Datasheet:

EN 1.4307/304L – Austenite Welded Tubes - Stainless Steel

Alumeco ApS
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Internal alloy name:	**1.4307**
Alloy type:	**Austenite**
Chemical Symbol:	**X2CrNi18-9**
EN:	**EN 1.4307**
AISI:	**304L**
UNS:	**S30403**
SS:	**2352**
JIS:	**SUS304L**
GB:	**S30403**

Main usage:

- Food and beverage industry equipment
- Chemical and pharmaceutical industry equipment
- Heat exchangers
- Storage tanks and containers
- Pipes
- Flanges and valves

Main properties:

- Excellent weldability
- Good stability against corrosion
- Good formability, both cold and hot
- Resistance to intergranular corrosion (EN 10088-3)

Important norms and literature:

General Standards
EN 10088-1: List of stainless Steel

Product standards:
EN 10217-7: Welded steel tubes for pressure purposes- Technical delivery conditions-Part 7: Stainless steel tubes

Geometric Tolerance:
EN 1127 D3/T3: Stainless steel tubes- Dimensions, tolerances and conventional masses per unit length

ASTM A554-98E1: Standard specification for welded stainless steel mechanical tubing

Chemical composition in %: EN 10217-7

C	Si	Mn	P	S	Cr	Cu	Ni	Remarks	Rest
≤ 0,030	≤ 1,00	≤ 2,00	≤ 0,045	≤ 0,030*	17,5-19,5	-	8,0-10,5	N ≤ 0,10	Fe

*** For machinability, a controlled sulfur content of 0,015%-0,030% is recommended & permitted. For weldability a controlled sulfur content of 0,008%- 0,030% is recommended & permitted. For polishability, a controlled sulfur content of 0,015% is recommended.**

Mechanical properties: EN 10217-7

Outer diameter (mm)	Wall thickness (mm)	Rm MPa	$Rp_{0,2}$ MPa	$Rp_{1,0}$ MPa	Elongation (Longitudinal) A%	Impact energy (Longitudinal) KV_2	Hardness* HB
21,3 - 600	1,3 - 3	500 - 700	Min. 220	Min. 250	45	100	Max. 215

*** Information values only;**

Physical properties:

Density g/cm³	Electrical resistivity Ω mm² / m	Thermal conductivity W/m K	Thermal expansion (µm m^{-1} K^{-1})	Specific heat (J kg^{-1} K^{-1})	E - modulus (N / mm²)	Magnetizable	PREN (Min.)
7,9	0,73	15	16,0	500	200.000	No	17,5

Typical Alumeco products with this alloy

- **Outer Dia: 21.3 (3.5´´)-606 mm (21.3´´) ; Wall Thickness: 1.6-3 mm**

Tolerances for welded steel tubes for EN 1.4307:

Tolerances on outside diameter	
Tolerance class	**Tolerance on outside diameter**
D_1	± 1,5% with min. ± 0,75 mm
D_2	± 1% with min. ± 0,5 mm
D_3	± 0,75% with min. ± 0,3 mm
D_4	± 0,5% with min. ± 0,1 mm

* Values are referred from Table 1 of EN 1127:1992

Tolerances on thickness	
Tolerance class	**Tolerance on thickness**
T_1	± 15% with min. ± 0,6 mm
T_2	± 12,5% with min. ± 0,4 mm
T_3	± 10% with min. ± 0,2 mm
T_4	± 7,5% with min. ± 0,15 mm
T_5	± 5% with min. ± 0,1 mm

* Values are referred from Table 2 of EN 1127:1992

Tolerances on exact lengths	
Length *L* (mm)	**Tolerance on exact length (mm)**
$L \leq 6000$	+ 5 0
$6000 < L \leq 12000$	+10 0
$L > 12000$	+ by agreement 0

* Values are referred from Table 12 of EN 10217-7:2014