

DECLARATION OF PERFORMANCE		
NR. 0103/013		Rel. 1
Identification code of the product-type	Welded tube made of non-alloy structural steel S355J2H in accordance with EN10210:2006.	
Identification of the construction product	In accordance with the information included in the identification label with barcode and/or bundle number and in the inspection certificate.	
Intended use of the construction product	Hot finished hollow sections of non-alloy and fine grain for structural uses of circular, square, rectangular or elliptical forms.	
Manufacturer (registered office)	<b>Marcegaglia S.p.A.</b> Via Bresciani, 16 – 46040 Gazoldo degli Ippoliti (MN) – Italia	
Production plant	<b>Casalmaggiore</b> s.s.420 Sabbionetana – 26041 Casalmaggiore (CR) - Italia	
System of assessment and verification of constancy of performance of the construction product	2+	
Name and identification number of the notified body	RINA Service S.p.A. – Via Corsica, 12 – 16128 Genova - Italia <b>0474</b>	
Issued the certificate of conformity of the factory production control on the basis of the following elements: <ul style="list-style-type: none"> <li>starting inspection of the production plant and of the factory production control.</li> <li>surveillance, evaluation and continuous audits of the factory production control.</li> </ul>		
DECLARED PERFORMANCE		
Essential characteristics	Performance	Harmonised technical specification
Tolerances on dimensions and shape	in compliance with table 2	EN10210-2:2006
Elongation	in compliance with table 1	EN10210-1:2006
Tensile strength		
Yield strength		
Impact strength		
Weldability (CEV)	0,45% max	
Durability	N.P.D.	
The performance of the product identified above is in conformity with the set of declared performance/s. This declaration of performance is issued, in accordance with Regulation (EU) No 305/2011, under the sole responsibility of the manufacturer identified above.		
Signed for and on behalf of Marcegaglia S.p.A. by:  <i>Roberto Ing. Ferrari</i> <i>Casalmaggiore Plant Manager</i>		
		<i>Casalmaggiore 21/07/2014</i>
This declaration of performance is valid only in presence of the material identification label and the waybill or the inspection certificate issued after delivery.		

Steel grade		Minimum yield strength $R_{eH}$	Tensile strength $R_m$		Minimum elongation A <sub>(a,b)</sub>	Minimum impact energy	
Steel name	Steel number	[MPa]	[MPa]		[%]	KV in J <sup>(c)</sup>	
		Specified thickness in mm				Test temperature	Min. impact energy
		≤ 16	≤ 3	> 3 ≤ 100	≤ 40		
<b>S355J2H</b>	<b>1.0576</b>	355	510+680	470+630	22	-20°	27
a. Longitudinal values. Transverse values are 2% lower. b. For thicknesses < 3 mm, see 9.2.2 of EN10210-1:2006. c. For impact properties for reduced section test pieces see 6.6.2.							

Outside dimensions (D, B e H)	Circular hollow sections	Square and rectangular hollow sections	Elliptical hollow sections
		± 1% with a minimum of ± 0,5 mm and a maximum of ±10 mm	± 1% <sup>1)</sup> with a minimum of ± 0,5 mm
Thickness (T)	-10% <sup>2)</sup>		
Out of roundness (O)	2% for hollow sections having a diameter to thickness ratio not exceeding 100 <sup>3)</sup>	-	
Concavity/Convexity ( $x_1, x_2$ ) <sup>(4)</sup>	-	1%	-
Squareness of side ( $\theta$ )	-	90° ± 1°	-
External corner profile ( $C_1, C_2$ o R) <sup>5)</sup>	-	3T maximum at each corner	-
Twist (V)	-	2 mm <sup>1)</sup> plus 0,5 mm/m length <sup>1)</sup>	
Straightness (e)	0,2 <sup>1)</sup> % of total length and 3 mm over any 1 m length		
Mass (M)	± 6 % on individual delivered lengths		

Tolerances on length <sup>(3)</sup>	Exact length	2000 mm ≤ L ≤ 6000 mm	⇒ 0; + 10 mm
		Standard length	> 6000 mm <sup>7)</sup>
		4000 mm ≤ L ≤ 16000 mm	⇒ +/- 500 mm <sup>6)</sup>

- For elliptical hollow sections of sizes H<250 mm the permitted tolerance is twice the value given in this table.
- The positive deviation is limited by the tolerance on mass.
- Where the diameter to thickness ratio exceeds 100, the tolerance on out of roundness shall be agreed.
- The tolerance on convexity and concavity is independent of the tolerance on outside dimensions.
- The sides need not to be tangential to the corner arcs.
- Option 2.1 (EN10210-2:2006) the tolerance on approximate length is 0; +150 mm.
- Common lengths available are 6m and 12m.