



Designation: A1110/A1110M – 21

Standard Specification for Cold-Formed Welded and Seamless Carbon Steel Structural Tubing in Rounds and Shapes with 52 KSI [360 MPa] Minimum Yield Strength and Impact Requirements¹

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1. Scope*

1.1 This specification covers cold-formed welded and seamless carbon steel round, square, rectangular, or special shape structural tubing for welded, riveted, or bolted construction of bridges and buildings, and for general structural purposes where impact properties are required.

1.2 This tubing is produced in both welded and seamless sizes with a periphery of 88 in. [2235 mm] or less, and a specified wall thickness from 0.148 in. [4 mm] up to 0.875 in. [22 mm].

1.3 The welded and seamless tubing can be supplied in two different grades each with a specified impact test temperature. Different strength levels, CVN acceptance criteria, and impact test temperatures than listed may be available. To determine their availability, the purchaser should contact the producer (see 4.1.4 and 4.1.13).

1.4 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 non-conformance with the standard. The inch-pound units shall apply unless the “M” designation of this specification is specified in the order.

1.5 The text of this specification contains notes and footnotes that provide explanatory material. Such notes and footnotes, excluding those in tables and figures, do not contain any mandatory requirements.

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 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.

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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:²

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A700 Guide for Packaging, Marking, and Loading Methods for Steel Products for Shipment

A751 Test Methods and Practices for Chemical Analysis of Steel Products

A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys

A1058 Test Methods for Mechanical Testing of Steel Products—Metric

2.2 Military Standards:

MIL-STD-129 Marking for Shipment and Storage³

2.3 Federal Standards:

Fed. Std. No. 123 Marking for Shipment³

2.4 AIAG Standard:

B-1 Bar Code Symbology Standard⁴

2.5 Steel Tube Institute Standard:⁵

Methods to Check Dimensional Tolerances on Hollow Structural Sections

3. Terminology

3.1 *Definitions*—For definitions of terms used in this specification, refer to Terminology A941.

² 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.

³ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

⁴ Available from Automotive Industry Action Group (AIAG), 26200 Lahser Rd., Suite 200, Southfield, MI 48033-7156, http://www.aiag.org.

⁵ Available from the Steel Tube Institute (STI), 2516 Waukegan Rd., STE 172, Glenview, IL 60025-1774, https://steeltubeinstitute.org.

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

4. Ordering Information

4.1 Orders for material under this specification shall contain information concerning as many of the following items as are required to describe the desired material adequately:

- 4.1.1 Quantity (feet [metres] or number of lengths),
- 4.1.2 Name of material (cold-formed tubing),
- 4.1.3 Method of manufacture (seamless or welded),
- 4.1.4 Grade (A or B) and Test Temperature (1 or 2), or other tensile strength, CVN acceptance criteria, and test temperature,
- 4.1.5 Size (outside diameter and wall thickness for round tubing, and outside dimensions and wall thickness for square and rectangular tubing),
- 4.1.6 Copper-containing steel (see **Table 1**), if applicable,
- 4.1.7 Length (random, multiple, specific; see **11.3**),
- 4.1.8 End condition (see **16.3**),
- 4.1.9 Burr removal (see **16.3**),
- 4.1.10 Certification (see **Section 18**),
- 4.1.11 ASTM specification designation and year of issue,
- 4.1.12 End use,
- 4.1.13 Special requirements, including flare testing on round tubing or other destructive weld tests to be conducted in lieu of or in addition to those specified, and
- 4.1.14 Bar coding (see **19.3**).

5. Process

5.1 The steel shall be made by one or more of the following processes: basic-oxygen or electric-furnace.

5.2 When steels of different grades are sequentially strand cast, the steel producer shall identify the resultant transition material and remove it using an established procedure that positively separates the grades.

6. Manufacture

6.1 The tubing shall be made by a seamless or welding process.

6.2 Welded tubing shall be made from flat-rolled steel by the electric-resistance-welding process. The longitudinal butt joint of welded tubing shall be welded across its thickness in such a manner that the structural design strength of the tubing section is assured.

6.3 The weld shall not be located within the radius of the corners of any shaped tube unless specified by the purchaser.

NOTE 1—Welded tubing is normally furnished without removal of the inside flash.

7. Heat Analysis

7.1 Each heat analysis shall conform to the requirements specified in **Table 1** for heat analysis.

8. Product Analysis

8.1 The tubing shall be capable of conforming to the requirements specified in **Table 1** for product analysis.

8.2 If product analyses are made, they shall be made using test specimens taken from two lengths of tubing from each lot of 500 lengths, or fraction thereof, or two pieces of flat-rolled stock from each lot of a corresponding quantity of flat-rolled stock. Methods and practices relating to chemical analysis shall be in accordance with Test Methods, Practices, and Terminology **A751**. Such product analyses shall conform to the requirements specified in **Table 1** for product analysis.

8.3 If both product analyses representing a lot fail to conform to the specified requirements, the lot shall be rejected.

8.4 If only one product analysis representing a lot fails to conform to the specified requirements, product analyses shall be made using two additional test specimens taken from the lot. Both additional product analyses shall conform to the specified requirements or the lot shall be rejected.

9. Tensile and Charpy Requirements

9.1 The material, as represented by the test specimen or specimens, shall conform to the requirements as to tensile and CVN properties prescribed in **Table 2**.

9.2 CVN Impact Tests are required for Grades A and B. The customer may select either test temperature with either grade listed in **Table 2**. The customer may also request a different test temperature and CVN acceptance criteria than listed in **Table 2**. If a temperature is not specified, then Temperature 1 is the default. The acceptance criteria for sub sized specimens shall be proportional to that of a full size bar in accordance with Test Methods and Definitions **A370** or Test Methods **A1058**.

10. Flattening and Flaring Tests

10.1 The flattening test shall be made on round structural tubing. A flaring test on round tubing up to and including 10 in.

TABLE 1 Chemical Requirements

Element	Composition, % Grade A, and B ^C	
	Heat Analysis	Product Analysis
Carbon, max ^A	0.26	0.30
Manganese, max ^A	1.35	1.40
Phosphorus, max	0.035	0.045
Sulfur, max	0.035	0.045
Copper, min ^B	0.20	0.18

^A For each reduction of 0.01 percentage point below the specified maximum for carbon, an increase of 0.06 percentage point above the specified maximum for manganese is permitted, up to a maximum of 1.50 % by heat analysis and 1.60 % by product analysis.

^B If copper-containing steel is specified in the purchase order.

^C Additional alloying elements such as Columbium, Vanadium, Titanium, or others may be added at the manufacturer's discretion to meet the tensile and CVN requirements. These additional elements shall be reported.

TABLE 2 Tensile and Charpy Requirements

	Round and Shaped Structural Tubing	
	Grade A	Grade B
Tensile strength, min, psi [MPa]	65 000 [450]	70 000 [480]
Yield strength, min, psi [MPa]	52 000 [360]	57 000 [393]
Elongation in 2 in. [50 mm], min, % ^A	19	17
Test Temperature, °F [°C]	–20 [–29]	–40 [–40]
CVN Minimum Average Impact ft-lbs [J] based on a set of 3 full sized specimens ^B	25 [34]	25 [34]

^A The minimum elongation values specified apply only to tests performed prior to shipment of the tubing.

^B See Test Methods and Definitions **A370** or Test Methods **A1058** for acceptance criteria for sub size specimens.

in diameter can be made if stated in the purchase order. Either a flattening test or a flaring test shall be made on shaped tubing with a side up to and including 10 in.

10.2 For welded round structural tubing, a test specimen at least 4 in. [100 mm] in length shall be flattened cold between parallel plates in three steps, with the weld located 90° from the line of direction of force. During the first step, which is a test for ductility of the weld, no cracks or breaks on the inside or outside surfaces of the test specimen shall be present until the distance between the plates is less than two-thirds of the specified outside diameter of the tubing. For the second step, no cracks or breaks on the inside or outside parent metal surfaces of the test specimen, except as provided for in 10.5, shall be present until the distance between the plates is less than one-half of the specified outside diameter of the tubing. During the third step, which is a test for soundness, the flattening shall be continued until the test specimen breaks or the opposite walls of the test specimen meet. Evidence of laminated or unsound material or of incomplete weld that is revealed during the entire flattening test shall be cause for rejection.

10.3 For seamless round structural tubing 2 3/8 in. [60 mm] specified outside diameter and larger, a specimen not less than 2 1/2 in. [65 mm] in length shall be flattened cold between parallel plates in two steps. During the first step, which is a test for ductility, no cracks or breaks on the inside or outside surfaces, except as provided for in 10.5, shall occur until the distance between the plates is less than the value of “H” calculated by the following equation:

$$H = (1 + e)t(e + t/D) \quad (1)$$

where:

- H = distance between flattening plates, in. [mm],
- e = deformation per unit length (0.06 for Grade A and B),
- t = specified wall thickness of tubing, in. [mm], and
- D = specified outside diameter of tubing, in. [mm].

During the second step, which is a test for soundness, the flattening shall be continued until the specimen breaks or the opposite walls of the specimen meet. Evidence of laminated or unsound material that is revealed during the entire flattening test shall be cause for rejection.

10.4 Surface imperfections not found in the test specimen before flattening, but revealed during the first step of the flattening test, shall be judged in accordance with Section 15.

10.5 When low D -to- t ratio tubulars are tested, because the strain imposed due to geometry is unreasonably high on the inside surface at the 6 and 12 o'clock locations, cracks at these locations shall not be cause for rejection if the D -to- t ratio is less than 10.

10.6 *Flaring Test*—A section of tube shall stand being flared with a tool having a 60° included angle until the tube has been expanded a minimum of 15 % of the largest inside dimension without any cracking in the weld area. The cone tool shall not have a weld relief groove. Cracking in the corners of shaped tubing after flaring is not grounds for rejection.

10.7 Other destructive weld tests may be requested in lieu of or in addition to the tests listed. The purchaser should contact the producer to determine their availability.

11. Permissible Variations in Dimensions

11.1 Outside Dimensions:

11.1.1 *Round Structural Tubing*—The outside diameter shall not vary more than ±0.5 %, rounded to the nearest 0.005 in. [0.1 mm], from the specified outside diameter for specified outside diameters 1.900 in. [48 mm] and smaller, and ±0.75 %, rounded to the nearest 0.005 in. [0.1 mm], from the specified outside diameter for specified outside diameters 2.00 in. [5 cm] and larger. The outside diameter measurements shall be made at positions at least 2 in. [5 cm] from the ends of the tubing.

11.1.2 *Square and Rectangular Structural Tubing*—The outside dimensions, measured across the flats at positions at least 2 in. [5 cm] from the ends of the tubing, shall not vary from the specified outside dimensions by more than the applicable amount given in Table 3, which includes an allowance for convexity or concavity.

11.2 *Wall Thickness*—The minimum wall thickness at any point of measurement on the tubing shall be not more than 10 % less than the specified wall thickness. The maximum wall thickness, excluding the weld seam of welded tubing, shall be not more than 10 % greater than the specified wall thickness. For square and rectangular tubing, the wall thickness requirements shall apply only to the centers of the flats.

11.3 *Length*—Structural tubing is normally produced in random lengths 5 ft [1.5 m] and over, in multiple lengths, and in specific lengths. Refer to Section 4. When specific lengths are ordered, the length tolerance shall be in accordance with Table 4.

11.4 *Straightness*—The permissible variation for straightness of structural tubing shall be 1/8 in. times the number of feet [10 mm times the number of metres] of total length divided by 5.

11.5 *Squareness of Sides*—For square and rectangular structural tubing, adjacent sides shall be square (90°), with a permissible variation of ±2° max.

TABLE 3 Permissible Variations in Outside Flat Dimensions for Square and Rectangular Structural Tubing

Specified Outside Large Flat Dimensions, in. [mm]	Permissible Variations Over and Under Specified Outside Flat Dimensions, ^A in. [mm]
2 1/2 [65] or under	0.020 [0.5]
Over 2 1/2 to 3 1/2 [65 to 90], incl	0.025 [0.6]
Over 3 1/2 to 5 1/2 [90 to 140], incl	0.030 [0.8]
Over 5 1/2 [140]	0.01 times large flat dimension

^A The permissible variations include allowances for convexity and concavity. For rectangular tubing having a ratio of outside large to small flat dimension less than 1.5, and for square tubing, the permissible variations in small flat dimension shall be identical to the permissible variations in large flat dimension. For rectangular tubing having a ratio of outside large to small flat dimension in the range of 1.5 to 3.0 inclusive, the permissible variations in small flat dimension shall be 1.5 times the permissible variations in large flat dimension. For rectangular tubing having a ratio of outside large to small flat dimension greater than 3.0, the permissible variations in small flat dimension shall be 2.0 times the permissible variations in large flat dimension.

TABLE 4 Length Tolerances for Specific Lengths of Structural Tubing

	22 ft [6.5 m] and Under		Over 22 ft [6.5 m]	
	Over	Under	Over	Under
Length tolerance for specific lengths, in. [mm]	1/2 [13]	1/4 [6]	3/4 [19]	1/4 [6]

11.6 *Radius of Corners*—For square and rectangular structural tubing, the radius of each outside corner of the section shall not exceed three times the specified wall thickness.

11.7 *Twist*—For square and rectangular structural tubing, the permissible variations in twist shall be as given in **Table 5**. Twist shall be determined by holding one end of the tubing down on a flat surface plate, measuring the height that each corner on the bottom side of the tubing extends above the surface plate near the opposite ends of the tubing, and calculating the twist (the difference in heights of such corners), except that for heavier sections it shall be permissible to use a suitable measuring device to determine twist. Twist measurements shall not be taken within 2 in. [5 cm] of the ends of the tubing.

12. Special Shape Structural Tubing

12.1 The availability, dimensions, and tolerances of special shape structural tubing shall be subject to inquiry and negotiation with the manufacturer.

13. Number of Tests

13.1 One tension test as specified in Section 15 shall be made from a length of tubing representing each lot.

13.2 The flattening test, as specified in Section 10, shall be made on one length of round tubing from each lot. The flare test, as specified in Section 10, shall be made on one length of shaped tubing from each lot.

13.3 One set of CVN specimens (3) as specified in Section 15 shall be made from a length of tubing representing each lot.

13.4 The term “lot” shall apply to all tubes of the same specified size that are produced from the same heat of steel.

14. Retests

14.1 If the results of the mechanical tests representing any lot fail to conform to the applicable requirements specified in Sections 9 and 10, the lot shall be rejected or retested using

additional tubing of double the original number from the lot. The lot shall be acceptable if the results of all such retests representing the lot conform to the specified requirements.

14.2 If one or both of the retests specified in 14.1 fail to conform to the applicable requirements specified in Sections 9 and 10, the lot shall be rejected or, subsequent to the manufacturer heat treating, reworking, or otherwise eliminating the condition responsible for the failure, the lot shall be treated as a new lot and tested accordingly.

15. Test Methods

15.1 Tension test specimens shall conform to the applicable requirements of Test Methods and Definitions A370, Annex A2 or Test Methods A1058.

15.2 Tension test specimens shall be full-size longitudinal test specimens or longitudinal strip test specimens. For welded tubing, any longitudinal strip test specimens shall be taken from a location at least 90° from the weld and shall be prepared without flattening in the gage length. Longitudinal strip test specimens shall have all burrs removed. Tension test specimens shall not contain surface imperfections that would interfere with proper determination of the tensile properties.

15.3 The yield strength corresponding to an offset of 0.2 % of the gage length or to a total extension under load of 0.5 % of the gage length shall be determined.

15.4 CVN Impact test specimens shall conform to the applicable requirements of Test Methods and Definitions A370 or Test Methods A1058. Subsize specimens are permitted in accordance with Test Methods and Definitions A370 or Test Methods A1058.

16. Inspection

16.1 All tubing shall be inspected at the place of manufacture to ensure conformance to the requirements of this specification. The dimensional tolerances shall be inspected in accordance with the Steel Tube Institute’s Methods to Check Dimensional Tolerances on Hollow Structural Sections.

16.2 All tubing shall be free from defects and shall have a workmanlike finish.

16.2.1 Surface imperfections shall be classed as defects when their depth reduces the remaining wall thickness to less than 90 % of the specified wall thickness. It shall be permissible for defects having a depth not in excess of 33 1/3 % of the specified wall thickness to be repaired by welding, subject to the following conditions:

16.2.1.1 The defect shall be completely removed by chipping or grinding to sound metal,

16.2.1.2 The repair weld shall be made using a low-hydrogen welding process, and

16.2.1.3 The projecting weld metal shall be removed to produce a workmanlike finish.

16.2.2 Surface imperfections such as handling marks, light die or roll marks, or shallow pits are not considered defects provided that the imperfections are removable within the specified limits on wall thickness. The removal of such surface imperfections is not required. Welded tubing shall be free of protruding metal on the outside surface of the weld seam.

TABLE 5 Permissible Variations in Twist for Square and Rectangular Structural Tubing

Specified Outside Large Flat Dimension, in. [mm]	Maximum Permissible Variations in Twist per 3 ft of Length [Twist per Metre of Length]	
	in.	[mm]
1 1/2 [40] and under	0.050	[1.3]
Over 1 1/2 to 2 1/2 [40 to 65], incl	0.062	[1.6]
Over 2 1/2 to 4 [65 to 100], incl	0.075	[1.9]
Over 4 to 6 [100 to 150], incl	0.087	[2.2]
Over 6 to 8 [150 to 200], incl	0.100	[2.5]
Over 8 [200]	0.112	[2.8]