

Square & Rectangular Hollow Sections

Welded hollow sections — section range, wall thickness and standards.

What this covers

Square and rectangular hollow sections are made the same way as round pipe, then re-formed and sized to the square or rectangular section after welding. The table gives the ranges published for the two lines we build in this format.

Line	Round	Square	Rectangular	Wall	Cut length tol.
HG127	Φ76 – Φ127 mm	30×30 – 100×100	20×40 – 120×80	1.5 – 5.0 mm	0 – 6 mm
HF ERW line	Φ16 – Φ50 mm	14×14 – 40×40	10×20 – 40×50	0.5 – 2.5 mm	0 – 3 mm

The section is set by the roll tooling. If the section you sell is outside these ranges, send the drawing — tooling is designed and cut per order.

Standards the sections are specified to

- **ASTM A500** — cold-formed welded carbon steel structural tubing; the specification most hollow sections for construction are bought to.
- **ASTM A513** — electric-resistance-welded carbon and alloy steel *mechanical* tubing, where tighter dimensional control than structural tubing is wanted.
- **EN 10219** — cold formed welded structural hollow sections, the European route for the same family of shapes.
- **GB/T 6728** — cold formed steel hollow sections.

The applicable standard governs grade, mechanical properties and tolerances. Grade and coating for your order are confirmed at quotation.

What we need to quote

Section and dimensions (or the drawing), wall thickness, length and length tolerance, material grade or standard, required output, and whether the line must also run round pipe from the same mill.

Machine pages and further reading

- HG127 tube mill — round, square and rectangular — steelpipemachines.com/posts/hg127-tube-mill-for-diameter-10-150mm-thickness-1-5mm
- HF ERW pipe and tube rolling line — steelpipemachines.com/posts/high-frequency-erw-pipe-tube-rolling-line