

# WELDED PIPES FOR STRUCTURAL APPLICATIONS

## UNI EN 10219 1-2

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

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**USE** Pipes for welded structures

**STEEL GRADE** S235 - S275 - S355 - S420 - S460

**PROCESSING**

- Longitudinal welded (ERW- SAW)
- Spiral welded

**TOLERANCES**

**OUTSIDE DIAMETER**  
+/- 1% (min +/- 0,5mm / max +/- 10mm)

### THICKNESS

Diameter (mm)	Tolerance (mm)
D ≤406,4	t ≤5mm +/-10%
	t >5mm +/-0,5mm
D >406,4	+/-10% (max 2mm)

### OUT OF ROUNDNESS

2% for hollow sections with a ratio D/t ≤100

### MASS

+/- 6% on individual delivered length

### STRAIGHTNESS

0,2% of total length and no more than 3mm/m

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<b>MARKING</b>	<p>Each hollow section shall be marked by suitable and durable methods and including the following information:</p> <ul style="list-style-type: none"><li>➤ Reference standard and grade</li><li>➤ Manufacturer's name or trademark</li><li>➤ Diameter and thickness</li><li>➤ Identification number: i.e. heat nr. and order nr.</li><li>➤ Mark of the external inspection representative (where applicable)</li></ul> <p>Where the products are supplied in bundles, the marking shall be on a label securely attached to the bundle</p>
<b>CERTIFICATION</b>	UNI EN 10204
<b>SIZE RANGE</b>	UNI EN 10219-2