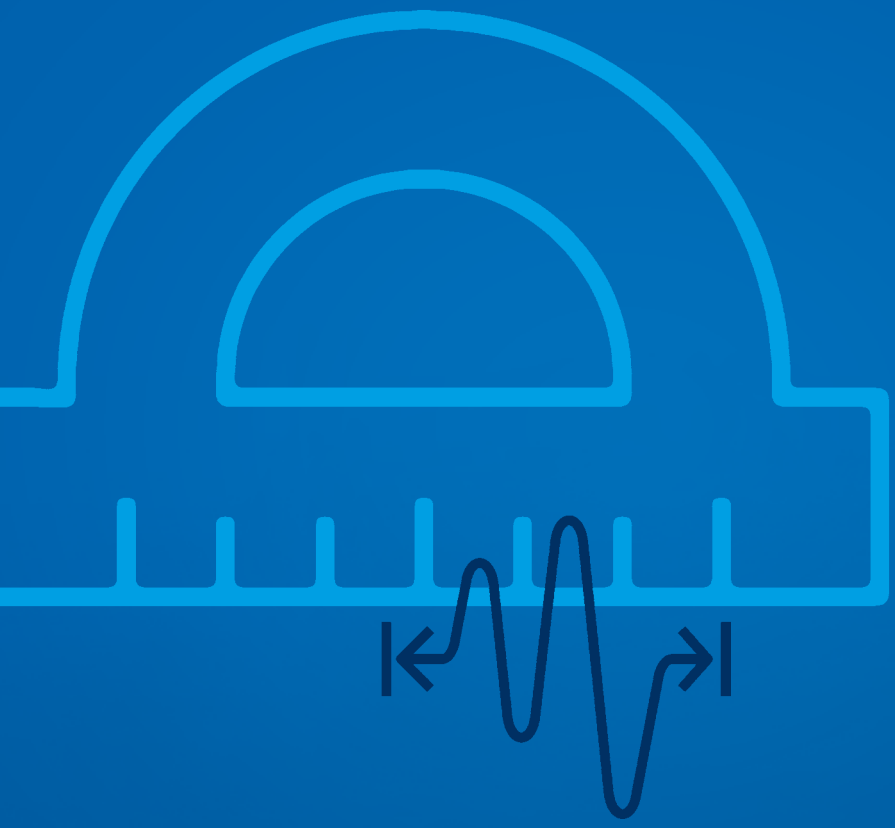
DOCKWEILER

connecting flow to purity

SPECIFICATIONS

FOR TUBES, PIPES, FITTINGS AND CONNECTIONS



FOR SEMICONDUCTOR AND HIGH-TECH INDUSTRIES

- ultron
- finetron
- TCC / TCC.1
- VSR80

FOR PHARMA, BIOTECH AND OTHER LIFE SCIENCE INDUSTRIES

- ASME BPE Certified
- weldtron
- safetron

EMEA

Specification
ultron

For UHP gas applications in semiconductor industry and fine chemistry

ultron

ep **Electropolished**

1. SURFACES QUALITIES

Tubes and fittings:	Inner surface (ep)	Outer surface
ultron	**$Ra_{avg.} \leq$ 0,25 µm (10 µin)**	**$Ra_{avg.} \leq$ 1.0 µm (40 µin)**
On request:	$Ra_{avg.} \leq$ 0,13 µm (5 µin) $Ra_{avg.} \leq$ 0,18 µm (7 µin) $Ra_{avg.} \leq$ 0,38 µm (15 µin)	

Pipe:	Inner surface (ep)	Outer surface
ultron	**$Ra_{avg.} \leq$ 0,51 µm (20 µin)**	Mill finish, RA not defined

Additional notes:
- Tube and Fittings are prepared for orbital welding (acc. to Dockweiler guideline Doc. 8.3-9/7).
- Ra values may differ for 1/8" tubes
- Pipe will be supplied with a square cut (acc. to Dockweiler guideline Doc. 8.3-9/7).
- Other specified surfaces or ends are available upon request.
- The Ra value in the cold worked area of fittings (inner and outer surface) and on the surface of circumferential welds is not defined. For dimensions OD < 1/4" (6,35 mm) roughness is not defined.
- Free of oil and grease acc. to CGA G-4.1-2018 and ASTM G93 – level A.
- Electropolishing procedure acc. to Dockweiler guideline Doc. 8.4-40/3.1/3.3.1
- Cleanroom cleaning and packing (ISO Class 4 / Federal Class 10)

2. MATERIALS

ultron	1.4404 / UNS S31603 (316L) 1.4435 / UNS S31603 (316L) UNS S31603 (316L)
Hardness equivalent to:	- max. 180 HV* according to DIN EN ISO 6507-1 - max. 90 HRB* according to DIN EN ISO 6508-1 * comparable to ASTM E-384 (HV) and ASTM E 18-22 (HRB)

3. DIMENSIONS

Imperial:	Imperial according to ASTM A269 / A270 / A632	
OD x WT	1/8" x 0.022" to 6" x 0.109"	3,18 x 0,56 mm to 152,4 x 2,77 mm

Pipe:	Pipe according to ASTM A312	
Dimensions	NPS 8, 10, 12 Schedule 10S	Length: min. 19.36 ft to max. 19.98 ft

Metric:		
OD x WT	6,00 x 1,00 mm to 35,00 x 1,50 mm	Lenght: 6000 mm -100/+90

Manufacturing process:	Seamless tubes (≤ 1")	Welded or seamless tubes (> 1")

4. QUALITY AND TEST PROCEDURES

- Verification of basic test certificate
- Visual inspection
- Endoscopic inspection of bright finished tubes
- Verification of dimensions
- Roughness measurements
- Conductivity test (DI water)
- TOC-measurement of DI water
- Particle measurements
- Scanning electron microscope (SEM)
- XPS / ESCA
- Auger analysis (AES)

5. TECHNICAL TERMS OF DELIVERY

Tubes and fittings are prepared for orbital welding:

Tubes

Acc. to ASTM A 632/ A 269 / A 312 (Pipe), DIN EN 10217-7 / 10216-5 with a length of 19.35 ft - 19.98 ft (5900 - 6090 mm), max. 10% short lengths of min. 9.84 ft (3000 mm)

Tube fitting components

Prematerial acc. to ASTM A 269 / A 632 / A 312 / A 403 (Pipe), DIN EN 10217-7 / 10216-5

Machined components

Prematerial acc. to ASTM A 479, DIN EN 10088-3, DIN 17440, ASTM A403 (Pipe)

Marking always with

DOCKWEILER / DW-Number / Dimension / Material / Heat number

Tube, pipe and fittings shall be permanently marked as per Dockweiler guideline AA 8.5.2-80. The marking must provide all necessary information to trace back the heat number and the material grade.

6. DOCUMENTATION, PACKAGING & SHIPPING

Documentation

The documentation result by the Dockweiler Inspection Certificate 3.1 according to DIN EN 10204.
Optional online documentation WebCert.

Packaging

Tubes and fittings filled with N2 (99.9998% incl. inert gas), capped with PA/PE squares and yellow PE caps, double-bagged and sealed in PE-sleeves.

The batch label on the foil contains the information ultron.

Shipping

Delivery in tubular container or wooden crate, fittings in strong cardboard box with shock absorbing filler.

Specification
finetron

For gas applications in semiconductor industry as well as in photovoltaics

finetron

bf **bright finished**

1. SURFACES QUALITIES

Tubes and fittings:	Inner surface (bf)	Outer surface
finetron	**Ra avg. ≤ 0,40 µm (16 µin)**	**Ra avg. ≤ 1.0 µm (40 µin)**
Additional notes:	- Tubes and fittings are prepared for orbital welding. - Other specified surfaces or ends are available upon request. - The Ra value in the cold worked area of fittings (inner and outer surface) and on the surface of circumferential welds is not defined. For dimensions OD ≤ 3/8" (5.00 mm) roughness is not measured. - Cleaning and test procedure ASTM A 632, S3 – level C.	

2. MATERIALS

	Austenitic stainless steel tubes and fittings (seamless or welded / depending on diameter):
finetron	1.4404 / UNS S31603 (316L) 1.4435 / UNS S31603 (316L) UNS S31603 (316L)
Hardness equivalent to:	- max. 180 HV* according to DIN EN ISO 6507-1 - max. 90 HRB* according to DIN EN ISO 6508-1 * comparable to ASTM E-384 (HV) and ASTM E 18-22 (HRB)

3. DIMENSIONS

Imperial:	according to ASTM A269 / A632	
OD x WT	1/4" to 6" (0.250 x 0.035 inch to 6.000 x 0.109 inch)	6,35 x 0,89 mm to 152,40 x 2,77 mm
Lenght	min. 19.36 ft to max. 19.98 ft	6000 mm -100/+90

Metric:		
OD x WT	6,00 x 1,00 mm to 35,00 x 1,50 mm	
Lenght	6000 mm -100/+90	
Manufacturing process:	Seamless tubes (≤ 1")	Welded or seamless tubes (> 1")

4. QUALITY AND TEST PROCEDURES

- Verification of basic test certificate
- Visual inspection
- Endoscopic inspection of bright finished tubes
- Verification of dimensions
- Roughness measurements

5. TECHNICAL TERMS OF DELIVERY

Tubes and fittings are prepared for orbital welding:

Tubes

Acc. to ASTM A 632 / A 269 / A 270, DIN EN 10217-7 / 10216-5 with a length of 5900 - 6090 mm (max. 10% short lengths of min. 3000 mm possible).

Tube fitting components

Prematerial acc. to ASTM A 269 / A 632 / A 312 / A 403 (Pipe), DIN EN 10217-7 / 10216-5

Marking always with

DOCKWEILER / DW-Number / Dimension / Material / Heat number

Tubes and fittings shall be permanently marked as per Dockweiler guideline AA 8.5.2-80. The marking must provide all necessary information to trace back the heat number and the material grade.

6. DOCUMENTATION, PACKAGING & SHIPPING

Documentation

The documentation result by the Dockweiler Inspection Certificate 3.1 according to DIN EN 10204.
Optional online documentation WebCert.

Packaging

Bright finished tubes and fittings are capped with transparent PE caps and are individually sealed in PE foil.

The batch label on the foil contains the information finetron.

Shipping

Delivery in tubular container or wooden crate, fittings in strong cardboard box with shock absorbing filler.

Specification
TCC/TCC.1

Widely used in production, process measurement and photovoltaic

TCC / TCC.1

bf **bright finished**
ac **anodical cleaned**

1. SURFACES QUALITIES

Tubes and fittings:	Inner surface	Outer surface
TCC (bf)	**not defined;** on request Ra $_{avg.}$ ≤ 0,80 µm (32 µin)	**not defined**
TCC.1 (ac)	**not defined;** on request Ra $_{avg.}$ ≤ 0,80 µm (32 µin)	**not defined**

Pipe and pipe fittings:	Inner surface	Outer surface
TCC (bf)	**not defined;** on request Ra $_{avg.}$ ≤ 0,80 µm (32 µin)	**not defined**
TCC.1 (ac)	**not defined;** on request Ra $_{avg.}$ ≤ 0,80 µm (32 µin)	**not defined**

Additional notes:
- Tubes and fittings are prepared for orbital welding.
- Other specified surfaces or ends are available upon request.
- Pipes and fitting will be supplied with a square cut. Different end preparations may be agreed on.
- The Ra value in the cold worked area of fittings (inner and outer surface) and on the surface of circumferential welds is not defined. For dimensions OD ≤ 3/8" (5.00 mm) roughness is not measured.
- TCC (bf): Cleaning and test procedure ASTM A 632, S3 and ASTM G93 – level D.
- TCC.1 (ac): Free of oil and grease acc. to CGA G-4.1-2018 and ASTM G93 – level B.

2. MATERIALS

	Austenitic stainless steel tubes and fittings (seamless or welded) in:
TCC / TCC.1	1.4435 / UNS S31603 (316L) 1.4404 / UNS S31603 (316L) UNS S31603 (316L) UNS S30403 (304L)

Hardness equivalent to:	- max. 180 HV* according to DIN EN ISO 6507-1 - max. 90 HRB* according to DIN EN ISO 6508-1 * comparable to ASTM E-384 (HV) and ASTM E 18-22 (HRB)

3. DIMENSIONS

Imperial:	according to ASTM A269 / A270 / A632	
OD x WT	1/8" x 0.022" to 6" x 0.109"	3.18 x 0.56 mm to152.4 x 2.77 mm
Length	min. 19.36 ft to max. 19.98 ft (6000 mm -100/+90)	

Pipe:	according to ASTM A312	
Dimensions	NPS 8, 10, 12, 16, 20 Schedule 10S	219,08 x 3,76 mm to 508,00 x 5,54 mm
Length	min. 19.36 ft to max. 19.98 ft (6000 mm -100/+90)	

Metric:		
Dimensions	3,00 x 0,50 mm to 35,00 x 1,50 mm	
Length	min. 19.36 ft to max. 19.98 ft (6000 mm -100/+90)	

Manufacturing process:	Seamless tubes (≤ 1/2")	Welded or seamless tubes (> 1/2")

4. QUALITY AND TEST PROCEDURES

- Verification of basic test certificate
- Visual inspection
- Endoscopic inspection of bright finished tubes
- Verification of dimensions
- Roughness measurements

5. TECHNICAL TERMS OF DELIVERY

Tubes and fittings are prepared for orbital welding:

Tubes

Acc. to ASTM A 632 / A 269 / A 270, DIN EN 10217-7 / 10216-5 with a length of 5900 - 6090 mm (max. 10% short lengths of min. 3000 mm possible).

Fittings

According to DIN 11865, ASTM A 403 (Pipe), ASTM A 182 (Pipe)

Marking always with

DOCKWEILER / DW-Number / Dimension / Material / Heat number

Tube and fittings shall be permanently marked as per Dockweiler guideline AA 8.5.2-80. The marking must provide all necessary information to trace back the heat number and the material grade.

6. DOCUMENTATION, PACKAGING & SHIPPING

Documentation

The documentation result by the Dockweiler Inspection Certificate 3.1 according to DIN EN 10204.
Optional online documentation WebCert.

Packaging

Bright finished tubes and fittings are capped with white/transparent PE caps and packaged in PE foil.
The batch label contains the information TCC.

Anodically cleaned tubes and fittings are capped with PE/PA squares and white/transparent PE caps and packed in PE foil. The batch label contains the information TCC.1.

Shipping

Delivery in tubular container or wooden crate, fittings in strong cardboard box with shock absorbing filler.

Specification
VSR80

For leak-tight but detachable connections
with controlled hardness for easy installation

VSR80

bf **bright finished**

1. SURFACES QUALITIES

Tubes:	Inner surface	Outer surface
VSR80	**Ra values are not defined**	**$Ra_{avg.}$ ≤ 1.0 µm (40 µin)** free of longitudinal and vertical scratches

2. MATERIALS

VSR80	1.4404 / UNS S31603 (316L) 1.4571 / S31635
Hardness equivalent to:	- max. 70-90 HRB* according to DIN EN ISO 6508-1 * comparable to ASTM E-384 (HV) and ASTM E 18-22 (HRB)

3. DIMENSIONS

Imperial:	according to ASTM A269 and DIN 11866 Series C	
OD x WT	1/16" (0,0625"x 0,010") to 1" (1,000" x 0,065 ")	1,59 mm x 0,25 mm to 25,40 mm x 1,65 mm
Length	min. 19.36 ft to max. 19.98 ft (6000 mm -100/+90)	

Metric:	according to DIN 11866 Series A	
Dimensions	3,00 mm x 0,50 mm to 28,00 mm x 1,50 mm	Length: 6000 mm -100/+90

Manufacturing process: Seamless austenitic stainless steel tubes

4. QUALITY AND TEST PROCEDURES

- Verification of basic test certificate
- Visual inspection
- Endoscopic inspection of bright finished tubes
- Verification of dimensions
- Roughness measurements

5. TECHNICAL TERMS OF DELIVERY

Tubes according to the following standards:

Tubes

Acc. to ASTM A 632 / A 269 / A 270, DIN EN 10217-7 / 10216-5 with a length of 19.35 ft - 19.98 ft (max. 10% short lengths of 9.8 ft min. possible)

Marking always with

DOCKWEILER / DW-Number / Dimension / Material / Heat number

Tubes are permanently marked in accordance with Dockweiler guideline AA 8.5.2-80.

6. DOCUMENTATION, PACKAGING AND SHIPPING

Documentation

The documentation result by the Dockweiler Inspection Certificate 3.1 according to DIN EN 10204.
Optional online documentation WebCert.

Packaging

The batch label on the foil contains the information VSR80.

Shipping

Delivery in tubular container or case for safe transport.

Specification
ASME BPE

For pharma, biotech and other life science industries

ASME BPE

ASME BPE SF1 / mechanically polished

ASME BPE SF4 / electropolished

1. SURFACE QUALITIES

Tubes and fittings:	Inner surface (mechanically polished)*
ASME BPE SF0 - on request	No finish requirements
■ ASME BPE SF1	**Ra max. ≤ 0,51 µm / 20 µin** (Dockweiler Standard)
ASME BPE SF2 - on request	Ra max. ≤ 0,64 µm / 25 µin
ASME BPE SF3 - on request	Ra max. ≤ 0,76 µm / 30 µin

Tubes and fittings:	Inner surface (electropolished)
■ ASME BPE SF4	**Ra max. ≤ 0,38 µm / 15 µin** (Dockweiler Standard)
ASME BPE SF5 - on request	Ra max. ≤ 0,51 µm / 20 µin
ASME BPE SF6 - on request	Ra max. ≤ 0,64 µm / 25 µin

Surface treatment:	- Mechanically polished (or any other finishing method that meets the Ra max.): Cleaning and test procedure ASTM A 632, S3 - Electropolished: Procedure acc. to Spec. Doc. 8.4-40/3.2/3.3.2 - Free of oil and grease acc. to CGA G-4.1-2018 and ASTM G93 – level B (SF4) / level C (SF1)

2. MATERIALS

■ **ASME BPE**	UNS S31603 (316L)*, UNS S31603 (316L), 1.4404, 1.4435* * defined sulphur of 0.005 - 0.017%

Hardness equivalent to:	- max. 180 HV* according to DIN EN ISO 6507-1 - max. 90 HRB* according to DIN EN ISO 6508-1 * comparable to ASTM E-384 (HV) and ASTM E 18-22 (HRB)

3. DIMENSIONS

Imperial:	acc. to ASME BPE, Part DT	
OD x WT	1/4" to 6" (0.250 x 0.035 inch to 6.000 x 0.109 inch)	6,35 x 0,89 mm to 152,40 x 2,77 mm

Manufacturing process:	Welded or seamless tubes

4. QUALITY AND TEST PROCEDURES

- Verification of basic test certificate
- Visual inspection
- Endoscopic inspection of bright finished tubes
- Verification of dimensions
- Roughness measurements

5. TECHNICAL TERMS OF DELIVERY

Tubes and fittings

Acc. to ASME BPE-2024, ASTM A 269/270, tubes with a length of 5900 - 6090 mm (19.35 ft - 19.98 ft), max. 10% short lengths of min. 3000 mm (9.84 ft)

Marking always with

DOCKWEILER / DW-Number / Dimension / Material / Heat Number / ASME Certification Mark, Surface Finish Designation

Tubes, pipes and fittings shall be permanently marked as per ASME BPE-2024, DT-11. The marking must provide all necessary information to trace back the heat number and the material grade.

6. DOCUMENTATION, PACKAGING AND SHIPPING

Documentation

The documentation result by the Dockweiler Inspection Certificate 3.1 according to DIN EN 10204.
Optional online documentation WebCert.

Packaging

Mechanically polished tubes and fittings are closed with transparent PE caps and are individually sealed in PE foil. The batch label on the foil contains the information ASME BPE SF1.

Electropolished tubes and fittings are closed with PA/PE squares and yellow PE caps, sleeved and sealed in PE. The batch label on the foil contains the information ASME BPE SF4.

Shipping

Delivery in tubular container or wooden crate, fittings in strong cardboard box with shock absorbing filler.

Specification
safetron

For sensitive media in pharma and biotech:
WFI, serums and parenterals

safetron

bf **bright finished**
ep **electropolished**

1. SURFACE QUALITIES

Tubes and fittings:	Inner surface (bf)
safetron | H4o	**Ra $_{avg.}$ ≤ 0,40 µm / 16 µin**
Surface treatment:	- Bright finished (bf) / H4o Hygienic Class according to DIN 11866/11865/11864/DIN 32676 - Ra value for circumferential weld seam of fittings not defined - T-pieces according to DIN 11865, option “u”. - Circular weld seams ground with specified Ra value on request - Cleaning and testing methods ASTM A 632, S3 - Weld ends of tubes and fittings are prepared for orbital welding (square cut and faced).

Tubes and fittings:	Inner surface (ep)
safetron | HE5o	**Ra $_{avg.}$ ≤ 0,25 µm / 10µin**
Surface treatment:	- Electropolished (ep)/HE5o Hygienic Class according to DIN 11866/11865/11864/DIN 32676 - Ra value for circumferential weld seam of formed parts not defined - T-pieces according to DIN 11865, option “u”. - - Circular weld seams ground with specified Ra value on request. - Cleaning and testing procedures according to Spec. doc. 8.4-40/3.2/3.3.2 - Oil and grease-free in accordance with CGA G-4.1-2018 and ASTM G93 – level B - Weld ends of tubes and fittings are prepared for orbital welding (square cut and faced).

2. MATERIALS

	Austenitic stainless steel tubes and fittings in:
safetron	1.4435 / UNS S31603 (316L) acc. to Basler Norm 2 (BN2) 1.4404 / UNS S31603 (316L)

Hardness equivalent to:	- max. 180 HV* according to DIN EN ISO 6507-1 - max. 90 HRB* according to DIN EN ISO 6508-1 * comparable to ASTM E-384 (HV) and ASTM E 18-22 (HRB)

3. DIMENSIONS

Imperial	acc. to ASTM A269 / A270 / A632, ASME BPE and DIN 11866 Serie C
OD x WT:	1/4" to 6" (0.250 x 0.035 inch to 6.000 x 0.109 inch) 6,35 x 0,89 mm to 152,40 x 2,77 mm
ISO	**acc. to DIN EN ISO 1127 und DIN 11866 Serie B**
OD x WT:	13,50 x 1,60 mm to 219,10 x 2,60 mm
Metric	**acc. to DIN 11866 Series A**
	on request

Manufacturing process:	Welded or seamless tubes

4. QUALITY AND TEST PROCEDURES

- Verification of basic test certificate
- Visual inspection
- Endoscopic inspection of bright finished tubes
- Verification of dimensions
- Roughness measurements
- Delta ferrite measurement 1.4435 BN2 / 316L

5. TECHNICAL TERMS OF DELIVERY

Tubes and fittings are prepared for orbital welding:

Tubes

According to 11866, ASTM A 269/A 270, DIN EN 10217-7/ 10216-5 with a length of 5900 - 6090 mm
(max. 10% short lengths of min. 3000 mm possible).

For electropolished tubes with outer diameter ≤ 5.00 mm, the length is 2950 ± 50 mm.

Fittings

According to DIN 11865, DIN 32676, DIN 11864

Marking always with

DOCKWEILER / DW-Number / Dimension / Material / Heat number / Standards and Hygiene Class

Tube and fittings shall be permanently marked as per Dockweiler guideline AA 8.5.2-80. The marking must provide all necessary information to trace back the heat number and the material grade.

6. DOCUMENTATION, PACKAGING AND SHIPPING

Documentation

The documentation result by the Dockweiler Inspection Certificate 3.1 according to DIN EN 10204.
Optional online documentation WebCert.

Packaging

Bright finished tubes and fittings are sealed with transparent PE caps and individually packaged in PE foil. The batch label on the foil packaging contains the information safetron.

Electropolished tubes and fittings are sealed with PA/PE squares and yellow PE caps, sleeved and sealed in PE. The batch label on the foil packaging contains the information safetron ep.

Shipping

Delivery in tubular container or wooden crate, fittings in strong cardboard box with shock absorbing filler.

Specification
weldtron

For biotech and the pharma industry
and for sensitive sectors of cosmetics and food industries

■ weldtron

bf **bright finished**
ep **electropolished**

1. SURFACE QUALITIES

Tubes and fittings:	Inner surface (bright finished)
■ **weldtron | H3o**	**Ra $_{avg.}$ ≤ 0,80 µm / 32 µin**
Surface treatment:	- Bright finished (bf) / H3o according to DIN 11866 / 11865 / 11864 / DIN 32676 - Ra value for circumferential weld seam of fittings not defined - T-pieces according to DIN 11865, option "u". - Circular weld seams ground with specified Ra value on request - Cleaning and testing methods ASTM A 632, S3

Tubes and fittings:	Inner surface (electropolished)
■ **weldtron | HE3o**	**Ra $_{avg.}$ ≤ 0.60 µm / 24 µin**
Surface treatment:	- Electropolished (ep) / HE3o according to DIN 11866 / 11865 / 11864 / DIN 32676 - Ra value for circumferential weld seam of formed parts not defined - T-pieces according to DIN 11865, option "u". - - Circular weld seams ground with specified Ra value on request. - Cleaning and testing procedures according to Spec. doc. 8.4-40/3.2/3.3.2 - Oil and grease-free in accordance with CGA G-4.1-2018 and ASTM G93 – level B

2. MATERIALS

	Austenitic stainless steel tubes and fittings in:
■ **weldtron**	1.4435 / UNS S31603 (316L) acc. to Basler Norm 2 (BN2) 1.4404 / UNS S31603 (316L)

Hardness equivalent to:	- max. 180 HV* according to DIN EN ISO 6507-1 - max. 90 HRB* according to DIN EN ISO 6508-1 * comparable to ASTM E-384 (HV) and ASTM E 18-22 (HRB)

3. DIMENSIONS

Imperial:	acc. to ASTM A269 / A270 / A632, ASME BPE and DIN 11866 Serie C	
OD x WT	1/4" to 6" (0.250 x 0.035 inch to 6.000 x 0.109 inch)	6,35 x 0,89 mm to 152,40 x 2,77 mm
ISO:	**acc. to DIN EN ISO 1127 and DIN 11866 Serie B**	
OD x WT	13,50 x 1,60 mm to 219,10 x 2,60 mm	
Metric:	**acc. to DIN 11866 Series A**	
OD x WT	6,00 x 1,00 mm to 154,00 x 2,00 mm	

Manufacturing process:	Welded or seamless tubes

4. QUALITY AND TEST PROCEDURES

- Verification of basic test certificate
- Visual inspection
- Endoscopic inspection of bright finished tubes
- Verification of dimensions
- Roughness measurements
- Delta ferrite measurement 1.4435 BN2 / 316L

5. TECHNICAL TERMS OF DELIVERY

Tubes and fittings are prepared for orbital welding:

Tubes

Acc. to 11866, ASTM A 269 / A 270, DIN EN 10217-7 / 10216-5 with a length of 5900 - 6090 mm (max. 10% short lengths of min. 3000 mm possible).

For electropolished tubes with outer diameter ≤ 5.00 mm, the length is 2950 ± 50 mm.

Fittings

Acc. to DIN 11865, DIN 32676, DIN 11864

Marking always with

DOCKWEILER / DW-Number / Dimension / Material / Heat number / Standards and Hygiene Class

Tubes, pipes and fittings shall be permanently marked as per Dockweiler guideline AA 7.5.3–80. The marking must provide all necessary information to trace back the heat number and the material grade.

6. DOCUMENTATION, PACKAGING AND SHIPPING

Documentation

The documentation result by the Dockweiler Inspection Certificate 3.1 according to DIN EN 10204.
Optional online documentation WebCert.

Packaging

Bright finished tubes and fittings are sealed with transparent PE caps and individually packaged in PE foil. The batch label on the foil packaging contains the information weldtron.

Electropolished tubes and fittings are sealed with PA/PE squares and yellow PE caps, sleeved and sealed in PE. The batch label on the foil packaging contains the information weldtron ep.

Shipping

Delivery in tubular container or wooden crate, fittings in strong cardboard box with shock absorbing filler.

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SPEC EMEA / EN 12-2024