



Designation: **A1065/A1065M – 15 A1065/A1065M – 18**

# Standard Specification for Cold-Formed Electric-Fusion (Arc) Welded High-Strength Low-Alloy Structural Tubing in Shapes, with 50 ksi [345 MPa] Minimum Yield Point<sup>1</sup>

This standard is issued under the fixed designation A1065/A1065M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope\*

1.1 This specification covers three Types and two Grades of cold formed electric-fusion (arc) welded high-strength low-alloy steel tubing of 50 ksi [345 MPa] minimum yield point for use in welded or bolted construction of buildings and for general structural purposes.

1.2 This tubing is produced in square and rectangular sizes with a periphery of 200 in. [500 cm] or less and a specified wall thickness of 1.00 in. [25 mm] or less. Tubes are joined by two longitudinal electric-fusion (arc) welds. Circumferential welds are disallowed. Sizes outside of those listed in **Tables 4 and 5** may be ordered provided all other requirements of the specification are met. Typical lengths are 15 to 50 ft-ft [5 to 15 m].

NOTE 1—Products manufactured to this specification may not be suitable for those applications such as dynamically loaded elements in welded structures, etc. where low-temperature toughness properties may be important. (See Supplementary Requirement S1.)

1.3 This specification covers the following Types:

1.3.1 *Type 1*—Welded with backing, backing left in the product,

1.3.2 *Type 2*—Welded with backing, backing removed,

1.3.3 *Type 3*—Welded without backing.

1.4 Tubing is available in Grades 50 [345] and 50W [345W]. Grade 50 [345] is manufactured from high-strength low-alloy steel. Grade 50W [345W] is manufactured from high-strength low-alloy steel with enhanced atmospheric corrosion resistance. (See **10.1.2**) The Grades may not be interchanged without approval of the purchaser. ASTM Specifications for plate that may be applied to Grade 50 [345] and 50W [345W] are listed in Reference Documents and in **Table 1**.

1.5 This specification is expressed in both inch-pound units and in SI units; however, unless the purchase order or contract specifies the applicable M specification designation (SI units), the inch-pound units shall apply. The values stated in either SI units or inch-pound units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in nonconformance with the standard.

1.6 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.7 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

## 2. Referenced Documents

2.1 *ASTM Standards:*<sup>2</sup>

**A6/A6M Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling**

**A242/A242M Specification for High-Strength Low-Alloy Structural Steel**

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.09 on Carbon Steel Tubular Products.

Current edition approved May 1, 2015; Sept. 1, 2018. Published May 2015; September 2018. Originally approved in 2009. Last previous edition approved in 2014 as A1065/A1065M-15, 15 (2014). DOI: 10.1520/A1065\_A1065M-15; DOI: 10.1520/A1065\_A1065M-18.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

\*A Summary of Changes section appears at the end of this standard



**TABLE 1 ASTM Plate Specifications<sup>A</sup>**

|                 |  |
|-----------------|--|
| Grade 50 [345]  | A572/A572M, A656/A656M, A709/A709M, A945/A945M |
| Grade 50W [345] | A242/A242M, A588/A588M, A709/A709M HPS 50W     |

<sup>A</sup>Individual specifications may have more than one Grade or Type and provide chemical requirements.

**TABLE 2 Tensile Requirements**

|                                     | Grade 50 [345] | Grade 50W [345W] |
|-------------------------------------|----------------|------------------|
| Tensile strength, min, psi [MPa]    | 60 000 [415]   | 70 000 [480]     |
| Yield strength, min, psi [MPa]      | 50 000 [345]   | 50 000 [345]     |
| Elongation in 2 in. [50 mm], min. % | 21             | 21               |

[A572/A572M Specification for High-Strength Low-Alloy Columbium-Vanadium Structural Steel](#)

[A588/A588M Specification for High-Strength Low-Alloy Structural Steel, up to 50 ksi \[345 MPa\] Minimum Yield Point, with Atmospheric Corrosion Resistance](#)

[A656/A656M Specification for Hot-Rolled Structural Steel, High-Strength Low-Alloy Plate with Improved Formability](#)

[A700 Guide for Packaging, Marking, and Loading Methods for Steel Products for Shipment](#)

[A709/A709M Specification for Structural Steel for Bridges](#)

[A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys](#)

[A945/A945M Specification for High-Strength Low-Alloy Structural Steel Plate with Low Carbon and Restricted Sulfur for Improved Weldability, Formability, and Toughness](#)

[G101 Guide for Estimating the Atmospheric Corrosion Resistance of Low-Alloy Steels](#)

2.2 *AWS Standard*<sup>3</sup>

[AWS D1.1 Structural Welding Code-Steel](#)

2.3 *Military Standard*<sup>4</sup>

[MIL-STD-129 Marking for Shipment and Storage](#)

2.4 *Federal Standard*<sup>4</sup>

[Fed. Std. No. 123 Marking for Shipment](#)

2.5 *Steel Tube Institute*<sup>5</sup>

[Hollow Structural Sections](#)

2.6 *AISC*<sup>6</sup>

[Manual of Steel Construction](#)

### 3. Terminology

3.1 *Definitions*—For definitions of terms used in this specification, refer to Terminology [A941](#).

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *HSS*<sup>5</sup>, *n*—a Hollow Structural Section is a cold-formed welded steel tube used for welded or bolted construction of buildings, bridges and other structures.

3.2.2 *electric fusion (arc) welded, n*—a welding process that uses an electric arc as the source of heat to melt and join metals.

3.2.3 *weld reinforcement, n*—that portion of the weld seam above the plane of the plate surface.

### 4. Ordering Information

4.1 Orders for material under this specification shall contain the following mandatory information:

4.1.1 Size (outside dimensions, thickness and length),

4.1.2 Name Cold Formed Arc Welded HSLA Structural Tubing,

4.1.3 Quantity (number of lengths of each size),

4.1.4 Type (1, 2, or 3),

4.1.5 Grade 50 [345] or Grade 50W [345W],

<sup>3</sup> Available from American Welding Society (AWS), 550 NW LeJeune Rd., Miami, FL 33126, <http://www.aws.org>.

<sup>4</sup> Available from Global Engineering Documents, 15 Inverness Way, East Englewood, CO 80112-5704, <http://www.global.ihs.com>.

<sup>5</sup> Available from Steel Tube Institute of North America, 2000 Ponce de Leon, Suite 600, Coral Gables, FL 33134.

<sup>6</sup> Available from American Institute of Steel Construction (AISC), One E. Wacker Dr., Suite 700, Chicago, IL 60601-2001, <http://www.aisc.org>.



TABLE 3 Permissible Variations in Outside Flat Dimensions

| Nominal Outside Large Flat Dimension  | Permissible Variation Over and Under Nominal Outside Flat Dimensions |
|---|--|
| Squares and rectangles with a large flat to small flat ratio less than 3.0    | 0.015 times each flat dimension                                      |
| Rectangles with a large flat to small flat ratio equal to or greater than 3.0 | 0.02 times each flat dimension                                       |

TABLE 4 Wall Thicknesses for Square Shapes<sup>A</sup>

| Wall in./mm           | 0.313 [8] | 0.375 [10] | 0.500 [13] | 0.625 [16] | 0.750 [19] | 1.000 [25] |
|-----------------------|-----------|------------|------------|------------|------------|------------|
| 12 × 12 [300 × 300]   | X         | X          | X          | X          | X          | X          |
| 13 × 13 [330 × 330]   | X         | X          | X          | X          | X          | X          |
| 14 × 14 [360 × 360]   | X         | X          | X          | X          | X          | X          |
| 15 × 15 [380 × 380]   | X         | X          | X          | X          | X          | X          |
| 16 × 16 [410 × 410]   | X         | X          | X          | X          | X          | X          |
| 17 × 17 [430 × 430]   | X         | X          | X          | X          | X          | X          |
| 18 × 18 [460 × 460]   | X         | X          | X          | X          | X          | X          |
| 19 × 19 [480 × 480]   | X         | X          | X          | X          | X          | X          |
| 20 × 20 [510 × 510]   | X         | X          | X          | X          | X          | X          |
| 21 × 21 [530 × 530]   |           | X          | X          | X          | X          | X          |
| 22 × 22 [560 × 560]   |           | X          | X          | X          | X          | X          |
| 23 × 23 [580 × 580]   |           | X          | X          | X          | X          | X          |
| 24 × 24 [610 × 610]   |           | X          | X          | X          | X          | X          |
| 25 × 25 [640 × 640]   |           | X          | X          | X          | X          | X          |
| 26 × 26 [660 × 660]   |           | X          | X          | X          | X          | X          |
| 27 × 27 [690 × 690]   |           | X          | X          | X          | X          | X          |
| 28 × 28 [710 × 710]   |           | X          | X          | X          | X          | X          |
| 29 × 29 [740 × 740]   |           | X          | X          | X          | X          | X          |
| 30 × 30 [760 × 760]   |           | X          | X          | X          | X          | X          |
| 31 × 31 [790 × 790]   |           |            | X          | X          | X          | X          |
| 32 × 32 [810 × 810]   |           |            | X          | X          | X          | X          |
| 33 × 33 [840 × 840]   |           |            | X          | X          | X          | X          |
| 34 × 34 [860 × 860]   |           |            | X          | X          | X          | X          |
| 35 × 35 [890 × 890]   |           |            | X          | X          | X          | X          |
| 36 × 36 [910 × 910]   |           |            | X          | X          | X          | X          |
| 37 × 37 [940 × 940]   |           |            | X          | X          | X          | X          |
| 38 × 38 [970 × 970]   |           |            | X          | X          | X          | X          |
| 39 × 39 [990 × 990]   |           |            |            | X          | X          | X          |
| 40 × 40 [1020 × 1020] |           |            |            | X          | X          | X          |
| 41 × 41 [1040 × 1040] |           |            |            | X          | X          | X          |
| 42 × 42 [1070 × 1070] |           |            |            | X          | X          | X          |
| 43 × 43 [1090 × 1090] |           |            |            | X          | X          | X          |
| 44 × 44 [1120 × 1120] |           |            |            | X          | X          | X          |
| 45 × 45 [1140 × 1140] |           |            |            | X          | X          | X          |
| 46 × 46 [1170 × 1170] |           |            |            | X          | X          | X          |
| 47 × 47 [1190 × 1190] |           |            |            | X          | X          | X          |
| 48 × 48 [1220 × 1220] |           |            |            | X          | X          | X          |

<sup>A</sup>Consult the producer for weight per foot calculations.

4.1.6 Individual supplementary requirements, if required (Supplementary Requirements S1 to S4, inclusive).

## 5. Manufacture

5.1 The steel from which the tubing is made shall conform to Specifications [A242/A242M](#), [A572/A572M](#), [A588/A588M](#), [A656/A656M](#), [A709/A709M](#), or [A945/A945M](#). The Specifications are identified in [Table 1](#) according to Grade 50 [345] or Grade 50W [345W]. The choice of Grade and ASTM Standard steel material is at the manufacturer's option unless identified in the purchase order (See Supplementary Requirement S3).

5.2 Two equally shaped pieces of flat-rolled plate product of the same ASTM plate specification shall be press brake formed into halves of the finished size. Types 1 and 2 tubing shall have continuous backup bars tack welded to each leg of one of the half-sections. The two half sections shall be fitted together and arc welded with two seam welds to complete the tubing. Type 2 tubing shall have the backing removed after seam welding. Type 3 tubing shall be manufactured without backup bars.

5.3 The electric-fusion (arc) weld shall be deposited by the submerged arc welding process, flux cored arc welding process or gas metal arc welding process. The electrode shall be of matching strength.

5.4 Grade 50W [345W] backing shall be enhanced atmospheric corrosion resistant material. The electrode shall comply with atmospheric corrosion resistance requirements.

5.5 The standard weld shall be a partial joint penetration Single-V-groove weld with groove depth not less than eighty percent of the material thickness. For complete joint penetration welds, see Supplementary Requirement S2.