

Trimming of the inner weld bead

Capabilities of Forcon® TT

Do you need a tube that provides a clear, unrestricted tube bore?

Tata Steel Nederland Tubes has expanded its capabilities and can now produce a wide range of dimensions and steel grades of our Forcon® TT structural hollow sections to EN 10219 with a scarfed inside weld bead.

Applications

If pipes, hoses or pistons will be located in the tube, if something needs to be plugged in, if the hollow section will be further processed with the aid of an internal tool or to ensure telescopability - in all these cases a clear and unrestricted tube inside is essential. For these applications we can offer a product fit for purpose with the inner weld bead removed.

Technical support

We want you to get the best from Forcon® TT hollow sections. Our sales team is always happy to answer your questions on steel selection or available options. And our engineers are available to assist you with the application of Forcon® TT for efficient and lightweight design.

Tolerances

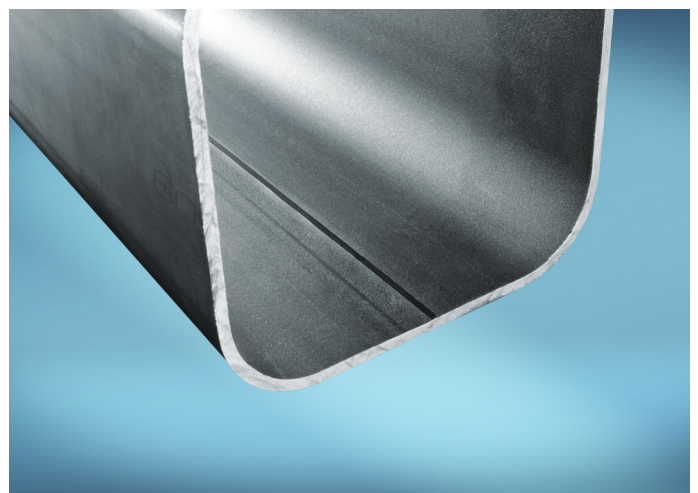
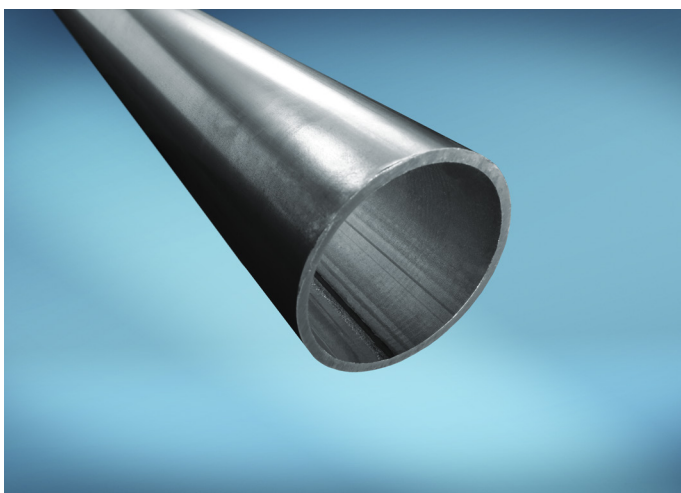
Our standard is a maximum height of the scarfed internal weld bead of +0.3mm. Other specifications on request.

Availability

The scarfing of the internal weld bead is available across the size range indicated in the below tables in the steel grades from S235JRH to S500MH.

Higher steel grades up to S700MH on request.

Minimum order quantities may apply - please contact your Tata Steel representative for details.



D / T (mm)	1.5	2.0	2.3	2.5	2.9	3.0	4.0	5.0	6.0	6.3	7.1	8.0
28.0												
31.8												
32.0												
33.7												
35.0												
38.0												
40.0												
41.5												
42.0												
42.4												
44.5												
45.0												
48.3												
50.0												
51.0												
54.0												
57.0												
60.0												
60.3												
63.5												
70.0												
76.1												
82.5												
88.9												
101.6												
108.0												
114.3												
121.0												
133.0												
139.7												
146.0												
152.4												
156.0												
158.0												
158.4												
159.0												
160.0												
162.0												
162.4												
168.3												
177.8												

www.tatasteelnederland.com/tubes

Tata Steel Nederland Tubes B.V.

Souvereinstraat 35
4903 RH Oosterhout
The Netherlands

E: TubesNL@tatasteeleurope.com

While care has been taken to ensure that the information contained in this publication is accurate, neither Tata Steel, nor its subsidiaries, accept responsibility or liability for errors or for information which is found to be misleading.

Before using products or services supplied or manufactured by Tata Steel and its subsidiaries, customers should satisfy themselves as to their suitability.

Copyright 2025
Tata Steel IJmuiden B.V.