



AUSTENITE AND FERRITE STAINLESS STEEL TUBES PRODUCTION

TUBES FOR HEAT EXCHANGERS, AUTOMOTIVE INDUSTRY, EXHAUST PIPE
PRODUCTION, DAIRY INDUSTRY, PHARMACEUTICAL INDUSTRY, SUGAR FACTORIES



Elit Inox is the manufacturer of stainless steel tubes. Our customers recognize us by top quality products, excellent service and permanent customer support.

Elit Inox has state-of-the-art equipment for stainless steel TIG welded tubes production.

Twenty-five-year-long experience with Inox materials in boiler and pressure vessel production resulted in 2008 in development of top quality tubes.

We have 3 tubes production lines of the following ranges:

- MK Line - from 7 to 20 mm
- IT Line - from 6 to 35 mm
- VK Line - from 20 to 55 mm

Along with the extension of the production range, the Company permanently works on the improvement of quality aiming at customer satisfaction. Our compliance with ISO 9001 and ISO 14001 represents the guarantee for the required quality.

Tool manufacturing is entirely under control in Elit Inox. Rollers are manufactured in our toolroom on CNC machines with support of Solid Works and Solidcam designing and programming software.

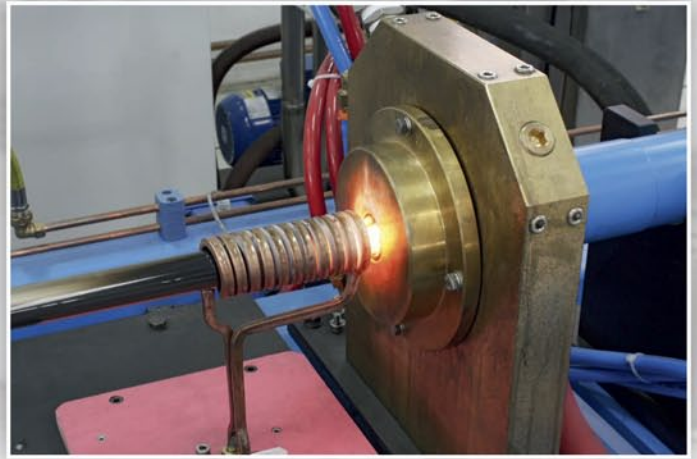
In order to provide and maintain top quality of final products, we perform the procurement of raw materials exclusively from renowned manufacturers who strictly define chemical compositions, dimensional tolerance, physical features and finishing.

EN 10204, AD 2000 W2 / 3.1 b



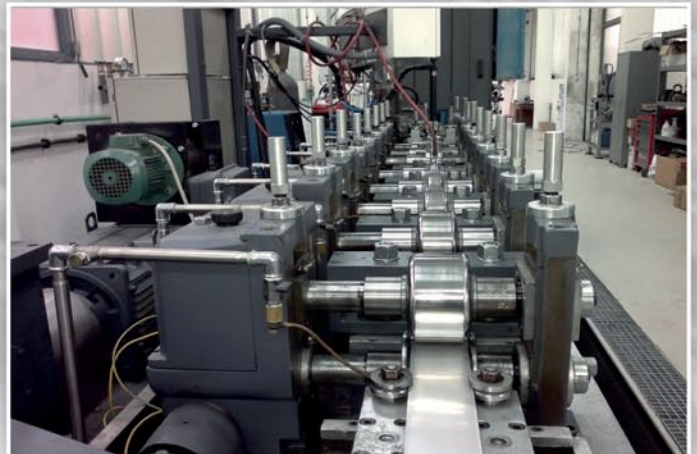
TIG WELDING

TIG welding is completely automated and performed on state-of-the-art equipment in argon-protected atmosphere. Top quality tube welding is guaranteed (EN ISO 9692-1).



TUBE ANNEALING

Heat treatment of the tubes is performed on an automated annealing line in protected atmosphere. Pre-defined performances of the material and required microstructures are obtained at annealing temperatures of up to 1150°C. Protected atmosphere enables the tubes to maintain their big shine. Annealing parameters are in compliance with A 249/A 249M-08 standard.



MARKING

Marking of the tubes guarantees perfect material traceability required by EN 10217-7.



ACCURACY

One of the distinguishing features of Elit Inox tubes is accuracy. Final calibration and straightening of tubes guarantees the compliance with all EN and ASTM norms.

THANKS TO THE STATE-OF-THE-ART EQUIPMENT AND TRAINED PERSONNEL, WE CAN ALSO PRODUCE T3/D4 TOLERANCE.

BEAD ROLLING

Special attention is paid to the treatment of weld seams on both outer and inner sides of the tube. „ROLLING BEAD“ is special cold treatment of the welded area on the tube which provides top quality required for the tubes used in heat exchangers, sanitary pipes, pharmaceutical industry and automotive industry. EN 102017-7 W2RB



CONTROL

Elit Inox employees are entirely dedicated to top quality production. Automated equipment provides 100% production process control.

Control process is conducted in each phase of production, which is necessary if we want to have products and services complying with the highest standards..

- Welding control **PRUFTECHNIK** - EN10893-2, ASTM E426, SEP1914,1915
- Eddycurrent test on line 100%
- Tube crack control **EDDY check 5** - 100% **PRUFTECHNIK**
- Automatic marking and sorting - Each tube with identified defect is automatically marked and sorted.
- Size control according to **EN ISO 1127**
- Flare test **ASTM A 370, DIN EN 10233**
- Flattening test **ASTM A 370, DIN EN 10233**
- Tensile strength test **A370**
- Metallographic testing **ASTM A789, EN 10216-5, EN ISO 643**
- Surface roughness measurement
- Hardness test **HV1-HV5 / ASTM EN 384**



TUBE BENDING

Mewag 76S is a 10-axis tube bending machine (D=76 mm, tube wall thickness up to 3 mm).

Top accuracy and repeatability of tube bending is enabled by servo motors controlled by CNC program. It is suitable for exhaust pipes, rollbars and chassis bending.



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EM 102017-7, EN 10204, EN ISO 1127, A270, A312, A249,
A269, DIN 17457, 17455, A370, AD2000.

MATERIAL

EUROPE	U.S.A.	EUROPE	U.S.A.
W.N. 17007	AISI	W.N. 17007	AISI
1.4301	304	1.4571	316 Ti
1.4307	304L	1.4541	321
1.4828	309	1.4878	321
1.4401	316	1.4512	409
1.4404	316 L	1.4521	444

STAINLESS STEEL TIG WELDED TUBES

Outside diameter (mm)	Wall thickness (mm)								
	0,4	0,5	0,6	0,7	0,8	1,0	1,2	1,5	2,0
7,5	0,072	0,088	0,104	0,12	0,135	0,164	0,19		
8	0,076	0,095	0,111	0,128	0,145	0,175	0,206		
9,5	0,091	0,113	0,134	0,155	0,175	0,214	0,25		
10	0,097	0,120	0,142	0,164	0,185	0,227	0,266	0,321	
12	0,117	0,145	0,172	0,199	0,226	0,277	0,327	0,397	
13					0,246	0,302	0,357	0,435	
14				0,233	0,266	0,328	0,387	0,473	
15						0,351	0,417	0,507	
16	0,156	0,194	0,231	0,268	0,304	0,378	0,448	0,548	0,706
17,2						0,406	0,481		
18						0,428	0,508	0,624	0,806
20						0,479	0,569	0,699	0,907
21,3						0,512	0,608	0,748	0,967
22						0,526	0,625		
25						0,601	0,715	0,883	0,159
26,9						0,653	0,772	0,96	1,255
30						0,726	0,865	1,070	1,411
33,7						0,824	0,983	1,217	1,598
35						0,857	1,022	1,266	1,663
40						0,983	1,173	1,455	1,915
50						1,201	1,435	1,783	2,352
53							1,556	1,934	
Production range tubes weights kg/m									

PACKING

Packing is entirely adjusted to customer requirements. Standard packing can be hexagonal, rectangular and wood crates sizes are adjusted to customer needs.



CERTIFICATES

Enclosure to
Certificate-№ TIC 15 100 117815
TIC 15 104 131157



ELIT INOX d.o.o.
Milutina Mandića br. 2
SRB - 32000 Čačak

Following local branch is part of the certificate:

Central office
ELIT INOX d.o.o.
Milutina Mandića br. 2
SRB - 32000 Čačak

Scope: Production of welded stainless steel pipes

Certificate-№ TIC 15 100 117815
Certificate-№ TIC 15 104 131157

Location
ELIT INOX d.o.o.
Pakovraće bb
SRB - 32000 Čačak

Scope: Production of electric boilers, heaters, LED luminaries for road and street lighting

A. Drechsel
TÜV Thüringen e.V.
Certification body for
systems and personnel



Jena, 2015-02-06



Original certificates are issued with a hologram.
This annex is valid only in connection with the certificate No. TIC 15 100 117815 / 15 104 131157 (2015) Series I



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