



# BHULESHWAR SEAMLESS

High Precision. High Performance.

Manufacturer of Seamless Pipes & Tubes



**BUILT TO ENDURE**  
**DESIGNED TO PERFORM**





## From The **Chairman's Desk**

At Bhuleshwar Steel, trust is a foundational pillar—trust placed in us by our customers, trust in our products and people & trust in our ability to evolve with changing times.

As we enter a new chapter in our journey, diversifying into seamless pipes & tubes, our vision remains the same: to carry forward this legacy built on trust, with a commitment to innovation, passion & excellence. This move is not just about diversification, but an opportunity to continue raising the bar for ourselves & set new benchmarks in global manufacturing.

With an uncompromising focus on product quality, customer satisfaction & technological innovation, we have evolved & adapted to changing global scenarios & market dynamics. With our guiding principles of constant innovation & technological evolution, Bhuleshwar Seamless aims to serve international leaders who value precision, durability & consistency by providing products & customer service of the highest quality.

Along with our portfolio of steel products, we are dedicated to investing in our greatest asset: the people at Bhuleshwar Seamless. It is because of their expertise, passion & dedication that we could forge an enduring legacy & it is with them that we're walking toward a brighter future.

Our promise, as always, is to keep the customer at the core of everything we do. Because we believe in being more than a manufacturer, but a trusted companion offering a lifetime of support, reliability & partnership.

As we venture into this new market, we invite our customers, partners & employees on a shared journey to help us set higher standards for today & for the future.



# Introducing Bhuleshwar Seamless

Founded by technocrats averaging over five decades of industry expertise, Sant Gyaneshwar Steels Pvt. Ltd & Indrayani Ferrocast Pvt. Ltd. has grown into key players in the steel industry. Built on a foundation of passionate innovation & a pursuit of excellence, we take pride in serving leading brands in diverse industries across the globe.

Our state-of-the-art facility, spread over 25 acres, brings hot finish & cold drawn processes under one roof to ensure unparalleled precision & consistency. We are proud to bring extend this manufacturing excellence to high-quality seamless pipes & tubes through BSPL.

Combining sophisticated infrastructure, including continuous Hot rolling mills, Induction, Piercing, Sizing Cold Drawn Seamless Tubing, with best-in-class testing equipment, we deliver precision products engineered to meet international standards such as ASTM, DIN, EN, JIS, IS & BS. At BSPL, we also customise products to clients' specifications to help meet the evolving demands of global industries.

Our extensive range of seamless tubes & pipes includes line pipes, marine-grade pipes, mechanical & automotive tubing, high-pressure boiler tubes, machining tubes, high-strength oil pipelines & specialised petroleum machinery components. This has made BSPL the preferred partner for leaders in metallurgy, automobile, chemicals, engineering machinery, construction, petroleum, oil & gas, electricity & other industries.

Our in-house NABL-accredited research & development (R&D) lab enables rigorous testing at every stage of the manufacturing process from planning to execution—allowing us to

adhere to the highest standards of quality & accountability.

Our seamless steel pipes & tubes are available in various standard dimensions & tolerances:

## Cold Drawn Seamless Tubing

Outer Diameter : 10 mm to 73 mm

Wall Thickness : 1 mm to 13 mm

Maximum Length : 13 meters

## Hot Finished Seamless Pipes

Outer Diameter : 33.4 mm to 63.5 mm

Wall Thickness : 3 mm to 14 mm

Maximum Length : 8 meters

Our proximity to two major ports ensures cost-effective & export-ready operations for an installed capacity exceeding 18,000 metric tons annually.

Aligning with our culture of sustainability & social responsibility, we support the 'Make in India' initiative of the Government of India, the National Sustainable Development Strategy & Environmental Protection.

For us, BSPL is more than an enterprise. It is the next chapter in our story, carrying forward the uncompromising standards that defined the Bhuleshwar brand name for decades. Our guiding principle will always remain at the heart of everything we do



***Character determines product quality. Everything else is secondary.***





## Our Vision

To manufacture seamless steel pipes & tubes of the highest quality by leveraging the finest raw materials, advanced technology & scientific management practices, while continuing to elevate our people & processes.

## Our Mission



To produce the highest quality seamless tubular products for diverse industries while expanding our global market share.



To deliver the best value in terms of cost, quality & service with an unwavering commitment to our Quality Systems.



To maximise the utilisation of our assets as measured by the 'Contribution' generated.



To lead proactively & responsibly in social development & environmental protection within our sphere of influence.



To build a workplace that inspires creativity, empowers individuals, ensures accountability & rewards performance & evolves as a self-learning organisation that adapts to changing customer needs, market dynamics & the environment.



# Bhuleshwar Tube Plant

The BSPL plant at Deulgaongada, 60 km from Pune, is fully equipped with tube-making, finishing & testing facilities. The tube plant comprises equipment such as:

## Hot Mill Equipment



Piercing Mills



Sizing Mill



Cooling Bed

## Cold Mill Equipment



Cold Draw Benches



Bright Annealing  
Furnaces

## Finishing Facilities

- Heat Treatment Furnaces (Normalizing, Annealing, Stress Relieving, Quench & Tempering)
- End Finishing Machines (Cutting, Straightening, Beveling,)
- Peeling Machines
- Cold Ring Rolling Machines (Bad Deuben)
- Swaging Machines
- Stenciling & Lacquering Machines

## Inspection & Testing Facilities

- Hydro-testing
- Eddy Current Testing
- Chemical, Mechanical & Metallurgical Testing

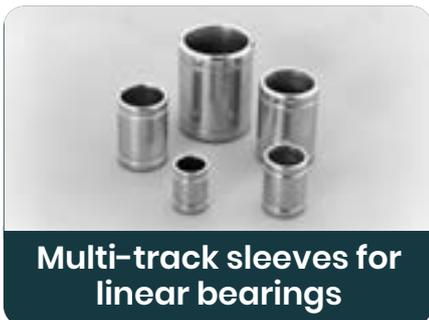
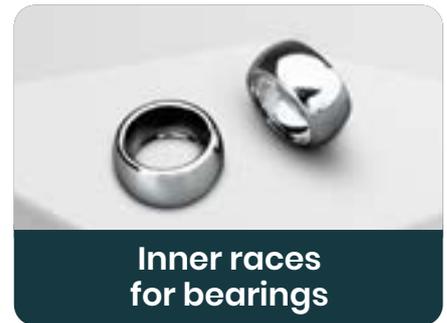
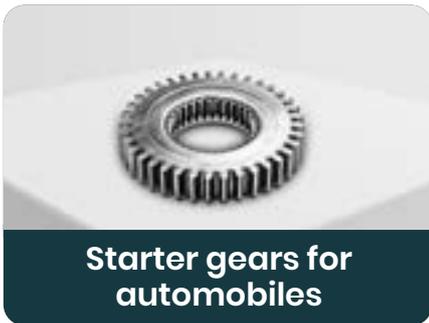


# Product Range

BSPL has poured its decades of expertise in the steel industry into its seamless pipes & tubes. As one of the world's most respected & diversified steel manufacturers, our combined piercing & sizing mills enable us to produce both hot-finished & cold-finished seamless tubes within the same facility, ranging from 10 mm to 73 mm in outside diameter.

BSPL's high-quality tubes power critical applications in the manufacturing of auto-components, drill rods, boilers, heat-exchangers, cylinder tubes etc.

## Precision-Engineered Products





# Grade Chart

Product Specification	Grades	Product Specification	Grades
ASTM A 53	A,B,C	BS 3601	
ASTM A 106	A,B,C	BS 3602-1	
ASTM A 179		BS 3059	
ASTM A 192		BS 6323-4	
ASTM A 210	A,I,C	EN 10084	16MnCr5, 20MnCr5
ASTM A 333	1, 3, 6	EN 10305-1	
ASTM A 334	1, 3, 6	EN 10305-4	
ASTM A 519	1010, 1018, 1019, 1020, 1026, 1035, 1040, 1045, 1141, 1518, 1541, 4130, 4140	EN 10297-1	
ASTM A 513	1010, 1018, 1019, 1020, 1026, 1035, 1040, 1045, 1141, 1518, 1541, 4130, 4140	EN 10216-1	P195GH, P235T, P265T
ASTM A 312	TP 304, TP 304L, TP 316, TP 316L	EN 10216-2	P195GH, P235GH, P265GH, 16Mo3
ASTM A 269	TP 304, TP 304L, TP 316, TP 316L	EN 10216-3	P275+N, P355+N
ASTM A 213	T5, T5b, T5c, T11, T12, T22	EN 10025	S235 (J0,J2,JR), S275 (J0, J2, JR), S355 (J0, J2, JR, K2)
ASTM A 335	P5, P6b, P5c, P11, P12, P22	DIN 2391	ST35, ST45, ST52
IS 1875	Class 4	DIN 17175	ST 35, ST 45, 17Mn4, 17Mn6, 15Mo3
IS 3074	CDS-1	SAE J524	
IS 1239 PART-1		JIS 4105	SCM 415, SCM 418, SCM 420, SCM 421
STKM	11, 20		

## Dimensional Tolerance:

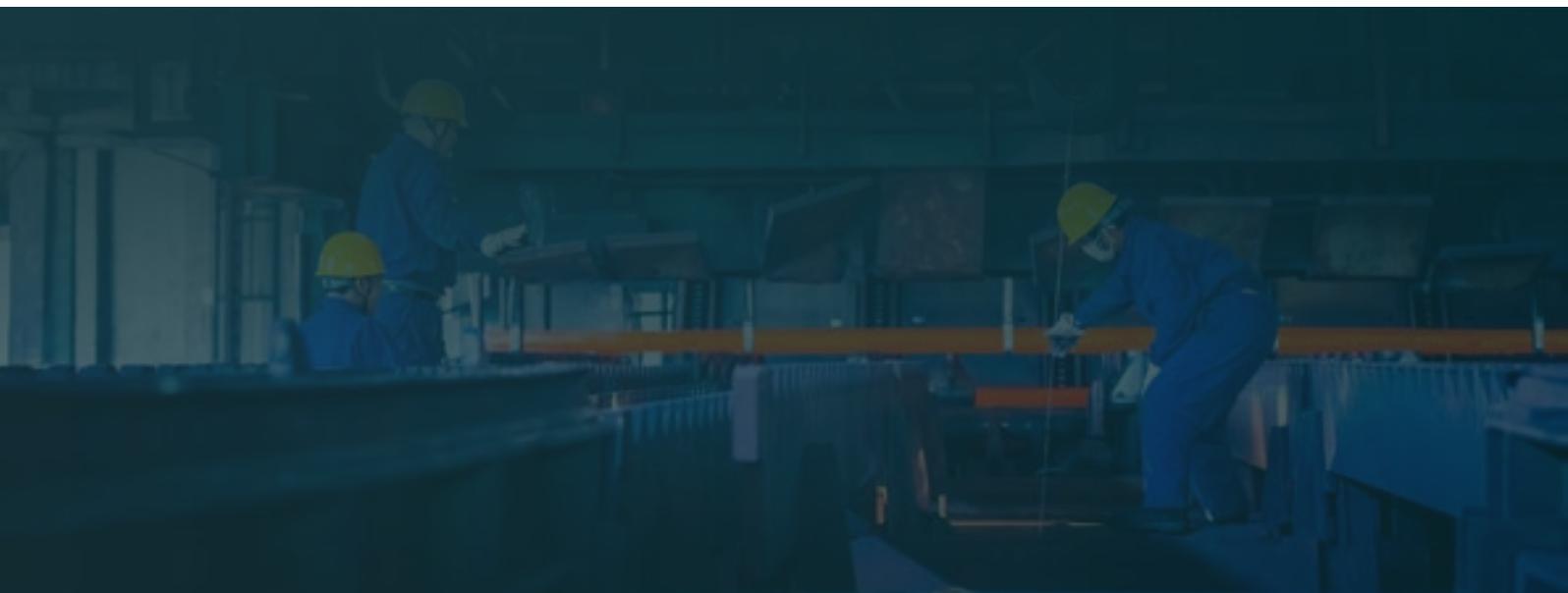
Hot Finished Tube/Pipe	OD: 33.4-63.5mm	Tolerance +/- 1% of OD Min +/- 0.5 mm Max +/- 0.8 mm
	WT: 3 - 14 mm	Tolerance +/- 10% of WT
	Length: upto 8 meters	Tolerance -0/+ 6 mm
Cold Drawn Tube/Pipe	OD up to 38.1 mm	Tolerance +/- 0.5 %
	OD over 38.1 mm	Tolerance +/- 0.5 %
	WT up to 4 mm	Tolerance +/- 5 %
	WT over 4 mm	Tolerance +/- 5 %
	Length: any length up to 13 meters	Tolerance +/- 5 %

Tolerance & length customized as per customer requirements.



## ASTM Schedule Size Chart:

Nominal Bore		Outside Diameter		Wall Thickness	Schedule	Class	Weight	
Inch	Inch	MM	MM	Kg Per Meter			Ibs Per Foot	
1/8"	0.405	10.3	1.70	40	STD	0.36	0.242	
			2.40	80	XS	0.47	0.316	
1/4"	0.54	13.7	2.20	40	STD	0.62	0.417	
			3.02	80	XS	0.79	0.531	
3/8"	0.375	17.1	2.30	40	STD	0.84	0.565	
			3.20	80	XS	1.10	0.739	
1/2"	0.84	21.3	2.77	40	STD	1.30	0.874	
			3.73	80	XS	1.62	1.089	
			4.78	160	-	1.95	1.310	
			7.47	-	XXS	2.55	1.714	
3/4"	1.05	26.7	2.87	40	STD	1.69	1.136	
			3.91	80	XS	2.20	1.478	
			5.56	160	-	2.90	1.949	
			7.82	-	XXS	3.64	2.446	
1"	1.315	33.4	3.38	40	STD	2.50	1.680	
			4.55	80	XS	3.24	2.177	
			6.35	160	-	4.24	2.849	
			9.09	-	XXS	5.45	3.662	
1-1/4"	1.66	42.2	3.56	40	STD	3.39	2.278	
			4.85	80	XS	4.47	3.004	
			6.35	160	-	5.61	3.770	
			9.70	-	XXS	7.77	5.221	
1-1/2"	1.9	19	3.68	40	STD	1.23	0.827	
			5.08	80	XS	1.65	1.109	
			7.14	160	-	2.20	1.478	
			10.16	-	XXH	2.91	1.955	
2"	2.375	60.3	3.91	40	STD	5.44	3.656	
			5.54	80	XS	7.48	5.026	
			8.74	160	-	11.11	7.466	
			11.07	-	XXH	13.47	9.051	
2-1/2"	2.875	73	5.16	40	STD	8.63	5.799	
			7.01	80	XS	11.41	7.667	
			9.53	160	-	14.92	10.026	
			14.02	-	XXS	20.37	13.688	





### CDS Size Chart:

OD	WT																			Length	
	0.89	1.50	2.00	2.30	2.60	2.90	3.20	3.60	4.00	4.50	5.00	5.60	6.30	7.10	8.00	9.00	10.0	11.0	12.0		13.0
10.00																					
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38.00																					
40.00																					
42.20																					
44.50																					
48.30																					
50.00																					
50.80																					
54.00																					
57.00																					
60.00																					
60.30																					
65.00																					
70.00																					
73.00																					

Length 13 mtrs.

Upto WT 4mm Length 12 mtrs/WT 4mm above length 10 mtrs

### HFS Size Chart:

OD	WT												Length
	3.00	4.00	5.00	6.00	7.00	8.00	9.00	10.00	11.00	12.00	13.00	14.00	
33.40													
42.20													
48.30													
60.30													

Upto 8.00 Mtr.



**SA 192, SA 179, SA 210 GR A1, C, SAE J 524, EN SERIES (European) Size Chart:**

OD	WT																			Length			
	0.89	1.50	2.00	2.30	2.60	2.90	3.20	3.60	4.00	4.50	5.00	5.60	6.00	6.30	7.10	8.00	9.00	10.0	11.0		12.0	13.0	
9.53																							
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50.80																							
54.00																							
57.00																							
60.00																							
63.50																							
70.00																							
73.00																							

Upto 13 Mtrs., it may depends on OD X WT

**EN8 / C45 / SAE1045 Size Chart:**

OD	WT																Length						
	2.90	3.25	3.50	4.00	4.50	5.00	5.50	6.00	6.50	7.00	7.50	8.00	9.00	10.00	11.00	12.00		13.00					
20.00																							
22.00																							
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57.00																							
60.00																							
63.50																							
65.00																							
70.00																							
73.00																							

Upto 13 mtrs. or as per customer requirement



**ST - 52 & DOM Size Chart:**

OD	WT																Length
	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00	6.50	7.00	8.00	9.00	10.00	11.00	12.00	12.70	
25.00																	
25.40																	
26.00																	
30.00																	
32.00																	
35.00																	
38.10																	
40.00																	
44.50																	
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54.00																	
57.00																	
60.00																	
63.50																	
65.00																	
70.00																	
73.00																	

Upto 13 Mtrs., it may depends on OD X WT

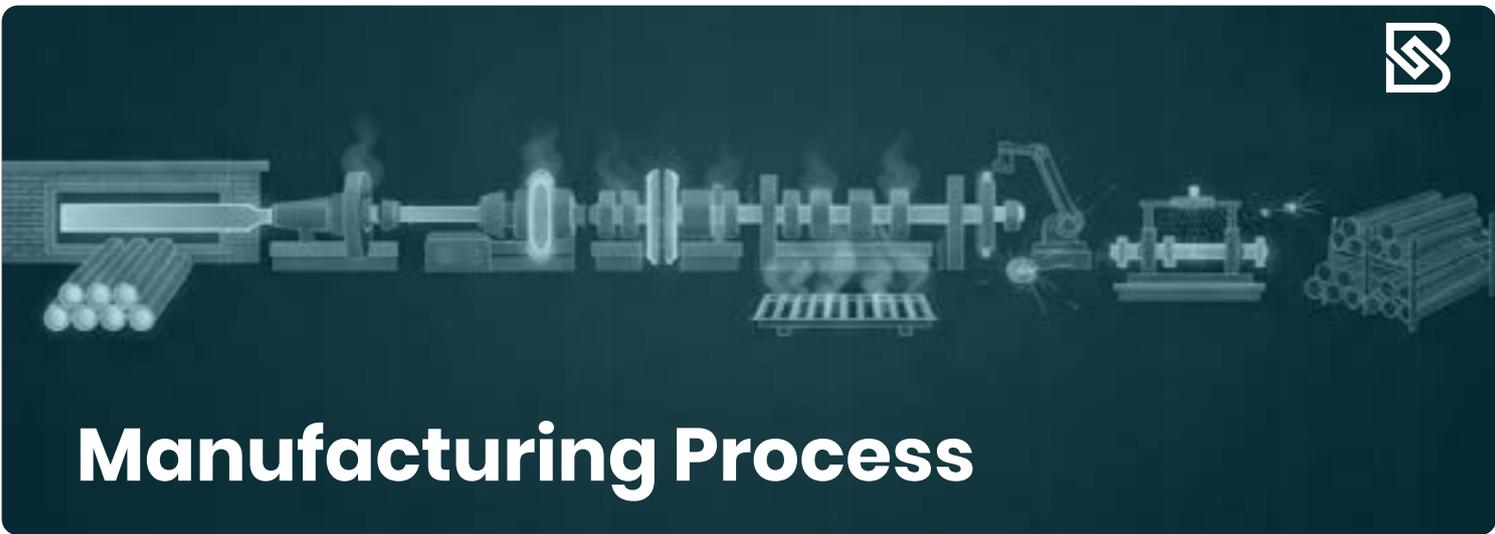
**Stainless Steel Tubes / Pipes Size:**

ASTM A269 Gr. TP 304 & 304 L / TP 310 / TP 316 & 316L / TP 321

OD	WT															
	1.50	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00	6.50	7.00	7.50	8.00		
12.00																
14.00																
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63.50																
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76.00																

ASTM A312 Gr. TP 304 & 304 L / TP 310 / TP 316 & 316L / TP 321

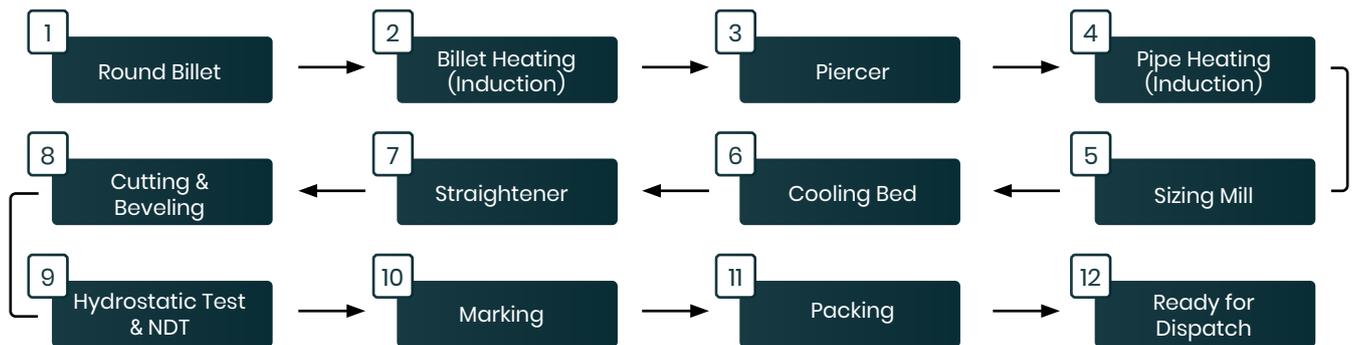
OD	WT													
	2.30	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00	6.50	7.00	7.50	8.00	
17.10														
21.34														
26.67														
33.40														
42.16														
48.26														
60.33														



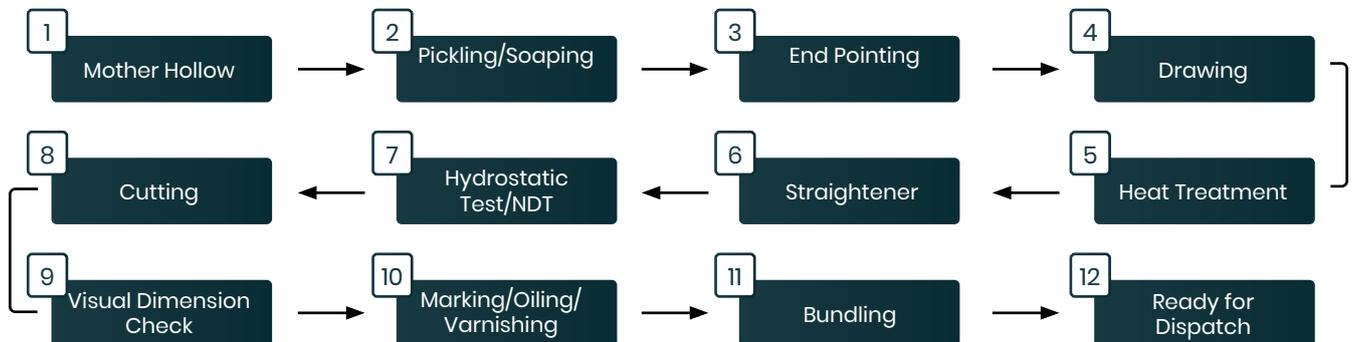
# Manufacturing Process

BSPL holds a distinct edge in the industry: with both hot-finishing & cold-drawn manufacturing processes integrated within a single facility, we offer unmatched precision & quality at every stage of production.

## Hot Finishing Process for MS:

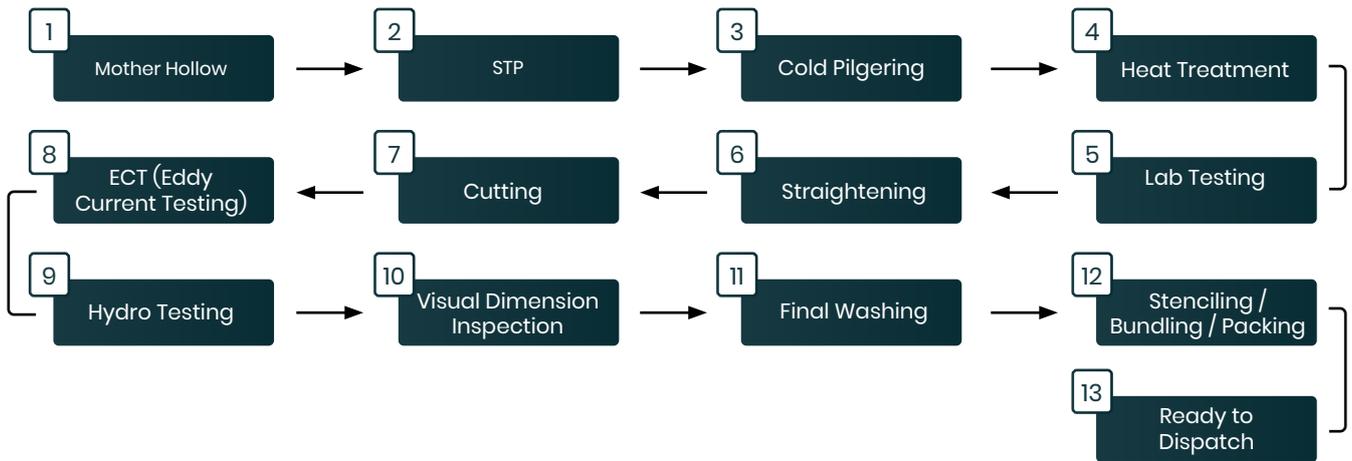


## Cold Finishing Process:

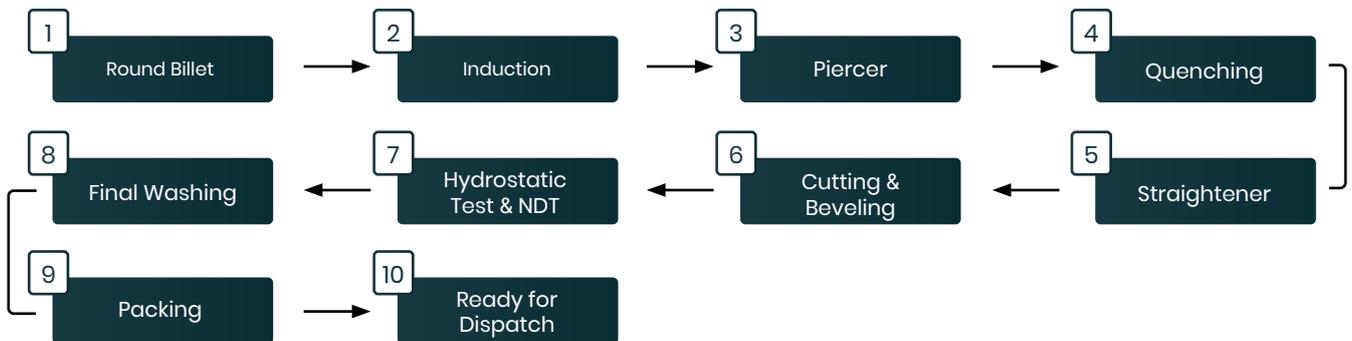




## Cold Process Stainless Steel Tubes/ Pipes



## Hot Process for SS



Manufacturing Route	
<b>HFS</b>	<b>CDS</b>
Centre Drilling	Hollow from Hot Mill
Peeling Machine	STP Process - 11 tank
Circular saw cutting machine	Cold drawing - 3 automated benches (30 MT - 1, 40 MT triple - 1, 40MT - 1)
Billet Heating Induction	Heat Treatment - Bright Annealing 2MT/hour)
Piercing Mill	Straightening - 1 nos. 10 roll straightening machine
Pipe Heating Induction	Cutting - and 3 nos. end cutters
Sizing -18 strand sizing mill	
Cooling- Motorized cooling Bed	
Straightening -10 Roll online Straightener	
<b>Finishing (HFS &amp; CDS combined)</b>	
Eddy Current Testing - 1 nos.	
Visual Dimension Inspection equipment	
Hydrostatic Testing Machine	
Coating - automated varnishing, oiling, red oxide	
Stenciling - online	
Packing machine	
Polishing Machine	
ID Grinding Machine	



# Inspection Centre

Our state-of-the-art inspection & testing centre empowers us to maintain superior quality of finished products. We closely inspect Billets, Mother Hollow & finished pipes/tubes for physical aspects, such as their roundness, outer diameter, wall thickness, surface roughness, porosity, inclusion rating etc.

Our testing laboratory has 14 sets of test equipment, including Universal Testing M/G, Optical Emission Spectrometer, Flattening Test Units, Hydraulic Test Unit & Ultrasonic Flaw Detection Units used in the production workshop.

Our Inspection Centre is equipped with advanced testing instruments like:

- **Hydrostatic Tester:**

Tubes & pipes are tested hydrostatically up to 5000 PSI in a heavy-duty PLC-based unit, guided by relevant industry standards

- **Eddy Current Tester:**

An offline SCADA-based testing system is used to detect subsurface & surface defects, based on the customer's tolerance requirements

- **Metallurgical Microscope:**

Grain structure & grade confirmation are ensured using an imported Inverted Metallurgical Microscope with 100X magnification & an optical emission spectrometer

- **Mechanical Testing:**

We conduct Tensile, Flattening, Flare & Reverse Bend tests, in compliance with relevant standards, using a 600KN capacity Universal Testing Machine. Additionally, a digital Rockwell Hardness Tester is used to check the hardness of the steel products

## Key Industries & Applications

### Our Products

BSPL has a strong emphasis on meticulous planning & complete traceability across every stage of the manufacturing process for both hot & cold-finished pipes & tubes.



### HYDRAULIC TUBES

Precision-crafted steel seamless hydraulic tubes for efficient & reliable fluid power transmission.



### HEAT EXCHANGER TUBES

Specialized tubes designed for optimal heat transfer in industrial & commercial applications.



## ALLOY TUBES

High-performance alloy tubes engineered for diverse industrial applications requiring strength & corrosion resistance.

## BOILER TUBES

Robust tubes tailored for efficient heat exchange in boiler systems, ensuring reliable performance.

## LINE PIPES

Durable & corrosion-resistant pipes, ideal for transporting various fluids & gases over long distances.

## MECHANICAL & STRUCTURAL TUBES

Versatile tubes designed to meet mechanical & structural requirements in a wide range of applications.

## STAINLESS STEEL PIPES

Durable corrosion-resistant stainless steel pipes, offering hygiene for diverse industrial & residential uses.

## MINING TUBES

Rugged tubes designed to withstand harsh mining conditions, providing reliable performance in extraction & processing.

## CASING PIPE

We manufacture API 5CT Tubing & API 5CT Casing designed for extracting oil & gas from wells.

## DRILL PIPE

We offer API 5DP drilling pipe, specifically for well drilling.

## PETROLEUM CRACKING TUBE

The GB9948-1988 product is used in the manufacturing of furnace tubes, heat exchangers & pipelines in refineries.



## Typical Automotive Grades

SAE 1019, 1518, 1035, 1040, SAE 4130H, SAE 4140H, SAE 8620, 20 Mn Cr5, 16NiCr4 & ST-62-N. Other steel grades may also be used on specific request.

## Specifications

We manufacture based on standard specifications, including BS 980, DIN 2391, BS 1717, IS 1601, IS 1074, JIS Gr.6 & STK 45. In addition, we manufacture products to customized specifications, based on the specific requirements of our customers.

## Standard Packing

Each tube is oiled internally & externally before being packed into hexagonal bundles, ensuring protection against corrosion & maintaining straightness during transportation. On request, we can provide end caps & bundles can be wrapped in LDPE sheets for enhanced protection.

## Lengths

Our tubes are supplied in discrete lengths of 4 to 7 meters (or in a different range as per customer specifications). We also manufacture tubes in specified unit lengths, multiples of specified unit lengths, or in long lengths.

## Testing & Inspection

All tubes are tested in accordance with customer requirements, utilizing in-house equipment such as Eddy Current & Hydro Testing.

## Seamless Tubes For Hydraulic & Pneumatic Pressure Lines

BSPL manufactures cold-drawn precision seamless tubes for use in hydraulic pressure lines. These tubes are specially designed to withstand high static & dynamic loads, offering a long-lasting, reliable solution that reflects our expertise & quality assurance.

### Product Features



Bright annealed scale-free surfaces



Fully annealed for easy bending & flaring



Consistent quality to ensure total reliability



Manufactured from fully aluminium killed & vacuum degassed steel



## Delivery Condition

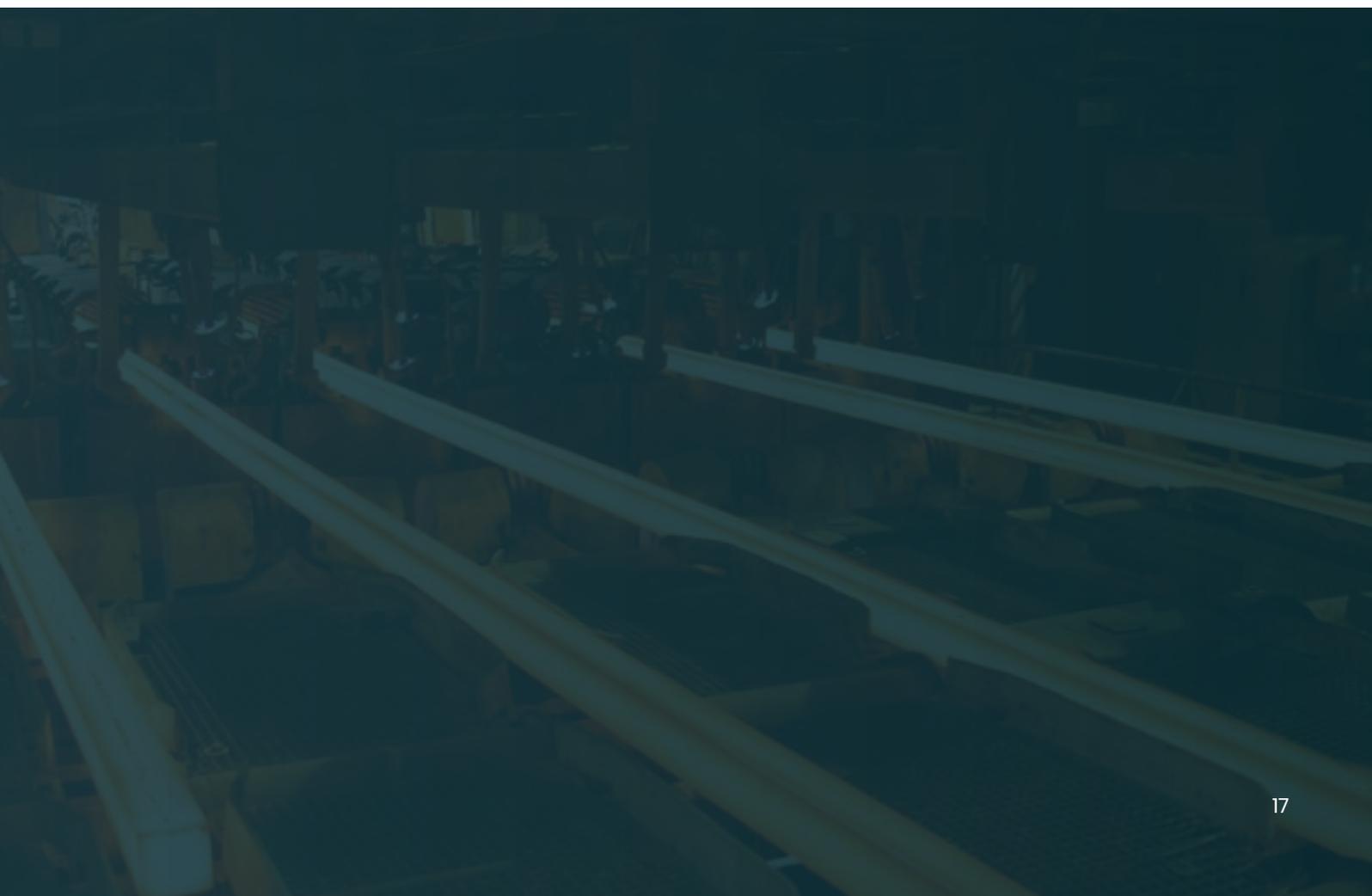
Designation	Symbol	Delivery Condition Description
Cold drawn / hard	+c(BK)	No heat treatment after the final cold drawing process
Cold drawn / soft	+LC(BKW)	After the final heat treatment, there is a suitable drawing pass
Cold drawn & stress delivered	+SR(BKS)	After the final cold drawing process, there is a stress relief heat treatment in a controlled atmosphere
Annealed	+A(GBK)	After the final cold drawing process, the tubes are annealed in a controlled atmosphere
Normal	+N(NBK)	After the final cold drawing process the tubes are normalized in a controlled atmosphere

## Standard Packing

Each tube is oiled internally & externally before being packed into hexagonal bundles, ensuring protection against corrosion & maintaining straightness during transportation. On request, we can provide end caps & bundles can be wrapped in LDPE sheets for enhanced protection.

## Customized Sizes

We offer seamless tubes with an outer diameter of up to 73 mm. In addition to standard sizes, we can produce customized sizes.





## Microstructure

The microstructure comprises grains of pearlite & ferrite, with grain size verified in accordance with ASTM E112 to ensure No. 5 or finer. Inclusion rating, conducted as per ASTM standards, is guaranteed to be better than 2.5A, 1.5C & 1.5D for both thick & thin series. Plus, the tube bore is free from isolated inclusions that can cause pinholes after brushing or honing the inner diameter.

## Lengths

Tubes are supplied in cut-to-length pieces (max. 6 meters), or as per the customer's specification, with a tolerance of (+5, -0) mm.

## Best In Class Tolerances

BSPL takes pride in offering the tightest tolerances in the industry, achieved through proprietary processes that we have developed in-house. For example, to ensure tight control over eccentricity (+/- 5%), we apply very high cross-sectional reductions during the cold-drawing process.

Similarly, we use internally developed special surface treatment processes to ensure good dimensional control & surface cleanliness after heat treatment. In the same vein, to consistently achieve a high-quality surface finish, all cold-draw tooling is manufactured from advanced materials such as Tungsten Carbide or coated with TiN. For applications that demand a superior surface finish, we also offer Bright Annealed tubes.



# Why Choose Bhuleshwar Seamless Pipes

## **Utmost Strength:**

The lowest levels of sulphur & phosphorus give our pipes a strong, hard outer surface with a flexible core.

## **Lifelong Stability:**

By leveraging sponge iron & billets in our manufacturing, our seamless tubes & pipes offer superior rust resistance & peace of mind.

## **Cost-effectiveness:**

Our range of seamless tubes & pipes provide value for money across industries with competitive pricing & assured long-lasting performance.

## **Integrated Manufacturing Excellence:**

As a fully integrated manufacturer handling both hot- & cold-finished pipes & tubes, we offer enhanced traceability & quality control across the manufacturing cycle.

Why choose us? Because Bhuleshwar Seamless is more than just a brand. It is a hallmark of trust, quality & enduring leadership in the steel industry.



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 **Corporate**

1st Floor, Plot No. 354, Lane No.6,  
Dattaguru Complex, Koregaon Park,  
Pune, Maharashtra 411001

 **Work Address**

Gat No.- 419/2/3, Next To Shiva Valley School,  
Chaufulla Supa Road, Off Pune - Solapur Road,  
Vill.- Deulgaongada, Tal- Daund, Pune 412203