

HOT FINISHED WELDED SQUARE AND RECTANGULAR HOLLOW SECTIONS

THE NORM EN 10210

It defines the technical delivery conditions for hot finished (or cold finished followed by heat treatment) square, circular and rectangular hollow sections.



DIMENSIONAL TOLERANCES

Shape

Outside dimension: $\pm 1\%$ with a minimum of ± 0.5 mm

Wall thickness: $- 10\%$

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.