



SLOVENSKI STANDARD
SIST EN 10225-3:2019+A1:2023

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Konstruksijska jekla za varjene konstrukcije naftnih ploščadi - Tehnični dobavni pogoji - 3. del: Vroče izdelani votli profili (vključno z dopnilom A1)

Weldable structural steels for fixed offshore structures - Technical delivery conditions - Part 3: Hot finished hollow sections

Schweißgeeignete Baustähle für feststehende Offshore-Konstruktionen - Technische Lieferbedingung - Teil 3: Warmgefertigte Hohlprofile

Aciers de construction soudables destinés à la fabrication de structures marines fixes - Conditions techniques de livraison - Partie 3 : Profils creux finis à chaud

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77.140.10	Jekla za toplotno obdelavo	Heat-treatable steels
77.140.70	Jekleni profili	Steel profiles

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Weldable structural steels for fixed offshore structures - Technical delivery conditions - Part 3: Hot finished hollow sections

Aciers de construction soudables destinés à la
fabrication de structures marines fixes - Conditions
techniques de livraison - Partie 3 : Profils creux finis à
chaud

Schweißgeeignete Baustähle für feststehende Offshore-
Konstruktionen - Technische Lieferbedingung - Teil 3:
Warmgefertigte Hohlprofile

This European Standard was approved by CEN on 23 December 2018 and includes Amendment approved by CEN on 17 April 2023.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

Contents	Page
European foreword	5
1 Scope	7
2 Normative references	7
3 Terms and definitions	9
4 Classification and designation	11
4.1 Classification	11
4.2 Designation	11
5 Information to be supplied by the purchaser	12
5.1 Mandatory information	12
5.2 Options	12
5.3 Example of an order	12
6 Manufacturing process	13
6.1 Steel manufacturing process	13
6.2 Structural hollow section manufacturing process	13
6.3 Qualification of personnel for NDT activities	13
6.4 Delivery condition	13
7 Requirements	13
7.1 General	13
7.2 Chemical composition	14
7.2.1 Heat analysis	14
7.2.2 Product analysis	14
7.2.3 Carbon equivalent values (CEV) and P_{cm}	14
7.3 Mechanical properties	14
7.3.1 General	14
7.3.2 Post weld heat treatment (PWHT)	14
7.3.3 Through thickness testing	15
7.3.4 Flattening test	15
7.3.5 Prequalification for arctic areas	15
7.4 Weldability data	15
7.5 Internal soundness and non-destructive testing	15
7.5.1 Non-destructive testing of the weld seam of HFW hollow sections	15
7.5.2 Non-destructive testing of seamless hollow sections for longitudinal imperfections	15
7.5.3 Laminar discontinuities of hollow sections	16
7.6 Surface quality	16
7.7 Dimensions, tolerances, mass	16
7.7.1 Dimensions and tolerances on dimensions and shape	16
7.7.2 Mass of steel	16
8 Inspection	17
8.1 General	17
8.2 Types of inspection documents	17
8.3 Summary of inspections	18
8.4 Intermediary supply	18
9 Frequency of testing and preparation of samples and test pieces	18
9.1 Frequency of test	18
9.1.1 Chemical analysis	18

9.1.2	Tensile test and impact test.....	19
9.1.3	Testing the weld seam of welded hollow sections.....	19
9.1.4	Testing of the corner regions for rectangular hollow sections.....	19
9.2	Selection and preparation of samples for product analysis.....	19
9.3	Location of samples and orientation of tensile test pieces.....	19
9.4	Location of samples and orientation of impact test pieces	20
9.5	Preparation of test pieces for mechanical tests.....	20
9.5.1	General	20
9.5.2	Preparation of tensile test pieces	20
9.5.3	Preparation of impact test pieces.....	20
10	Test methods.....	21
10.1	Chemical analysis	21
10.2	Mechanical tests.....	21
10.2.1	Test temperatures.....	21
10.2.2	Tensile test.....	21
10.2.3	Impact test.....	22
10.3	Visual inspection and dimensional check.....	22
10.4	Non-destructive tests	22
10.4.1	General	22
10.4.2	NDT for the weld seam of HFW hollow sections	22
10.4.3	Full peripheral NDT for seamless hollow sections.....	23
10.4.4	Ultrasonic testing for laminar imperfections.....	23
10.4.5	NDT for surface quality.....	23
10.5	Retests, sorting and reprocessing	23
11	Marking and bundling.....	23
11.1	Die stamping and paint marking.....	23
11.2	Bundling.....	23
12	Options	24
Annex A	(normative when Option 1 is specified by the purchaser) Further details of steel manufacturing procedures to be supplied by the manufacturer	37
Annex B	(normative when Option 17 is specified by the purchaser) Weldability testing and mechanical testing of butt welds.....	38
B.1	General requirements.....	38
B.2	Welding processes and procedure	38
B.3	Butt-weld requirements.....	39
B.3.1	General	39
B.3.2	Test piece dimensions.....	39
B.3.3	Bevel detail	40
B.3.4	Welding processes.....	40
B.3.5	Nominal heat input.....	40
B.3.6	Heat treatment	41
B.3.7	Dehydrogenation of test pieces	41
B.4	Mechanical testing.....	42
B.4.1	General	42
B.4.2	Charpy V-notch impact tests.....	43

EN 10225-3:2019+A1:2023 (E)

B.4.3	Fracture mechanic test	44
B.4.4	Macrohardness	45
B.4.5	Cross-weld tensile test	46
Annex C	(normative when Option 17 is specified by the purchaser) Weldability testing - Bead-on-plate	51
C.1	General	51
C.2	Test material dimension	51
C.3	Welding method	51
C.4	Test condition	51
C.5	Specific test requirements: macrosection and hardness tests	52
Annex D	(normative when Option 17 is specified by the purchaser) Weldability testing - Controlled thermal severity tests (CTS)	54
D.1	General	54
D.2	Test block dimensions	54
D.3	General welding details	54
D.3.1	Anchor welds	54
D.3.2	Test welds	54
D.4	Evaluation of the test welds	55
D.5	Hardness testing	55
Annex E	(informative) Prequalification of steels for offshore structures operating in arctic areas	61
Bibliography	62

European foreword

This document (EN 10225-3:2019+A1:2023) has been prepared by Technical Committee CEN/TC 459/SC 3 “Structural steels other than reinforcements”, the secretariat of which is held by DIN.

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 2023, and conflicting national standards shall be withdrawn at the latest by November 2023.

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.

EN 10225-3:2019, together with EN 10225-1:2019, EN 10225-2:2019, and EN 10225-4:2019, superseded EN 10225:2009.

This document EN 10225-3:2019+A1:2023 supersedes EN 10225-3:2019.

This document includes Amendment 1 approved by CEN on 7 April 2023.

The start and finish of text introduced or altered by amendment is indicated in the text by tags A1 A1.

This European Standard consists of the following parts, under the general title '*Weldable structural steels for fixed offshore structures – Technical delivery conditions*':

- Part 1: Plates
- Part 2: Sections
- Part 3: Hot finished hollow sections
- Part 4: Cold formed welded hollow sections

In comparison to the previous edition EN 10225:2009 the following technical changes were made:

- split of the standard in four parts;
- the steel names were adapted to EN 10027-1;
- former grades of group 3 are no longer listed, new options with the same enhanced properties have been introduced (*Options 2 and 3*);
- an informative Annex E was added for the prequalification of steels for fixed offshore structures in arctic areas.

Any feedback and questions on this document should be directed to the users' national standards body. A complete listing of these bodies can be found on the CEN website.

EN 10225-3:2019+A1:2023 (E)

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

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1 Scope

This document specifies requirements for weldable structural steels made of hot finished seamless and high frequency welded hollow sections to be used in the fabrication of fixed offshore structures.

The following thickness limitations are given in this standard:

- for seamless hollow sections up to and including 65 mm;
- for HFW hollow sections up to and including 25,4 mm.

Greater thicknesses can be agreed, provided the technical requirements of this European Standard are maintained.

This European Standard is applicable to steels for offshore structures, designed to operate in the offshore sector but not to steels supplied for the fabrication of subsea pipelines, risers, process equipment, process piping and other utilities. It is primarily applicable to the North Sea Sector, but may also be applicable in other areas provided that due consideration is given to local conditions e.g. design temperature.

NOTE This document has an informative Annex E on the prequalification of steels for fixed offshore structures in arctic areas.

Minimum yield strengths up to 770 MPa are specified together with impact properties at temperatures down to -40°C .

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 1011-1, *Welding — Recommendations for welding of metallic materials — Part 1: General guidance for arc welding*

EN 10020, *Definition and classification of grades of steel*

EN 10021, *General technical delivery conditions for steel products*

EN 10027-1, *Designation systems for steels — Part 1: Steel names*

EN 10027-2, *Designation systems for steels — Part 2: Numerical system*

EN 10079, *Definition of steel products*

EN 10164, *Steel products with improved deformation properties perpendicular to the surface of the product — Technical delivery conditions*

EN 10168, *Steel products — Inspection documents — List of information and description*

EN 10204, *Metallic products — Types of inspection documents*

EN 10210-2, *Hot finished structural hollow sections of non-alloy and fine grain steels — Part 2: Tolerances, dimensions and sectional properties*

CEN/TR 10261, *Iron and steel — European standards for the determination of chemical composition*

EN 10225-3:2019+A1:2023 (E)

EN ISO 148-1, *Metallic materials — Charpy pendulum impact test — Part 1: Test method (ISO 148-1)*

EN ISO 377, *Steel and steel products — Location and preparation of samples and test pieces for mechanical testing (ISO 377)*

EN ISO 643, *Steels — Micrographic determination of the apparent grain size (ISO 643)*

EN ISO 2566-1, *Steel — Conversion of elongation values — Part 1: Carbon and low alloy steels (ISO 2566-1)*

EN ISO 4063, *Welding and allied processes — Nomenclature of processes and reference numbers (ISO 4063)*

EN ISO 4136, *Destructive tests on welds in metallic materials — Transverse tensile test (ISO 4136)*

EN ISO 4885, *Ferrous materials — Heat treatments — Vocabulary (ISO 4885)*

EN ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method (ISO 6507-1)*

EN ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature (ISO 6892-1)*

EN ISO 6947, *Welding and allied processes — Welding positions (ISO 6947)*

EN ISO 8492, *Metallic materials — Tube — Flattening test (ISO 8492)*

EN ISO 9712, *Non-destructive testing — Qualification and certification of NDT personnel (ISO 9712)*

EN ISO 10893-2, *Non-destructive testing of steel tubes — Part 2: Automated eddy current testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of imperfections (ISO 10893-2)*

EN ISO 10893-3, *Non-destructive testing of steel tubes — Part 3: Automated full peripheral flux leakage testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for the detection of longitudinal and/or transverse imperfections (ISO 10893-3)*

EN ISO 10893-5, *Non-destructive testing of steel tubes — Part 5: Magnetic particle inspection of seamless and welded ferromagnetic steel tubes for the detection of surface imperfections (ISO 10893-5)*

EN ISO 10893-8, *Non-destructive testing of steel tubes — Part 8: Automated ultrasonic testing of seamless and welded steel tubes for the detection of laminar imperfections (ISO 10893-8)*

EN ISO 10893-9, *Non-destructive testing of steel tubes — Part 9: Automated ultrasonic testing for the detection of laminar imperfections in strip/plate used for the manufacture of welded steel tubes (ISO 10893-9)*

EN ISO 10893-10, *Non-destructive testing of steel tubes — Part 10: Automated full peripheral ultrasonic testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of longitudinal and/or transverse imperfections (ISO 10893-10)*

EN ISO 10893-11, *Non-destructive testing of steel tubes — Part 11: Automated ultrasonic testing of the weld seam of welded steel tubes for the detection of longitudinal and/or transverse imperfections (ISO 10893-11)*

EN ISO 14284, *Steel and iron — Sampling and preparation of samples for the determination of chemical composition (ISO 14284)*

EN ISO 15614-1, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys (ISO 15614-1)*

ISO 11484, *Steel products — Employer's qualification system for non-destructive testing (NDT) personnel*

ISO 12135, *Metallic materials — Unified method of test for the determination of quasistatic fracture toughness*

ISO 15653, *Metallic materials — Method of test for the determination of quasistatic fracture toughness of welds*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 10020, EN 10021, EN ISO 4885, EN 10079 and EN ISO 14284 and the following apply.

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

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

3.1

continuous casting process route (concast)

steel produced by a continuous casting process route

3.2

fine grain steel

steels with fine grain structure with an equivalent index of ferritic grain size ≥ 6

Note 1 to entry: For the determination of grain sizes except for +QT steels see EN ISO 643.

3.3

high frequency welded hollow section (HFW)

hollow long product, open at both ends, of circular, elliptical, square or rectangular section, made by pressure welding in a continuous or non-continuous process, in which strip is formed cold into a hollow profile and the seam weld made by heating the adjacent edges through the resistance to the passage of a high frequency current and pressing the edges together

Note 1 to entry: The electric current may be applied by direct electrode contact or by induction or conduction. After welding, the hollow section is further hot finished (see 3.4).

3.4

hot finished

for this standard: hollow sections formed hot, with or without subsequent heat treatment, or formed cold with subsequent heat treatment equal to or greater than AC3 to obtain equivalent metallurgical conditions to those obtained in the hot formed product

EN 10225-3:2019+A1:2023 (E)**3.5****intermediary**

organization that is supplied with products by the manufacturers and that then, in turn, supplies them without further processing or after processing without changing the properties specified in the purchase order and referenced product specification

3.6**manufacturer**

organization that manufactures the respective products according to the requirements of the order and to the properties specified in the referenced product specification to the final customer

3.7**normalized rolled**

rolling process in which the final deformation is carried out in a certain temperature range leading to a material condition equivalent to that obtained after normalizing so that the specified values of the mechanical properties are retained even after normalizing

Note 1 to entry: In international publications for both the normalizing rolling, as well as the thermomechanical rolling, the expression “controlled rolling” may be found. However in view of the different applicability of the products a distinction of the terms is necessary.

3.8**normalizing**

heat treatment with the object of refining and eventually making uniform the grain size of a ferrous product and comprising heating it at a temperature slightly above A_3 [A_1 for hypereutectoid steels], without prolonged soaking at this temperature, followed by cooling at a suitable rate \square_{A_1} to produce a fine ferritic-pearlitic structure $\langle A_1 \rangle$

3.9**parent product**

product produced from one piece of steel

3.10**purchaser**

purchaser or their representative

3.11**quenching**

operation which consists of cooling a ferrous product more rapidly than in still air \square_{A_1} , such cooling is intended to produce a predominantly bainitic or martensitic microstructure $\langle A_1 \rangle$

Note 1 to entry: Quenching includes direct quenching.

3.12**seamless hollow section (S)**

hollow long product, open at both ends, of circular, elliptical, square or rectangular section, made by piercing a solid product to obtain a tube hollow which is further hot finished into its final dimensions (see 3.4)

3.13**tempering**

heat treatment applied to a ferrous product generally after quenching or other heat treatment to bring the properties to the required level

Note 1 to entry: Tempering consists of heating to specific temperatures ($<A_{C1}$) and soaking one or more times followed by cooling at an appropriate rate.

A1 3.14

accelerated cooling

operation which consists of cooling a ferrous product faster than achieved in still air but with a rate less than achieved by quenching, for this document, such cooling is intended to produce a predominantly ferritic-pearlitic microstructure **A1**

4 Classification and designation

4.1 Classification

All steel grades specified in this European Standard are classified as special steels according to EN 10020.

NOTE The steel grades in this standard are substantially modified from steel grades in EN 10210-1.

4.2 Designation

4.2.1 For the products covered by this European Standard the steel names are allocated in accordance with EN 10027-1; the steel numbers are allocated in accordance with EN 10027-2.

4.2.2 For steels for offshore structures the steel designation consists of:

- the number of this European Standard (EN 10225-3);
- the capital letter S for structural steel;
- the indication of the minimum specified yield strength for thicknesses ≤ 16 mm expressed in MPa;
- further designations for either
 - normalized/normalized rolled structural steels: capital letters N - letter N to indicate normalized or normalized rolled; or
 - normalized/normalized rolled structural steels: capital letters NL - letter N to indicate normalized or normalized rolled, letter L to indicate specified impact properties at -40 °C (see 6.4); or
 - quenched and tempered structural steels: capital letters QL - capital letter Q to indicate the quenched and tempered condition, letter L to indicate specified impact properties at -40 °C (see 6.4); and
- the capital letter H for hollow sections;
- a further capital letter H for hot-finished; and
- the capital letter O for offshore structures.

EN 10225-3:2019+A1:2023 (E)

EXAMPLE 1 Structural steel (S) with a specified minimum yield strength for a thickness not greater than 16 mm of 355 MPa, normalized condition (N), with a minimum impact energy value of 50 J at $-40\text{ }^{\circ}\text{C}$ (L), hollow section hot finished (HH), for offshore application (O):

EN 10225-3 — S355NLHHO

or

EN 10225-3 — 1.1182

NOTE For a transition period the old steel names and numbers are given in Tables 3 to 8 in brackets.

5 Information to be supplied by the purchaser**5.1 Mandatory information**

The following information shall be supplied by the purchaser at the time of enquiry and order:

- a) the quantity (number of hollow sections, total length or mass);
- b) details of the product form: HFCHS = hot finished circular hollow sections (or HFEHS for elliptical, HFRHS for square or rectangular);
- c) the name of the standard for dimensions and tolerances and the dimensions and tolerances: EN 10210-2;
- d) the name of this standard (EN 10225-3) and the steel designation (steel name or steel number, see 4.2.2);
- e) standard designation in accordance with EN 10204 for an inspection certificate 3.1 or, if required, inspection certificate 3.2 (see also **Option 24**).

5.2 Options

A number of options are specified in Clause 12. In the event that the purchaser does not indicate a wish to implement any of these options, the manufacturer shall supply in accordance with the basic specification (see 5.1). The options in Clause 12 are numbered through all four parts of EN 10225, therefore some options are not available for this part.

5.3 Example of an order

50 hot-finished circular hollow sections in accordance with EN 10210-2 with specified dimensions $244,5\text{ mm} \times 25,0\text{ mm} \times 4\ 500\text{ mm}$, made according to EN 10225-3 from structural steel S355NLHHO for offshore application, supplied with inspection certificate 3.1 and a product analysis:

50 HFCHS – EN 10210-2 — $244,5 \times 25,0 \times 4\ 500$

EN 10225-3 — S355NLHHO – inspection certificate 3.1, *Option 7*

or

50 HFCHS – EN 10210-2 — $244,5 \times 25,0 \times 4\ 500$

EN 10225-3 — 1.1182 inspection certificate 3.1, *Option 7*

6 Manufacturing process

6.1 Steel manufacturing process

The steel manufacturing process shall be at the discretion of the manufacturer with the exception that the open hearth (Siemens-Martin) process shall not be employed.

All steels shall be fully killed.

All steels shall be made to fine grain practice.

See **Option 1** (further details of steel manufacturing process)

See **Option 2** (vacuum degassed and/or ladle refined)

See **Option 3** (reduced S-content)

All products shall be traceable to the cast.

6.2 Structural hollow section manufacturing process

Hot finished structural hollow sections shall be manufactured by a seamless or by a high frequency welding process. Welded sections manufactured by a continuous process shall not include the welds used to join the lengths of strip prior to forming the hollow section.

HFV welded hollow sections shall be supplied with the external weld bead trimmed to an essentially flush condition. Internal trimming is at the discretion of the manufacturer. Normally sections are supplied without trimming the internal weld bead unless **Option 21** is specified, see 7.5.1.

The ends of the hollow section shall be cut perpendicular to the axis of the product.

6.3 Qualification of personnel for NDT activities

All NDT activities shall be carried out by qualified and competent level 1, 2 and/or 3 personnel authorised to carry out this work by the employer.

The qualification shall be in accordance with ISO 11484 or ASNT TC-1A or ISO 9712.

It is recommended that the level 3 personnel be certified in accordance with EN ISO 9712 or ASNT.

The operating authorisation issued by the employer shall be in accordance with a written procedure.

NDT operations shall be authorised by a level 3 NDT individual approved by the employer.

NOTE The definition of levels 1, 2 and 3 can be found in the appropriate standards, e.g. EN ISO 9712 and ISO 11484.

6.4 Delivery condition

Hollow sections shall be supplied full body heat treated, either in the normalized/normalized rolled (N) or quenched and tempered (Q) condition as shown in Tables 3 to 8.

A1 If normalized grades S420NLHHO and S460NLHHO are delivered with accelerated cooling (+DC) they get the addition +DC in the steel name. **A1**

7 Requirements

7.1 General

In addition to the requirements of this European Standard, the general technical delivery requirements specified in EN 10021 apply.