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**National Standard of the People's Republic of China**

**中华人民共和国国家标准**

GB/T 3091—2008  
Replace GB/T 3091—2001

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**Wekded Steel Pipes for Low Pressure  
Liquid Delivery  
低压流体输送用焊接钢管**

(ISO 559:1991,NEQ)

Issued on: May 13, 2008

Implemented on: November 01, 2008

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Issued by: General Administration of Quality Supervision, Inspection and  
Quarantine of the People's Republic of China  
Standardization Administration of the People's Republic of China

## Foreword

This standard is not equivalent to ISO 559:1991 “Steel Tubes for Water and Sewage” (English edition).

This standard will replace GB/T 3091–2001 “Welded Steel Pipe for Low Pressure Liquid Delivery”. There have been some significant changes in this standard over GB/T 3091–2001 in the following technical aspects:

- Add spiral seam submerged arc welding steel tube and relevant contents;
- Adjust outside diameter and wall thickness series;
- Become strict with permissible variation of outside diameter of steel tube whose outside diameter is larger than 508mm;
- Become stricter with permissible variation of steel tube's wall thickness;
- Add permissible variation of weight;
- Add Q195 steel grade;
- Become strict with tensile test;
- Become strict with flattening test requirement;
- Add requirement of face guided bend test for submerged arc welding steel tube;
- Adjust hydraulic test value of steel tube;
- More definite provisions about galvanizing coat.

Appendix A of this standard is informative; appendix B and appendix C are normative.

This standard was proposed by China Iron & Steel Association.

This standard is under the jurisdiction of National Technical Committee of Standardization for Steel.

This standard was drafted by: Jinxi Steel Pipe Co., Ltd., Panyu Chu Kong Steel Pipe Co., Ltd., Jinghua Innovation Group Co., Ltd., and Zhejiang Kingland Pipeline Co., Ltd.

Chief drafting staffs of this standard: Qi Huijuan, Zhu Xingwei, Zhao Fuliang, Wang Lishu, Shen Ganrong, Huang Kejian, and Yang Weifang.

Issuance of all previous editions of the standard replaced by this standard

- GB/T 3091–1982, GB/T 3091–1993, GB/T 3091–2001.

# Welded Steel Pipes for Low Pressure Liquid Delivery

## 1 Scope

This standard specifies dimension, appearance, weight, technical requirements, test method, test rules, packing, and marking and quality certificate of welded steel pipes for low pressure liquid delivery.

This standard is applicable to welded steel pipes for delivering low pressure liquid such as water, air, heating steam and gasses.

This standard comprises longitudinal-seam high-frequency electrical resistance welded (ERW) steel pipes, longitudinal-seam submerged arc welded (SAWL) steel pipe and spiral-seam submerged arc welded (SAWH) steel pipe, and respectively marks different requirements related to them. Those without marks are simultaneously applicable to longitudinal-seam high-frequency electrical resistance welded steel pipe, longitudinal-seam submerged arc welded steel pipe and spiral seam submerged arc welded steel pipe.

## 2 Normative references

The following documents contain provisions which, through reference in this standard, constitute provisions of this standard. For dated reference, subsequent amendments to (excluding corrigenda contents), or revisions of, any of these publications do not apply. However, parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the documents. For undated references, the latest edition of the normative document referred to applies.

GB/T 222 Permissible Tolerances for Chemical Composition of Steel Products

GB/T 223.3 Methods for Chemical Analysis of Iron, Steel and Alloy; The Diantipyrylmethane Phosphomolybdate Gravimetric Method for the Determination of Phosphorus Content

GB/T 223.5 Methods for Chemical Analysis of Iron, Steel and Alloy; The reduced molybdosilicate spectrophotometric method for the determination of acid-soluble silicon content

GB/T 223.10 Methods for Chemical Analysis of Iron, Steel and Alloy; The Cupferron Separation-chrome Azurol S Photometric Method for the Determination of Aluminium Content

GB/T 223.11 Methods for Chemical Analysis of Iron, Steel and Alloy; The Ammonium Persulfate Oxidation Volumetric Method for the Determination of Chromium Content

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