



STAR PIPE Polska Sp. z o.o.

ul. Gdyńska 51

62-004 Czerwonak

tel. +48 61 650 49 00

fax. +48 61 812 01 31

internet www.starpipe.com.pl

STAR PIPE pipes and fittings system is designed for cold or hot medium transportation.

STAR PIPE system is mostly used as heating network placed directly in soil.

The STAR PIPE system consists of an internal service pipe for transport of medium, insulated with polyurethane foam PUR and protected by an outer polyethylene casing (PEH).

The service pipe is centered in a PEH-casing by means of polypropylene distance holders.

As standard, STAR PIPE is manufactured with a service pipe of carbon steel, galvanized steel or copper.

In special orders, manufactured on clients request, service pipe can be made of stainless steel or polyethylene (PEH).

STAR PIPE products are delivered as one complete product group, bonded system.

The group includes straight pipes and preinsulated fittings, such as bends, T-pieces, anchors, compensators and valves etc.

Furthermore, split steel fittings (joints, reduction joints, bends, T-pieces and hot tapping T-pieces) can be delivered to the bonded system, as well as a complete alarm system for surveillance of the pipe network.

Bonded external expanding system.

The polyurethane foam adheres with great strength to both the service pipe and the casing pipe.

The expansion can be absorbed in compensating bends, placed on bending of the network – it is natural compensation by: bellows compensators or one-time compensators.

Max. continued operating temperature: +140°C
(with possibility of transitory exceedance of 150°C)

Together with technological development it is possible to introduce modern solutions.

SERVICE PIPE (STEEL)

STRAIGHT PIPES

Longitudinally welded or spirally welded steel pipe

Material: P235GH, P235TR1, P235TR2
 Production: PN EN 10217-1
 PN EN 10217-2
 PN EN 10217-5
 Certificate: PN EN 10204 – 3.1B
 Welding edge: $d_z > 88,9$ mm
 PN ISO 6761

Seamless steel pipe (delivered on request)

Material: P235GH,
 Production: PN EN 10216-2
 Certificate: PN EN 10204 – 3.1B
 Welding edge: $d_z > 88,9$ mm
 PN ISO 6761

DN	OUTER DIAMETER x WALL THICKNESS	
	Steel pipes	Seamless steel pipes
20	26,9 x 2,3	26,9 x 2,3
25	33,7 x 2,6	33,7 x 2,6
32	42,4 x 2,6	42,4 x 2,6
40	48,3 x 2,6	48,3 x 2,6
50	60,3 x 2,9	60,3 x 2,9
65	76,1 x 2,9	76,1 x 2,9
80	88,9 x 3,2	88,9 x 3,2
100	114,3 x 3,6	114,3 x 3,6
125	139,7 x 3,6	139,7 x 4,0
150	168,3 x 4,0	168,3 x 4,5
200	219,1 x 4,5	219,1 x 6,3
250	273,0 x 5,0	273,0 x 6,3
300	323,9 x 5,6	323,9 x 7,1
350	355,6 x 5,6	355,6 x 8,0
400	406,4 x 6,3	406,4 x 8,8
500	508,0 x 6,3	508,0 x 11,0
600	610,0 x 7,1	610,0 x 12,5

BENDS

Dn 20-25

Coldbended seamless steel pipe.

Material: P235GH
 Production: PN EN 10216-2
 Certificate: PN EN 10204 – 3.1B
 Bending radius: 3 x D
 Wall thickness: same as straight pipes

Dn 32-80

Coldbended longitudinally welded steel pipe.

Material: P235GH, P235TR1, P235TR2
 Production: PN EN 10217-1,
 PN EN 10217-2
 Certificate: PN EN 10204 – 3.1B
 Bending radius: 3 x D
 Wall thickness: same as straight pipes

Dn 100-125

Coldbended seamless steel pipe.

Material: P235GH
 Production: PN EN 10216-2
 Certificate: PN EN 10204 – 3.1B
 Bending radius: 3 x D
 Wall thickness: same as straight pipes

Dn 150

Seamless welded bend with longitudinally welded straight pipe.

Material: P235GH, P235TR1, P235TR2
 Production: PN EN 10216-2 (welding bends)
 PN EN 10217-1 (straight pipe pcs)
 PN EN 10217-2 (straight pipe pieces)
 Certificate: PN EN 10204 – 3.1B
 Bending radius: 1,5 x D
 Wall thickness: same as straight pipes

Dn 200-600

Longitudinally welded bends with longitudinally welded or spirally welded straight pipe pieces.

Material: P235GH, P235TR1, P235TR2
 Production: PN EN 10217-1
 PN EN 10217-2
 PN EN 10217-5
 Certificate: PN EN 10204 – 3.1B
 Bending radius: 1,5 x D
 Wall thickness: same as straight pipes

T-pieces

Longitudinally welded or spirally welded steel pipe (DN 100-125 – seamless steel pipe)

MAIN PIPE

Material: P235GH, P235TR1, P235TR2
 Production: PN EN 10216-2
 PN EN 10217-1
 PN EN 10217-2
 PN EN 10217-5
 Certificate: PN EN 10204 – 3.1B
 Wall thickness: same as seamless steel pipes

BRANCH

Production: same as bends
 Wall thickness: Same as seamless steel pipes

COMPENSATORS, VALVES

Longitudinally or spirally welded steel pipe.

Material: P235GH, P235TR1, P235TR2
 Production: PN EN 10217-1
 PN EN 10217-2
 PN EN 10217-5
 Certificate: PN EN 10204 – 3.1B
 Wall thickness: same as straight pipes

ATTENTION: Bends DN 150-500 can be produced as bent. Other materials on a request.

GALVANIZED PIPES

STRAIGHT PIPES Welded galvanized pipes
Material: St 0, St 33
Production: DIN 2440
Galvanizing: DIN 2440

DIMENSIONS / WALL THICKNESS STRAIGHT PIPES	
Dn	Galvanized steel pipe
20	26,9 x 2,65
25	33,7 x 3,25
32	42,4 x 3,25
40	48,3 x 3,25
50	60,3 x 3,65
65	76,1 x 3,65
80	88,9 x 4,05
100	114,3 x 4,50

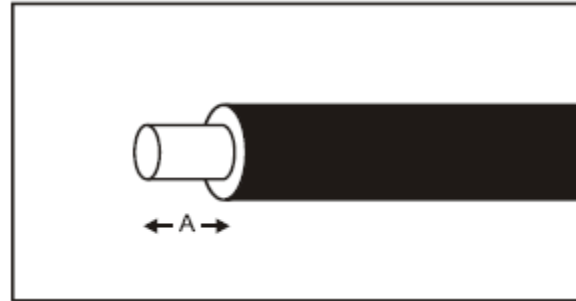
COPPER PIPES

STRAIGHT PIPES Thin-walled half-hard copper pipe.
Production: $\varnothing \leq 54$ mm – DIN 1786
 $\varnothing \geq 70$ mm - DIN 1787

DIMENSIONS / WALL THICKNESS STRAIGHT PIPES	
External diameter x wall thickness	
12,0 x 1,0	
15,0 x 1,0	
18,0 x 1,0	
22,0 x 1,0	
28,0 x 1,2	
35,0 x 1,5	
42,0 x 1,5	
54,0 x 1,5	
70,0 x 2,0	

Larger diameters on request.

EXTENDED SERVICE PIPE END



A = 150 ÷ 170 mm

INSULATION POLYURETHANE FOAM (PUR)

Polyurethane foam consists of two components: polyol and isocyanate. Mixing and dosage are made in a high-pressure system.

Density: min 60 kg/m³
 Closed cells: min 88%
 Thermal conductivity: 0,027 W/mK

CASINGS

STRAIGHT PIPES

Material: High Density Polyethylene (PEHD)
Production: EN253
Treatment: Corona treatment

DIMENSIONS / WALL THICKNESSES PEH-casing – straight pipes	
External Ø	Wall thickness
90	3,0
110	3,0
125	3,0
140	3,0
160	3,0
180	3,0
200	3,2
225	3,4
250	3,6
280	3,9
315	4,1
355	4,5
400	4,8
450	5,2
500	5,6
560	6,0
630	6,6
710	7,2
800	7,9
900	8,7
1000	9,4

FITTINGS

Material: High Density Polyethylene (PEHD)
Production: EN448
Treatment: Corona treatment

DIMENSIONS / WALL THICKNESSES PEH-casing - fittings	
External Ø	Wall thickness
90	3,0
110	3,0
125	3,5
140	3,7
160	3,9
180	4,4
200	4,5
225	5,0
250	5,5
280	5,5
315	4,9
355	5,6
400	6,3
450	7,0
500	7,8
560	8,8
630	9,8
710	11,1
800	12,5
900	12,9
1000	13,3

SPLIT STEEL FITTINGS

Material: Steel DC06
Production: EN 10130
Wall thickness: 3mm
Coating thickness: 300÷500 µm