


Marketing Bulletin		
Date:	8th June 2015	 Pegler Yorkshire
Issue: AS	Steel Tube Bending Guidance Update	

Bending XPress Carbon and XPress Stainless system tubes.

This bulletin is intended to supplement, and in some areas supercede the guidance offered within the section 'Tube Bending' on pages 131 and 132 of the latest XPress Data Book.

XPress Carbon and XPress Stainless Steel tubes are stated within the Data Book as being suitable for bending up to 28mm.

Above this side we can now confirm that the tube can be bent as long as the correct suitable tooling is used and no heat is applied in the process of bending the tube.

The following rules apply with regards to bending radii and methods of bending up to 28mm:

Bending by hand: $r > 5d$
Using bending tool: $r > 3.5d$

Tools for bending both Carbon Steel and Stainless Steel for sizes 35mm and above can be obtained from general tool supplier outlets within the marketplace. Please observe the instructions provided by the manufacturer of the tool in order to determine the bending radii.

The second update is regarding the positioning of the welded seam when bending XPress system tube.

The Data Book has previously advised that it is important to ensure that the weld seam is kept to the inside radius of the bend.

Although Pegler Yorkshire still advise that positioning the weld seam on the inside is good practice, we can also now confirm that the position of the weld seam when bending XPress system tube will have no detrimental effect on the performance of the tube.