

# ILNAS

Institut luxembourgeois de la normalisation  
de l'accréditation, de la sécurité et qualité  
des produits et services

**ILNAS-EN 39:2001**

**04/2001**



## National Foreword

This European Standard EN 39:2001 was adopted as Luxembourgish Standard ILNAS-EN 39:2001.

Every interested party, which is member of an organization based in Luxembourg, can participate for FREE in the development of Luxembourgish (ILNAS), European (CEN, CENELEC) and International (ISO, IEC) standards:

- Participate in the design of standards
- Foresee future developments
- Participate in technical committee meetings

<https://portail-qualite.public.lu/fr/normes-normalisation/participer-normalisation.html>

### **THIS PUBLICATION IS COPYRIGHT PROTECTED**

Nothing from this publication may be reproduced or utilized in any form or by any mean - electronic, mechanical, photocopying or any other data carries without prior permission!

English version

## Loose steel tubes for tube and coupler scaffolds - Technical delivery conditions

Tubes libres en acier pour échafaudages à tubes et raccords - Conditions techniques de livraison

Systemunabhängige Stahlrohre für die Verwendung in Trag- und Arbeitsgerüsten - Technische Lieferbedingungen

This European Standard was approved by CEN on 18 January 2001.

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 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 Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: rue de Stassart, 36 B-1050 Brussels

## Contents

Foreword.....	3
1 Scope .....	4
2 Normative references .....	4
3 Terms and definitions.....	5
4 Classification and designation .....	5
4.1 Classification.....	5
4.2 Designation.....	5
5 Information to be supplied by the purchaser .....	5
5.1 Mandatory Information .....	5
5.2 Options.....	5
5.3 Examples of ordering .....	6
6 Manufacturing process .....	6
6.1 Steelmaking process .....	6
6.2 Tube manufacture.....	6
7 Requirements .....	6
7.1 General.....	6
7.2 Chemical composition and mechanical properties .....	7
7.3 Appearance.....	7
7.4 Straightness .....	7
7.5 External weld bead and preparation of ends .....	7
7.6 Dimensions, mass and tolerances .....	8
8 Inspection .....	9
8.1 Type of inspection .....	9
8.2 Inspection documents.....	9
8.3 Summary of inspection and testing .....	10
9 Sampling .....	10
9.1 Frequency of tests .....	10
9.2 Preparation of samples and test pieces .....	11
10 Test methods.....	11
10.1 Tensile test .....	11
10.2 Flattening test.....	11
10.3 Visual examination.....	11
10.4 Dimensional inspection.....	12
11 Retests, sorting and reprocessing.....	12
12 Marking .....	12
13 Coating.....	12
Annexe A (informative) Values for design of structures.....	13
Bibliography .....	14

## Foreword

This European Standard has been prepared by Technical Committee ECISS/TC 29 “Steel tubes and fittings for steel tubes”, the secretariat of which is held by UNI, in conjunction with CEN/TC 53 “Temporary works equipment”

This European Standard replaces HD 1039:1990.

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 October 2001, and conflicting national standards shall be withdrawn at the latest by October 2001.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

This European Standard is derived with modifications from Harmonisation Document HD 1039 “Steel tubes for falsework and working scaffolds -Requirements, tests”.

This European Standard cancels and replaces HD 1039:1990 “Steel tubes for falsework and working scaffolds - Requirements, tests”.

The significant technical changes are:-

- tubes will now be supplied galvanized unless an option for them to be supplied without a coating (bare) or painted is specified.
- all tubes are now required to be suitable for galvanising.
- requirements for the coating, previously contained in Annexes A and B are now covered (in accordance with CEN rules) by reference to European or International Standards and are not included in the text of this standard.
- tubes may only be manufactured using killed steel.
- the maximum tensile strength of the tubes has been increased to 520 MPa <sup>1)</sup>.
- a maximum manganese content has been introduced and the sulphur and phosphorus contents reduced.
- the mass tolerance for single tubes has been changed from - 8% to - 7,5%. The maximum single tube mass tolerance and the mass tolerance for batches of tubes have been deleted from the standard (outside diameter tolerances have not been changed).
- length types, standard or approximate or exact, and tolerances on those length types are now specified.
- a flattening test requirement has been introduced for welded tubes.
- requirements for the type and content of inspection documents have been introduced for use when inspection documentation is specified.
- specific inspection is now permitted as an option with testing frequencies specified.
- the depth of marking of at least 0,2 mm is now a recommendation with an option to specify it as a requirement. The order of marking has changed slightly in order to preserve the separation of standard number and thickness type.

Annex A is informative.

---

1) 1 MPa = 1 N/mm<sup>2</sup>