

# ISO 12633-1:2011-09 (E)

## Hot-finished structural hollow sections of non-alloy and fine grain steels - Part 1: Technical delivery conditions

---

<b>Contents</b>		<b>Page</b>
Foreword .....		iv
1	Scope .....	1
2	Normative references .....	1
3	Terms and definitions .....	2
4	Classification and designation .....	2
4.1	Classification .....	2
4.2	Designations .....	3
5	Information to be supplied by the purchaser .....	4
5.1	Mandatory information .....	4
5.2	Options .....	4
5.3	Example .....	5
6	Requirements .....	5
6.1	General .....	5
6.2	Steel manufacturing process .....	5
6.3	Structural hollow section manufacturing process .....	6
6.4	Delivery conditions .....	6
6.5	Chemical composition .....	6
6.6	Mechanical properties .....	8
6.7	Technological properties .....	8
6.8	Surface condition .....	9
6.9	Non-destructive testing of welds .....	9
6.10	Tolerances and mass .....	9
7	Inspection .....	10
7.1	Types of inspection and testing .....	10
7.2	Types of inspection documentation .....	10
7.3	Inspection and testing .....	11
8	Samples .....	12
8.1	Frequency of tests .....	12
8.2	Preparation of samples and test pieces .....	13
9	Test methods .....	14
9.1	Chemical analysis .....	14
9.2	Mechanical tests .....	14
9.3	Visual examination and dimensional inspection .....	15
9.4	Non-destructive testing .....	15
9.5	Retests, sorting and reprocessing .....	16
10	Marking .....	16
Annex A (normative)	Structural hollow sections of non-alloy steels -- Chemical composition and mechanical properties .....	17

<b>Annex B (normative) Structural hollow sections of fine grain steels -- Chemical composition and mechanical properties .....</b>	<b>19</b>
<b>Annex C (normative) Location of samples and test pieces for hollow sections .....</b>	<b>21</b>
<b>Bibliography .....</b>	<b>24</b>