
Hladno oblikovani varjeni votli profili iz jekla - 1. del: Tehnični dobavni pogoji

Cold formed welded steel structural hollow sections - Part 1: Technical delivery conditions

Kaltgeformte geschweißte Hohlprofile für den Stahlbau - Teil 1: Technische Lieferbedingungen

Profils creux de construction en aciers soudés formés à froid - Partie 1 : Conditions techniques de livraison

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froid - Partie 1 : Conditions techniques de livraison

Kaltgeformte geschweißte Hohlprofile für den Stahlbau
- Teil 1: Technische Lieferbedingungen

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 459/SC 3.

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European foreword

This document (prEN 10219-1:2026) 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 document is currently submitted to the CEN Enquiry.

This document will supersede EN 10219-1:2006 and EN 10219-3:2020.

This document includes the following significant technical changes with respect to the previous version:

- part 1 and part 3 were merged;
- the chemical compositions of some grades were slightly changed;
- Annex ZA and provisions that apply under the Construction Products Regulation were moved to EN 10380;
- editorial revised.

This standard consists of the following parts:

- EN 10380, *Finished non-alloy and alloy steel products for structural use*
- EN 10219-1, *Cold formed welded steel structural hollow sections - Part 1: Technical delivery conditions*
- EN 10219-2, *Cold formed welded steel structural hollow sections - Part 2: Tolerances, dimensions and sectional properties*

It forms part of a series of standards on hollow sections together with EN 10210-1 and EN 10210-2.

1 Scope

This document specifies the technical delivery conditions for electric welded and submerged arc welded cold formed structural steel hollow sections of circular, square, rectangular or elliptical forms and applies to structural hollow sections formed cold without subsequent heat treatment other than the heat treatment of the weld line.

NOTE 1 The requirements for tolerances, dimensions and sectional properties in EN 10219-2.

NOTE 2 The provisions that apply under the Construction Products Regulations (CPR) are specified in EN 10380.

NOTE 3 The attention of users is drawn to the fact that whilst cold formed grades in this document can have equivalent mechanical properties to hot-finished grades in EN 10210-1 the sectional properties of square and rectangular hollow sections in EN 10219-2 and EN 10210-2 are not equivalent.

NOTE 4 A range of steel grades is specified in this document and the user selects the grade most appropriate to the intended use and service conditions. The grades and mechanical properties, but not the final supply condition of cold formed hollow sections are generally comparable with those in EN 10025-2, EN 10025-3, EN 10025-4, EN 10025-5, EN 10025-6, EN 10149-2 and EN 10149-3.

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 1011-2, *Welding — Recommendations for welding of metallic materials — Part 2: Arc welding of ferritic steels*

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 10160, *Ultrasonic testing of steel flat product of thickness equal or greater than 6 mm (reflection method)*

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

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

EN 10219-2, *Cold formed welded steel structural hollow sections — Part 2: Tolerances, dimensions and sectional properties*

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

EN 10266, *Steel tubes, fittings and structural hollow sections — Symbols and definitions of terms for use in product standards*

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

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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 1461, *Hot dip galvanized coatings on fabricated iron and steel articles — Specifications and test methods (ISO 1461)*

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

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

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

EN ISO 9606-1, *Qualification testing of welders — Fusion welding - Part 1: Steels (ISO 9606-1)*

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 10893-6, *Non-destructive testing of steel tubes — Part 6: Radiographic testing of the weld seam of welded steel tubes for the detection of imperfections (ISO 10893-6)*

EN ISO 10893-7, *Non-destructive testing of steel tubes — Part 7: Digital radiographic testing of the weld seam of welded steel tubes for the detection of imperfections (ISO 10893-7)*

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 14713-2:2020, *Zinc coatings — Guidelines and recommendations for the protection against corrosion of iron and steel in structures — Part 2: Hot dip galvanizing (ISO 14713-2:2019)*

EN ISO 15607, *Specification and qualification of welding procedures for metallic materials — General rules (ISO 15607)*

EN ISO 15609-1, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 1: Arc welding (ISO 15609-1)*

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*

SNT TC-1A, *Personnel Qualification and Certification in non-destructive Testing*

3 Terms, definitions and symbols

3.1 Terms and definitions

For the purposes of this document, the following terms and definitions apply in addition to or where different from those in EN 10020, EN 10021, EN 10266 and EN ISO 4885.

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

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

3.1.1 cold forming

process where the forming to final shape of the welded hollow section is carried out at ambient temperature

Note 1 to entry: Circular hollow sections produced from normalized strip with a normalized weld seam and with a cold forming ratio of $D/T \geq 20$ may be classified as hot-finished hollow sections.

3.1.2 normalizing rolling for feedstock material

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 subsequent normalizing

3.1.3 thermomechanical rolling for feedstock material

rolling process in which the final deformation is carried out in a certain temperature range leading to a material condition with certain properties which cannot be achieved or repeated by heat treatment alone

Note 1 to entry: Thermomechanical rolling can include processes with an increased cooling rate with or without tempering including self-tempering but excluding direct quenching and quenching and tempering.

Note 2 to entry: In some publications the word TMCP (Thermomechanical Control Process) is also used.

prEN 10219-1:2026 (E)**3.1.4****steel with improved atmospheric corrosion resistance for feedstock material**

steel in which a certain number of alloying elements has been added in order to increase its resistance to atmospheric corrosion, by forming an auto-protective oxide layer on the base metal under the influence of weather conditions

Note 1 to entry: Steel with improved atmospheric corrosion resistance is often called weathering steel.

Note 2 to entry: Additional information for the use of steel with improved atmospheric corrosion resistance is given in Annex E.

3.1.5**quenching and tempering for feedstock material**

process which consists of the following two steps:

- first quenching, where the steel is heated up above A_{c3} temperature and then rapidly cooled down in liquids to create a process specific grain structure;
- afterwards tempering, during which the steel is heated up to a certain temperature to adjust the desired properties and cooled down in air afterwards

3.1.6**fine grain steel**

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

Note 1 to entry: For the determination of grain sizes, see EN ISO 643.

3.1.7**hot-dip zinc coating**

application of a zinc coating by immersing the prepared strip or hollow section in a molten bath containing a zinc content of at least 98 %

3.2 Symbols

For the purposes of this document, the symbols defined in EN 10266 apply.

4 Classification and designation**4.1 Classification**

4.1.1 Within the grades of the non-alloy steels given in Annex A, four qualities JR, J0, J2 and K2 are specified. These differ in respect of specified impact requirements, limits on values of various elements, with particular reference to sulphur and phosphorus, and the inspection and testing requirements.

In accordance with the classification system in EN 10020, all steel grades in Annex A are non-alloy quality steels.

4.1.2 Within the grades of steels given in Annex B, C and D seven qualities N, NL, M, ML, Q, QL and QL1 are specified. These differ in respect of the carbon, sulphur and phosphorus content, low temperature impact properties, production process, heat treatment and grain size.

In accordance with the classification system in EN 10020, steel grades S275NH, S275NLH, S355NH and S355NLH are non-alloy quality steels and all other steel grades are alloy special steels.

4.1.3 Within the grades of steels given in Annex E, three qualities J0, J2 and K2 are specified. These differ in respect of specified impact requirements and limits on values of various elements.

In accordance with the classification system in EN 10020, all steel grades in Annex E are alloy special steels.

4.2 Designation

4.2.1 For the products covered by this document 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 The designation of steel hollow sections consists of:

- a) the number of this document (EN 10219-1);
- b) the capital letter S for structural steel;
- c) the indication of the minimum specified yield strength for thicknesses ≤ 16 mm expressed in MPa;
- d) further designations for either:
 - 1) non-alloy structural steels:
 - i. the capital letters JR for the qualities with specified impact properties at room temperature;
 - ii. the characters J0 for the qualities with specified impact properties at 0 °C;
 - iii. the characters J2 or K2 for the qualities with specified impact properties at -20 °C; or
 - 2) normalized/normalized rolled structural steels:
 - i. capital letter N to indicate normalized or normalized rolled with specified impact properties at -20 °C (see 6.4);
 - ii. capital letters NL for qualities with specified impact properties at -50 °C; or
 - 3) thermomechanical rolled structural steels:
 - i. capital letter M to indicate thermomechanical rolled with specified impact properties at -20 °C (see 6.4);
 - ii. capital letters ML for qualities with specified impact properties at -50 °C; or
 - 4) structural steels in the quenched and tempered condition:
 - i. capital letter Q to indicate the quenched and tempered condition with specified impact properties at -20 °C (see 6.4);
 - ii. capital letters QL or QL1 for qualities with specified impact properties at -40 or -50 °C; or
 - 5) steels with improved atmospheric corrosion resistance:
 - i. the characters J0 for the qualities with specified impact properties at 0 °C;
 - ii. the characters J2 or K2 for the qualities with specified impact properties at -20 °C; and

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- iii. the letter W (weather) for improved atmospheric corrosion resistance; and
- e) the capital letter H to indicate hollow sections.

EXAMPLE 1 Hollow section made of structural steel (S) with a specified minimum yield strength for thickness not greater than 16 mm of 355 MPa, with a minimum impact energy value of 27 J at $-20\text{ }^{\circ}\text{C}$ (J2), hollow section (H):

EN 10219-1 — S355J2H

or

EN 10219-1 — 1.0576

EXAMPLE 2 Hollow section made of structural steel (S) with a specified minimum yield strength for thickness not greater than 16 mm of 420 MPa, thermomechanically rolled steel (M), with a minimum impact energy value of 27 J at $-50\text{ }^{\circ}\text{C}$ (L), hollow section (H):

EN 10219-1 — S420MLH

or

EN 10219-1 — 1.8848

5 Information to be obtained by the manufacturer

5.1 Mandatory information

The following information shall be contained in the order document at the time of enquiry and order:

- a) the quantity (mass or total length);
- b) details of the product form:
 - 1) CFCHS = cold formed circular hollow section;
 - 2) CFRHS = cold formed square or rectangular hollow section;
 - 3) CFEHS = cold formed elliptical hollow section;
- c) the name of the standard for dimensions and tolerances (EN 10219-2);
- d) the dimensions and the type of length, length range or length (see EN 10219-2);
- e) the steel designation (see 4.2).

5.2 Options

A number of options are specified in this document. These are listed below with appropriate clause references. In the event that the purchaser does not indicate a wish to implement any of these options at the time of enquiry and order, the hollow sections shall at least be supplied in accordance with the basic specification.

- 1.1 Internal weld bead trimmed (see 6.5.2);
- 1.2 Other surface condition than as rolled (see 6.6);

- 1.3 Product analysis (see 7.1.1);
- 1.4 Cr, Cu, Mo, Ni, Ti and V cast analysis contents to be reported for non-alloy quality steels (see 7.1.2);
- 1.5 Tensile test in corner region (see 7.2.1);
- 1.6 Impact test in corner region (see 7.2.2);
- 1.7 Verification of impact properties for qualities J0 and JR (see 7.2.3);
- 1.8 The product shall have a chemical composition suitable for hot-dip-zinc coating (see 7.3.2);
- 1.9 Weld repairs to the body of structural steel hollow sections are permitted (see 7.4.4);
- 1.10 Full peripheral NDT (non-destructive testing) of the circular tube for imperfections – not possible for elliptical, rectangular, square and SAW (submerged arc welded) hollow sections (see 7.5);
- 1.11 Ultrasonic testing for laminar imperfections (see 7.5);
- 1.12 Inspection certificate 3.1 for steel grades S235JRH, S275J0H, S355J0H of Annex A and S355J0WH of Annex E instead of a test report 2.2 (see 8.1);
- 1.13 Inspection certificate 3.2.

5.3 Example of an order

10 t cold formed welded square hollow sections in accordance with EN 10219-2 with specified outside dimensions 100 mm × 100 mm and wall thickness of 8 mm of 12 m approximate lengths, grade S355MH according to EN 10219-1 including product analysis (Option 1.3) and chemical composition for hot dip zinc coating (Option 1.8), supplied with inspection certificate 3.1 and with regulatory marking according to EN 10380:

10 t – CFRHS – EN 10219-2 — 100 × 100 × 8 – approximate length 12 m
EN 10219-1 — S355MH – Options 1.3 and 1.8

6 Manufacturing process

6.1 General

Structural welded cold formed hollow sections of non-alloy steels shall conform to the requirements of Annex A. Structural welded cold formed hollow sections of normalized/normalized rolled, thermomechanical rolled and quenched and tempered steels shall conform to Annexes B to D and steels with improved atmospheric corrosion resistance shall conform to the requirements of Annex E.

In addition, the general technical delivery requirements specified in EN 10021 shall apply.

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6.2 Steel manufacturing process

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

6.2.2 The method of deoxidation shall be as specified in Tables A.1, B.1, C.1, D.1 and E.1.

6.3 Grain structure

The steel grades given in Annexes B to D shall have a ferritic grain size equal to or finer than 6 when measured in accordance with EN ISO 643 (see 7.2.4).

6.4 Condition of feedstock material

According to the designation given in the order the following delivery conditions apply for the feedstock material used for the manufacture of cold formed hollow sections:

- as rolled or normalized/normalized rolled or thermomechanically rolled for steels according to Annex A;
- normalized/normalized rolled for steels of qualities N and NL according to Annex B;
- thermomechanical rolled for steels of quality M and ML according to Annex C;
- quenched and tempered for steels of qualities Q, QL and QL1 according to Annex D;
- as rolled or normalized/normalized rolled or thermomechanical formed for steels with improved atmospheric corrosion resistance W according to Annex E.

6.5 Structural hollow section manufacturing process

6.5.1 Structural hollow sections shall be manufactured by electric welding or submerged arc welding without subsequent heat treatment (see 6.6). Hollow sections manufactured by a continuous process shall not include the welds used to join the lengths of strip prior to forming the hollow section, except that for helically welded submerged arc-welded (SAW) hollow sections, such welds shall be permitted when tested in accordance with 10.4.3.

6.5.2 Electric welded hollow sections shall be supplied with the external weld bead trimmed to an essentially flush condition. Trimming of the internal weld bead is at the discretion of the manufacturer unless Option 1.1 is specified.

Option 1.1 Electric welded hollow sections shall be supplied with the internal weld bead trimmed, the maximum height of the internal weld bead after trimming shall be agreed at the time of enquiry and order.

6.5.3 All NDT activities shall be carried out by qualified and competent level 1, 2 and/or 3 personnel authorized to operate by the employer.

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

6.6 Delivery condition

The hollow sections shall be delivered cold formed without subsequent heat treatment except that the weld seam may be in the as welded or heat treated condition.

NOTE For SAW hollow sections, it can be necessary to perform a warm shaping operation, which does not affect the mechanical properties, in order to meet the out-of-roundness tolerance requirements.

The surface of the hollow sections shall be typical of the feedstock employed and manufacturing method used.

Option 1.2 Other possible surface conditions are:

- a) S2 pickled feedstock;
- b) S3 pickled hollow section;
- c) S4 hot-dip-zinc coated feedstock;
- d) S5 hot-dip-zinc coated hollow section (There shall also be an agreement on the coating of the weld seam.)

7 Requirements

7.1 Chemical composition

7.1.1 The chemical composition determined by the cast analysis and reported by the steel producer shall comply to the requirements given in Tables A.1, B.1, C.1, D.1 or E.1.

The maximum carbon equivalent value (CEV) for all grades, based on the cast analyses, given in Tables A.2, B.2, C.2, D.2 or E.2 shall apply.

When determining the CEV the following formula of the International Institute of Welding (IIW) shall be used:

$$CEV = C + \frac{Mn}{6} + \frac{Cr + Mo + V}{5} + \frac{Ni + Cu}{15}$$

In addition to the cast analysis the following option can be specified by the purchaser at the time of enquiry and order:

Option 1.3 For products supplied with specific inspection and testing, a product analysis shall be reported.

Deviations of the product analysis from the specified limits of the cast analysis shall be in accordance with Table 1.

7.1.2 For non-alloy steel products with specific inspection (3.1 or 3.2) the following option may be specified:

Option 1.4 The recording on the inspection certificate of the Cr, Cu, Mo, Ni, Ti and V content (cast analysis).