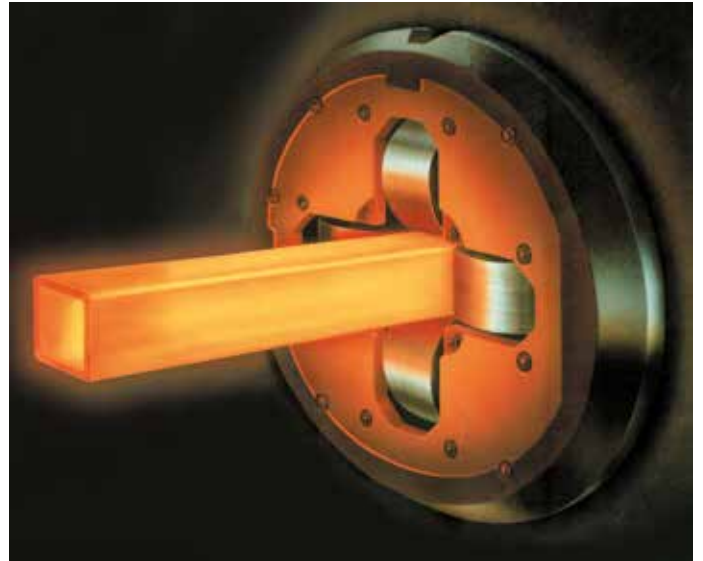


## HOT FINISHED SEAMLESS SQUARE AND RECTANGULAR HOLLOW SECTIONS EN 10210

### 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  $\pm 0.5$  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.