WELDED PIPES FOR STRUCTURAL APPLICATIONS
UNI EN 10219 1-2
Cold formed welded structural hollow sections of non-alloy and fine grain steels

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

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Tolerance (mm)</th>
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</thead>
<tbody>
<tr>
<td>D ≤406,4</td>
<td>t ≤5mm +/-10%</td>
</tr>
<tr>
<td></td>
<td>t &gt;5mm +/-0,5mm</td>
</tr>
<tr>
<td>D &gt;406,4</td>
<td>+/-10% (max 2mm)</td>
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</tbody>
</table>

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
MARKING

Each hollow section shall be marked by suitable and durable methods and including the following information:

➤ 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)

Where the products are supplied in bundles, the marking shall be on a label securely attached to the bundle

CERTIFICATION

UNI EN 10204

SIZE

RANGE

UNI EN 10219-2