



# Hollow Sections

**Square and rectangular section shaped pipes are produced by sectioning circular pipes on the electric-welding mill line. Application: building structures for different applications.**

Weld shaped pipes are produced from St 1, St 2, St 3 carbon steel grades, 08, 10 and 20 steel grades, as well as from S235JRH, S355J0H, S355J2H, E155, E190, E195, E220, E235, E260 grades.

Pipes are manufactured at the electric-weld pipe units by high-frequency induction welding.

## Product range and scope of application

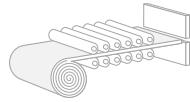
Standard	Outside dia., (mm)	Wall thickness, mm	Steel grade	Scope of application
DIN EN 10219-1-2 DIN EN 10305-5	20 × 20	1.5-2.0	S235JRH, E155, E195, E220, E235, E260	For construction of multi-purpose structures
	25 × 25	1.5-3.0		
	30 × 20	1.5-2.0		
	30 × 30	1.5-3.0		
	40 × 20	1.5-3.0		
	40 × 25			
	40 × 40	1.5-4.0		
	50 × 25	1.5-3.0		
	50 × 30	1.5-4.0		
	50 × 50	2.0-5.0		
	60 × 60	2.0-6.3		
	60 × 30	2.0-4.0		
	60 × 40	2.0-5.0		
	70 × 50			
	70 × 70	2,5-6,3		
	80 × 40	2.0-5.0		
	80 × 60	2,0-5,0		
	80 × 80	3,0-6,3		
	90 × 50	2,0-5,0		
	90 × 90	3,0-6,3		
	100 × 40	2,5-5,0		
	100 × 60	2,5-6,3		
	100 × 80			
	100 × 100	3,0-6,3		
120 × 60	2,5-6,3			
120 × 80	3,0-6,3			
160 × 160	4.5-10.0	S355J2H S235JRH		
180 × 140				
180 × 180				
200 × 160				
200 × 200				

Producing mill: Vyksa Steel Works

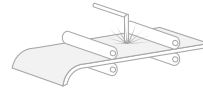
## Hollow sections manufacturing process



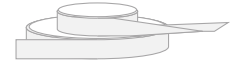
1. Coils examination



2. Uncoiling, leveling and shearing



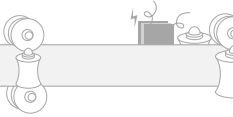
3. Welding



4. Looper



5. Skelp forming



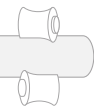
6. HF welding



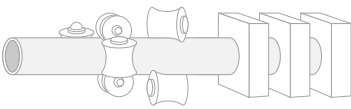
7. Inside & Outside weld bead removal



8. Cooling



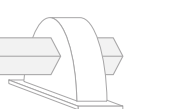
9. Stabilizing stand



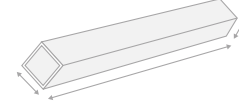
10. Pipe sizing, straightening and sectioning



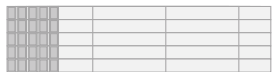
11. Sizing



12. Cutting-to-length



13. Final inspection



14. Packaging & storage



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COMPANY

### JSC "United Metallurgical Company"

Ozerkovskaya naberezhnaya, 28, bld. 2, Moscow, 115184, Russia  
Tel.: +7 (495) 231-77-71; fax: +7 (495) 231-77-72  
e-mail: steel@omk.ru; www.omk.ru