

DIN EN 10225-4:2019-11 (E)

Weldable structural steels for fixed offshore structures - Technical delivery conditions - Part 4: Cold formed welded hollow sections

Contents		Page
European foreword		5
1	Scope	6
2	Normative references	6
3	Terms and definitions	8
4	Classification and designation	10
4.1	Classification	10
4.2	Designation	10
5	Information to be supplied by the purchaser	11
5.1	Mandatory information	11
5.2	Options	11
5.3	Examples of an order	11
6	Manufacturing process	12
6.1	Steel manufacturing process	12
6.2	Condition of feedstock material	12
6.3	Structural hollow section manufacturing process	12
6.4	Qualification of personnel for NDT-activities	12
6.5	Delivery condition	13
7	Requirements	13
7.1	General	13
7.2	Chemical composition	13
7.2.1	Heat analysis	13
7.2.2	Product analysis	13
7.2.3	Carbon equivalent values (CEV) and Pcm	13
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	14
7.3.4	Flattening or bend test	14
7.3.5	Prequalification for arctic areas	14
7.4	Weldability data	14
7.5	Internal soundness and non-destructive testing	15
7.5.1	Non-destructive testing of the weld seam of hollow sections	15
7.5.2	Laminar discontinuities of hollow sections	15
7.6	Surface quality	15
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	16
8.1	General	16
8.2	Types of inspection documents	16
8.3	Summary of inspections	18
8.4	Intermediary supply	23

9	Frequency of testing and preparation of samples and test pieces	23
DIN EN 10225-4:2019-11 EN 10225-4:2019 (E) 9.1	Frequency of test	23
9.1.1	Chemical analysis	23
9.1.2	Tensile test and impact test	23
9.1.3	Testing of the weld seam	24
9.1.4	Testing of the corner regions for square or rectangular HFW hollow sections	24
9.2	Selection and preparation of samples for product analysis	24
9.3	Location of samples and orientation of tensile test pieces	24
9.4	Location of samples and orientation of impact test pieces	24
9.5	Preparation of test pieces for mechanical tests	25
9.5.1	General	25
9.5.2	Preparation of tensile test pieces	25
9.5.3	Preparation of impact test pieces	25
9.5.4	Test pieces for flattening and bend tests	26
10	Test methods	26
10.1	Chemical analysis	26
10.2	Mechanical tests	26
10.2.1	Test temperatures	26
10.2.2	Tensile test	26
10.2.3	Impact test	26
10.2.4	Flattening test	27
10.2.5	Weld bend test	27
10.3	Visual inspection and dimensional check	27
10.4	Non-destructive tests	27
10.4.1	General	27
10.4.2	NDT for the weld seam of HFW hollow sections	28
10.4.3	NDT for the weld seam of submerged arc welded hollow sections	28
10.4.4	Ultrasonic testing for laminar imperfections	28
10.4.5	NDT for surface quality	28
10.5	Retests, sorting and reprocessing	28
11	Marking and bundling	28
11.1	Die stamping and paint marking	28
11.2	Bundling	29
12	Options	29
Annex A (normative when Option 1 is specified by the purchaser) Further details of steel manufacturing procedures to be supplied by the manufacturer		40
Annex B (normative when Option 17 is specified by the purchaser) Weldability testing and mechanical testing of butt welds		41
B.1	General requirements	41
B.2	Welding processes and procedure	41
B.3	Butt-weld requirements	42
B.3.1	General	42
B.3.2	Test piece dimensions	42
B.3.3	Bevel detail	43
B.3.4	Welding processes	44
B.3.5	Nominal heat input	44
DIN EN 10225-4:2019-11 EN 10225-4:2019 (E) B.3.6 Heat treatment of S355NLHCO, S355MLHCO, S420MLHCO, S460MLHCO, S500MLHCO, S550MLHCO, S600 MLHCO, S650 MLHCO and S700MLHCO grades		44
B.3.7	Dehydrogenation of test pieces	45
B.4	Mechanical testing	45
B.4.1	General	45
B.4.2	Charpy-V-notch impact tests	46
B.4.3	Fracture mechanic test	47

B.4.4	Macrohardness	48
B.4.5	Cross-weld tensile test	49
Annex C (normative when Option 17 is specified by the purchaser) Weldability testing - Bead-on-strip		
		54
C.1	General	54
C.2	Test material dimension	54
C.3	Welding method	54
C.4	Test condition	54
C.5	Specific test requirements: Macrosection and hardness tests	55
Annex D (normative when Option 17 is specified by the purchaser) Weldability testing - Controlled thermal severity tests (CTS)		
		57
D.1	General	57
D.2	Test block dimensions	57
D.3	General welding details	57
D.3.1	Anchor welds	57
D.3.2	Test welds	57
D.4	Evaluation of the test welds	58
D.5	Hardness testing	58
Annex E (informative) Helical submerged arc welded (SAWH) hollow sections		
		64
E.1	General	64
E.2	Additional weld geometry tolerances	64
Annex F (informative) High strength square and rectangular cold formed HFW hollow sections		
		65
Annex G (informative) Prequalification of steels for offshore structures operating in arctic areas		
		68
Bibliography		
		69