



# ERW RIGID CONDUITS

Stove Enamelled Black

IS: 9537



## GUPTA BROTHERS

CONDUIT PIPE MFG. CO. PVT. LTD.

Incorporating Latest High Frequency Induction Welding Technology

## Introduction

**G**UPTA BROTHERS is a story of steady growth of an enterprise which started in a modest way over six decades ago. Having pioneered manual gas-welding of pipe manufacturing in 1941, the unit grew into a company in 1964 which was to become a landmark in conduit pipe manufacturing industry. Subsequently, professionalism came early in the company culture which initiated the high frequency induction Welding System in 1980 and became a landmark in the history of the Company. And then there was no looking back and the Company strived for its fast growth. GUPTA BROTHERS have since handled manufacturing of high value and great prestige.

Over the years, GUPTA BROTHERS have acquired a kind of specialisation in the field. The company has today carved a niche for itself in the constantly growing market-nationwide and overseas. At GUPTA BROTHERS, quality has been the watchword and a regular quality culture and technology up-gradation has evolved over the years which has become fundamental to the company and formidable strength in its own right.

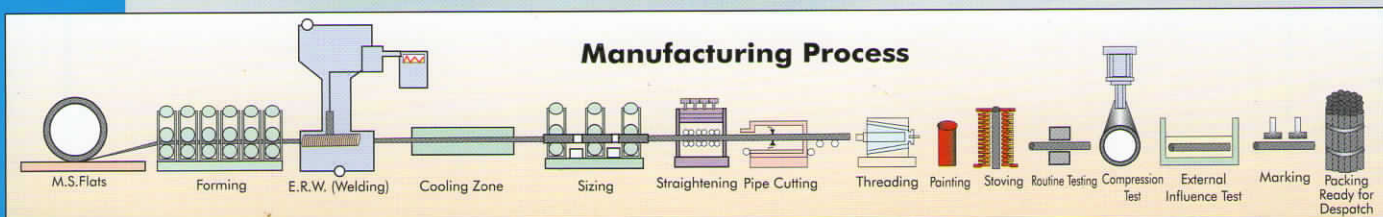
It is not only the quality of materials, equipment and man-power that has mattered at GUPTA BROTHERS, it is that attitude of quality which has taken the company where it has reached today. With its eyes on the future, the company has a commitment and a strong zeal to take the enterprising endeavour in its stride.



**'GB' Stamped at every metre of ISI marked Pipe**

TEST TO CHECK RIGID STEEL  
CONDUITS CONFIRMING TO IS : 9537 (PART-II) 1981

| Sr. No. | Name of Test   | Mode of Testing  |
|---------|--|--|
| 1.      | Inspection of Surfaces & Edges   | Visual Examination<br>(By Normal or Corrected Vision)<br>Without Magnification)  |
| 2.      | Dimensional Check  | For Maximum OD by GO Gauges<br>and minimum OD by NO GO Gauges  |
| 3.      | Wall Thickness   | Measured with the help of Micrometer<br>(Accuracy equal to or more than<br>0.01 mm)  |
| 4.      | Screw Threads  | 1. Length measured by vernier<br>calipper<br>2. profile of threads by GO & NO<br>GO gauges   |
| 5.      | Bending Test   | By bending the samples on Bend Test Apparatus<br>& testing the samples for deformity and cracking of<br>original material or protective coating as mentioned<br>in BIS 9537 Part I & II  |
| 6.      | Compression Test   | With the help of compression test apparatus  |
| 7.      | Test for protective coating<br>(For Checking the effect of<br>external influences) | With the help of chemicals as prescribed<br>in IS : 9537 Specifications for medium protection<br>of Rigid steel conduits for the effect of external<br>influences or Anti-Corrosive effectiveness of the<br>protective coating |
| 8.      | Marking  | A. Trade Mark<br>B. Country of Mfg.<br>C. Nominal Size of Conduits   |
| 9.      | Durability of Marketing  | Compliances tested by method<br>as mentioned in IS : 9537<br>Specifications  |





**GB ISI RIGID STEEL CONDUITS  
MADE TO IS:9537 (PT-II) 1981 SPECIFICATIONS  
DIMENSIONAL REQUIREMENTS \***

| <b>SIZE IN MM</b>                  | <b>20</b> | <b>25</b> | <b>32</b> |
|------------------------------------|-----------|-----------|-----------|
| Diameter (mm)                      | 20        | 25        | 32        |
| Tolerance on outside diameter (mm) | -0.30     | -0.40     | -0.40     |
| Minimum Outside diameter (mm)      | 19.70     | 24.60     | 31.60     |
| Maximum outside diameter (mm)      | 20.04     | 25.04     | 32.04     |
| <b>Wall Thickness</b>              |           |           |           |
| (a) Minimum (mm)                   | 1.40      | 1.40      | 1.40      |
| (b) Maximum (mm)                   | 1.80      | 1.80      | 1.80      |

**TECHNICAL SPECIFICATIONS FOR G.B. STANDARD CONDUITS**

| <b>Sr. No</b> | <b>Size in MM</b> | <b>Size in Inches</b> | <b>Gauge</b> | <b>App.Weight in Kgs. per 100 Ft.</b> |
|---------------|-------------------|-----------------------|--------------|---------------------------------------|
| 1             | 19                | 3/4                   | 20           | 11-0                                  |
| 2             | 19                | 3/4                   | 18           | 14-15                                 |
| 3             | 19                | 3/4                   | 16           | 19-20                                 |
| 4             | 19                | 3/4                   | 14           | 23-24                                 |
| 5             | 25                | 1                     | 20           | 14-15                                 |
| 6             | 25                | 1                     | 18           | 19-20                                 |
| 7             | 25                | 1                     | 16           | 25-26                                 |
| 8             | 25                | 1                     | 14           | 32-33                                 |
| 9             | 31                | 1-1/4                 | 20           | 17-18                                 |
| 10            | 31                | 1-1/4                 | 18           | 25-26                                 |
| 11            | 31                | 1-1/4                 | 16           | 31-32                                 |
| 12            | 31                | 1-1/4                 | 14           | 38-39                                 |
| 13            | 38                | 1-1/2                 | 18           | 32-33                                 |
| 14            | 38                | 1-1/2                 | 16           | 38-39                                 |
| 15            | 38                | 1-1/2                 | 14           | 46-47                                 |
| 16            | 50                | 2                     | 16           | 55-56                                 |
| 17            | 50                | 2                     | 14           | 64-65                                 |



**Quality is not by chance**



AUTHORISED DEALER