

**Kaldformede sveiste hulprofiler av ulegerte  
og finkornbehandlede konstruksjonsstål**  
**Del 1: Tekniske leveringsbetingelser**

Cold formed welded structural hollow sections of non-alloy and fine grain  
steels

Part 1: Technical delivery conditions

---

**Nasjonalt forord**

Den engelskspråklige versjonen av europeisk standard EN 10219-1:2006 er fastsatt som Norsk Standard NS-EN 10219-1:2006.

**National foreword**

The English language version of European Standard EN 10219-1:2006 has been adopted as Norwegian Standard NS-EN 10219-1:2006.

English Version

## Cold formed welded structural hollow sections of non-alloy and fine grain steels - Part 1: Technical delivery conditions

Profils creux pour la construction soudés, formés à froid en aciers non alliés et à grains fins - Partie 1 : Conditions techniques de livraison

Kaltgefertigte geschweißte Hohlprofile für den Stahlbau aus unlegierten Baustählen und aus Feinkornbaustählen - Teil 1: Technische Lieferbedingungen

This European Standard was approved by CEN on 16 March 2006.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



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

**Management Centre: rue de Stassart, 36 B-1050 Brussels**

<b>Contents</b>	<b>Page</b>
Foreword .....	3
<b>1 Scope</b> .....	<b>4</b>
<b>2 Normative references</b> .....	<b>4</b>
<b>3 Terms, definitions and symbols</b> .....	<b>5</b>
<b>3.1 Terms and definitions</b> .....	<b>5</b>
<b>3.2 Symbols</b> .....	<b>5</b>
<b>4 Classification and designation</b> .....	<b>6</b>
<b>4.1 Classification</b> .....	<b>6</b>
<b>4.2 Designation</b> .....	<b>6</b>
<b>5 Information to be obtained by the manufacturer</b> .....	<b>7</b>
<b>5.1 Mandatory information</b> .....	<b>7</b>
<b>5.2 Options</b> .....	<b>7</b>
<b>5.3 Example of an order</b> .....	<b>7</b>
<b>6 Requirements</b> .....	<b>7</b>
<b>6.1 General</b> .....	<b>7</b>
<b>6.2 Steel manufacturing process</b> .....	<b>8</b>
<b>6.3 Condition of feedstock material</b> .....	<b>8</b>
<b>6.4 Structural hollow section manufacturing process</b> .....	<b>8</b>
<b>6.5 Delivery condition</b> .....	<b>8</b>
<b>6.6 Chemical composition</b> .....	<b>8</b>
<b>6.7 Mechanical properties</b> .....	<b>9</b>
<b>6.8 Technological properties</b> .....	<b>10</b>
<b>6.9 Surface condition</b> .....	<b>10</b>
<b>6.10 Non-destructive testing of welds</b> .....	<b>11</b>
<b>6.11 Tolerances and mass</b> .....	<b>11</b>
<b>7 Inspection</b> .....	<b>11</b>
<b>7.1 Types of inspection</b> .....	<b>11</b>
<b>7.2 Types of inspection document</b> .....	<b>11</b>
<b>7.3 Summary of inspection</b> .....	<b>12</b>
<b>8 Sampling</b> .....	<b>14</b>
<b>8.1 Frequency of tests</b> .....	<b>14</b>
<b>8.2 Preparation of samples and test pieces</b> .....	<b>14</b>
<b>9 Test methods</b> .....	<b>15</b>
<b>9.1 Chemical analysis</b> .....	<b>15</b>
<b>9.2 Mechanical tests</b> .....	<b>16</b>
<b>9.3 Visual inspection and dimensional check</b> .....	<b>16</b>
<b>9.4 Non-destructive testing</b> .....	<b>16</b>
<b>9.5 Retests, sorting and reprocessing</b> .....	<b>17</b>
<b>10 Marking</b> .....	<b>17</b>
<b>11 Evaluation of conformity</b> .....	<b>17</b>
<b>Annex A (normative) Structural hollow sections of non-alloy quality steels — Chemical composition and mechanical properties</b> .....	<b>18</b>
<b>Annex B (normative) Structural hollow sections of fine grain steels — Chemical composition and mechanical properties</b> .....	<b>20</b>
<b>Annex C (normative) Location of samples and test pieces</b> .....	<b>24</b>
<b>Annex D (normative) Evaluation of conformity</b> .....	<b>25</b>
<b>Annex ZA (informative) Clauses of this European Standard addressing the provisions of the EU Construction Products Directive</b> .....	<b>30</b>
<b>Bibliography</b> .....	<b>35</b>

## Foreword

This European Standard (EN 10219-1:2006) has been prepared by Technical Committee ECISS/TC 10 "Structural steels - Grades and qualities", the secretariat of which is held by NEN.

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 October 2006, and conflicting national standards shall be withdrawn at the latest by October 2006.

This European Standard supersedes EN 10219-1:1997.

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this European Standard.

This standard consists of the following parts under the general title 'Cold formed welded structural hollow sections of non-alloy and fine grain steels':

- Part 1: Technical delivery conditions
- Part 2: Tolerances, dimensions and sectional properties

It forms part of a series of standards on hollow sections together with EN 10210-1 and 2, which are also under revision.

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