



South India Tubes Pvt Ltd

SEAMLESS TUBES MANUFACTURES

Manufacturer & Exporter of
carbon and alloy steel
seamless tubes and pipes

FOR THE LAST
15+ YEARS

We have strived to be Your
First Resource



www.southindiatubes.com



South India Tubes Pvt Ltd

COMPANY PROFILE

South India tubes has been set up as the large manufacturing facility for cold drawn seamless tubes products, in India with fully Automatic, semi-Auto, manual. South India tubes is located at Jalaram Industrial Estate, Morbi Rajkot Highway, Chattar village Rajkot in the state of Gujarat which is about 25 km from Rajkot towards Chattar. The company is an ISO 9001:2015 registered company. South India tubes is fully managed by skilled and experienced manpower in full strength to achieve the production target and full fill forthcoming and challengeable requirement from the market.



South India tubes are produced by cold drawing precision seamless tubes over a plug through a reducing die to achieve reduction in outside diameter and wall thickness. The tubes are bright annealed under closely controlled reducing atmosphere in a

highly sophisticated LPG heated roller heart annealing furnace so as to ensure bright, scale free and clean tubes, completely free from oxidation, this meeting critical requirements of end users.



South India Tubes Pvt Ltd

ABOUT US

We, "SOUTH INDIA TUBES," are a well-renowned manufacturer also Importer and Distributor of a comprehensive range of Hard Chrome Plated Rod & Hydraulic Piston Rod, Induction Hardened Steel Shaft, Linear Motion Bearing Shaft and Peeled and Ground Steel Rod.

SOUTH INDIA TUBES design, manufacture, supply of hydraulic equipment the HONED TUBES, HARD CHROME PLATED RODS, INDUCTION HARDENROD, LM SHAFT, READY TO HONE TUBE etc. along with customized Hydraulic systems for almost every industries.

SOUTH INDIA TUBES serve offerings have since greatly expanded and its name has come to represent quality and trust. Today with significant industry experience the firm to become both a manufacturer as well as distributor.





South India Tubes Pvt Ltd



▶ WHO AM

SIT the leading Manufacturer and Wholesaler of excellent quality Steel Rod, Steel Shafting, Linear Motion Bearing Shaft, Tie Rods for Plastic Molding etc

MISSION: Our goal is to empower the Indian industry by introducing advanced automation techniques and the latest technology to boost production rates. We ensure that quality remains uncompromised while offering the most competitive commercial packages, providing businesses with both efficiency and value.

OBJECTIVE: At South India Tubes, customer satisfaction is our top priority, built on a foundation of unwavering trust in our products and services. We offer a comprehensive range of products, paired with expert advice and professional guidance, to ensure we meet our customers' needs and exceed their expectations.



South India Tubes Pvt Ltd

HIGHLIGHT

Catering To Major Requirements Of Major Vehicles And Diesel Engine Manufacturers Their Ancillaries.

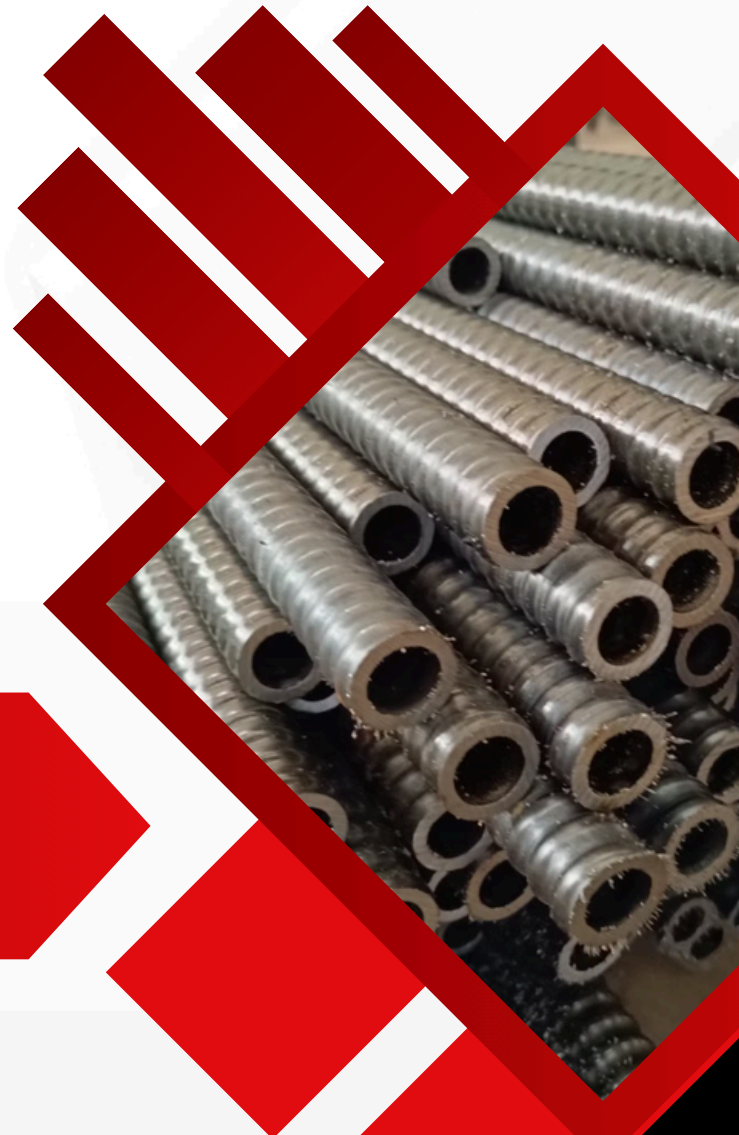
Internally & Externally Scale Free Bright Tubes Since Normalized In Bright Annealing Furnace.

Tubes Manufactured Out Of Fully Aluminum Killed Steel Having Resistance To Corrosion And High Degree Of Reliability.

Reliable & Individual Quality Department Having All In House Testing Facility

Quick And On Time Delivery

Good Bendability, Flaring, Forming, Flattening, Up Setting, Tensile Testing, Hardness Testing Facility As Per Customer Requirements.





South India Tubes Pvt Ltd

OUR PRODUCTS

Hydraulic Seamless Tubes

Purpose / Application:

Used in hydraulic and pneumatic systems requiring high pressure, leak-proof performance, dimensional accuracy, and smooth internal surfaces.

Size / Thickness:

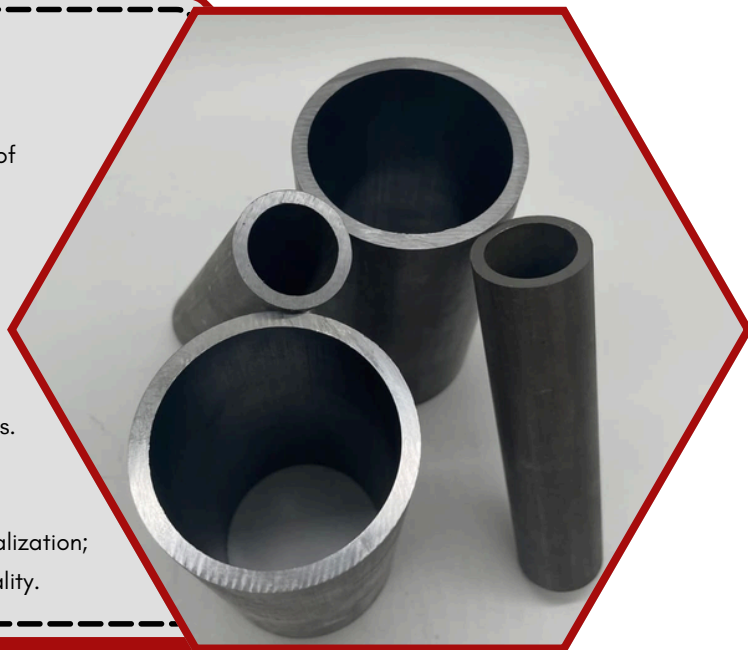
Outer diameter from 4 mm to 80 mm; wall thickness 0.5 mm to 8 mm.

Materials / Grades:

DIN 2391 (ST35, ST45, ST52), EN 10305-4, ASTM A106, A519, and equivalents.

Key Properties:

Cold-drawn seamless tubes with heat treatment for stress relief and normalization; high fatigue and corrosion resistance; excellent straightness and finish quality.



Hard Chrome Plated Rod & Honed Tubes

Purpose / Application:

Designed for hydraulic and pneumatic cylinders. Hard chrome rods provide wear resistance, while honed tubes offer precision fit and smooth internal surfaces.

Rod / Tube Dimensions:

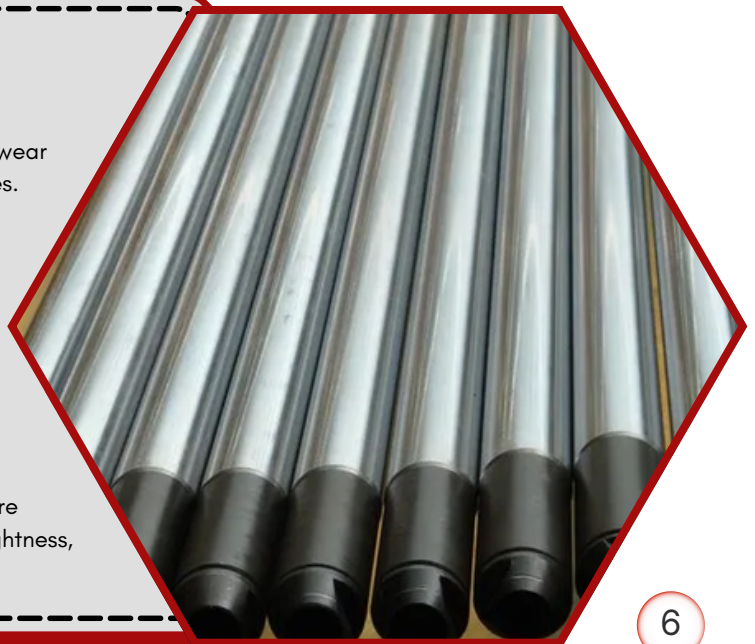
Rods range from 12 mm to 300 mm diameter; Tubes from 30 mm OD to 400 mm OD with 4 mm to 50 mm wall thickness.

Materials / Grades:

Rods - CK45, EN8D, EN9, EN19; Tubes - ST52, ST52.3, E355.

Manufacturing & Quality:

Rods are ground, polished, and chrome-plated for durability; honed tubes are precision-finished for high accuracy. Quality checks include hardness, straightness, surface finish, and chrome thickness.





South India Tubes Pvt Ltd

OUR PRODUCTS

Bearing Tubes

Purpose / Application:

Used to produce bearing races, sleeves, bushes, and rotating mechanical components requiring precision and strength.

Size / Thickness:

Outer diameter 30 mm to 400 mm; thickness 4 mm to 50 mm.

Materials / Grades:

EN8D, EN353, SAE 52100, ST52, and equivalents.

Key Properties:

Cold-drawn for precision, then stress-relieved or annealed for machinability.

Inspected for roundness, straightness, microstructure, and surface finish.



Precision Seamless Tubes

Purpose / Application:

Designed for hydraulic and pneumatic cylinders. Hard chrome rods provide wear resistance, while honed tubes offer precision fit and smooth internal surfaces.

Rod / Tube Dimensions:

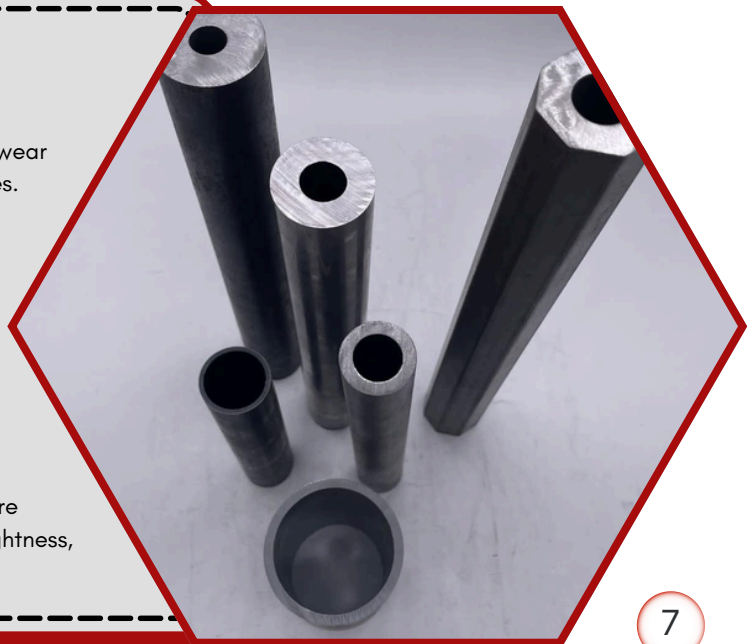
Rods range from 12 mm to 300 mm diameter; Tubes from 30 mm OD to 400 mm OD with 4 mm to 50 mm wall thickness.

Materials / Grades:

Rods - CK45, EN8D, EN9, EN19; Tubes - ST52, ST52.3, E355.

Manufacturing & Quality:

Rods are ground, polished, and chrome-plated for durability; honed tubes are precision-finished for high accuracy. Quality checks include hardness, straightness, surface finish, and chrome thickness.





South India Tubes Pvt Ltd

OUR PRODUCTS

Carbon Steel Seamless Pipes & Tubes

Purpose / Application:

Used for conveying fluids and gases under pressure and for structural or general engineering purposes in industries like oil & gas, power, and boilers.

Size / Thickness:

1/4" NB to 24" NB; wall thickness from SCH 20 to SCH 160 / XXS; Grades - ASTM A106 Gr. B, ASTM A53 Gr. B, API 5L Gr. B, ASTM A333 Gr. 6.

Materials / Grades:

Produced by cold drawing or hot rolling; heat-treated for strength and dimensional accuracy; tested for pressure, mechanical properties, and finish.



Heat Exchanger Tubes

Purpose / Application:

Designed for thermal transfer applications such as heat exchangers, condensers, boilers, and superheaters operating at high pressure and temperature.

Size / Thickness:

6 mm OD to 101.60 mm OD; wall thickness 0.7 mm to 12.70 mm.

Material Grades:

ASTM A213, A269, A179, A192, A210, A334, and similar.

Manufacturing & Quality:

Cold-drawn or hot-finished, heat-treated for stability and corrosion resistance, and tested for dimensional accuracy, thermal performance, and pressure tolerance.





South India Tubes Pvt Ltd

OUR PRODUCTS

Hydraulic Cylinder Tubes / Ready to Hone Tubes

Purpose / Application:

Tubes used in hydraulic cylinders, supplied either honed (internally refined) or in a "ready to hone" state for further finishing in assembly.

Key Characteristics:

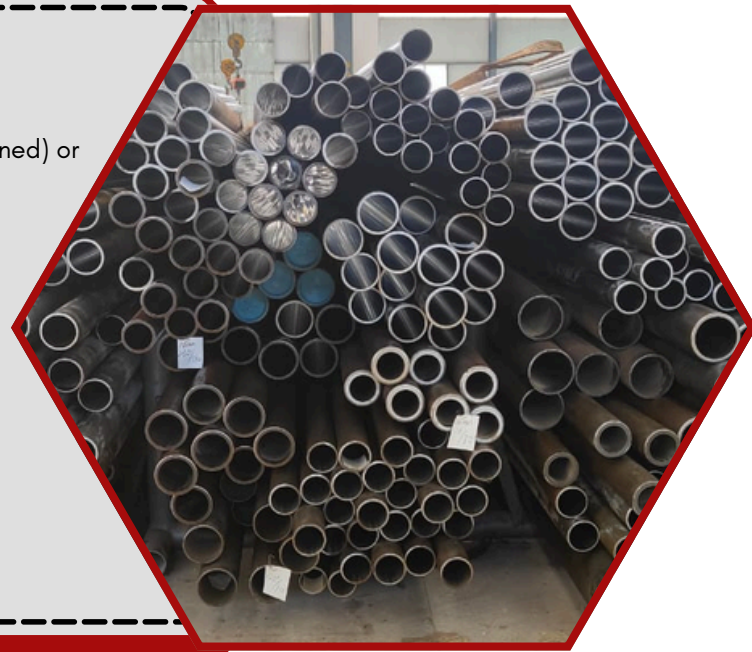
Smooth inner bores, precise tolerances, suitable for high-pressure environments.

Materials & Grades:

Typically grades suited for hydraulic service (e.g. low carbon or alloy steels, e.g. ST52, CK45, etc.).

Quality / Checks:

Inspections for internal finish, straightness, dimensional accuracy, surface cleanliness.



Fuel Injection Tubes & Mechanical Tubes

Purpose / Application:

For fuel injection systems in engines and various mechanical uses where precision and pressure handling are essential.

Size / Thickness:

Outer diameter from 6 mm up to 101.60 mm; wall thickness from 0.7 mm to 12.70 mm.

Material Grades:

ST52, SAE 1010, SAE 1020, ASTM A179, ASTM A106 Gr.B, and equivalents.

Manufacturing & Quality:

Seamless cold drawing to ensure accurate internal diameter, smooth surfaces, good pressure resistance. Normalizing or annealing is done depending on application.





South India Tubes Pvt Ltd

OUR PRODUCTS

Boiler Seamless Tubes

Purpose / Application:

Tubes meant for boilers, steam, superheaters, heat recovery systems – where they face high temperature, pressure, and heat stresses.

Material / Grades / Standards:

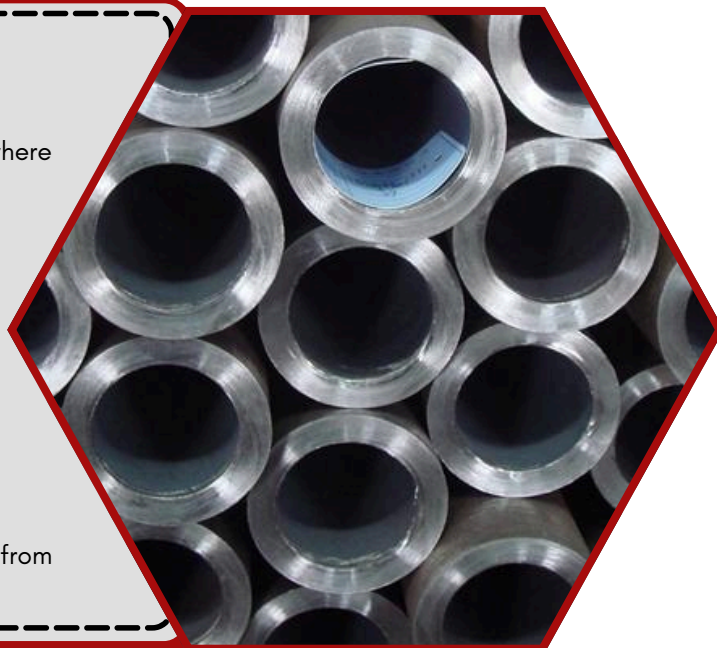
Often made of heat-resisting carbon or low-alloy steels; standards like EN 10216-2, DIN 17175, BS 3059, BS 3602 etc.

Manufacturing & Processing:

Hot rolled or cold drawn, then heat-treated (annealing, normalization) to stabilize microstructure and avoid stresses

Dimensions & Thickness:

For example, sizes may vary from ~10.2 mm to ~139.7 mm, wall thickness from ~2.6 mm upward depending on pressure class.



Cold Drawn Seamless Tubes

Purpose / Application:

General-purpose precision tubes used across industries – hydraulic, structural, mechanical, etc. They are used where tight tolerances, superior strength, and surface finish are required.

Characteristics / Benefits:

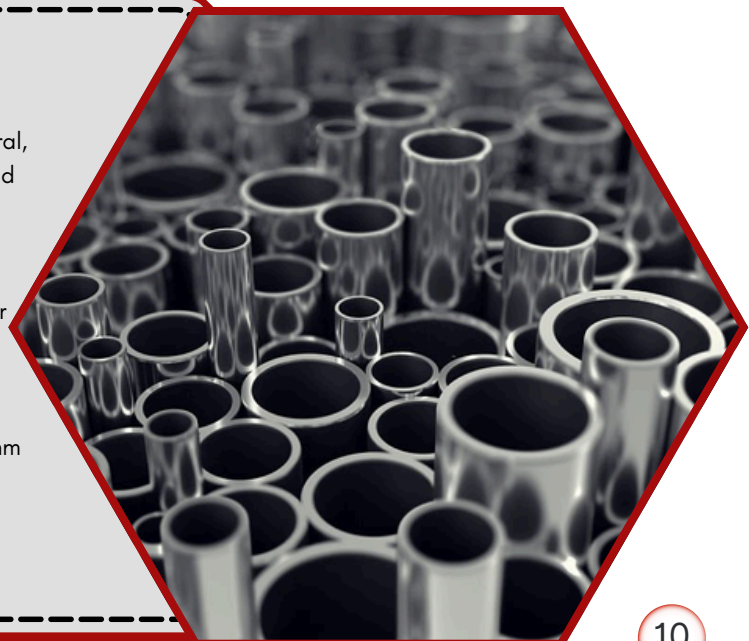
Cold drawing improves dimensional accuracy, uniform microstructure, better mechanical properties, and improved machinability over hot-finished tubes.

Sizes / Thicknesses:

Typical OD range from ~6 mm upward; wall thicknesses starting from ~0.5 mm or more (depending on the application).

Standards / Grades:

Conform to DIN 2391, EN 10305, ASTM A519, etc.





South India Tubes Pvt Ltd

CARBON STEEL SEAMLESS PRECISION TUBES: MANUFACTURING PROCESS

South India Tubes have specialization of manufacturing cold drawn seamless carbon steel tubes normalized / annealed in controlled atmosphere. These tubes are superior than the tubes annealed in normal annealing and due to controlled atmosphere these tubes are bright finished, semi bright and scale free also.

APPLICATIONS

Tubes produced in controlled atmosphere is widely used in application of

 HIGH PRESSURE FUEL INJECTION TUBING

 HYDRAULIC TUBING

 AUTOMOBILES INDUSTRIES

 BRAKE SHOE LINES

 CNG PIPINGS

 FUEL PUMP LINE

 PRECISE ENGINEERING ETC.



South India Tubes Pvt Ltd

◆ **MANUFACTURING PROCESS: COLD DRAWN BENCH**

Before drawing operation the Pipes are coated by Phosphate to avoid metal to metal contact and static for lubrication purpose. Than approx 200 mm of the input end are reduced by using tagging process.

Cold Drawing is the process applied when very precise tolerances are specified for a tube diameter. Besides the improved diameter tolerances, specified mechanical properties can also be attained. In addition, this process is o ered in all cases where special requirements are placed on the quality of the surface of the tube bore.

In cold drawing, the tube is pulled through a Tungsten Carbide Die with a fixed floating plug resulting in reduced tube diameter/thickness and increase in tubelength.

◆ **HEAT TREATMENT: BRIGHT ANNEALING**

Afer each process of manufacturing tubes& pipes are subjected to heat treatment in a continuous annealing furnace at the specified temperature asper specification followed by slow air cooling and fast cooling sub sequent annealing process is carried out.

Full Annealing, Normal Lising and Tempering ensures

- ◆ Homogenous structure/ refining grain size.
- ◆ Removal of residual stresses developed during the process.
- ◆ Imparts ductility and so ness for further process

CARBON STEELS SEAMLESS TUBES MANUFACTURING PROCESS





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» INSPECTION & TESTING

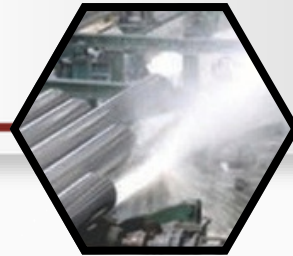
Ultrasonic Testing (UT)

This Is The Non Destructive Test Carried Out To Detect The Surface Defect/pin Holes On The Outside Diameter Or Inside Diameter Of The Tube



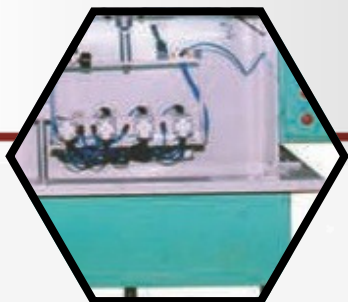
Hydrostatic Test

100% Hydrostatic Test is Carried out on Finished tubes/pipes to check the tube for any leakage under elevated hydraulic by high flash point oil pressure as per specification or customer requirement so as changes of rusting near occurs



Air Under Water Test

Pneumatic Test is Carried out to Check any leakage in tube by air pressure under water



Tensile Test

This is the destructive test carried out to obtain the mechanical test values of finished products.



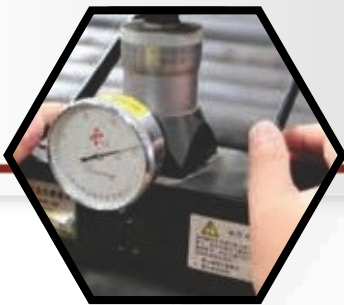


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» INSPECTION & TESTING

Hardness Test

Hardness Tester is Used for Measuring hardness value of Tubes & Pipes.



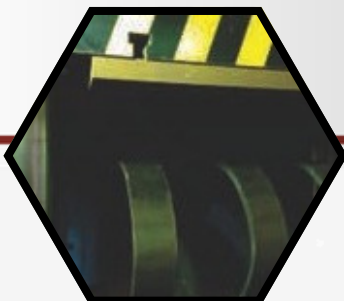
Flaring & Flange Test

Flaring test is carried out to check ductility of the material & Flange test is carried out to check the material under deformation.



Flattening

Flattening test is carried out to check the material under compression.



Visual & Dimension Inspection

Inspection is carried out to detect any Dents, Surface Defect or Scratch on the surface of Tube. The Dimensional Inspection is carried out with calibrated Measuring Instruments for Product dimensions are within tolerance requirements, ID clean test in millpor test as well as wire roding testing.





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» CARBON STEEL SEAMLESS PRECISION TUBES

CHEMICAL COMPOSITION & MECHANICAL PROPERTIES

Specifications	En10235, DIN 2391, DIN 17175, DIN 1629, DIN 2448 in Bright anneals, Zinc coated/phosphated condition
Size Product	3.00 mm to 90 mm & 0.40 mm to 6.00 mm
Strength	<ul style="list-style-type: none"> (1) Bright annealed tubes which give high corrosion resistance strength (2) Supply in close dimension tolerances (3) Reliable for high pressure applications. (4) Having less than 2 microns Ra value on ID

CHEMICAL COMPOSITION IN %

Grade	Material Number	"C" Max	Min.	"Si" Max.	"P" Max.	"S" Max.
St. 35	1.0308	0.17	0.40 Min	0.35	0.025	0.025
St. 35.8	1.0305	0.17	0.40 to 0.80 Min	0.35	0.040	0.040
St. 37	1.0254	0.17	0.40 Min	0.35	0.025	0.025
St. 37.4	1.0255	0.17	0.35 Min	0.35	0.040	0.040
St. 45	1.0408	0.21	0.40 Min	0.35	0.025	0.025
St. 52	1.0580	0.22	1.60 Min	0.35	0.025	0.025



South India Tubes Pvt Ltd

➤➤➤ CARBON STEEL SEAMLESS PRECISION TUBES

MECHANICAL PROPERTIES

Steel Grade	BK		NBK		
	Tensile Strength N/mm ²	% Elongation	Tensile Strength N/mm ²	Yield Stress N/mm ²	% Elongation
St. 35	480	8	340 to 470	235	25
St. 35.8	–	–	360 to 480	235	25
St. 37	480	8	340 to 470	235	25
St. 37.4	–	–	350 to 480	235	25
St. 45	580	5	440 to 570	255	25
St. 52	640	4	490 to 630	355	22

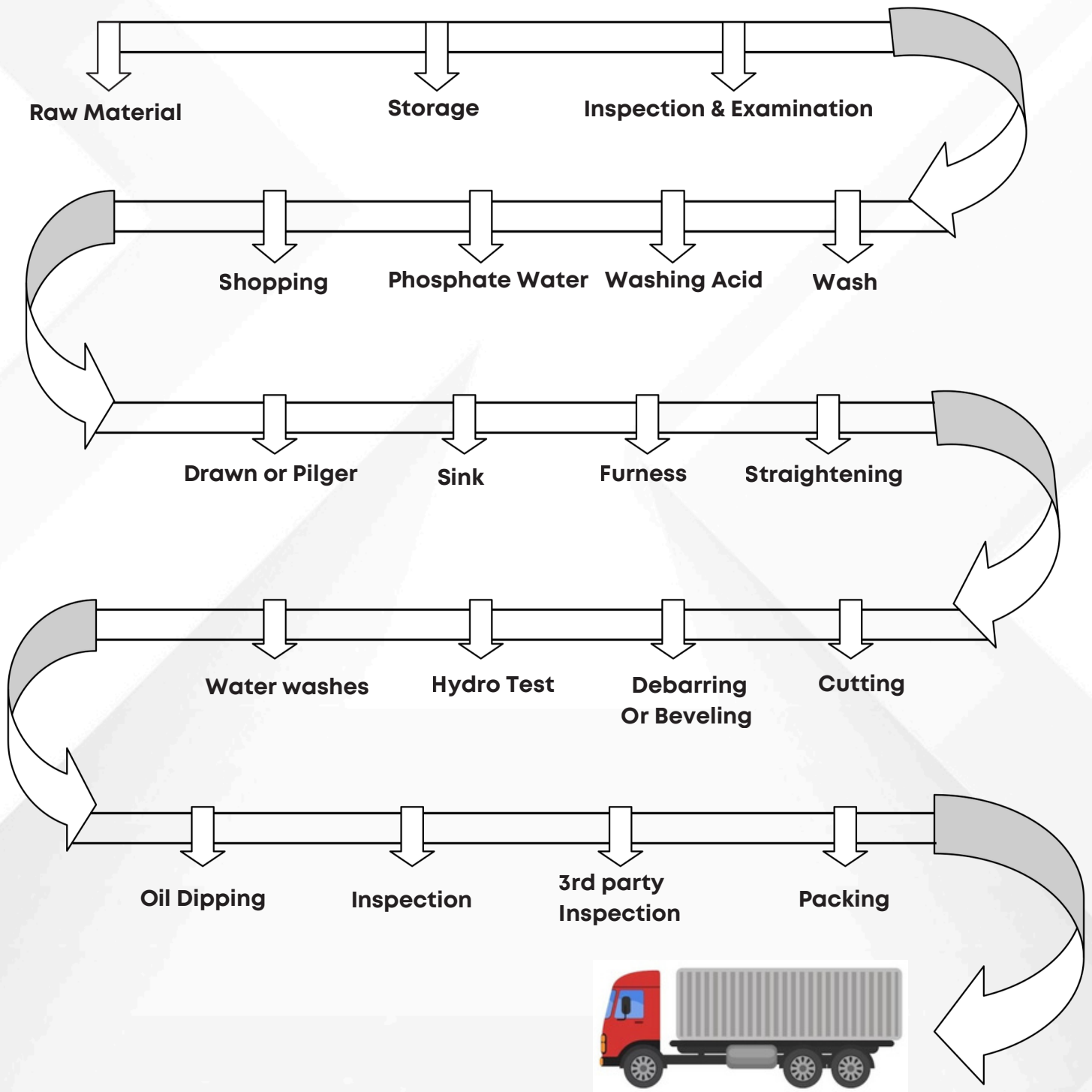
NBK	Normalized	Tubes are heated critical transformation point in a controlled atmosphere furnace.
BK	Cold Drawn (Hard)	No Heat Treatment is Carried out after final cold Forming, Hence, These tubes cannot be cold worked any further. (e-g. bending, end forming, etc.)
BKW	Cold Drawn (So)	After Final Heat Treatment these tubes are given a light cold forming pass and hence can be cold worked further to a limited extent.

PRODUCT HIGHLIGHTS

- ❖ Tubes are annealed in controlled atmosphere hence it will be completely scale free and in bright mirror finish.
- ❖ It gives uniformity in hardness and it will be suitable for precision bending as heat treatment is carried out in control atmosphere by uniform heating.
- ❖ Tubes are supplied in closer dimensional tolerances.
- ❖ Having better surface quality on IID and OD both with homogeneous Ra Value.



South India Tubes Pvt Ltd





South India Tubes Pvt Ltd

SECTORS SERVING

We deliver high-quality precision tubes and tubular products engineered to meet the rigorous demands of diverse industrial applications. With advanced manufacturing capabilities and an unwavering commitment to quality, South India Tubes provides reliable solutions that empower global customer success.



AGRI & FARMING



CONSTRUCTION & MINING



GENERAL ENGINEERING



AUTOMOTIVE



POWER & ENERGY



DEFENSE & AEROSPACE



South India Tubes Pvt Ltd

SOUTH INDIA TUBES EXPANDING BEYOND BORDERS

**EMBARKING ON A JOURNEY TO BUILD A POWERFUL
GLOBAL FOOTPRINT**





South India Tubes Pvt Ltd

Leading Manufacturers of Carbon & Alloy Steel Seamless Tubes & Pipes in India



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Dist: Morbi At Chhatar Gujarat.



Registered Company Address:

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