

Docol Tube 420LA

General Product Description

Docol® Tube 420LA is high-strength formable precision tube. Available in circular, rectangular and square shapes, it comes with different coating and surface options including cold rolled, hot rolled pickled, galvanized, galvanized and galfan. Customized shapes and other tailoring options are available upon request. Typical uses include automotive and light engineering, where durability, formability and weldability are important.

Dimension Range

Docol Tube 420LA is available at circular, square and rectangular shapes.

Circular	16 - 88.9 mm
Square	19x19 - 60x60 mm
Rectangular	20x15 - 100x40 mm
Wall thickness	0.9 - 3.0 mm
Mill length	5000 - 8000 mm

Other shapes and sizes are available upon request.

Dimensions

Circular

Diameter	0.9 mm (kg/m)	1.0 mm (kg/m)	1.25 mm (kg/m)	1.5 mm (kg/m)	2.0 mm (kg/m)	2.5 mm (kg/m)	3.0 mm (kg/m)
16 mm	0.335	0.370	0.455	0.536			
18 mm	0.380	0.419	0.516	0.610			
19 mm	0.402	0.444	0.547	0.647			
20 mm	0.424	0.469	0.578	0.684			
22 mm	0.468	0.518	0.640	0.758			
25 mm	0.535	0.592	0.732	0.869	1.13		
28 mm		0.666	0.825	0.980	1.28	1.57	1.85
30 mm		0.715	0.886	1.05	1.38	1.70	2.00
32 mm		0.765	0.948	1.13	1.48	1.82	2.15
35 mm		0.838	1.04	1.24	1.63	2.00	2.37
38 mm		0.912	1.13	1.35	1.78	2.19	2.59
41 mm		0.990	1.22	1.46	1.92	2.37	2.81
44.5 mm		1.07	1.33	1.59	2.10	2.59	3.07
48 mm			1.44	1.72	2.27	2.81	3.33
50 mm				1.79	2.37	2.93	3.48
55 mm				1.98	2.61	3.24	3.85
57 mm				2.05	2.71	3.36	4.00
60 mm				2.16	2.86	3.55	4.22
63.5 mm				2.29	3.03	3.76	4.48
76.1 mm				2.76	3.65	4.54	5.41
88.9 mm					4.29	5.33	6.36

Square

Height x Width	1.0 mm (kg/m)	1.25 mm (kg/m)	1.5 mm (kg/m)	2.0 mm (kg/m)	2.5 mm (kg/m)
19 x 19 mm	0.564	0.694	0.820		
20 x 20 mm	0.595	0.733	0.868		
22 x 22 mm	0.658	0.812	0.962		
25 x 25 mm	0.752	0.930	1.10	1.44	
25.4 x 25.4 mm	0.764	0.945	1.12	1.46	
30 x 30 mm	0.909	1.13	1.34	1.75	2.15
32 x 32 mm	0.972	1.20	1.43	1.88	2.31
35 x 35 mm	1.07	1.32	1.57	2.07	2.54
40 x 40 mm			1.81	2.38	2.93
50 x 50 mm			2.28	3.01	3.72
60 x 60 mm			2.75	3.64	4.50

Rectangular

Height x Width	1.0 mm (kg/m)	1.25 mm (kg/m)	1.5 mm (kg/m)	2.0 mm (kg/m)	2.5 mm (kg/m)	3.0 mm (kg/m)
20 x 15 mm	0.516	0.635				
25 x 15 mm	0.595	0.733	0.868			
30 x 10 mm	0.595	0.733	0.868	1.12		
30 x 15 mm	0.673	0.831	0.985	1.28		
30 x 20 mm	0.752	0.930	1.10	1.44		
30 x 25 mm	0.830	1.03	1.22	1.59		
35 x 15 mm	0.752	0.930	1.10	1.44		
35 x 20 mm	0.830	1.03	1.22	1.59	1.95	
40 x 20 mm	0.909	1.13	1.34	1.75	2.15	
40 x 25 mm	0.987	1.22	1.46	1.91	2.34	
40 x 30 mm	1.07	1.32	1.57	2.07	2.54	
50 x 20 mm	1.07	1.32	1.57	2.07	2.54	2.86
50 x 25 mm		1.42	1.69	2.22	2.74	3.10
50 x 30 mm			1.81	2.38	2.93	3.33
50 x 40 mm			2.05	2.69	3.33	3.80
50.8 x 25.4 mm			1.72	2.26	2.78	3.15
60 x 20 mm			1.81	2.38	2.93	3.33
60 x 30 mm			2.05	2.69	3.33	3.80
60 x 40 mm			2.28	3.01	3.72	4.28
70 x 25 mm			2.16	2.85	3.52	
70 x 30 mm			2.28	3.01	3.72	
70 x 50 mm			2.75	3.64	4.50	5.22
80 x 20 mm			2.28	3.01	3.72	4.28
80 x 40 mm			2.75	3.64	4.50	5.22
80 x 60 mm			3.22	4.26	5.29	
100 x 40 mm			3.22	4.26	5.29	

Mechanical Properties

Grade	Yield strength $R_{p0.2}$ (min MPa)	Tensile strength R_m (min MPa)	Elongation A (min %)
CR420LA	420	490	12
HR420LA	420	490	12

Mechanical properties meet the requirements of EN 10305 (+CR2).

Chemical Composition

Grade	C (max %)	Si (max %)	Mn (max %)	P (max %)	S (max %)	Al _{tot} ¹⁾ (min %)
CR420LA	0.16	0.55	1.70	0.025	0.025	0.020
HR420LA	0.16	0.55	1.70	0.025	0.025	0.020

Chemical composition meets the requirements of EN 10305.

If other chemical elements such as Ti, Nb or V are used, the content of these elements are reported in the inspection document.

1) This requirement is not applicable provided the steel contains a sufficient amount of other nitrogen binding elements, such as Ti, Nb or V.

Tolerances

Characteristic	Circular precision tubes Tolerances based on the requirements of EN 10305-3
Outside diameter (D) ¹⁾	
D < 20	±0.12 mm
20 ≤ D < 32	±0.15 mm
32 ≤ D < 44	±0.20 mm
44 ≤ D < 55	±0.25 mm
55 ≤ D < 70	±0.30 mm
70 ≤ D < 80	±0.35 mm
80 ≤ D < 100	±0.40 mm
100 ≤ D < 108	±0.50 mm
108 ≤ D < 127	±0.60 mm
127 ≤ D ≤ 133	±0.80 mm
Out-of-roundness	The diameter tolerances include the out-of-roundness
Thickness (T)	T ≤ 1.5 mm: ±0.15 mm T > 1.5 mm: ±10% of nominal thickness or ±0.35 mm whichever is the smaller
Straightness	Maximum 0.15% of measured length
Height of internal weld bead, g;	
Bead removed	g ≤ 0.3 mm
Bead not removed	g < 0.8 mm, when T ≤ 1.5 mm g < 0.6 × T, when 1.5 mm < T ≤ 4.0 mm
Mill length	0/+50 mm, 5000 ≤ L ≤ 8000 mm (standard length 6000 mm)
Exact length, single cutting	
30 ≤ L ≤ 1500 mm	±0.5 mm
1500 < L ≤ 4000 mm	±1.0 mm
Exact length, bundle cutting	
1000 ≤ L ≤ 5000 mm	±2 mm
5000 < L ≤ 10000 mm	±3 mm

1) For a maximum distance of 100 mm, the ends may, due to the cutting method, have diameters outside the tolerances

Characteristic	Square, rectangular, flat oval and ellipse precision tubes Tolerances based on the requirements of EN 10305-5
Outside dimensions (H) and (B), longer side ¹⁾	
H < 25 mm	±0.20 mm
25 ≤ H < 40 mm	±0.25 mm
40 ≤ H < 60 mm	±0.30 mm
60 ≤ H < 70 mm	±0.35 mm
70 ≤ H < 80 mm	±0.40 mm
80 ≤ H < 90 mm	±0.50 mm
90 ≤ H < 100 mm	±0.60 mm
100 ≤ H < 120 mm	±0.65 mm
H ≥ 120 mm	±0.70 mm
Side concavity and convexity	Included in outside dimension tolerance
Thickness (T)	T ≤ 1.5 mm: ±0.15 mm T > 1.5 mm: ±10% of nominal thickness or ±0.35 mm whichever is the smaller
Straightness	Maximum 0.15% of measured tube length when shorter side length > 30 mm Maximum 0.25% of measured tube length when the shorter side length ≤ 30 mm
Location of weld seam from the centre line	On narrow side for square and rectangular, optionally on wide side. On wide side for flat oval and ellipse. ± 10% of side length or ± 3 mm, whichever is greater.
Height of internal weld bead (g)	
Bead removed	g ≤ 0.3 mm
Bead not removed	g < 0.8 mm, when T ≤ 1.5 mm g < 0.6 × T, when 1.5 mm < T ≤ 4.0 mm
Squareness of sides	90° ± 1°
Corner profile	R < 1.5 × T, when T ≤ 2.5 mm R < 2.2 × T, when T > 2.5 mm
Twist (V)	V ≤ 3 mm for B and H ≤ 30 mm V ≤ B/10 or ≤ H/10 for B or H > 30 mm
Mill length	0/+50 mm, 5000 ≤ L ≤ 8000 mm (standard length 6000 mm)
Exact length, single cutting	
30 ≤ L ≤ 1500 mm	±0.5 mm
1500 < L ≤ 4000 mm	±1.0 mm
Exact length, bundle cutting	
1000 ≤ L ≤ 5000 mm	±2 mm
5000 < L ≤ 10000 mm	±3 mm

1) For a maximum distance of 100 mm, the ends may, due to the cutting method, have diameters outside the tolerances

Characteristic	Square, rectangular, flat oval and ellipse precision tubes Tolerances based on the requirements of EN 10305-5
Outside dimensions (H) and (B), longer side ¹⁾	
H < 25 mm	±0.20 mm
25 ≤ H < 40 mm	±0.25 mm
40 ≤ H < 60 mm	±0.30 mm
60 ≤ H < 70 mm	±0.35 mm
70 ≤ H < 80 mm	±0.40 mm
80 ≤ H < 90 mm	±0.50 mm
90 ≤ H < 100 mm	±0.60 mm
100 ≤ H < 120 mm	±0.65 mm
H ≥ 120 mm	±0.70 mm
Side concavity and convexity	Included in outside dimension tolerance
Thickness (T)	T ≤ 1.5 mm: ±0.15 mm T > 1.5 mm: ±10% of nominal thickness or ±0.35 mm whichever is the smaller
Straightness	Maximum 0.15% of measured tube length when shorter side length > 30 mm Maximum 0.25% of measured tube length when the shorter side length ≤ 30 mm
Location of weld seam from the centre line	On narrow side for square and rectangular, optionally on wide side. On wide side for flat oval and ellipse. ± 10% of side length or ± 3 mm, whichever is greater.
Height of internal weld bead (g)	
Bead removed	g ≤ 0.3 mm
Bead not removed	g < 0.8 mm, when T ≤ 1.5 mm g < 0.6 × T, when 1.5 mm < T ≤ 4.0 mm
Squareness of sides	90° ± 1°
Corner profile	R ≤ 3.0 × T
Twist (V)	V ≤ 3 mm for B and H ≤ 30 mm V ≤ B/10 or ≤ H/10 for B or H > 30 mm
Mill length	0/+50 mm, 5000 ≤ L ≤ 8000 mm (standard length 6000 mm)
Exact length, single cutting	
30 ≤ L ≤ 1500 mm	±0.5 mm
1500 < L ≤ 4000 mm	±1.0 mm
Exact length, bundle cutting	
1000 ≤ L ≤ 5000 mm	±2 mm
5000 < L ≤ 10000 mm	±3 mm

1) For a maximum distance of 100 mm, the ends may, due to the cutting method, have diameters outside the tolerances

Coatings and Surfaces

Surface designation and general usability		
C	Cold rolled	Paintability or chromium plating are required
GI	Zinc coated (zinc 99%)	Corrosion resistance is required
ZA	Galfan coated (zinc 95%-aluminium 5%)	Corrosion resistance and demanding forming are required
GA	Galvannealed coated (zinc 90%-iron 10%)	Corrosion resistance and paintability are required

Surface is slightly oiled to protect it from corrosion during transportation and short-term storing. By request, tubes can be delivered dry, however in that case SSAB will not be responsible for any possible rust.

Surface roughness, Ra	
C	< 0,6 µm

Different metal coatings and minimum coating mass			
Coating thickness	Zinc (GI)	Galfan (ZA)	Galvannealed (GA)
μm^3)	g/m^2 ¹⁾	g/m^2 ²⁾	g/m^2 ¹⁾
7	GI50/50		GA50/50
8	GI60/60		GA60/60
20	GI115/115	ZA255	

1) Minimum coating mass - g/m² refers the coating mass for each side in g/m² according to VDA 239-100.

2) Minimum coating mass - g/m² refers the total weight of coatings on both sides of a 1 m² plate.

3) Theoretical guidance values for coating thickness per surface.

Indicative specification for proper coating selection			
Coating type	Coating mass [g/m ²]	Coating life - marine [year]	Properties
GI	50/50	10	Good weldability and formability with tolerable corrosion resistance.
GI	115/115	25	Good combination of corrosion resistance and usability.
ZA	255	80	Superior corrosion resistance in marine condition
GA	50/50	15	Superior paint adhesion and corrosion resistance as painted. Weldability in same level as cold rolled material under proper welding conditions.
GA	60/60	17	Superior paint adhesion and corrosion resistance as painted. Weldability in same level as cold rolled material under proper welding conditions.
GA	140	20	Superior paint adhesion and corrosion resistance as painted. Weldability in same level as cold rolled material under proper welding conditions.

Delivery Conditions

The tubes are not intended to undergo any heat treatment after welding and sizing as that may alter the mechanical properties of the material.

The tubes are oiled with anti-corrosive oil.

Fabrication and Other Recommendations

For information concerning fabrication, see SSAB's brochures on www.ssab.com/downloads or consult Tech Support, techsupport@ssab.com.

Appropriate health and safety precautions must be taken when welding, cutting, grinding or otherwise working on the product.

Contact Information

www.ssab.com/contact