

**SPECIFICATION FOR STANDARD SIZES
EN 10219-1&2:2006 SQUARE HOLLOW SECTIONS**

SQUARE HOLLOW SECTIONS																
Nominal Sizes		Wall Thickness		Weight		Pieces/bdl s	Nominal Sizes		Wall Thickness		Weight		Pieces/bdl s			
Inch	NB(MM)	Inch	MM	Kg/Mtr	lb/Ft		Inch	NB(MM)	Inch	MM	Kg/Mtr	lb/Ft				
5/8 X 5/8	16 X 16	0.047	1.2	0.53	0.355	200	31/7 x 31/7	80 x 80	0.079	2.0	4.82	3.237	36			
		0.059	1.5	0.64	0.428				0.098	2.5	5.96	4.003		36		
		0.071	1.8	0.74	0.495				0.118	3.0	7.07	4.751			36	
		0.079	2.0	0.80	0.536				0.157	4.0	9.22	6.196				25
3/4X 3/4	19 x 19	0.047	1.2	0.64	0.431				200	31/7	80 x 80	0.177	4.5	10.26	6.894	
		0.059	1.5	0.78	0.523							0.197	5.0	11.30	7.594	20
		0.071	1.8	0.91	0.609				0.236	6.0	13.20	8.871	16			
		0.079	2.0	0.99	0.663				0.315	8.0	16.40	11.022		12		
		0.098	2.5	1.17	0.785		0.079	2.0	6.07	4.081	20					
		0.118	3.0	1.33	0.890		0.098	2.5	7.53	5.058		20				
1 x 1	25 x 25	0.047	1.2	0.87	0.583		150	4 x 4	100 x 100	0.118	3.0		8.96	6.022	20	
		0.059	1.5	1.06	0.713					0.157	4.0	11.70	7.863	20		
		0.071	1.8	1.25	0.837	0.177				4.5	13.08	8.793	16			
		0.079	2.0	1.36	0.914	0.197				5.0	14.40	9.677		16		
		0.091	2.3	1.53	1.030	0.217				5.5	15.71	10.556	12			
		0.098	2.5	1.64	1.102	0.236				6.0	17.00	11.425		12		
		0.118	3.0	1.89	1.270	0.315				8.0	21.40	14.382	9			
		0.354	9.0	23.53	15.813	0.354				9.0	23.53	15.813		9		
11/5 x 11/5	30 x 30	0.047	1.2	1.06	0.710	100		4 11/16 x 4 11/16	120 x120	0.098	2.5	9.10	6.116		20	
		0.059	1.5	1.30	0.871					0.118	3.0	10.80	7.258	20		
		0.071	1.8	1.53	1.027					0.157	4.0	14.20	9.543		16	
		0.079	2.0	1.68	1.129					0.197	5.0	17.50	11.761	12		
		0.098	2.5	2.03	1.364					0.236	6.0	20.70	13.911		12	
		0.118	3.0	2.36	1.586					0.315	8.0	26.40	17.742	9		
		0.157	4.0	2.94	1.977					0.354	9.0	29.19	19.617		9	
11/8 x 1 1/8	38 x 38	0.059	1.5	1.67	1.124	100		5 x 5	125 x	0.098	2.5	9.49	6.378	20		
		0.071	1.8	1.98	1.331		80									

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TOLERANCES :-							
CHARACTERISTIC		SQUARE HOLLOW SECTIONS					
OUT SIDE DIMENSION S (B)	Side Length(mm)	Tolerance					
	B<100	± 1% with a min. ± 0.5mm					
	100≤B≤200	± 0.8%					
	B>200	± 0.6%					
THICKNESS	± 10% for thickness ≤ 5.0mm & ± 0.5mm for Thickness >5.0mm						
CONCAVITY/ FLATNESS	Max. 0.8% with a min. of 0.5mm						
SQUARENESS OF SIDE	90° ± 1°						
EXTERNAL CORNER PROFILE	T≤6.0mm - 1.6T to 2.4T, 6.0 <T≤10.0mm - 2.0T to 3.0T, T>10.0mm - 2.4T to 3.6T						
TWIST	2.0 mm + 0.5mm/m length						
STRAIGHTNESS	0.15% of total length and 3.0 mm over any 1m length						
MASS PER UNIT LENGTH	± 6% on individual delivered length						
CHEMICAL COMPOSITION							
GRADE	Chemical composition % max.						
	C	Si	Mn	P	S	N	Carbon Equivalent(CEV)
S235JRH	0.17	--	1.40	0.040	0.040	0.009	0.35
S275J0H	0.20	--	1.50	0.035	0.035	0.009	0.40
S275J2H	0.20	--	1.50	0.030	0.030	--	0.40

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S355J0H	0.22	0.55	1.60	0.035	0.035	0.009	0.45
S355J2H	0.22	0.55	1.60	0.030	0.030	--	0.45

Carbon Equivalent : Max carbon equivalent shall

be $CEV = C + (Mn / 6) + (Cr + Mo + V) / 5 + (Ni +$

$Cu) / 15$ MECHANICAL PROPERTIES

GRADE	Min. Yield Strength R_{eh} (Mpa)	Tensile Strength R_m (MPa)		Elongatio n % Min.	Min. Impact		
		Thk<3 mm	Thk≥3 mm		-20°C	0°C	20°C
S235JRH	235	360-510	360-510	24	--	--	--
S275J0H	275	430-580	410-560	20	--	27	27
S275J2H	275	430-580	410-560	20	27	--	--
S355J0H	355	510-680	470-630	20	--	27	27
S355J2H	355	510-680	470-630	20	27	--	--

WORKMANSHIP-Free from overlap, Lamination,tool/roll marks,pin holes,open seam & other harmful defect.

PACKING-Box Type

MILL TEST CERTIFICATE-We can issue a MTC, Certifying that the tubes supplied comply with this standard.