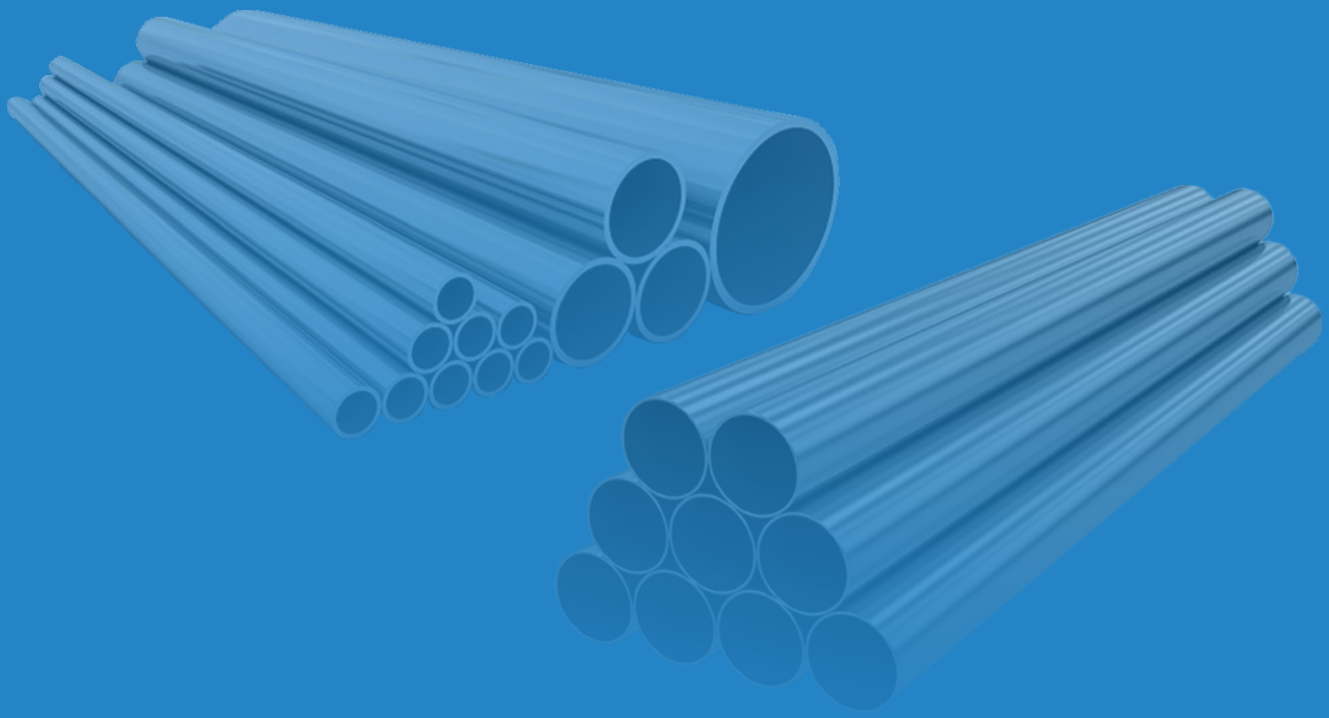
# DHV STAINLESS

**Manufacturers & Exporters of :**

## STAINLESS STEEL
## PIPES & TUBES



# Company Profile

DHV STAINLESS is a leading manufacturer of Stainless Steel Welded Pipes & Tubes in India. The company was found and is headed by Mr. Champalal Shah. He has vast experience of over 45 years in the Steel industry. DHVS is family Owned business run by the founder along with his 3 sons since 2007.

Our Manufacturing plant is located in Chiplun (Maharashtra) and Umbergaon (Gujarat).

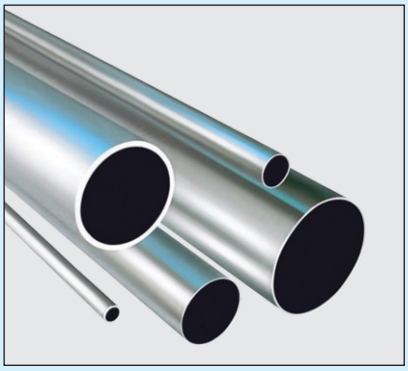
We are a growing company and plan for continuous expansion to increase more capacity in pipes & tubes.

We have served our prestigious clients by giving them quality material; timely delivery on regular basis at the most reasonable prices, thus developing long term business relationships with them.

Our Research & Development team keeps on proposing necessary changes as we are in constant touch with various successful clients in the World. We have been supplying our products to more than 500 customers worldwide. The retention of customers and their continuous Orders are a proof of our quality and service.

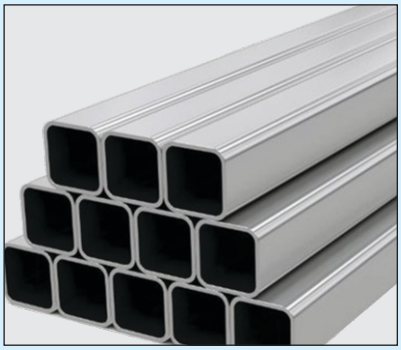
# Product Range

## ROUND PIPES / TUBES



| | | |
|---|---|---|
| Size | : | ROUND PIPE : 6 mm OD to 609 mm OD<br>1/4" to 24" NB |
| Thickness | : | 1.5 mm to 6 mm &<br>SCH 5 to SCH 80 |
| Length | : | Random Length - 4 to 7 MTR.<br>Fixed Length as per customers requirement |
| Condition | : | Heat Treated, Pickled & Passivated |
| Standards | : | ASTM A 249, A 268, A 269, A 312, A 358 |
| Grades | : | 304, 304H, 304L, 316, 316L, 316H,<br>316Ti, 321, 309, 310, 347, 904L etc. |
| Special Grades | : | Duplex 32205, Super Duplex 32750/32760<br>Haste Alloy C276, C22 |

## SQUARE AND RECTANGULAR PIPES



| | | |
|---|---|---|
| Size | : | 12 mm to 200 mm |
| Thickness | : | 1 mm to 8 mm |

# Welded Pipes & Tubes

Welded Pipes & Tubes manufacturing operation are carried out on the tube mill. Cold/Hot stainless steel strip are slitted to the required width as per the diameter of tube to be formed. The strips are then fed to the decoiler from where its passes through series of rollers & continuously formed in to a tubular shape and welded by tungsten -inert -gas (TIG) welding process. It is highly precision, completely automated process where the edge of script are heated and fused together under a protect in atmosphere of argon gas through a non consumable electrode without using any filler metal. Bead crushing operation if required is carried out where inside bead are crushed by bead hammer unit and out side are polished by a polishing belt. After calibration to the correct size, tubes are cut online and then send to further operation like cold draw, solution annealing, finishing operations, pickling, inspections, marking and dispatch.

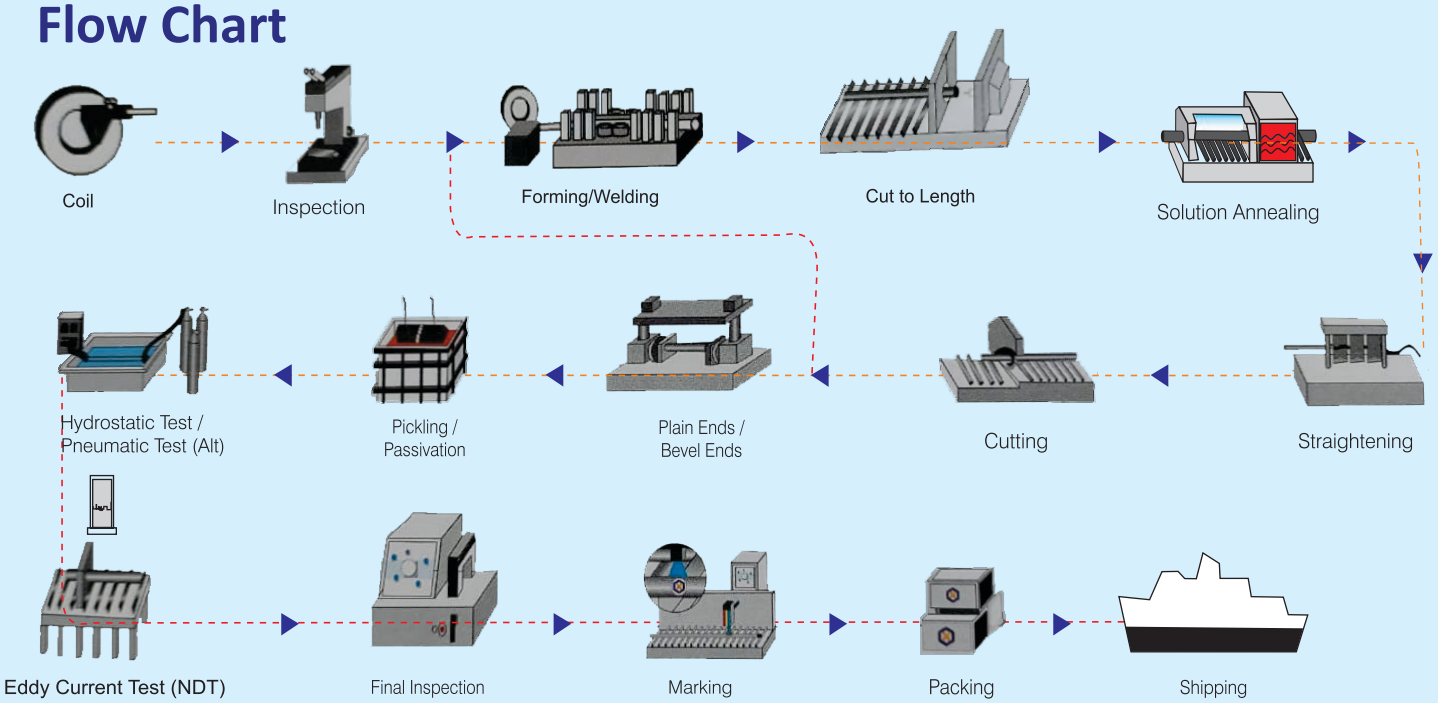
## Heat Treatment (solution annealing)

After each process of manufacturing, tubes & pipes are subject to heat treatment in a continuous annealing furnace at the specified temperatures as per grade of materiels and followed by rapidly quenching process as per the grade to prevent carbide formation.

## Solution Annealing ensures

- Homogenous structure for optimum inter - granular corrosion resistance
- Removal of residual stresses developed during the cold process
- Improves ductility and softness for further process
- Transformation of weld and heat affected zone homogenous austenitic structure.

# Flow Chart



# Quality Policy

At DHVS you can be assured of the best quality products. As a policy, we procure raw materials from only recognized suppliers and reputed mills world wide. We have an internal Quality System that rates our supplier's performance in terms of quality of products to a level of service and delivery reliability.100% Inspection is done again after receipt of raw material from our approved suppliers & finished goods. We can offer our products under Third Party Inspection Agencies like TCE, TPL, BVIS, TUV, DNV, CEIL, PDIL, MECON, BARC, NPCIL, BHEL, JACOB H & G, UHDE, TOYO, SGS, SH ROFF & ASSOCIATES, JOSH I & ASSOCIATES etc.

We have all in-house facilities for manufacturing Stainless Steel Welded Pipes & Tubes. So, we can supply with Material Test Certificate duly inspected & accepted by reputed 3rd Party Inspection Agencies. QUALITY AND CUSTOMER SATISFACTION is our main concern. We have well experienced and trained technical hands to carry out the inspection on each individual product. Every Pipe & Tube is duly marked with our logo and heat no.

ICL Integral Certification (P) Ltd.

Certificate OF REGISTRATION

This is to Certify that the Management System of

**DHV STAINLESS**

**Factory Address - Plot no C-25, MIDC Gane Khadpoli, Taluka Chiplun, District Ratnagiri - 415605, Maharashtra, India**

**Office Address : 51A, Cutch Castle, No. 14 B, 2nd Floor, JSS Road, Opp. Tewari Sweets, Opera House, Mumbai - 400004, Maharashtra, India**

**.has been found to conform to the Quality Management System standard:**

**ISO 9001:2015**

**This certificate is valid for the following scope of operations:**

**Manufacturers of Stainless Steel Pipes and Tubes**

*Certificate No.: IN19520A*

| *Date of initial registration* | *Date of this Certificate* | *Recertification Due* |
|---|---|---|
| *11 February 2023* | *11 February 2023* | *10 February 2026* |

Accreditation

This Certificate remains valid subject to satisfactory surveillance audits.

EGAC Accredited QMS Certification CAB # 011201

IAF MEMBER OF MULTILATERAL RECOGNITION ARRANGEMENT

*Director*

ICL/FM-001/REV06

For verification and updated information concerning the present certificate visit to www.iclcert.com

This certificate is property of Integral Certification (P) Ltd. and shall be returned immediately when demanded.

**Integral Certification (P) Ltd.**
301, U-60 (3rd Floor), Shakar Pur, Laxmi Nagar, Delhi-110092
E-mail: info@iclcert.com Website : www.iclcert.com
Contact No. : +91-9319332223

# Testing Equipments

## Mandatory Tests We conduct

### Hydro Test :

100% Compulsory Test for each & every Tube / Pipe Produced in out plant as per the specifications required by our customers.

### Visual & Dimension Inspection :

100% Compulsory Test for each & every Tube / Pipe produced in our plant by well Technically Qualified Engineers to check any type of surface defects or scratches on Tube / Pipe.

### Mechanical Test :

All Mechanical Testing on Tube / Pipe like Hardness Test, Tensile Test, Flattening & Flaring Test, Reverse Bend & Flattening Test as per the specification requirement.

### Chemical Test :

100% Compulsory Test for each & every lot of Tube/ Pipe produced in our plant.


## Supplementary Tests we conduct on Client's requirement

### Eddy Current Test :

This Test Carried out to detect Sub surface in homogeneity as per ASTM-426.

### PMI Test :

This Test is carried out for the grade confirmation of material at our in house facility.

### Ultrasonic Test :

This Test is carried out to detect Special Process Flow as per ASTM A 213 / A 450.

### Micro & Macro Test :

This Test is Carried out to certify microstructure, grain size as per ASTM E 112, to ensure that Carbides are dissolved and corrosion resistance is at Maximum.

### Intergranular Corrosion Test :

This Test is carried out to determine the materials' intergranular attract and to measure the rate of corrosion as per standard ASTM A-262 Practice "A", "B", "C" OR "E" within our company's own facilities with well equipped laboratory.

# Chemical Composition of Stainless Steel

| GRADE AISI | C | Mn | P | S | Si | Cr | Mo | Ni | Other | Tensile Mpa min | Yeild Mpa min | Elonga-tion % min. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 304 | 0.08 | 2.00 | 0.045 | 0.030 | 1.00 | 18.0-20.0 | -- | 8.0-11.0 | -- | 515 | 205 | 28 |
| 304H | 0.04-0.10 | 2.00 | 0.045 | 0.030 | 1.00 | 18.0-20.0 | -- | 8.0-11.0 | -- | 515 | 205 | 28 |
| 304L | 0.035 | 2.00 | 0.045 | 0.030 | 1.00 | 18.0-20.0 | -- | 8.0-13.0 | -- | 485 | 170 | 28 |
| 304LN | 0.030 | 2.00 | 0.045 | 0.030 | 0.75 | 18.0-20.0 | -- | 8.0-10.5 | N2.0.10-0.16 | 515 | 205 | 28 |
| 304N | 0.08 | 2.00 | 0.045 | 0.030 | 0.75 | 18.0-20.0 | -- | 8.0-11.0 | N2:010-0.16 | 550 | 240 | 28 |
| 309 | 0.15 | 2.00 | 0.045 | 0.030 | 1.00 | 22.0-24.0 | -- | 12.0-15.0 | -- | 515 | 205 | 28 |
| 310 | 0.15 | 2.00 | 0.045 | 0.030 | 1.50 | 24.0-26.0 | -- | 19.0-22.0 | -- | 515 | 205 | 28 |
| 316 | 0.08 | 2.00 | 0.045 | 0.030 | 1.00 | 16.0-18.0 | 2.00-3.00 | 10.0-14.0 | -- | 515 | 205 | 28 |
| 316H | 0.04-0.010 | 2.00 | 0.045 | 0.030 | 1.00 | 16.0-18.0 | 2.00-3.00 | 10.0-14.0 | -- | 515 | 205 | 28 |
| 316LN | 0.030 | 2.00 | 0.045 | 0.030 | 0.75 | 16.0-18.0 | 2.00-3.00 | 11.0-14.0 | N2:0.10-0.16 | 515 | 205 | 28 |
| 316L | 0.035 | 2.00 | 0.045 | 0.030 | 1.00 | 16.0-18.0 | 2.00-3.00 | 10.0-16.0 | -- | 485 | 170 | 28 |
| 316N | 0.08 | 2.00 | 0.045 | 0.030 | 0.75 | 16.0-18.0 | 2.00-3.00 | 11.0-14.0 | N2:0.10-0.16 | 550 | 240 | 28 |
| 317 | 0.08 | 2.00 | 0.045 | 0.030 | 1.00 | 18.0-20.0 | 3.00-4.00 | 11.0-15.0 | -- | 515 | 205 | 28 |
| 317L | 0.030 | 2.00 | 0.045 | 0.030 | 1.00 | 18.0-20.0 | 3.00-4.00 | 11.0-15.0 | -- | 515 | 205 | 28 |
| 321 | 0.08 | 2.00 | 0.045 | 0.030 | 1.00 | 17.0-20.0 | -- | 9.0-13.0 | Ti5C-0.7 | 515 | 205 | 28 |
| 347 | 0.08 | 2.00 | 0.045 | 0.030 | 1.00 | 17.0-20.0 | -- | 9.0-13.0 | Nb+Ta:10C-1.10 | 515 | 205 | 28 |
| UNS S32205 | 0.03 | 2.00 | 0.03 | 0.02 | 1.00 | 22.0-23.0 | 3.0-3.5 | 4.5-6.5 | N-14-.2 | 95 (655) | 65 (450) | 25 |
| UNS S32750 | 0.03 | 2.00 | 0.035 | 0.02 | 0.08 | 24.0-26.0 | 3.0-3.5 | 4.5-6.5 | N-.24-.32 CU-0.5 MAX | (95) 655 | (70) 485 | 25 |
| UNS S32760 | 0.05 | 1.00 | 0.030 | 0.01 | 1.00 | 24.0-26.0 | 3.0-5.0 | 6.0-8.0 | N-.20-.30 CU-0.5-1.0 W-0.5-1.0% CR3.3%M016% N=40 | (116) 800 | (80) 550 | 15 |
| UNS S31803 | 0.03 | 2.00 | 0.030 | 0.01 | 1.00 | 21.0-23.0 | 2.5-3.5 | 4.5-6.5 | N.08-2 | (90) 620 | (65) 450 | 25 |
| Hastealloy C276 | 0.01 | 1.00 | 0.040 | 0.03 | 0.08 | 14.5-16.5 | 15-17 | - |  | (100) 690 | (41) 283 | 40 |
| Hastealloy C222 | 0.015 | 0.05 | 0.020 | 0.02 | 0.08 | 20-22.5 | 12.5-14.5 | - |  | (100) 690 | (45) 310 | 45 |

# STAINLESS STEEL PIPE DIMENSION AS PER ASTM AND WEIGHT KG. PER MTR. (ANSI B 36.19 - 1965)

| Nominal Bore | | Outside Diameter | Schedule 5S | | Schedule 10S | | Schedule 20S | | Schedule 40S | | Schedule 80S | | Schedule 160S | | Schedule XXS | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| mm | Inch | Inch | Wt mm | Weight (Kg/mt) | Wt mm | Weight (Kg/mt) | Wt mm | Weight (Kg/mt) | Wt mm | Weight (Kg/mt) | Wt mm | Weight (Kg/mt) | Wt mm | Weight (Kg/mt) | Wt mm | Weight (Kg/mt) |
| 3 | 1/8 | 10.3 | 1.2 | 0.26 | 1.24 | 0.28 | 1.5 | 0.33 | 1.73 | 0.37 | 2.41 | 0.47 | - | - | - | - |
| 6 | 1/4 | 13.7 | 1.2 | 0.37 | 1.65 | 0.49 | 2.00 | 0.58 | 2.24 | 0.63 | 3.02 | 0.80 | - | - | - | - |
| 10 | 3/8 | 17.1 | 1.2 | 0.47 | 1.65 | 0.63 | 2.00 | 0.74 | 2.31 | 0.84 | 3.20 | 1.10 | - | - | - | - |
| 15 | 1/2 | 21.3 | 1.65 | 0.80 | 2.11 | 1.00 | 2.30 | 1.07 | 2.77 | 1.27 | 3.73 | 1.62 | 4.78 | 1.94 | 7.47 | 2.55 |
| 20 | 3/4 | 26.7 | 1.65 | 1.02 | 2.11 | 1.28 | 2.55 | 1.52 | 2.87 | 1.69 | 3.91 | 2.20 | 5.56 | 2.90 | 7.82 | 3.64 |
| 25 | 1 | 33.4 | 1.65 | 1.30 | 2.77 | 2.09 | 3.00 | 2.25 | 3.38 | 2.50 | 4.55 | 3.24 | 6.35 | 4.24 | 9.09 | 5.45 |
| 32 | 1.1/4 | 42.2 | 1.65 | 1.65 | 2.77 | 2.70 | 3.00 | 2.90 | 3.56 | 3.39 | 4.85 | 4.47 | 6.35 | 5.61 | 9.70 | 7.77 |
| 40 | 1.1/2 | 48.3 | 1.65 | 1.91 | 2.77 | 3.11 | 3.00 | 3.35 | 3.68 | 4.05 | 5.08 | 5.41 | 7.14 | 7.25 | 10.15 | 9.55 |
| 50 | 2 | 60.3 | 1.65 | 2.39 | 2.77 | 3.93 | 3.00 | 4.24 | 3.91 | 5.44 | 5.54 | 7.48 | 8.74 | 11.11 | 11.07 | 13.44 |
| 65 | 2.1/2 | 73.0 | 2.11 | 3.69 | 3.05 | 5.26 | 4.00 | 6.81 | 5.16 | 8.63 | 7.01 | 11.41 | 9.53 | 14.91 | 14.02 | 20.39 |
| 80 | 3 | 88.9 | 2.11 | 4.51 | 3.05 | 6.45 | 4.00 | 8.37 | 5.49 | 11.29 | 7.62 | 15.27 | 11.10 | 21.30 | 15.24 | 27.68 |
| 100 | 4 | 114.3 | 2.11 | 5.84 | 3.05 | 8.36 | 4.50 | 12.18 | 6.02 | 16.07 | 8.56 | 22.32 | 13.49 | 33.54 | 17.12 | 41.03 |
| 125 | 5 | 141.3 | 2.77 | 9.47 | 3.40 | 11.57 | 5.00 | 16.80 | 6.55 | 21.80 | 9.53 | 30.97 | 15.88 | 49.11 | 19.05 | 57.43 |
| 150 | 6 | 168.3 | 2.77 | 11.32 | 3.40 | 13.82 | 6.35 | 25.36 | 7.11 | 28.26 | 10.97 | 42.56 | 18.25 | 67.53 | 21.95 | 79.22 |
| 200 | 8 | 219.1 | 2.77 | 14.78 | 3.76 | 19.96 | 6.35 | 33.31 | 8.18 | 42.55 | 12.70 | 64.64 | 23.01 | 111.27 | 22.23 | 107.92 |
| 250 | 10 | 273.1 | 3.40 | 22.61 | 4.19 | 27.78 | 6.35 | 41.77 | 9.27 | 60.31 | 12.70 | 81.55 | 28.58 | 172.33 | 25.40 | 155.15 |
| 300 | 12 | 323.8 | 3.96 | 31.24 | 4.57 | 36.00 | 6.35 | 49.70 | 9.53 | 73.85 | 12.70 | 97.43 | 33.32 | 238.68 | 25.40 | 186.90 |
| 350 | 14 | 355.6 | 3.96 | 34.34 | 4.78 | 41.3 | 7.92 | 67.90 | 9.53 | 82.367 | | | | | | |
| 400 | 16 | 406.4 | 4.19 | 41.56 | 4.78 | 47.34 | 7.92 | 77.83 | 9.53 | 94.457 | | | | | | |
| 450 | 18 | 457.2 | 4.19 | 46.81 | 4.78 | 53.32 | 7.92 | 87.74 | 9.53 | 106.547 | | | | | | |
| 500 | 20 | 508.0 | 4.78 | 59.31 | 5.54 | 68.64 | 9.53 | 117.14 | 9.53 | 117.14 | | | | | | |
| 600 | 24 | 610.0 | 5.54 | 82.57 | 6.35 | 94.52 | 9.53 | 114.11 | 9.53 | 141.11 | | | | | | |

# DHV STAINLESS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Taluka : Umbergaon-396 150, Gujarat, India.