

SQUARE HOLLOW SECTION - Production Standards **EN 10219 1 & 2**

Material Quality

H: EN 10025 S235JR
 C: EN 10130:91 + A1 98 DCO1
 G: EN 10346:2009 DX51D

Finishing Operations

Square Cut

Surface Protection

Protective Oil upon Request

Mill Test Certificates

EN 10204 3.1

Quality Control

A. Eddy Current Test
 B. Flattering Test
 C. Expanding Test
 D. Tensile Test
 E. Visual & Dimensional Tests

Length to Cut

Up to T60 from 4,0m to 8,0m
 By T76 and above 12m

H : Hot Rolls

C : Cold Rolls

G : Galvanize Rolls

Size	Thickness									
	1	1,2	1,35	1,8	2	2,5	3	4	5	6
14x14	C	C & G	C & G							
17x17	C	C & G	C & G							
20x20	C	C & G	C & G	H & G	H	H				
25x25	C	C & G	C & G	H & G	H	H				
30x30	C	C & G	C & G	H & G	H	H	H			
38x38		C & G	C & G	H & G	H	H	H			
40x40		C & G	C & G	H & G	H	H	H			
50x50			C & G	H & G	H	H	H			
60x60				H & G	H	H	H	H	H	H
70x70				H & G	H	H	H	H	H	H
80x80				H & G	H	H	H	H	H	H
90x90				H & G	H	H	H	H	H	H
100x100				H & G	H	H	H	H	H	H
120x120							H	H	H	H
130x130								H	H	H

RECTANGULAR HOLLOW SECTION - Production Standards **EN 10219 1 & 2**

Material Quality

H: EN 10025 S235JR
 C: EN 10130:91 + A1 98 DCO1
 G: EN 10346:2009 DX51D

Finishing Operations

Square Cut

Surface Protection

Protective Oil upon Request

Mill Test Certificates

EN 10204 3.1

Quality Control

- A. Eddy Current Test
- B. Flattering Test
- C. Expanding Test
- D. Tensile Test
- E. Visual & Dimensional Tests

Length to Cut

Up to T60 from 4,0m to 8,0m
 By T76 and above 12m

H : Hot Rolls C : Cold Rolls G : Galvanize Rolls

Size	1	1,2	1,35	1,8	2	2,5	3	4	5	6
10x16	C	C & G	C & G							
20x14	C	C & G	C & G							
30x15	C	C & G	C & G							
30x20	C	C & G	C & G		H					
38x20	C	C & G	C & G		H					
40x20		C & G	C & G		H					
60x20		C & G	C & G		H					
50x20		C & G	C & G		H					
40x27		C & G	C & G		H					
40x30		C & G	C & G		H					
50x25		C & G	C & G		H					
50x30		C & G	C & G	H & G	H	H	H			
60x30		C & G	C & G	H & G	H	H	H			
50x40			C & G	H & G	H	H	H			
70x30			C & G	H & G	H	H	H			
60x40			C & G	H & G	H	H	H			
70x38				H & G	H	H	H			
80x40				H & G	H	H	H	H	H	H
100x40					H	H	H	H	H	H
100x50							H	H	H	H
100x60							H	H	H	H
120x40							H	H	H	H
120x60							H	H	H	H
120x80							H	H	H	H
150x50							H	H	H	H
160x80								H	H	H
160x100								H	H	H

CONSTRUCTION PIPE - Production Standards **EN 10219 1 & 2**

Material Quality

H: EN 10025 S235JR
 C: EN 10130:91 + A1 98 DCO1
 G: EN 10346:2009 DX51D

Finishing Operations

Square Cut

Surface Protection

Protective Oil upon Request

Mill Test Certificates

EN 10204 3.1

Quality Control

A. Eddy Current Test
 B. Flattering Test
 C. Expanding Test
 D. Tensile Test
 E. Visual & Dimensional Tests

Length to Cut

Up to T75,3 from 4,0m to 8,0m
 By T76 and above 12m

H: Hot Rolls

C: Cold Rolls

G: Galvanize Rolls

Size	Thickness									
	1	1,2	1,35	1,8	2	2,5	3	4	5	6
21	C & G	C & G	C & G							
26	C & G	C & G	C & G							
33	C & G	C & G	C & G	H & G						
38	C & G	C & G	C & G	H & G	H					
42	C & G	C & G	C & G	H & G	H					
48		C & G	C & G	H & G	H					
51		C & G	C & G	H & G	H					
60		C & G	C & G	H & G	H	H	H			
63,5		C & G	C & G		H	H	H			
68		C & G	C & G		H	H	H			
70		C & G	C & G		H	H	H			
76		C & G	C & G		H	H	H			
88					H	H	H	H		
95					H	H	H	H	H	H
102					H	H	H	H	H	H
108						H	H	H	H	H
114						H	H	H	H	H
127						H	H	H	H	H
152							H	H	H	H
168							H	H	H	H

GALVANIZED CONSTRUCTION PIPE - Production Standards **EN 10219 1 & 2**

Material Quality

H: EN 10025 S235JR
 C: EN 10130:91 + A1 98 DCO1

Finishing Operations

Square Cut

Surface Protection

Hot Dip Galvanized

Mill Test Certificates

EN 10204 3.1

H: Hot Rolls
 C: Cold Rolls

Quality Control

- A. Eddy Current Test
- B. Flattering Test
- C. Expanding Test
- D. Tensile Test
- E. Visual & Dimensional Tests

Length to Cut

From 4,0m up to 6,60m

Thickness

Size	1,2	1,35	2	3	4	5	6
21	C	C					
26	C	C					
33	C	C	H				
38	C	C	H				
42	C	C	H	H			
48	C	C	H	H			
51	C	C	H	H			
60	C	C	H	H			
63,5	C	C	H	H			
68	C	C	H	H			
70	C	C	H	H			
76		C	H	H	H	H	
88			H	H	H	H	H
102			H	H	H	H	H
108				H	H	H	H
114				H	H	H	H

WATER AND GAS PIPES - Production Standards **EN 10255**

Material Quality

H: EN 10025 S235JR

Finishing Operations

Threaded and Coupled

Plain End

Surface Protection

Hot Dip Galvanizing EN 10240

Primer Coated on request

Mill Test Certificates

EN 10204 3.1

Quality Control

A. Eddy Current Test

B. Flattering Test

C. Expanding Test

D. Tensile Test

E. Visual & Dimensional Tests

Length to Cut

From 4,0m up to 6,60m

Size		OD		Thread Thickness
DN	inch	Max	Min	
15	1/2	21,80	21,00	2,60
20	3/4	27,30	26,50	2,60
25	1	34,20	33,30	3,20
32	1 1/4	42,90	42,00	3,20
40	1 1/2	48,80	47,90	3,20
50	2	60,80	59,70	3,60
65	2 1/2	76,60	75,30	3,60
80	3	89,50	88,00	4,00
100	4	115,00	113,10	4,50

PIPES for FIRE SAFETY - Production Standards **EN 10255**

Material Quality

H: EN 10025 S235JR

Finishing Operations

Threaded and Coupled

Plain End

Surface Protection

Hot Dip Galvanizing EN 10240

Primer Coated on request

Mill Test Certificates

EN 10204 3.1

Quality Control

A. Eddy Current Test

B. Flattering Test

C. Expanding Test

D. Tensile Test

E. Visual & Dimensional Tests

Length to Cut

From 4,0m up to 6,60m

Size		OD		Thread Thickness
DN	inch	Max	Min	
40	1 1/2	48,80	47,90	3,20
50	2	60,80	59,70	3,60
65	2 1/2	76,60	75,30	3,60
80	3	89,50	88,00	4,00
100	4	115,00	113,10	4,50