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Purchasing guidelines for: EN 10219-1:2006 High Tensile Tube [3.2 mm]

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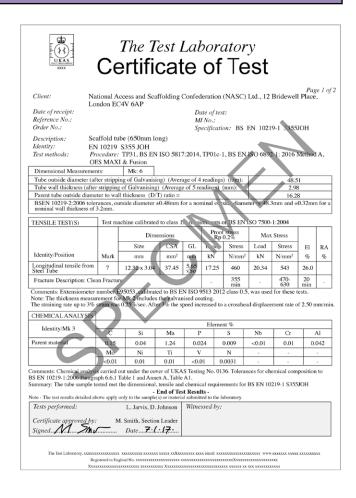
INTRODUCTION

The purpose of this guidance note is to detail best purchasing practice for EN 10219-1:2006 High Tensile 3.2 mm scaffold tube. If the tube is sourced from an NASC compliant company, as demonstrated by the NASC CoP assessment report, then no further action is required, other than a visual inspection of your supplier's certificate of product compliance with the NASC CoP product audit (a list of suppliers and products may be found on the NASC website). If the tube is not sourced from an NASC compliant company, then the guidelines below should be followed.

TEST DATA

Test data is the criteria to which the product is independently tested as seen on the test report example opposite, & should consist of:

- Annual testing should be on EN 10219-1 S355 JOH tube for all suppliers/manufacturers as follows:
- Chemical analysis [inc. nitrogen content.
- Mechanical analysis.
- Outside diameter & wall thickness dimension.
- Annual tests must be by a UKAS accredited facility or TUV/SGS.









MATERIAL CERTIFICATION

You need to check that a material test certificate from the manufacturer/supplier are available for all EN 10219-1 tube.

Below is an example of a material test certificate, which will detail the following information:

- The British or European specification/standard, EN 10219-1:2006 S355 JOH.
- The specification/standard should be clearly identified on the test certificate.
- The test certificate will detail that it is to the requirements of: EN 10204:2004 section 3.1.

	Contact N	No:		MILL	MILL TEST CERTIFICATE							Certificate No: XXXXX						
Buyer: Buyer s name here Description: SCAFFOLDING TUBE				BE	EN 10204-3.1							STANDARD:EN10219-1				DATE: XXXXXXX		
	GRADE	SIZE (mm)			HEAT NO	Chemical composition (%)						Mechanical property			Technical property			
ITEM				WEIGHT		С	Si	Mn	P	S	AL	Tensile (N/mm²)	Yield (N/mm²)	Elongat- ion %	Impact (Bend	
1	S355JOH	48.3*3.2*6400		743.556	L921182	0.17	0.02	0.16	0.018	10.0	0.029	565	440	37	20 C	0 C -2	Qualified	
2	S355JOH	48.3*3.2*6400		750.505	L921186	0.19	0.02	1.170	0.016	0.012	0.024	575	456	34.0		60	Qualified	
3	S355JOH	48.3*3.2*4870		249.586	L921188	0.17	0.01	1.140	0.017	0.011	0.026	579	421	30.0		65	Qualified	
4	S355JOH	48.3*3.2*3960		149.632	L921183	0.16	0.02	1.140	0.013	0.007	0.024	564	433	32.5		60	Qualified	
5	S355JOH	48.3*3.2*3050		106.636	L921183	0.16	0.02	1.140	0.013	0.007	0.024	564	433	32.5		60	Qualified	
6	S355JOH	48.3*3.2*2430		91.819	L921183	0.16	0.02	1.140	0.013	0.007	0.024	564	433	32.5		60	Qualified	
7	S355JOH	48.3*3.2*1520		78.89	L921188	0.17	0.01	1.140	0.017	0.011	0.026	579	421	30.0		65	Qualified	
		TOTAL		2170.62														
Issuer:							Signed By: DATE:											
Signed by. Signed by.																		

MARKING REQUIREMENTS

You need to check that each tube is marked on the surface with the following information:

- Reference to EN 10219-1, S355 JOH.
- Registered trade mark, or the manufacturer's name, [as indicated by XXXXXX].

Tube should be marked at intervals not exceeding 1.5 m, with the height of the characters at least 4.00 mm and the depth should be at least 0.2 mm.









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