

NIMET

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CTI

INTERNAL CHROME PLATED STEEL TUBES

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NIMAX CTI - E355+SR

For niche markets like concrete pumps and renewable energy sectors, NIMET has developed the optimal solution for elongating the service life of the cylinders.

The chrome layer protects the inside surface from corrosion and improves the durability.

STEEL GRADES CORRESPONDENTS

EN	Werkstoff	DIN	B.S.	UNI	JIS	GOST	AISI / SAE / ASTM
E355	1.0580	St52	CFS5	Fe510	STKM19A	St6sp	1524 / 1024

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	-	-	-	-	-	-

*Cr+Mo+Ni = max. 0.63

MECHANICAL PROPERTIES

Steel grade	Tensile strength	Yield point	Elongation (longitudinal)	Impact energy (longitudinal direction)	Hardness ***	Norm
	R _m N/mm ²	R _{p0.2} N/mm ²	A ₅ %	KV ₂ J	Brinell N/mm ²	
E355+SR	min. 580	min. 450	min. 10	(min. 27) / -20°C **	min. 175	EN 10305-1

SR = stress-relieved

* Wall thickness ≤ 12 mm

** On request

*** The hardness values is for information only

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Outside diameter - OD $\varnothing 80 - 225$ mm

Inside diameter - ID $\varnothing 70 - 200$ mm

Inside tolerance - ID ISO H8/ISO H9

Outside tolerance - OD according to EN 10305-1

Roundness - OD within the limits of the diameter tolerances

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Standard lengths requested by specification, but max. 1.100 mm

Surface roughness - ID Ra: max. 0.30 μm

Chrome layer thickness min. 20 μm

Chrome layer microhardness min. 900 HV0.1

Straightness max. 0.4 mm/1000 mm

TABLE OF DIMENSIONS ID TOLERANCE

Diameter mm	ISO H8 μm	ISO H9 μm
$50 < \varnothing \leq 80$	0/+46	0/+74
$80 < \varnothing \leq 120$	0/+54	0/+87
$120 < \varnothing \leq 180$	0/+63	0/+100
$180 < \varnothing \leq 200$	0/+72	0/+115

STANDARD DIMENSIONS RANGE

Outside diameter mm	80	90	105	110	115	125	145	150	160	165	170	175	190	195	210	216	225
Inside diameter mm	70	80	90	95	100	110	125	120	135	140	145	140	160	160	180	200	200
Wall thickness mm	5	5	7.5	7.5	7.5	7.5	10	15	12.5	12.5	12.5	17.5	15	17.5	15.0	8	12.5
	-	-	-	-	-	12.5	-	-	-	-	-	-	-	-	-	-	-

* Other dimensions on request

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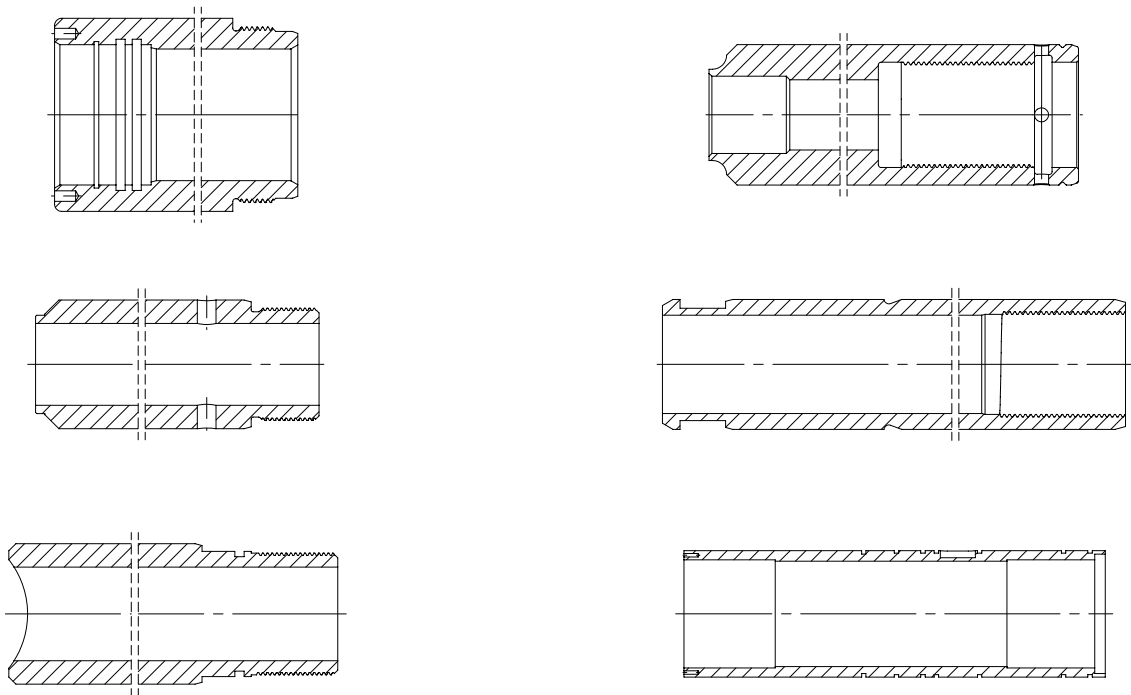
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CUSTOMIZED MACHINING



STORAGE AND HANDLING RECOMMENDATIONS

- Keep the products stored in dry and covered spaces.
- Do not expose for a long time the bars or tubes to the sunlight or to very low temperatures.
- For storage, preferable to use rubber supports or wood lined supports; direct contact with the floor and steel supports that are not lined with soft materials must be avoided.
- Whenever possible, please use the crane to load or unload the bundles; when you use the fork lifts please avoid the direct contact of the forks with the products.
- Always lift the bundles using textile slings. Don't use metal slings during handling of bundles.
- Always keep dry the cardboard tubes that protect the chromed products.



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