

PIPES FOR STRUCTURAL APPLICATIONS

UNI EN 10210 1-2

Cold formed welded structural hollow sections of non-alloy and fine grain steels

USE	Pipes for civil and industrial metal structures
STEEL GRADE	S235-S275-S355-S420-S460
PROCESSING	<ul style="list-style-type: none">➤ Seamless➤ Longitudinal welded (ERW-SAW)➤ Spiral welded
TOLERANCES	<p>OUTSIDE DIAMETER Seamless and welded: +/- 1% (min +/- 0,5mm / max +/- 10mm)</p> <p>THICKNESS</p> <ul style="list-style-type: none">• Seamless and Welded + not specified, it is limited by the tolerance mass / - 10%• For the seamless hollow sections, it can be found lower values but not less than 12,5% of the nominal thickness in the gradual connection zones and not greater than 25% of the perimeter <p>OUT OF ROUNDNESS 2% for hollow sections with a ratio D/t ≤ 100</p> <p>MASS</p> <ul style="list-style-type: none">• Seamless: – 6% / +8% on individual delivered length• Welded: +/- 6% on individual delivered length <p>STRAIGHTNESS</p> <ul style="list-style-type: none">• 0,2% on total length and no more than 3mm/m
MARKING	<p>Each hollow section shall be marked by suitable and durable methods and it must include the following information:</p> <ul style="list-style-type: none">➤ Reference standard and grade➤ Manufacturer's name or trademark➤ Diameter and thickness➤ Identification number: i.e. heat nr. and order nr.➤ Mark of the external inspection representative (where applicable) <p>Where the products are supplied in bundles, the marking shall be on a label securely attached to the bundle</p>
CERTIFICATION	UNI EN 10204
SIZE RANGE	UNI EN 10210-2