

Terms of delivery

Sheet piling steel grades for hot-rolled sheet piles conforming to DIN EN 10 248-1

Steel grade	Minimum yield point	Tensile strength	Minimum elongation
	MPa	MPa	%
S 240 GP	240	340	26
S 270 GP	270	410	24
S 320 GP	320	440	23
S 355 GP	355	480	22
S 390 GP*)	390	490	20
S 430 GP*)	430	510	19

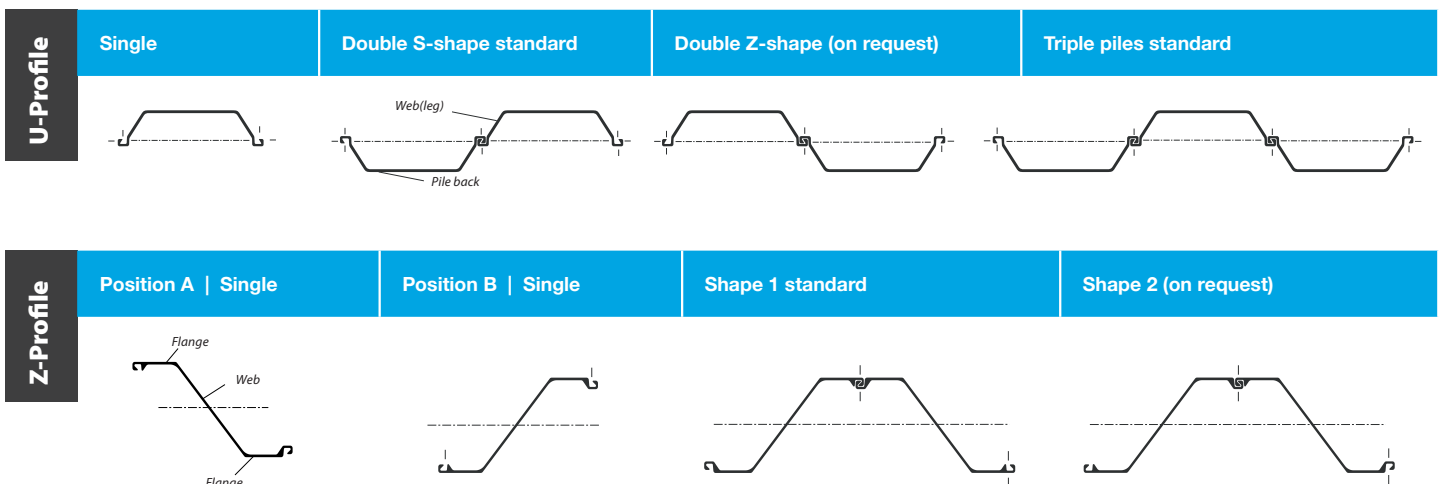
*) For the higher-strength sheet piling steels S 390 GP and S 430 GP, an approval certificate (Z-30, 1-17) from the building supervisory authorities is available.

Deviation limits and dimensional tolerances for hot-rolled sheet piles made of unalloyed steels conforming to DIN EN 10 248-2

Pile width	Single piles $\pm 2\%$; double and triple piles $\pm 3\%$
Wall thicknesses of U-sections	t: up to 8.5 mm = ± 0.5 mm; over 8.5 mm = $\pm 6\%$ t s: up to 8.5 mm = ± 0.5 mm; over 8.5 mm = $\pm 6\%$ s*
Wall thicknesses of Z-sections and straight-web sections	t, s: up to 8.5 mm = ± 0.5 mm; over 8.5 mm = $\pm 6\%$ s, t
Height of U-sections	h: up to 200 mm = ± 4 mm; over 200 mm = ± 5 mm
Height of Z-sections	h: up to 200 mm = ± 5 mm; von 200 up to 300 mm = ± 6 mm; over 300 mm = ± 7 mm
Head flush	For multiple profiles +20/-0 mm
Deviation from straightness	The longitudinal deviation from straightness must not exceed 0.2% of pile length.
Pile length	Sheet pile lengths are permitted to deviate by ± 200 mm from the ordered lengths.
Cut	Cut at right angles to the longitudinal axis. The total deviation between the highest and lowest points in the cutting plane, measured on a single pile along the longitudinal axis, must not exceed 2% of pile width.
Weight	The tolerance between the arithmetic weight (according to section tables) and weighed weight of the total consignment must be within $\pm 5\%$.
Section interlocks	The interlocks shall have adequate free play so that the piles can be fitted into each other and they must engage in such a manner that the in-service forces can be transmitted. The minimum interlock overlap on U and Z piles must not be less than 4 mm and on straight-web sections not less than 7 mm.

*) Normally the positive tolerance shall be at the discretion of the manufacturer. At the time of the enquiry and order, a limitation on the positive tolerance can be agreed. In this case, the following values should be chosen: + 0,5 mm for $s < 8,5$ mm and + 6 % for $> 8,5$ mm.

Available types

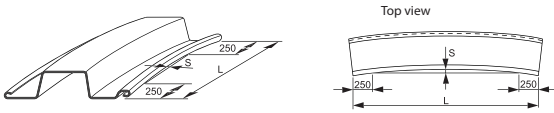
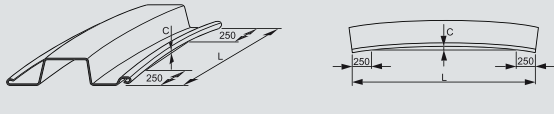
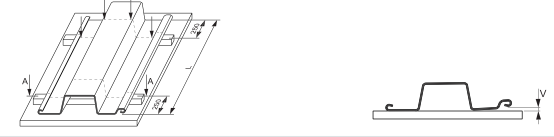


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Sheet piling steel grades for cold formed sheet piles conforming to EN 10 249-1

Steelgrade	Minimum yield point	Tensile strength	Minimum elongation
	MPa	MPa	%
S 235 JRC	235	360 - 510	26
S 275 JRC	275	410 - 560	23
S 355 J0C	355	470 - 630	22

Deviation limits and dimensional tolerances for cold formed sheet piles made of unalloyed steels conforming to EN 10 249-2

Pile width	Single piles $\pm 2\%$; double piles $\pm 3\%$
Wall thicknesses	The thickness is indicated in table 3 of the EN 10 051.
Height	h: up to 200 mm = ± 4 mm; over 200 up to 300 mm = ± 6 mm; over 300 up to 400 mm = ± 8 mm; over 400 mm = ± 10 mm.
Deviation from straightness S	The longitudinal deviation from straightness S, must not exceed 0,25 % of the pile length. 
Deviation from straightness C	The longitudinal deviation from straightness C, must not exceed 0,25 % of the pile length. 
Torsion V	The Size V must not exceed $\pm 0,2\%$ of the pile length, with a maximum of 100 mm. 
Pile length	Sheet pile lengths are permitted to deviate by ± 50 mm from the ordered lengths.
Cut	Cut at right angles to the longitudinal axis. The total deviation between the highest and lowest points in the cutting plane, measured on a single pile along the longitudinal axis, must not exceed 2 % of the pile width.
Weight	The tolerance between the arithmetic weight (according to section tables) and weighed weight of the total consignment must be within $\pm 7\%$.

Available types

IBO	Shape 1 standard	Shape 2 (on request)	MKU	Shape 1 standard	Shape 2 (on request)
					
VKZ	Position A Single	Position B Single	Shape 1 standard	Shape 2 (on request)	
	