HINDUSTAR

ERW Black & Galvanised Pipes

HUTCH
INDIA

BSCIC JAS-ANZ
ISO 9001 REGISTERED

KVQA NORSK AKKREDITERING QUAL 007
AN ISO 9001 CERTIFIED COMPANY

IS : 3601

IS : 1161

IS : 4923

IS : 1239

About Us

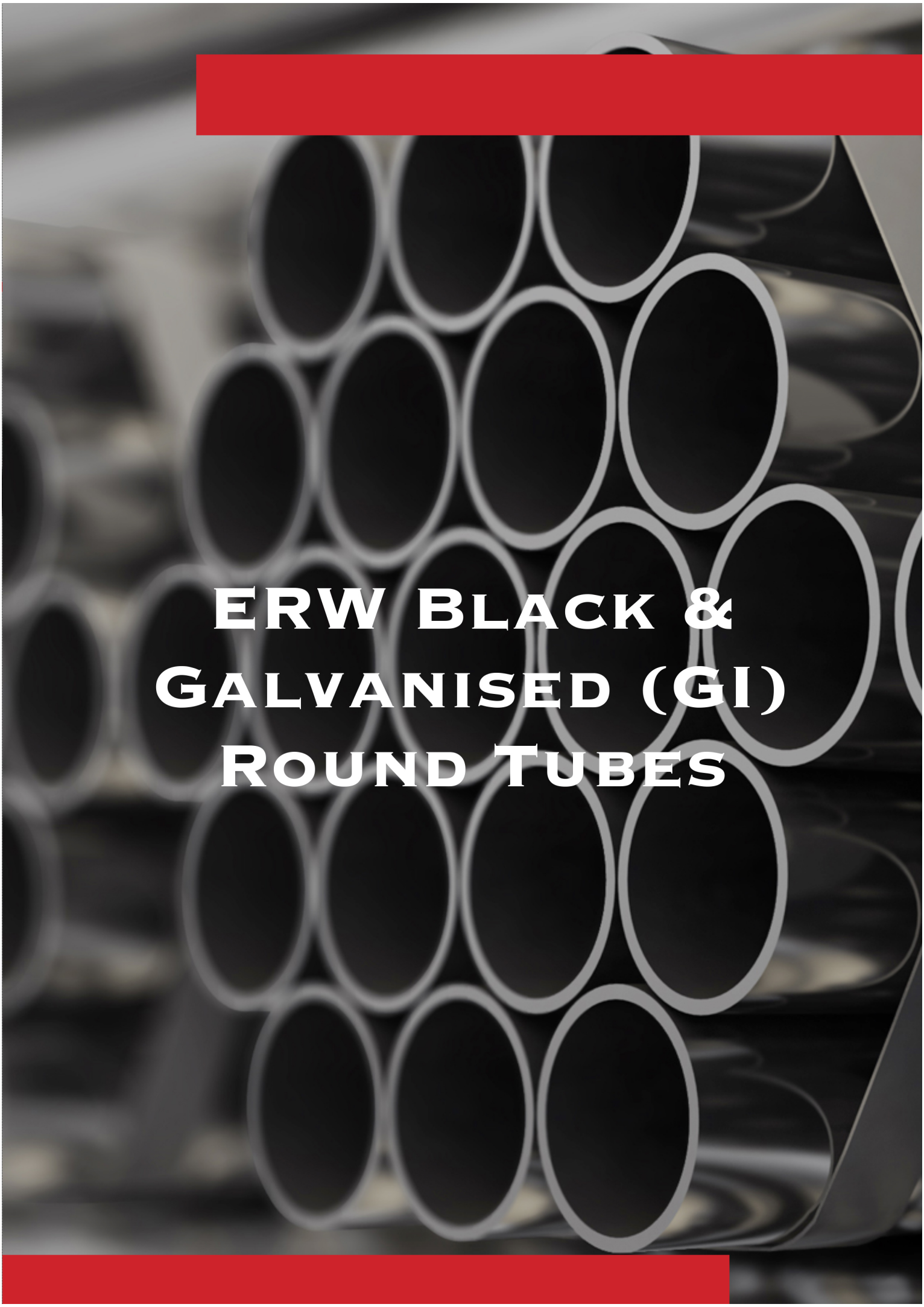
Hutch India Private Limited located at Surat, Gujarat in Western India, is an amalgamation of innovation, technology and human proficiency. With the best resources in the industry we cater to all the growing needs and demands of the market. We have started this factory in the western region to cater 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



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

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

IS: 3601

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

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

IS: 1161

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

N.B.	Series	Outside Diameter	Thickness	Nominal Weight Black Tube Plain End		Calculated Nominal Weight Gaivanized Tubes 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)	T.S.(min)	%Elongation
	MPA	MPA	
	(kg/mm2)	(kg/mm2)	
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 — TOLERANCES

SINGLE TUBE

1.LIGHT CLSS — +10%/-8%

2.MEDIUM & HEAVY CLASS — +/-10%

TOLERANCES :

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

THICKNESS: — TOLERANCES

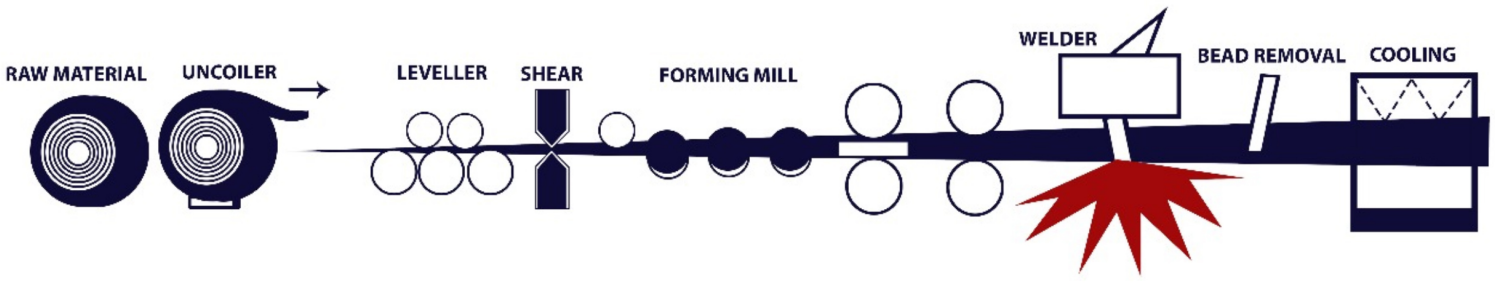
FOR ALL SIZE — +NOT LIMITED

WELDED TUBES — -10+

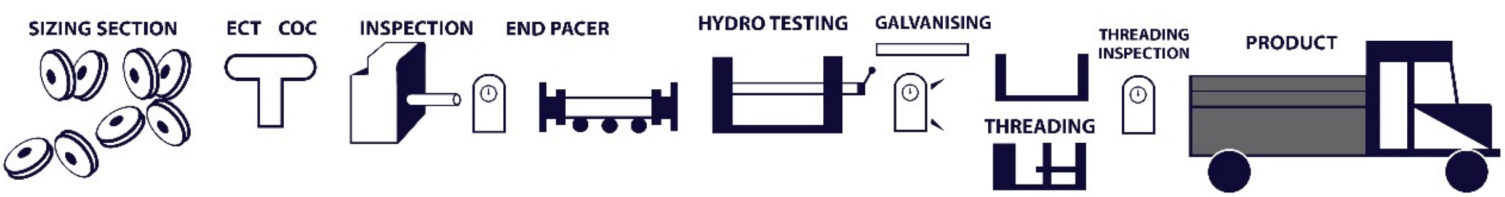
10 TON LOT

1.LIGHT CLASS — +/-5%

2. MEDIUM & HEAVY CLASS — +/-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)

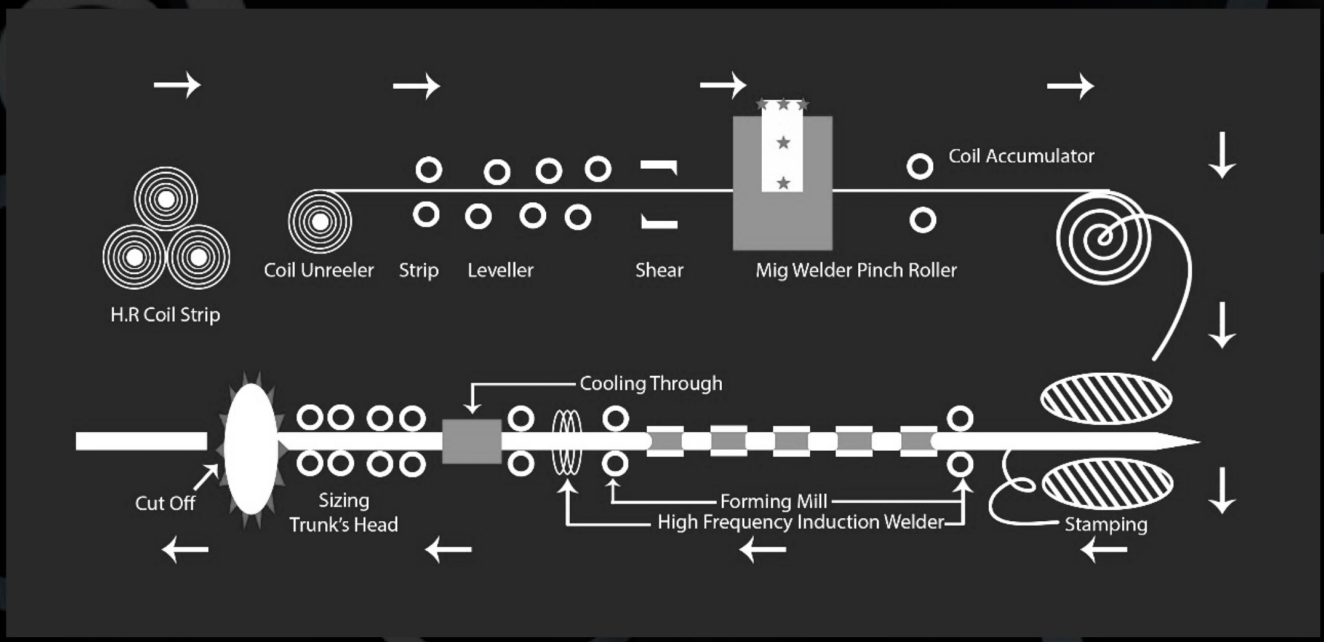
IS : 4923 : 1997/EN 10219-1 : 2006/ASTM A-500

IS: 4923

RHS DXB mm	Thickness t mm	Sec Area A cm2	Unit Wt W kg/m	Moment of inertia Ixx cm4	Moment of inertia ryy cm4	Radius of Gyration Ixx cm	Radius of Gyration ryy cm	Elastic Modulus zxx cm3	Elastic Modulus zyy cm3	Torsional Constants J cm4	Torsional Constants B cm3	Outer Surface Area per m m2
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
	4.8	10.01	7.85	73.22	24.03	2.71	1.55	18.30	12.02	62.81	20.79	0.215
96x48	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.

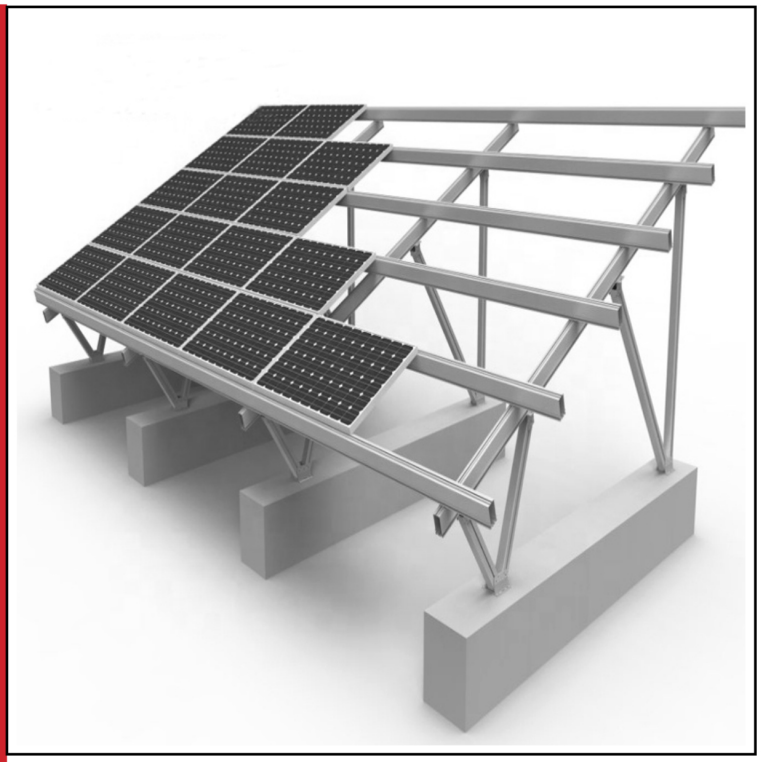
THE PROCESS



80 Micron Special Solar Structure

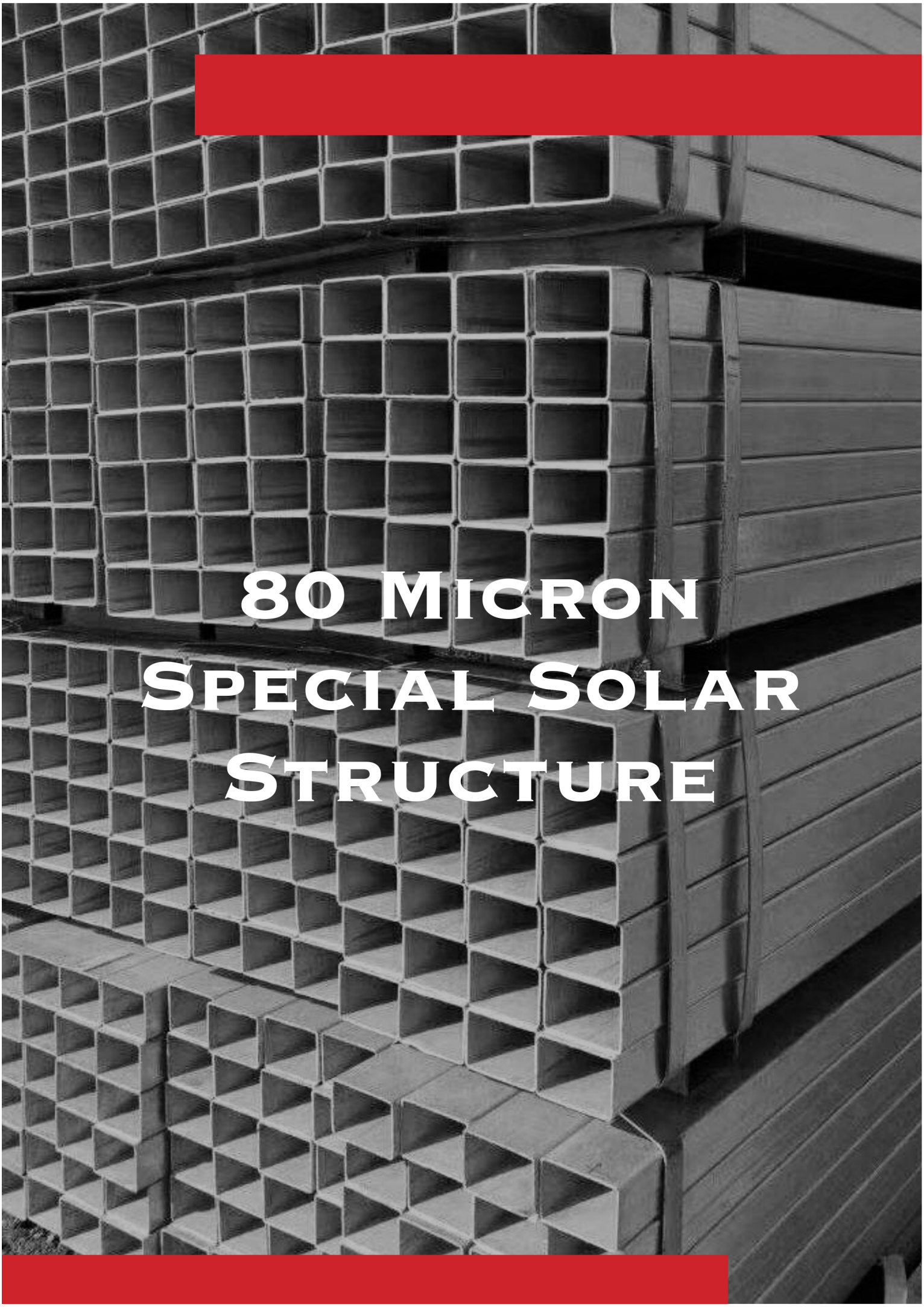
Solar Power Production is an ever growing industry in India and considering the demand for new power resources of energy increasing with the growing population, Hutch India Private Limited is providing **solar structure pipes**. All products are thoroughly inspected for quality check during every step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



80 Micron Special Solar Structure

HINDUSTAR

GALVANIZED PIPES

HUTCH INDIA

IS : 4923 IS : 3601

BSCIC JAS-ANZ ISO 9001 REGISTERED

IKVQA NORSK AKKREDITERING QUAL 007 AN ISO 9001 CERTIFIED COMPANY

IS : 1239 IS : 1161 Part-1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