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Svejselige konstruktionsstål til faststående offshorekonstruktioner – Tekniske leveringsbetingelser – Del 3: Varmebehandlede hulprofiler

Weldable structural steels for fixed offshore
structures – Technical delivery conditions –
Part 3: Hot finished hollow sections

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English Version

Weldable structural steels for fixed offshore structures - Technical delivery conditions - Part 3: Hot finished hollow sections

Aciers de construction soudables destinés
à la fabrication de structures marines
fixes - Conditions techniques de livraison
- Partie 3 : Profils creux finis à chaud

Schweißgeeignete Baustähle für feststehende
Offshore-Konstruktionen - Technische
Lieferbedingung - Teil 3: Warmgefertigte Hohlprofile

This European Standard was approved by CEN on 23 December 2018 and includes Amendment 0 approved by CEN on 17 April 2023.

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 CEN-CENELEC Management Centre 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 CEN-CENELEC Management Centre has the same status as the official versions.

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CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

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European foreword

This document ([EN 10225-3:2019+A1:2023](#)) has been prepared by Technical Committee CEN/TC 459/SC 3 "Structural steels other than reinforcements", the secretariat of which is held by DIN.

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of an identical text or by endorsement, at the latest by November 2023, and conflicting national standards shall be withdrawn at the latest by November 2023.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

[EN 10225-3:2019](#), together with [EN 10225-1:2019](#), [EN 10225-2:2019](#), and [EN 10225-4:2019](#), superseded [EN 10225:2009](#).

This document [EN 10225-3:2019+A1:2023](#) supersedes [EN 10225-3:2019](#).

This document includes Amendment 1 approved by CEN on 7 April 2023.

The start and finish of text introduced or altered by amendment is indicated in the text by tags A1 A1.

This European Standard consists of the following parts, under the general title '*Weldable structural steels for fixed offshore structures – Technical delivery conditions*':

- Part 1: Plates
- Part 2: Sections
- Part 3: Hot finished hollow sections
- Part 4: Cold formed welded hollow sections

In comparison to the previous edition [EN 10225:2009](#) the following technical changes were made:

- split of the standard in four parts;
- the steel names were adapted to [EN 10027-1](#);
- former grades of group 3 are no longer listed, new options with the same enhanced properties have been introduced (*Options 2 and 3*);
- an informative [Annex E](#) was added for the prequalification of steels for fixed offshore structures in arctic areas.

Any feedback and questions on this document should be directed to the users' national standards body. A complete listing of these bodies can be found on the CEN website.

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

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Weldable structural steels for fixed offshore structures – Technical delivery conditions –

Part 3: Hot finished hollow sections

1 Scope

This document specifies requirements for weldable structural steels made of hot finished seamless and high frequency welded hollow sections to be used in the fabrication of fixed offshore structures.

The following thickness limitations are given in this standard:

- for seamless hollow sections up to and including 65 mm;
- for HFW hollow sections up to and including 25,4 mm.

Greater thicknesses can be agreed, provided the technical requirements of this European Standard are maintained.

This European Standard is applicable to steels for offshore structures, designed to operate in the offshore sector but not to steels supplied for the fabrication of subsea pipelines, risers, process equipment, process piping and other utilities. It is primarily applicable to the North Sea Sector, but may also be applicable in other areas provided that due consideration is given to local conditions e.g. design temperature.

NOTE This document has an informative [Annex E](#) on the prequalification of steels for fixed offshore structures in arctic areas.

Minimum yield strengths up to 770 MPa are specified together with impact properties at temperatures down to -40 °C.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

[EN 1011-1](#), *Welding — Recommendations for welding of metallic materials — Part 1: General guidance for arc welding*

[EN 10020](#), *Definition and classification of grades of steel*

[EN 10021](#), *General technical delivery conditions for steel products*

[EN 10027-1](#), *Designation systems for steels — Part 1: Steel names*

[EN 10027-2](#), *Designation systems for steels — Part 2: Numerical system*

[EN 10079](#), *Definition of steel products*

[EN 10164](#), *Steel products with improved deformation properties perpendicular to the surface of the product — Technical delivery conditions*

[EN 10168](#), *Steel products — Inspection documents — List of information and description*

[EN 10204](#), *Metallic products — Types of inspection documents*

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[EN 10210-2](#), *Hot finished structural hollow sections of non-alloy and fine grain steels — Part 2: Tolerances, dimensions and sectional properties*

[CEN/TR 10261](#), *Iron and steel — European standards for the determination of chemical composition*

[EN ISO 148-1](#), *Metallic materials — Charpy pendulum impact test — Part 1: Test method (ISO 148-1)*

[EN ISO 377](#), *Steel and steel products — Location and preparation of samples and test pieces for mechanical testing (ISO 377)*

[EN ISO 643](#), *Steels — Micrographic determination of the apparent grain size (ISO 643)*

[EN ISO 2566-1](#), *Steel — Conversion of elongation values — Part 1: Carbon and low alloy steels (ISO 2566-1)*

[EN ISO 4063](#), *Welding and allied processes — Nomenclature of processes and reference numbers (ISO 4063)*

[EN ISO 4136](#), *Destructive tests on welds in metallic materials — Transverse tensile test (ISO 4136)*

[EN ISO 4885](#), *Ferrous materials — Heat treatments — Vocabulary (ISO 4885)*

[EN ISO 6507-1](#), *Metallic materials — Vickers hardness test — Part 1: Test method (ISO 6507-1)*

[EN ISO 6892-1](#), *Metallic materials — Tensile testing — Part 1: Method of test at room temperature (ISO 6892-1)*

[EN ISO 6947](#), *Welding and allied processes — Welding positions (ISO 6947)*

[EN ISO 8492](#), *Metallic materials — Tube — Flattening test (ISO 8492)*

[EN ISO 9712](#), *Non-destructive testing — Qualification and certification of NDT personnel (ISO 9712)*

[EN ISO 10893-2](#), *Non-destructive testing of steel tubes — Part 2: Automated eddy current testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of imperfections (ISO 10893-2)*

[EN ISO 10893-3](#), *Non-destructive testing of steel tubes — Part 3: Automated full peripheral flux leakage testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for the detection of longitudinal and/or transverse imperfections (ISO 10893-3)*

[EN ISO 10893-5](#), *Non-destructive testing of steel tubes — Part 5: Magnetic particle inspection of seamless and welded ferromagnetic steel tubes for the detection of surface imperfections (ISO 10893-5)*

[EN ISO 10893-8](#), *Non-destructive testing of steel tubes — Part 8: Automated ultrasonic testing of seamless and welded steel tubes for the detection of laminar imperfections (ISO 10893-8)*

[EN ISO 10893-9](#), *Non-destructive testing of steel tubes — Part 9: Automated ultrasonic testing for the detection of laminar imperfections in strip/plate used for the manufacture of welded steel tubes (ISO 10893-9)*

[EN ISO 10893-10](#), *Non-destructive testing of steel tubes — Part 10: Automated full peripheral ultrasonic testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of longitudinal and/or transverse imperfections (ISO 10893-10)*

[EN ISO 10893-11](#), *Non-destructive testing of steel tubes — Part 11: Automated ultrasonic testing of the weld seam of welded steel tubes for the detection of longitudinal and/or transverse imperfections (ISO 10893-11)*

[EN ISO 14284](#), *Steel and iron — Sampling and preparation of samples for the determination of chemical composition (ISO 14284)*

[EN ISO 15614-1](#), *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys (ISO 15614-1)*

[ISO 11484](#), *Steel products — Employer's qualification system for non-destructive testing (NDT) personnel*

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[ISO 12135](#), *Metallic materials — Unified method of test for the determination of quasistatic fracture toughness*

[ISO 15653](#), *Metallic materials — Method of test for the determination of quasistatic fracture toughness of welds*