

HOT FINISHED SEAMLESS SQUARE AND RECTANGULAR HOLLOW SECTIONS EN 10210

MANUFACTURING PROCESS

Through the hot forming process starting from seamless round pipes, it is possible to get hollow sections with favourable static/dynamic features typical of the hot finished material. Moreover this process allows to avoid possible critical states given by a longitudinal welding and the welding beam.



DIMENSIONAL TOLERANCES

Shape

Outside dimension: $\pm 1\%$ with a minimum of ± 0.5 mm.
Wall thickness: $- 10\%$ ($- 12.5\%$ for max 25% of the perimeter).
For deviations above the nominal value, tolerances on mass rule.

Concavity and convexity of sides

On external sides: 1%.

Twist

Up to max 2 mm, plus 0.5 mm for each meter on the whole tube length.

Squareness of sides

$90^\circ \pm 1^\circ$.

External corner radius

Max 3 times the w.t.

Straightness

The max. tolerance must be $\leq 0.20\%$ on the whole tube length.

Deviations on the local straightness: max 3 mm on each meter length.

Mass

Seamless tubes: $+ 8\%$ / $- 6\%$ on the single section.