



chinchurreta

FABRICACIÓN DE TUBOS Y PERFILES

STRUCTURAL HOLLOW SECTIONS

TECHNICAL CHARACTERISTICS

Produces a wide range of Structural Hollow sections, circular, square and rectangular.

The final product, has a good superficial finish and a clean cut.

The steel used is:

· Hot rolled, black (not pickled).

MANUFACTURING STANDARDS

The manufacture has been based on the following standards:

Structuctural Hollow Sections: EN 10219

COMMERCIAL LENGTH

Commercial length of 6 m. The lenghts to manufacturate may be between 4 m. and 16m.



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Steel designation	% maximum by mass					
	C	Si	Mn	P	S	N
S 235 JR	0,20		1,40	0,045	0,045	0,009
S 275 JR	0,21		1,50	0,045	0,045	0,009
S 355 JR	0,24	0,55	1,60	0,045	0,045	0,009

Mechanical properties of non-alloy steel Structural Hollow Sections.

Steel designation	Minimum yield strength	Tensite strength		Minimum elongation	Impact properties		
	N/mm ²	N/mm ²		%	Test temperature °C	Minimum average absorbed energy for standard test prieces	
	Nominal thickness	Nominal thickness		Nominal thickness			
T ≤ 16 mm	T ≤ 3 mm	3 mm ≤ T ≤ 40 mm		T ≤ 40 mm			
S 235 JR	235	360/510	340/470		26	20	0,009
(*S 275 JR	275	430/580	410/560		20	20	0,009
S 355 JR	355	510/680	490/630		20	20	0,009

TOLERANCES ON LENGTH

Type of length	Range in mm	Tolerance
Random length	Of 4.000 to 16.000 with a range of 2.000 per order item..	10% of sections supplied may be bellow the minimum for the ordered range but not less than 75% of the minimum of the range.



Type of length

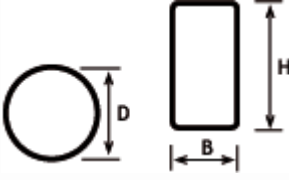
Range in mm

Tolerance

Aproximate length	≥ 4.000	+50 mm 0 mm
Exact length	< 6.000	+5mm 0 mm
	≥ 6.000 a ≤ 10.000	+15 mm 0 mm
	> 10.000	+5 mm + 1 mm/m 0 mm + 1 mm/m

• The purchaser shall indicate in the enquiry or in the order the type of length required and the length range or length required as appropriate.

TOLERANCES. CHARACTERISTIC AND DIMENSIONS.

Characteristic	Tolerances		
	Circular hollow sections	Square and rectangular hollow sections	
OUTSIDE DIAMETER	$\pm 1\%$ with a minimum of $\pm 0,5$ mm	Side length mm Tolerance	
	and a maximum of ± 10 mm	H, B < 100	$\pm 1\%$ with a minimum of $\pm 0,5$ mm
		100 \leq H, B \leq 200	$\pm 0,8\%$

Characteristics

Tolerances



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Characteristics

Tolerances

	Circular hollow sections	Square and rectangular hollow sections	
		Side length mm	Tolerance
STRAIGHTNESS			
	±6% of total length		±6% on individual lengths

- 1) The tolerance on convexity and concavity is independent of the tolerance on outside dimensions.
- 2) The radius need not be tangencial to the sides.