



Nederlandse norm

NEN-EN 10210-2

(en)

Warmvervaardigde buisprofielen voor
constructiedoeleinden - Deel 2: Toleranties,
afmetingen en profieigenschappen

Hot finished steel structural hollow sections - Part
2: Tolerances, dimensions and sectional
properties

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Voorbeeld
 Preview

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EUROPEAN STANDARD

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NORME EUROPÉENNE

EUROPÄISCHE NORM

May 2019

ICS 77.140.75

Supersedes EN 10210-2:2006

English Version

Hot finished steel structural hollow sections - Part 2: Tolerances, dimensions and sectional properties

Profilis creux de construction finis à chaud en aciers -
Partie 2 : Tolérances, dimensions et caractéristiques de
section

Warmgefertigte Hohlprofile für den Stahlbau - Teil 2:
Grenzabmaße, Maße und statische Werte

This European Standard was approved by CEN on 20 March 2019.

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Contents

Page

European foreword	3
1 Scope	4
2 Normative references	4
3 Terms and definitions	4
4 Symbols	4
5 Information to be obtained by the manufacturer	6
6 Tolerances	6
7 Measurement of size and shape	8
8 Dimensions and sectional properties	13
Annex A (normative) Formulae for the calculation of sectional properties	14
A.1 General	14
A.2 Circular hollow sections	14
A.3 Rectangular, including square, hollow sections	15
A.4 Elliptical hollow sections	17
Annex B (normative) Sectional properties for a limited range of standard sizes	19

European foreword

This document (EN 10210-2:2019) has been prepared by Technical Committee CEN/TC 459 “ECISS - European Committee for Iron and Steel Standardization”¹, the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by November 2019, and conflicting national standards shall be withdrawn at the latest by November 2019.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 10210-2:2006.

The main changes with respect to the previous edition are listed below:

- a) paragraph 5.2 two options were added;
- b) in Table 2 the mass tolerances were changed;
- c) Figure 2 was updated;
- d) for Tables B.1, B.2 and B.3 larger sizes and wall thicknesses were added;
- e) standard was editorially revised.

This standard consists of the following parts:

- EN 10368, *Steel structural hollow sections — General (Characteristics, evaluation of conformity and marking)* (in preparation)
- EN 10210-1, *Hot finished steel structural hollow sections — Part 1: Technical delivery conditions*
- EN 10210-2, *Hot finished steel structural hollow sections — Part 2: Tolerances, dimensions and sectional properties*
- EN 10210-3, *Hot finished steel structural hollow sections — Part 3: Technical delivery conditions for mechanical engineering purposes* (in preparation)

It forms part of a series of standards on hollow sections together with EN 10219-1 to EN 10219-3.

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¹ Through its subcommittee SC 3 “Structural steels other than reinforcements” (secretariat: DIN)

EN 10210-2:2019 (E)**1 Scope**

This document specifies tolerances for hot finished circular, square, rectangular and elliptical structural hollow sections, manufactured in wall thicknesses up to 120 mm, in the following size ranges:

- Circular: Outside diameters up to 2 500 mm;
- Square: Outside dimensions up to 800 mm × 800 mm;
- Rectangular: Outside dimensions up to 750 mm × 500 mm;
- Elliptical: Outside dimensions up to 500 mm × 250 mm.

The formulae for calculating sectional properties of sections manufactured to the dimensional tolerances of this standard, to be used for the purposes of structural design, are given in Annex A.

Dimensions and sectional properties for a limited range covering the more common sizes are given in Annex B.

NOTE The designation of the sections' major axis (yy) and minor axis (zz) aligns with the axis designation used for structural design in the structural Eurocodes.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 10210-1, *Hot finished structural hollow sections of non alloy and fine grain steels — Part 1: Technical delivery conditions*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 10210-1 apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

4 Symbols

For the purposes of this document, the symbols defined in Table 1 apply.

Table 1 — Symbols and definitions

Symbol	Unit	Definition
A	cm ²	Cross-sectional area
A_m	mm ²	Area of the surface delimited by the perimeter at mid-thickness
A_s	m ² /m	Superficial area per metre length
B	mm	Specified side dimension of a square hollow section. Specified dimension of the shorter side of a rectangular

Symbol	Unit	Definition
		hollow section. Specified outside dimension of an elliptical section on its minor axis
C_1/C_2	mm	Length of corner region of a square or rectangular hollow section
C_t	cm ³	Torsional modulus constant
D	mm	Specified outside diameter of a circular hollow section
D_{max}/D_{min}	mm	Maximum and minimum outside diameter of a circular hollow section measured in the same plane
e	mm	Deviation from straightness
H	mm	Specified dimension of the longer side of a rectangular hollow section. Specified outside dimension of an elliptical section on its major axis
I	cm ⁴	Second moment of area
I_t	cm ⁴	Torsional inertia constant (polar moment of inertia in the case of circular hollow sections only)
i	cm	Radius of gyration
L	mm	Length
M	kg/m	Mass per unit length
O	%	Out-of-roundness
P	mm	External perimeter of an elliptical hollow section
R	mm	External corner radius of a square or rectangular hollow section
T	mm	Specified thickness
U	mm	Perimeter of an elliptical hollow section at mid-thickness
V	mm	Total measured twist
V_1	mm	Twist measured at one end of a section
W_{el}	cm ³	Elastic section modulus
W_{pl}	cm ³	Plastic section modulus
x_1	mm	Concavity of a side of a square or rectangular hollow section
x_2	mm	Convexity of a side of a square or rectangular hollow section
yy	—	Axis of cross-section, major axis of a rectangular hollow section
zz	—	Axis of cross-section, minor axis of a rectangular hollow section
θ	°	Angle between adjacent sides of a square or rectangular hollow section

EN 10210-2:2019 (E)**5 Information to be obtained by the manufacturer****5.1 Mandatory information**

The following mandatory information from this part of EN 10210 shall be obtained by the manufacturer at the time of enquiry and order:

- a) the dimensions (see Clause 8);
- b) the type of length, length range or length (see Table 3).

NOTE This information is included in the list of information to be obtained by the manufacturer contained in EN 10210-1.

5.2 Options

Options are specified in this part of EN 10210. In the event that the purchaser does not indicate a wish to implement one of these options at the time of enquiry and order, the manufacturer shall supply in accordance with the basic specification.

- Option 2.1 The tolerance on approximate length shall be $^{+150}_0$ mm (see Table 3).
- Option 2.2 Tolerance of external corner radius of 2T maximum at each corner.
- Option 2.3 Out-of-roundness tolerances for diameter to thickness ratio exceeding 100 (see Table 2, footnote d).

6 Tolerances

6.1 Tolerances shall not exceed the values given in Table 2 for shape, straightness and mass, Table 3 for manufacturer's delivered length and Table 4 for the height of the internal and external weld bead of submerged arc welded hollow sections.

6.2 The internal corners of square and rectangular hollow sections shall be rounded, except in the case of EW sections for a corner containing the weld, should the weld be located in the corner region.

NOTE The internal corner profile is not specified.

Table 2 — Tolerances on shape, straightness and mass

Characteristic	Circular sections	hollow	Square and rectangular hollow sections	Elliptical hollow sections
Outside dimensions (D , B , H)	$\pm 1\%$ with a minimum of $\pm 0,5$ mm and a maximum of ± 10 mm		$\pm 1^a\%$ with a minimum of $\pm 0,5$ mm	
Thickness (T)	- 10 % ^{b c}			
Out-of-roundness (O)	2 % for hollow sections having a diameter to thickness ratio not exceeding 100 ^d		—	
Concavity/Convexity (x_1 , x_2) ^e	—		1 %	—
Squareness of side (θ)	—		$90^\circ \pm 1^\circ$	—
External corner profile (C_1 , C_2 or R) ^f	—		3T maximum at each corner	—
Twist (V)	2 mm ^a plus 0,5 mm/m length			
Straightness (e)	0,2 ^a % of total length and 3 mm over any 1 m length			
Mass (M)	- 6 % / + 8 % on individual delivered lengths			
<p>^a For elliptical hollow sections of sizes $H < 250$ mm, the permitted tolerance is twice the value given in this table.</p> <p>^b The positive deviation is limited by the tolerance on mass.</p> <p>^c For seamless sections thicknesses of less than 10 % but not less than 12,5 % of the nominal thickness may occur in smooth transition areas over not more than 25 % of the circumference.</p> <p>^d When the diameter to thickness ratio exceeds 100, application of tolerance on out-of-roundness is not required, unless specifically agreed (see 5.2).</p> <p>^e The tolerance on convexity and concavity is independent of the tolerance on outside dimensions.</p> <p>^f The sides need not be tangential to the corner arcs.</p>				

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