.44	694	1.49	671
20	L	26.90	2.30	1.38	725	1.43	699
	M		2.60	1.56	641	1.61	221
	H		3.20	1.87	535	1.92	521
25	L	33.70	2.60	1.98	5050	2.03	493
	M		3.20	2.41	415	2.46	407
	H		4.00	2.93	341	2.98	336
32	L	42.40	2.60	1.54	394	2.62	382
	M		3.20	3.10	323	3.18	314
	H		4.00	3.79	6264	3.87	258
40	L	48.30	2.90	3.23	310	3.34	29
	M		3.20	3.56	281	3.67	272
	H		4.00	4.37	229	4.48	223
50	L	60.30	2.90	4.08	245	4.20	238
	M		3.20	5.03	199	5.15	194
	H		4.00	6.19	162	6.31	158
65	L	76.10	3.20	5.71	175	5.86	171
	M		3.60	6.42	156	6.57	152
	H		4.50	7.93	126	8.10	123
80	L	88.90	3.20	6.72	149	6.90	145
	M		4.00	8.36	120	8.54	117
	H		4.80	9.90	101	10.08	99
100	L	114.30	3.60	9.75	103	9.97	100
	M		4.50	12.20	82	12.42	81
	H		5.40	14.50	69	14.72	68
125	L	139.70	4.50	15.00	67	15.25	66
	M		4.80	15.90	63	16.15	62
	H		5.40	17.90	56	18.15	55
150	L	165.10	4.50	17.80	56	18.20	55
	M		4.80	18.90	52	19.80	51
	H		5.40	21.30	47	21.70	46

TENSILE PROPERTIES :

Grade	Y.S.(min) MPA (kg/mm ²)	T.S.(min) MPA (kg/mm ²)	%Elongation
YST-210	210(21.42)	330(33.66)	20
YST-240	240(24.48)	410(41.82)	17
YST-310	610(31.62)	450(45.90)	14

WEIGHT
SINGLE TUBE
1.LIGHT CLSS
2.MEDIUM & HEAVY CLASS

TOLERANCES

+10%/-8%
+/-10%

TOLERANCES :

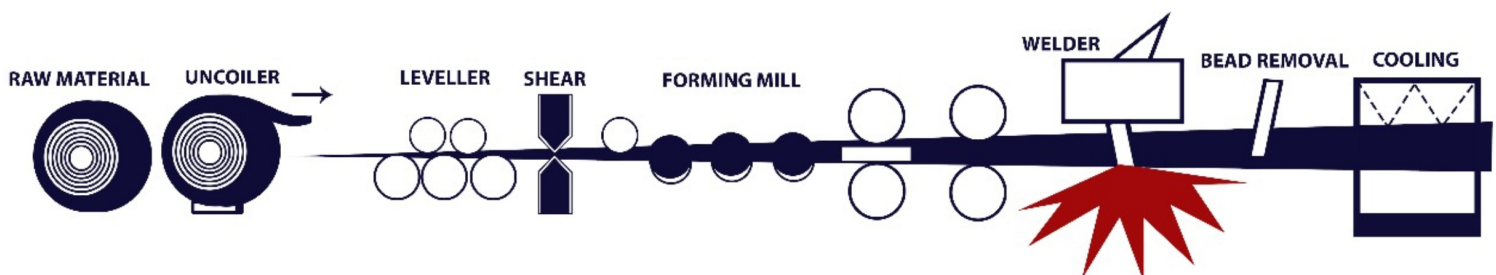
- ON OUTSIDE DIAMETER UP TO & INCLUDING 48.3 MM = +0.4MM/ -0.8MM
- OVER 48.3MM = +/- 1%

THICKNESS:
FOR ALL SIZE
WELDED TUBES

TOLERANCES
+NOT LIMITED
-10+

- 10 TON LOT
1.LIGHT CLASS
2. MEDIUM & HEAVY CLASS

+/-5%
+/-7.5%



SHS/RHS CLOSED HOLLOW SECTIONS & GALVANISED HOLLOW SECTIONS



SHS/RHS Hollow Sections

Hutch India Private Limited provides high tensile strength (high strength to weight ratio) hollow section which is used widely in various industries including automotive, machinery, furniture, construction etc. These sections come in various shapes and sizes and finishes. Most common among them include Rectangular Hollow Sections (RHS) and Square Hollow Sections (SHS) available in below mentioned

Size:

- Rectangular Hollow Sections (RHS): 40 mm X 20 mm – 122 mm X 61 mm,
- Square Hollow Sections (SHS): 20 mm X 20 mm – 90 mm X 90 mm,
Thickness: 1.0 mm to 12.0 mm

Galvanised Hollow Sections

This category of Hutch steel sections is generally made out of MS coils and then are covered by a layer of Zinc through Hot Dipped Galvanising. There are many preventive coatings (natural & synthetic) which are applied either before or after the production of tubes.

- Several coatings applied before and after tube production
- Tubes are tough, durable, light-weight and zinc coated from Hot Dip Galvanising Process
- Finds application in fencing, cabling and ducting, automotive (bus body) and greenhouse structures
- Product range comprises various sizes from :
 - Rectangular Hollow Sections (RHS): 40 mm X 20 mm – 122 mm X 61 mm,
 - Square Hollow Sections (SHS): 20 mm X 20 mm – 90 mm X 90 mm,

In the recent technological innovations and analysis by the experts, it has been proved that the Hot Dip galvanised hollow section is highly durable, stable and adhere to a long sustainability without atmospheric corrosion. These technological phenomena are adopted by some of the leading galvanised steel manufacturers for enhancing their market potential as well as the profitability as they have very optimum cost control parameters.

The coating provided to galvanised tubes is uniform and the thickness of the coating can be maintained as agreed between, which depends on the atmospheric and corrosive environment prevailing at individual sites. The overall look & finish is very aesthetically controlled. Having a homogeneous coating all through, these tubes can easily withstand any mechanical deformation without affecting their catalytic coating and the bonding of zinc coating with the parent material remains unchanged, thus making HUTCH as one of the leading GI pipe manufactures in India.

This gives a very good impression to the fence & greenhouse fabricator. Strict in-house quality checking is performed which helps in maintaining all conditioning parameters as per the standards laid down.

(RHS)

IS: 4923

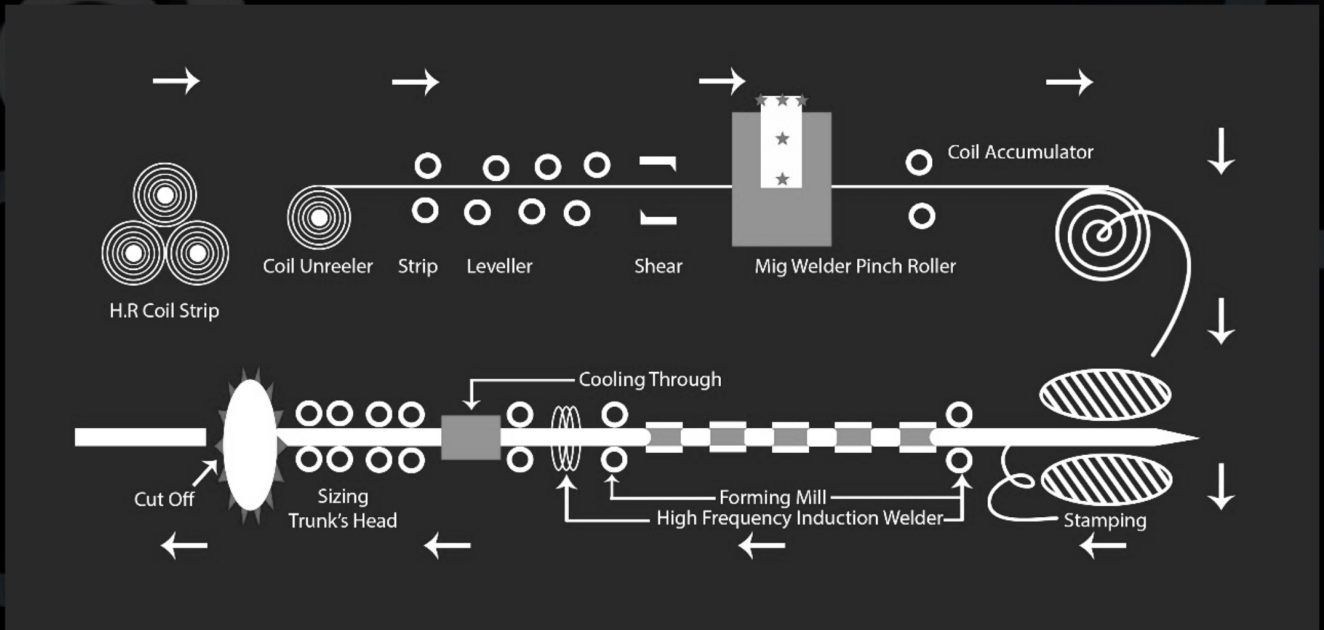


IS : 4923 : 1997/EN 10219-1 : 2006/ASTM A-500

RHS DXB mm	Thickness t mm	Sec Area A cm ²	Unit Wt W kg/m	Moment of inertia		Radius of Gyration		Elastic Modulus		Torsional Constants		Outer Surface Area per m ²
				I _{xx} cm ⁴	I _{yy} cm ⁴	r _{xx} cm	r _{yy} cm	E _{zxx} cm ³	E _{zyy} cm ³	J cm ⁴	B cm ³	
50x25	2	2.74	2.15	8.38	2.81	1.75	1.01	3.35	2.25	6.97	3.79	0.412
	2.6	3.46	2.71	10.16	3.36	1.71	0.99	4.06	2.69	8.27	4.53	0.137
	3.2	4.13	3.24	11.63	3.8	1.68	0.96	4.35	3.04	9.52	5.12	0.134
	4	4.95	3.88	13.13	4.23	1.63	0.92	5.25	3.38	10.86	5.69	0.129
60x40	2.6	4.76	3.73	22.76	12.09	2.19	1.59	7.59	6.05	25.59	9.83	0.187
	2.9	5.25	4.12	24.74	13.11	2.17	1.58	8.25	6.56	28.02	10.66	0.185
	3.6	6.35	4.98	28.90	15.23	2.13	1.55	9.63	7.62	33.30	12.41	0.181
	4.5	7.67	6.02	33.31	17.44	2.08	1.51	11.10	8.72	39.34	14.29	0.177
80x40	2.6	5.80	4.55	46.58	15.74	2.84	1.65	11.65	7.87	38.50	13.46	0.227
	2.9	6.41	6.03	50.87	17.11	2.82	1.63	12.72	8.56	42.23	14.66	0.225
	3.2	7.01	5.50	54.94	18.41	2.80	1.62	13.74	9.21	45.83	15.78	0.224
	4.0	8.55	6.71	64.79	21.49	2.75	1.59	16.20	10.74	54.7	18.49	0.219
96x48	4.8	10.01	7.85	73.22	24.03	2.71	1.55	18.30	12.02	62.81	20.79	0.215
	3.2	8.54	6.71	98.61	33.28	3.40	1.97	20.54	13.87	82.13	23.82	0.272
	4.0	10.47	8.22	117.54	39.32	3.35	1.94	24.49	16.38	99.11	28.24	0.267
	4.8	12.31	9.66	134.35	44.55	3.30	1.90	27.99	18.56	114.80	32.14	0.263
122x61	3.6	12.32	9.67	232.61	78.83	4.34	2.53	38.13	25.84	193.91	44.50	0.347
	4.5	15.14	11.88	278.94	93.78	4.29	2.49	45.73	30.75	235.39	53.13	0.343
120x60	3.2	10.85	8.51	199.88	67.95	4.29	2.5	33.31	22.65	165.83	28.95	0.334
	3.6	12.11	9.5	220.75	74.77	4.27	2.48	36.79	24.92	184.1	42.91	0.341
	4.5	14.87	11.67	264.52	88.88	4.22	2.44	44.09	29.63	223.34	51.19	0.337

*Note: These sizes would be included in our regular range of production in the near future. Sizes and Thickness other than listed above can be supplied on order basis.

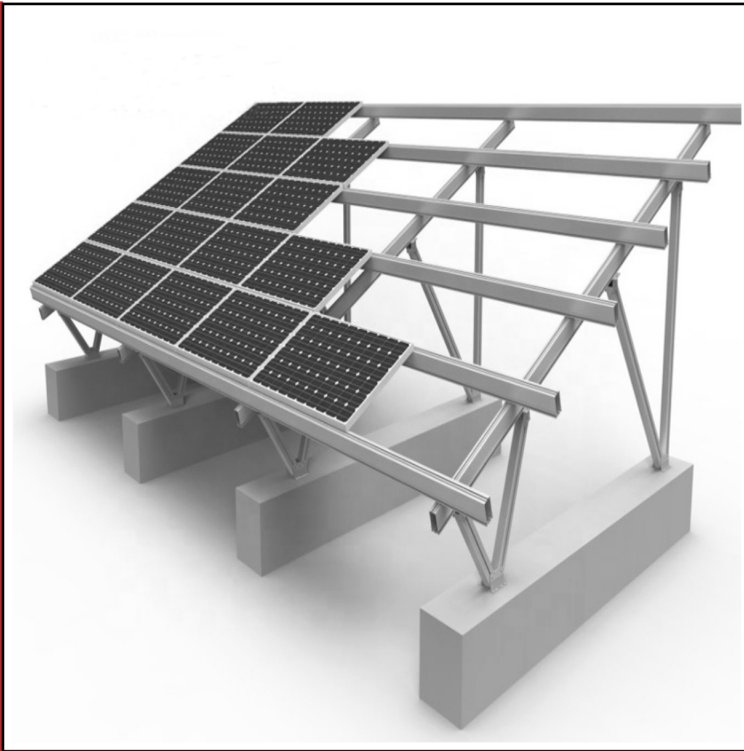
THE PROCESS



80 Micron Special Solar Structure

Solar Power Production is an ever growing industry in India and considering the demand for new power resources of energy increasing with the growing population, Hutch India Private Limited is providing **solar structure pipes**. All products are thoroughly inspected for quality check during every step of production as per specification & approvals.

The capacity of Solar Photo Voltaic Power Plants are increasing day by day. The industry is witnessing intense competition in the solar field and several bidders are compromising on the quality of the solar PV module mounting structures.



The mounting structures made of '**Hindustar 80 Micron Pipes**' are used to support the solar PV modules. Since the solar PV modules are built to last for 25 years, it is very important to choose the solar PV module mounting structure as it has to support the solar PV module for 25 years. At Hutch India, we strive to provide the top most quality products.

In galvanising zinc coating is applied to iron or steel to prevent it from rusting. There are several methods of galvanising. The most common method employed in '**80 Micron Pipe**' is the hot dip galvanisation. At Hutch, for **hot dip galvanisation**, the material to be galvanised is submerged in molten zinc at a temperature of around 450 °C. The galvanised material (steel) when exposed to atmosphere, the pure zinc reacts with the oxygen forming zinc oxide which further reacts with the carbon dioxide in the atmosphere to form Zinc Carbonate. The zinc carbonate is dull grey coloured and strong material. It gives protection to the material beneath the coating from any corrosion. In solar PV module mounting structure, our pipes provide the best option.

The image shows a large stack of square-section metal tubes, likely made of aluminum, used for solar panel structures. The tubes are arranged in a grid pattern, with several layers visible. The lighting is dramatic, with strong highlights and deep shadows, emphasizing the texture and geometry of the material. A solid red horizontal bar is positioned at the top of the image, and another red bar is at the bottom. The text is centered over the middle of the stack.

**80 MICRON
SPECIAL SOLAR
STRUCTURE**

HINDUSTAR

GALVANIZED PIPES



HUTCH
INDIA



IS : 4923



IS : 3601



IS : 1239



IS : 1161



Part-1







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INDIA**

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