Dudley plant

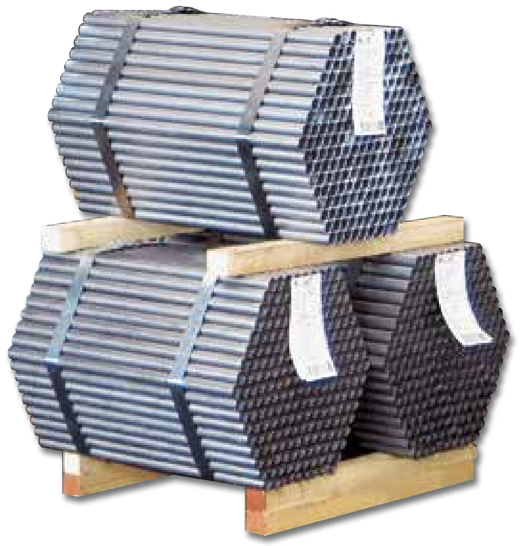
Marcegaglia UK

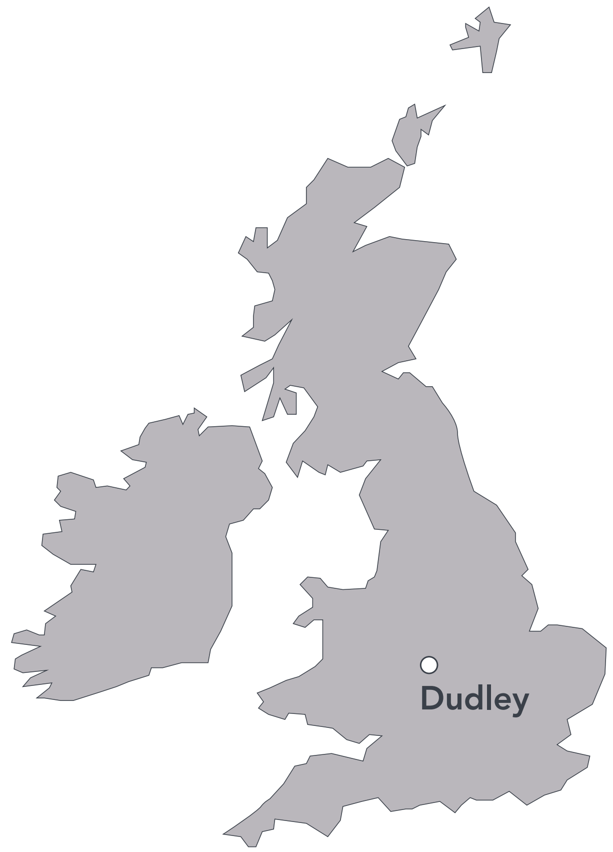
Marcegaglia UK was established in 1996 and it is devoted to the manufacturing of **electro-welded carbon steel tubes** for a wide range of applications.

Its production facilities are located in **Dudley** (West Midlands), with an overall surface of 28,000 sqm (11,498 sqm of which covered).

Marcegaglia UK production is ISO 9001 certified by SGS since 12/01/1996, with total **five tube production lines**.

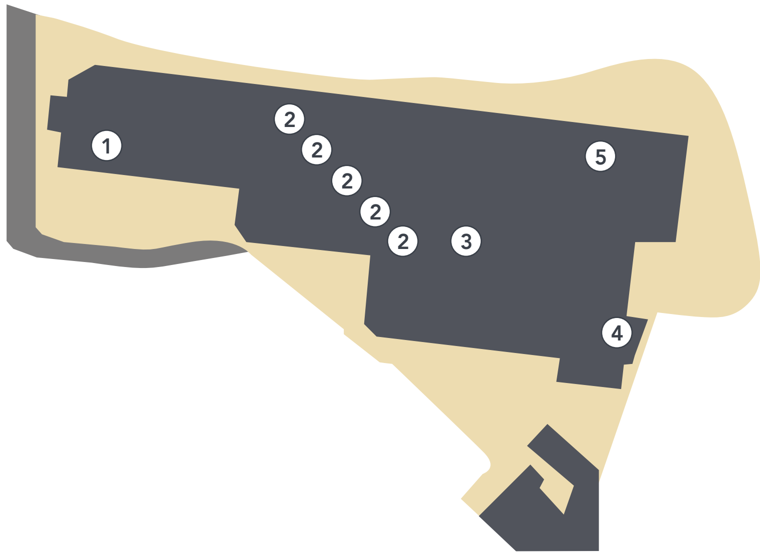
The facilities, employing 128 total workers, have a yearly total output capacity of **100,000 tonnes of finished products**, making Marcegaglia UK **the largest precision tube manufacturer in Great Britain**.





Production lines

The production lines in **Marcegaglia UK** are equipped to offer a wide range of specific tube finishes. Tubes are non-destructive eddy current tested inline to prevent weld seam defects. Additionally destructive testing includes tensile, flare and flattening.



①	**Slitting line**	1
②	**Tube mills**	
	manufacturing capacity (t/y)	100,000
	no. of mills	5
③	**Coating line**	
	In-line cleaning	3-stage wash system
	UV coating	Vacuum coating head
	Finishing	UV lamps
④	**Finishing and testing**	
⑤	**Warehouse**	

MARCE-COAT - Product Features:

- Superior corrosion protection
- Completely clean tube
- Suitable for direct painting/powder coating
- Can be used as a finished coated product due to its aesthetically pleasing appearance

Typical applications

Tubes for agricultural and farming applications

Tubes for building and construction applications

Tubes for the furniture industry

Tubes for industrial packaging applications

Tubes for mechanical and automotive applications

Carbon steel welded tubes

Round	
Min. thickness (mm)	0.5
Max. thickness (mm)	5
Min. diameter (mm)	12
Max. diameter (mm)	101.6

Square	
Min. thickness (mm)	0.70
Max. thickness (mm)	5
Ext. size min. (mm)	12x12
Ext. size max. (mm)	80x80

Rectangular	
Min. thickness (mm)	0.70
Max. thickness (mm)	5
Ext. size min. (mm)	20x10
Ext. size max. (mm)	100x60

Supply conditions

- Dimensional tolerances according to manufacturing standard
- Special tolerances upon request
- Control documents 2.1, 2.2, 3.1, 3.2 according to EN 10204 and specific norm requirements

Main manufacturing standards

MANUFACTURING STANDARD	PRODUCT DESIGNATION	TREATMENT	GRADE*	SURFACE CONDITIONS
EN 10305-3	Round and shaped precision tubes	**+CR1** Welded and sized **+CR2** Welded and sized	E190, E320, E220, E370, E260, E420 E155, E195, E235, E275, E355	**S1** From hot-rolled strip, black **S2** From hot-rolled strip, pickled **S3** From cold-rolled strip **S4** From coated strip
EN 10305-5	Square and rectangular precision tubes			
EN 10219	Cold formed welded structural tubes (CE homologation)		S235JRH S275J0H S275J2H S355J0H S355J2H	

(*) Upon request: supply of grades not included in the above mentioned standards

LENGTHS TOLERANCES

Marcegaglia can guarantee tight tolerances on tube in-line cutting: ±1 mm on standard lengths ranging from 2,000 to 12,500 mm.

OPTIONAL PROCESSING
Suitability for subsequent galvanizing
Bead rolling
Special end finishing
Cut to length
Customer defined marking
Restricted tolerances
Welding position
Specific corrosion protection
Specific packaging method
Unit testing composed of tubes from a single casting
Hot galvanization

STANDARD AND OPTIONAL TESTING
Chemical composition
Tensile test
Flattening test
Expansion test
Impact test
Non destructive weld test
Dimensional test
Micrographic analysis
Visual test
Surface roughness measurement
Release of special certificates

Round carbon steel welded precision tubes

ROUND TUBES EN 10305-3 S1. S2. S3. S4

outside diameter (mm - inches)	wall thickness mm									
	0.7	0.8	0.9	1	1.2	1.4	1.5	1.8	2	2.5	3
10	0.161	0.182	0.202	0.222	0.260						
12.7 - ½″	0.207	0.235	0.262	0.288	0.340	0.390	0.414				
13	0.212	0.241	0.269	0.296	0.349	0.400	0.425	0.497			
13.5	0.221	0.251	0.280	0.308	0.364	0.418	0.444	0.519			
14	0.230	0.260	0.291	0.321	0.379	0.435	0.462	0.541	0.592		
15	0.247	0.280	0.313	0.345	0.408	0.469	0.499	0.586	0.641		
15.88 - ⅝″	0.261	0.296	0.331	0.365	0.432	0.497	0.529	0.621	0.681		
16	0.264	0.300	0.335	0.370	0.438	0.504	0.536	0.630	0.690		
18	0.299	0.339	0.379	0.419	0.497	0.573	0.610	0.719	0.789		
18.39	0.305	0.347	0.388	0.429	0.509	0.587	0.625	0.736	0.808		
19	0.316	0.359	0.402	0.444	0.527	0.608	0.647	0.764	0.839	1.017	
19.05 - ¾″	0.317	0.360	0.403	0.445	0.528	0.609	0.649	0.766	0.841	1.020	
19.80	0.330	0.375	0.419	0.464	0.550	0.635	0.677	0.799	0.878	1.066	
20	0.333	0.379	0.424	0.468	0.556	0.642	0.684	0.808	0.888	1.079	
20.15	0.336	0.382	0.427	0.472	0.561	0.647	0.690	0.814	0.895	1.088	
21.25	0.355	0.403	0.452	0.499	0.593	0.685	0.730	0.863	0.949	1.156	
21.8	0.365	0.415	0.465	0.514	0.611	0.706	0.888	0.976	1.190	1.391	
22	0.368	0.418	0.468	0.518	0.615	0.711	0.758	0.897	0.986	1.202	
22.22 - ⅞″	0.371	0.423	0.473	0.523	0.622	0.719	0.766	0.906	0.997	1.216	
24	0.402	0.458	0.513	0.567	0.675	0.780	0.832	0.985	1.085	1.325	
24.2	0.406	0.462	0.517	0.572	0.681	0.787	0.840	0.994	1.095	1.338	
25	0.419	0.477	0.535	0.592	0.704	0.815	0.869	1.030	1.134	1.387	1.627
25.1	0.421	0.479	0.537	0.594	0.707	0.818	0.873	1.034	1.139	1.393	1.635
25.4	0.426	0.485	0.544	0.602	0.716	0.828	0.884	1.047	1.154	1.412	1.657
26	0.437	0.497	0.557	0.616	0.734	0.849	0.906	1.074	1.184	1.449	1.701
26.2	0.440	0.501	0.561	0.621	0.740	0.856	0.914	1.083	1.193	1.461	1.716
26.9	0.452	0.515	0.577	0.639	0.760	0.880	0.939	1.114	1.228	1.504	1.768
27	0.454	0.517	0.579	0.641	0.763	0.884	0.943	1.118	1.233	1.510	1.775
28	0.471	0.537	0.601	0.666	0.793	0.918	0.980	1.163	1.282	1.572	1.849
28.58	0.481	0.548	0.614	0.680	0.810	0.938	1.001	1.188	1.310	1.607	1.893
30	0.506	0.576	0.646	0.715	0.852	0.987	1.054	1.252	1.381	1.695	1.997
31.75 - 1¼″	0.536	0.610	0.685	0.758	0.904	1.048	1.119	1.329	1.467	1.803	2.127
32	0.540	0.615	0.690	0.764	0.911	1.056	1.128	1.340	1.479	1.818	2.145
33.7	0.570	0.649	0.728	0.806	0.962	1.115	1.191	1.416	1.563	1.923	2.271

ROUND TUBES EN 10305-3 S1. S2. S3. S4

weight kg/m

outside diameter (mm - inches)	wall thickness mm													
	0.7	0.8	0.9	1	1.2	1.4	1.5	1.8	2	2.5	3	3.5	4	5
34			0.735	0.814	0.970	1.125	1.202	1.429	1.578	1.942	2.293			
34.92			0.755	0.837	0.998	1.157	1.236	1.470	1.624	1.999	2.362			
35			0.757	0.838	1.000	1.160	1.239	1.473	1.627	2.003	2.367			
36			0.779	0.863	1.030	1.194	1.276	1.518	1.677	2.065	2.441			
38.1 - 1½″			0.826	0.915	1.092	1.267	1.354	1.611	1.780	2.194	2.596			
40			0.868	0.962	1.148	1.332	1.424	1.695	1.874	2.312	2.737		3.551	4.316
41			0.890	0.986	1.178	1.367	1.461	1.740	1.923	2.373	2.811		3.650	4.439
41.3			0.897	0.994	1.186	1.377	1.472	1.753	1.938	2.392	2.833		3.678	4.474
42			0.912	1.011	1.207	1.401	1.498	1.784	1.973	2.435	2.885		3.749	4.562
42.4					1.219	1.416	1.513	1.802	1.992	2.460	2.914		3.788	4.612
44.5					1.280	1.486	1.590	1.895	2.096	2.589	3.070		3.990	4.865
44.6			0.970	1.075	1.284	1.491	1.594	1.900	2.101	2.595	3.077		4.005	4.883
45			0.979	1.085	1.296	1.505	1.609	1.917	2.120	2.620	3.107		4.045	4.932
46.7			1.016	1.127	1.346	1.564	1.672	1.993	2.204	2.725	3.232		4.212	5.142
47					1.356	1.574	1.683	2.006	2.219	2.743	3.255		4.242	5.179
47.6			1.036	1.149	1.373	1.595	1.705	2.033	2.249	2.780	3.299		4.303	5.255
48			1.045	1.159	1.385	1.609	1.720	2.050	2.268	2.805	3.329		4.340	5.302
48.3					1.394	1.619	1.731	2.064	2.283	2.823	3.351		4.370	5.339
50			1.090	1.208	1.444	1.678	1.794	2.139	2.367	2.928	3.477		4.538	5.549
50.8 - 2″			1.107	1.228	1.468	1.705	1.823	2.175	2.406	2.977	3.536		4.617	5.648
54				1.307	1.562	1.816	1.942	2.317	2.564	3.175	3.772		4.932	6.042
57				1.381	1.651	1.919	2.053	2.450	2.712	3.359	3.994		5.228	6.412
57.15					1.656	1.925	2.059	2.457	2.720	3.369	4.006		5.243	6.431
60					1.740	2.023	2.164	2.583	2.860	3.544	4.216		5.524	6.782
60.30					1.749	2.033	2.175	2.596	2.875	3.563	4.238		5.554	6.819
63.50					1.843	2.144	2.293	2.738	3.033	3.760	4.475		5.869	7.214
65					1.888	2.195	2.349	2.805	3.107	3.853	4.586		6.017	7.399
70					2.036	2.368	2.533	3.027	3.353	4.161	4.956		6.511	8.015
76					2.213	2.575	2.755	3.293	3.649	4.531	5.400		7.103	8.755
76.2 - 3″					2.219	2.583	2.759	3.298	3.654	4.537	5.407		7.122	8.780
81							2.922	3.493	3.871	4.808	5.733		7.596	9.371
83							3.014	3.604	3.994	4.962	5.918		7.793	9.618
88.9 - 3½″ 3N							3.232	3.866	4.285	5.326	6.354		8.375	10.346
101.6							3.703	4.430	4.913	6.110	7.295	8.468	9.628	

N: nominal pipe size

Square carbon steel welded precision tubes

SQUARE TUBES EN 10305-5 S1. S2. S3. S4 — weight kg/m

external dimensions	wall thickness mm													
A x A mm - inch	0.7	0.8	0.9	1	1.2	1.4	1.5	1.8	2	2.5	3	3.5	4	5
12.7 x 12.7 - ½″ x ½″	0.263	0.298	0.332	0.366	0.431	0.493	0.524	0.611	0.665					
15 x 15	0.313	0.356	0.397	0.438	0.518	0.595	0.632	0.741	0.810					
15.87 x 15.87 - ⅝″ x ⅝″	0.333	0.377	0.422	0.465	0.550	0.633	0.673	0.790	0.864	1.039				
16 x 16	0.335	0.381	0.425	0.469	0.555	0.639	0.679	0.797	0.872	1.049				
19 x 19	0.401	0.456	0.510	0.564	0.668	0.770	0.820	0.967	1.061	1.285				
19.05 x 19.05 - ¾″ x ¾″	0.403	0.457	0.512	0.565	0.670	0.773	0.823	0.970	1.064	1.289				
20 x 20	0.423	0.481	0.538	0.595	0.706	0.814	0.868	1.023	1.124	1.363				
22 x 22	0.467	0.531	0.595	0.658	0.781	0.902	0.962	1.136	1.249	1.520				
22.2 x 22.2 - ⅞″ x ⅞″	0.472	0.536	0.601	0.664	0.789	0.911	0.971	1.148	1.262	1.536				
25 x 25		0.607	0.680	0.752	0.894	1.034	1.103	1.306	1.438	1.756	1.921			
25.4 x 25.4 - 1″ x 1″		0.617	0.691	0.764	0.909	1.052	1.122	1.328	1.463	1.787	1.958			
28.58 x 28.58		0.682	0.764	0.846	1.007	1.166	1.244	1.475	1.626	1.991	2.203			
30 x 30		0.732	0.821	0.909	1.083	1.254	1.339	1.588	1.752	2.148	2.392			
31.75 x 31.75 - 1¼″ x 1¼″		0.776	0.870	0.964	1.149	1.331	1.421	1.687	1.862	2.286	2.557			
32.00 x 32.00		0.773	0.868	0.962	1.148	1.333	1.424	1.696	1.874	2.312	2.737			
35 x 35			0.962	1.066	1.271	1.474	1.574	1.871	2.066	2.541	2.863		3.624	
38 x 38					1.384	1.606	1.715	2.041	2.254	2.776	3.145		4.001	
38.1 x 38.1 - 1½″ x 1½″					1.388	1.610	1.720	2.046	2.260	2.784	3.155		4.013	
40 x 40					1.460	1.694	1.810	2.154	2.380	2.933	3.334		4.252	
45 x 45					1.648	1.913	2.045	2.436	2.694	3.326	3.805		4.880	
48 x 48					1.761	2.045	2.186	2.606	2.882	3.561	4.087		5.257	
50 x 50					1.836	2.133	2.281	2.719	3.008	3.718	4.276		5.508	6.644
50.8 x 50.8 - 2″ x 2″					1.867	2.168	2.318	2.764	3.058	3.781	4.351		5.609	6.769
54 x 54					1.987	2.309	2.469	2.945	3.259	4.032	4.653		6.010	7.272
55 x 55					2.025	2.353	2.516	3.001	3.322	4.111	4.747		6.136	7.429
60 x 60					2.213	2.573	2.752	3.284	3.636	4.503	5.218		6.764	8.214
70 x 70					2.590	3.012	3.223	3.849	4.264	5.288	6.160		8.020	9.784
80 x 80							3.703	4.430	4.913	6.110	7.295	8.468	9.628	

Rectangular carbon steel welded tubes

RECTANGULAR TUBES EN 10305-5 S2. S3. S4 — weight kg/m

external dimensions	wall thickness mm											
A x B mm - inches	0.8	0.9	1	1.1	1.2	1.4	1.5	1.8	2	2.5	3	3.5	4
20 x 10	0.356	0.397	0.438	0.478	0.518	0.595	0.632	0.741	0.810				
20 x 15	0.418	0.468	0.516	0.564	0.612	0.704	0.750	0.882	0.967				
25 x 10	0.418	0.468	0.516	0.564	0.612	0.704	0.750	0.882	0.967				
25.4 x 12.7 - 1″ x ½″	0.457	0.512	0.565	0.618	0.670	0.773	0.823	0.970	1.064				
25 x 15	0.481	0.538	0.595	0.651	0.706	0.814	0.868	1.023	1.124				
30 x 10	0.481	0.538	0.595	0.651	0.706	0.814	0.868	1.023	1.124				
30 x 15	0.548	0.614	0.680	0.745	0.810	0.938	1.002	1.189	1.311				
30 x 20	0.607	0.680	0.752	0.823	0.894	1.034	1.103	1.306	1.438				
30 x 25	0.670	0.750	0.830	0.910	0.989	1.144	1.221	1.447	1.595				
34.92 x 15.88	0.616	0.685	0.758	0.832	0.904	1.048	1.119	1.330	1.467				
35 x 16	0.616	0.690	0.764	0.838	0.911	1.056	1.128	1.341	1.480				
38.10 x 12.70		0.690	0.765	0.838	0.912	1.057	1.128	1.341	1.480				
38.1 x 19.05 - 1½″ x ¾″		0.781	0.864	0.947	1.029	1.191	1.271	1.508	1.662				
38.1 x 25.4 - 1½″ x 1″		0.870	0.964	1.057	1.149	1.331	1.421	1.687	1.862				
40 x 10		0.680	0.752	0.823	0.894	1.034	1.103	1.306	1.438				
40 x 20		0.821	0.909	0.996	1.083	1.254	1.339	1.588	1.752	2.148			
40 x 25		0.892	0.987	1.083	1.177	1.364	1.456	1.730	1.909	2.344	2.627		
40 x 30		0.962	1.066	1.169	1.271	1.474	1.574	1.871	2.066	2.541	2.863		
40 x 35		1.033	1.144	1.255	1.365	1.584	1.692	2.012	2.223	2.737	3.098		
45 x 25		0.962	1.066	1.169	1.271	1.474	1.574	1.871	2.066	2.541	2.863		
50 x 20		0.962	1.066	1.169	1.271	1.474	1.574	1.871	2.066	2.541	2.863		
50 x 25		1.033	1.144	1.255	1.365	1.584	1.692	2.012	2.223	2.737	3.098		
50 x 30		1.104	1.223	1.342	1.460	1.694	1.810	2.154	2.380	2.933	3.334		
50 x 40			1.380	1.514	1.648	1.913	2.045	2.436	2.694	3.326	3.805		
50.8 x 25.4 - 2″ x 1″			1.163	1.276	1.388	1.610	1.720	2.046	2.260	2.784	3.155		
60 x 15			1.144	1.255	1.365	1.584	1.692	2.012	2.223	2.737	3.098		
60 x 20			1.223	1.342	1.460	1.694	1.810	2.154	2.380	2.933	3.334		
60 x 25			1.301	1.428	1.554	1.803	1.927	2.295	2.537	3.129	3.569		
60 x 30			1.380	1.514	1.648	1.913	2.045	2.436	2.694	3.326	3.805		
60 x 40				1.687	1.836	2.133	2.281	2.719	3.008	3.718	4.276		
63.5 x 38.1 - 2½″ x 1½″				1.715	1.867	2.168	2.318	2.764	3.058	3.781	4.351		
75 x 25				1.693	1.844	2.144	2.294	2.739	3.033	3.761	4.476		
80 x 20				1.687	1.836	2.133	2.281	2.719	3.008	3.718	4.276		
80 x 60							3.233	3.866	4.286	5.327	6.355	7.371	8.375
100 x 60							3.703	4.430	4.913	6.110	7.295	8.468	9.628
120 x 40							3.703	4.430	4.913	6.110	7.295	8.468	9.628

Rectangular carbon steel welded tubes

RECTANGULAR TUBES EN 10305-5 S1. S2. S4							weight kg/m
external dimensions	wall thickness mm						
A x B mm - inches	1.5	1.8	2	2.5	3	4	5
20 x 10	0.632	0.741	0.810				
20 x 15	0.750	0.882	0.967				
25 x 10	0.750	0.882	0.967				
25.4 x 12.7 - 1" x ½"	0.823	0.970	1.064				
25 x 15	0.868	1.023	1.124				
30 x 10	0.868	1.023	1.124				
30 x 20	1.103	1.306	1.438	1.756	1.921		
30 x 25	1.221	1.447	1.595	1.952	2.156		
38.1 x 19.05 - 1½" x ¾"	1.271	1.508	1.662	2.036	2.258		
38.1 x 25.4 - 1½" x 1"	1.421	1.687	1.862	2.286	2.557		
40 x 10	1.103	1.306	1.438	1.756			
40 x 20	1.339	1.588	1.752	2.148	2.392		
40 x 25	1.456	1.730	1.909	2.344	2.627		
40 x 30	1.574	1.871	2.066	2.541	2.863		
40 x 35	1.692	2.012	2.223	2.737	3.098		
45 x 25	1.574	1.871	2.066	2.541	2.863		
50 x 20	1.574	1.871	2.066	2.541	2.863		
50 x 25	1.692	2.012	2.223	2.737	3.098	3.938	
50 x 30	1.810	2.154	2.380	2.933	3.334	4.252	
50 x 40	2.045	2.436	2.694	3.326	3.805	4.880	
50.8 x 25.4 - 2" x 1"	1.720	2.046	2.260	2.784	3.155	4.013	

RECTANGULAR TUBES EN 10305-5 S1. S2. S4							weight kg/m
external dimensions	wall thickness mm						
A x B mm - inches	1.5	1.8	2	2.5	3	4	5
55 x 40	2.163	2.578	2.851	3.522	4.040	5.194	
60 x 10	1.574	1.871	2.066	2.541	2.863		
60 x 15	1.692	2.012	2.223	2.737	3.098		
60 x 20	1.810	2.154	2.380	2.933	3.334	4.252	
60 x 25	1.927	2.295	2.537	3.129	3.569	4.566	
60 x 30	2.045	2.436	2.694	3.326	3.805	4.880	
60 x 40	2.281	2.719	3.008	3.718	4.276	5.508	6.644
63.5 x 38.1 - 2½" x 1½"	2.318	2.764	3.058	3.781	4.351	5.609	6.769
70 x 30	2.281	2.719	3.008	3.718	4.276	5.508	
80 x 20	2.281	2.719	3.008	3.718	4.276		
80 x 40	2.752	3.284	3.636	4.503	5.218	6.764	8.214
88.9 x 38.1 - 3½" x 1½"	2.916	3.482	3.855	4.778	5.547	7.204	8.763
100 x 30	2.987	3.567	3.950	4.896	5.689	7.392	
110 x 30	3.233	3.866	4.264	5.288	6.160	8.020	

Oval carbon steel welded tubes

OVAL TUBES EN 10305-3 S1. S2. S3. S4													weight kg/m
external dimensions	wall thickness mm												
A x B mm	0.7	0.8	0.9	1	1.2	1.4	1.5	1.8	2	2.5	3	3.5	4
20 x 10	0.264	0.300	0.335	0.370	0.438	0.487	0.536	0.630	0.691				
25 x 12	0.324	0.385	0.480	0.476	0.565	0.630	0.695	0.884	0.927				
30 x 15	0.419	0.477	0.535	0.592	0.704	0.787	0.869	1.030	1.130				
31.75 x 15.8		0.500	0.562	0.622	0.740	0.827	0.914	1.085	1.194				
38 x 20		0.615	0.690	0.764	0.912	1.016	1.120	1.340	1.480	1.810			
40 x 20		0.635	0.712	0.789	0.941	1.051	1.160	1.380	1.520	1.880			
41.7 x 22.6		0.640	0.721	0.801	0.955	1.069	1.182	1.400	1.555	1.910			
40 x 25				0.839	1.001	1.121	1.240	1.475	1.629	2.005			
50 x 25				1.010	1.200	1.345	1.490	1.780	1.970	2.430	2.880		
50 x 30							1.513	1.802	1.993	2.460	2.915	3.358	3.788
60 x 30				1.220	1.440	1.615	1.790	2.140	2.370	2.930	3.470		
60 x 40							1.942	2.317	2.565	3.175	3.773	4.359	4.932
71 x 31							1.942	2.317	2.565	3.175	3.773	4.359	4.932
80 x 40							2.349	2.805	3.107	3.853	4.587	5.308	6.017

Quality and environment

Marcegaglia UK quality system is ISO 9001 certified (registered since 1996).
The Dudley plant hold accreditation to the "Directive 89/106/EEC" which allows to supply CE marked material to the European market.
Within a corporate policy promoting waste reduction and environmental safety, the plant has also implemented an ISO 14001 certified environmental quality system, while workplace health and safety system is certified according to ISO 45001 standard.

The membership of the Black Country Business Environment Association and the British Safety Council reinforces our commitment to the environment and workplace safety.

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