STEEL TUBE INSTITUTE

HSS Market Availability

Nine STI member producers, domestically produced

This guide summarizes regular-schedule and on-demand production capability for hollow structural sections (HSS) produced by the nine STI member producers — Atlas Tube, Bull Moose Tube, H.W. Metals, Maruichi American (MAC), Maruichi Leavitt, Maruichi Oregon (MOST), Nucor Tubular, Searing Industries, and Vest — across over 20 facilities, representing the majority of the domestic market. For current real-time availability across producers, use the **STI Capability Tool**.

PRODUCERS	FACILITIES	A500 COMBOS	A1085 COMBOS	A1065 COMBOS
9	**20+**	**1,007**	**648**	**1,496**
STI members	Domestic	72% produced regularly	Produced on demand	Produced on demand

ASTM GRADES

Scope of this guide: the tables in this guide cover **ASTM A500**, which is commonly produced on a regular rolling schedule. ASTM A1085's size availability largely mirrors A500's but is produced on demand only; ASTM A1065 is also on demand.

GRADE	DESCRIPTION	MINIMUM YIELD, F_Y	WALL THICKNESS	SIZE RANGE	AVAILABILITY
ASTM A500	Cold-formed carbon steel structural tubing — typically roll-formed from coil and joined by electric-resistance welding (ERW); seamless is also permitted by the spec. The most widely specified HSS standard for general structural use. Grade C (F_y = 50 ksi) is the recommended default.	50 ksi (Grade C)	Up to 1″	Max perimeter = 88″ per spec	**Produced Regularly** *see tables on following pages*
ASTM A1085	Cold-formed welded carbon steel HSS, manufactured like A500 but with tighter wall thickness and corner radii tolerances plus an added minimum mass tolerance. The tighter wall thickness tolerance lets designers use the full nominal wall thickness (no 0.93 reduction). Includes a Charpy V-notch (CVN) requirement.	50 ksi	0.148″ to 1″	Similar to A500; max perimeter = 88″	**Produced on Demand**
ASTM A1065	Cold-formed HSS that extends beyond A500's size range for square and rectangular sections. Each tube is press-brake-formed from two C-shape plate halves and joined by submerged-arc welds (SAW) along two seams. Typically specified for tall columns, long spans, and heavily-loaded members. Grades 50 and 50W (weathering).	50 ksi	Up to 1″	Square up to 50″×50″; rectangular up to 60″×40″; round not offered. Max perimeter = 200″.	**Produced on Demand**

COMMON STOCK LENGTHS FOR A500 HSS **20′ · 24′ · 40′ · 48′**

Stock lengths vary by size, wall thickness, and region. These reflect the most commonly available stock carried by major structural service centers. Custom and extended lengths are also available on direct mill orders or through specialty distributors.

HOW TO READ THE TABLES

PRODUCED REGULARLY

On the producer's published rolling schedule. Standard sizes are typically maintained in distributor inventory and can be filled within normal lead times.

PRODUCED ON DEMAND

The producer has the equipment and tooling to manufacture this size but does not run it on a recurring cycle. Expect extended lead times, minimum order quantities, and potential tooling setup fees.

LEGEND

REGULARLY PRODUCED
1 2 3–4 5–6 7 8

REGULARLY PRODUCED & ON DEMAND
6 — 6 regularly produce
6_{+2} — 6 regularly + 2 on demand

ON DEMAND ONLY

NOT PRODUCED
—

SQUARE HSS — A500

Rows = outside dimension, columns = wall thickness.

Size ↓ / Wall thickness →	0.065″	0.083″	0.095″	0.1″	0.109″	0.12″	1/8″	0.134″	0.165″	0.18″	3/16″	0.238″	1/4″	5/16″	3/8″	1/2″	5/8″	3/4″	7/8″	1″
1″ × 1″	2	3 +4	1 +1	4 +4	1 +2	4 +3	4 +2	—	—	—	—	—	—	—	—	—	—	—	—	—
1¼″ × 1¼″	2	2 +5	—	3 +4	—	4 +3	4 +2	1	—	1 +2	—	—	—	—	—	—	—	—	—	—
1½″ × 1½″	2	3 +4	1 +1	2 +5	1 +2	6 +2	3 +4	—	5	1 +4	7	—	4	—	—	—	—	—	—	—
1¾″ × 1¾″	—	1 +3	—	—	—	1 +3	—	—	—	—	1 +2	—	—	—	—	—	—	—	—	—
2″ × 2″	1	4 +3	1 +2	2 +5	1 +1	6 +2	5 +2	1 +5	5	—	7	—	7	1	—	—	—	—	—	—
2⅛″ × 2⅛″	—	1	—	—	1	—	2	2	—	—	1	—	—	—	—	—	—	—	—	—
2.17″ × 2.17″	—	2	—	2	1	—	2	2	—	—	1	—	1	—	—	—	—	—	—	—
2¼″ × 2¼″	—	1	1	—	—	1	4	4	—	—	3	—	3	—	—	—	—	—	—	—
2½″ × 2½″	1	3 +1	—	1 +2	1 +2	6 +2	6 +2	2 +2	5	—	8	4 +2	7 +1	3	—	—	—	—	—	—
2.53″ × 2.53″	—	—	—	—	—	—	—	—	—	—	—	3 +3	1 +5	—	—	—	—	—	—	—
3″ × 3″	—	2 +1	—	—	—	5 +3	6 +2	—	6	—	8	1 +5	8	5 +1	4	—	—	—	—	—
3½″ × 3½″	—	3	—	—	—	4 +4	4 +4	—	—	—	7 +1	—	7 +1	4 +2	3 +1	—	—	—	—	—
4″ × 4″	—	1 +2	3	—	—	4 +3	6 +2	—	—	—	8	—	8	8	8	6 +1	—	—	—	—
4½″ × 4½″	—	—	—	—	—	—	2 +1	—	—	—	2 +1	—	2 +1	2 +1	2 +1	3	—	—	—	—
5″ × 5″	—	—	—	—	—	3 +3	4 +4	—	—	—	8	—	8	8	8	8	—	—	—	—
5½″ × 5½″	—	—	—	—	—	—	1 +1	—	—	—	1 +1	—	1 +1	1 +1	1 +1	1 +1	1	—	—	—
6″ × 6″	—	—	—	—	—	1 +4	2 +5	—	—	—	8	—	8	8	8	8	3 +1	—	—	—
7″ × 7″	—	—	—	—	—	—	1 +2	—	—	—	7 +1	—	8	7 +1	8	8	2 +2	—	—	—
8″ × 8″	—	—	—	—	—	—	1 +1	—	—	—	8	—	8	8	8	8	3 +1	—	—	—
9″ × 9″	—	—	—	—	—	—	2	—	—	—	2 +3	—	2 +4	1 +5	2 +4	2 +4	1 +4	—	—	—
10″ × 10″	—	—	—	—	—	—	—	—	—	—	6	—	8	8	8	8	3 +1	2	—	—
12″ × 12″	—	—	—	—	—	—	—	—	—	—	2	—	3	3	3	3	3	2	—	—
14″ × 14″	—	—	—	—	—	—	—	—	—	—	—	—	1	3	3	3	3	2	1	1
16″ × 16″	—	—	—	—	—	—	—	—	—	—	—	—	—	1	1	1	1	1	1	1
18″ × 18″	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1	1	1	1	1	1
20″ × 20″	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1	1	1	1	1	1
22″ × 22″	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1	1	1	1	1	1

ROUND HSS — A500

Rows = outside diameter (OD), columns = wall thickness. Split into three tiers by OD.

SMALL ROUNDS

Outside diameter less than 4″

See legend on page 2

Wall thickness → / OD ↓	0.065″	0.083″	0.095″	0.1″	0.109″	0.113″	0.12″	1/8″	0.133″	0.134″	0.14″	0.145″	0.152″	0.154″	0.179″	0.18″	3/16″	0.191″	0.2″	0.203″	0.216″	0.218″	1/4″	0.276″	0.3″	5/16″
0.84″	—	1	—	—	4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
1″	1	1	1	1	1	—	—	1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
1.05″	—	2	—	1	1	6	—	1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
1¼″	1	1	1	1	—	—	1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
1.315″	—	3	—	1	4+1	—	1	2+2	6	—	—	—	—	—	1	—	—	—	—	—	—	—	—	—	—	—
1½″	1	1	—	1+1	1	—	4+1	1+1	—	2+1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
1.66″	—	4	1	2	7	—	—	2+3	—	2+3	7	—	—	—	—	—	—	2+1	—	—	—	—	—	—	—	—
1¾″	—	—	—	—	—	—	—	1+3	—	1+2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
1.9″	—	1	—	2+3	7	—	1+4	2+3	—	2	—	7	—	—	—	2	1+2	—	3	—	—	—	—	—	—	—
2″	—	1	1	2+1	1	—	1	2+1	—	1+1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
2¼″	—	—	—	—	—	—	—	3	—	—	—	—	—	—	—	—	2	—	—	—	—	—	—	—	—	—
2⅜″	—	2	1	1	5+1	—	—	3+3	—	2+2	—	—	—	6	—	—	3+1	—	—	—	—	3+1	2	—	—	—
2½″	—	—	—	—	—	—	1+3	3+2	—	1+1	—	—	—	—	3	—	2+2	—	—	—	—	—	1+2	—	—	—
2⅞″	—	1	—	1	1+1	—	4+3	2+3	—	1+1	—	—	—	—	—	—	2+4	—	—	7	—	—	1+3	2+2	—	—
3″	—	—	1	1	1	—	2+5	3+2	—	4	—	—	3	—	—	—	4+2	—	—	3	3	—	3+2	—	—	1
3½″	—	1	—	1	1	—	4+3	2+5	—	2	—	—	—	1	—	—	2+5	—	—	4	7	—	1+5	—	2+3	2

MEDIUM ROUNDS

Outside diameter 4″ to 10″

See legend on page 2

Wall thickness → / OD ↓	0.12″	1/8″	0.134″	0.148″	3/16″	0.22″	0.226″	0.237″	0.247″	1/4″	0.258″	0.28″	5/16″	0.318″	0.322″	0.337″	0.355″	3/8″	0.432″	7/16″	1/2″	0.562″	19/32″	5/8″
4″	5+2	3+3	1	—	4+3	1+3	6+1	1+2	—	2+3	—	—	1+3	3+1	—	—	—	1	—	—	—	—	—	—
4½″	4	5	1+4	—	3+4	—	—	7	—	2+4	—	—	2+3	—	—	4+1	—	3+2	—	—	—	—	—	—
5″	1+4	1+6	1+5	1	4+3	—	—	—	1+2	4+2	1+2	—	3+1	—	—	—	1+2	3+1	—	—	2+1	—	—	—
5½″	—	1	1	—	1+1	—	—	—	—	1+1	1	—	1+1	—	—	—	—	2+1	—	—	1+2	—	—	—
5.563″	—	—	2+4	—	2+4	—	—	—	—	2+5	7	—	—	—	—	—	—	4+1	—	—	2+2	—	—	—
6″	—	1+2	—	—	3	—	—	—	—	3	—	1+1	3	—	—	—	—	3	—	—	2+1	—	—	—
6⅝″	—	1+3	3+3	—	3+4	—	—	—	—	3+4	—	7	1+5	—	—	—	—	2+4	5+1	1+2	3+2	1+1	—	1
6⅞″	—	—	—	—	1	—	—	—	—	1	—	—	1	—	—	—	—	1	—	—	—	—	—	—
7″	—	—	—	—	1+1	—	—	—	—	1+1	—	—	2	—	—	—	—	1+1	—	—	2	—	—	—
7½″	—	—	—	—	1	—	—	—	—	2	—	—	2	—	—	—	—	2	—	—	2	—	—	1
8⅝″	—	1	—	1	3+3	—	—	—	—	4+2	—	—	1+4	—	6	—	—	2+4	—	—	6	—	1+1	1+2
9⅝″	—	—	—	—	—	—	—	—	—	1+1	—	—	1+1	—	—	—	—	1+1	—	—	1+1	—	—	1
10″	—	—	—	—	2	—	—	—	—	2	—	—	2	—	—	—	—	2	—	—	2	—	—	1

LARGE ROUNDS

Outside diameter greater than 10″

See legend on page 2

Wall thickness → / OD ↓	0.18″	3/16″	0.219″	1/4″	5/16″	0.365″	3/8″	0.393″	0.406″	7/16″	1/2″	0.562″	19/32″	5/8″	11/16″	3/4″	7/8″	1″
10¾″	—	3 +1	—	4 +1	2 +2	5	3 +2	—	—	—	4 +1	—	1 +1	1 +2	—	1	—	—
11¾″	—	—	—	1	—	—	1	—	—	—	1	—	—	1	—	—	—	—
12″	—	—	—	1 +1	1	—	1 +1	—	—	—	1 +1	—	—	1	—	—	—	—
12¾″	1 +2	—	—	4 +1	3 +1	—	5	2 +2	2 +2	—	4 +1	1 +1	—	2 +1	1 +1	2	1	—
13⅜″	—	—	—	1	1	—	1	—	—	—	1	—	—	1	—	—	—	—
14″	—	1	1	2 +1	1 +2	—	3	—	—	1 +1	3	—	1	3	1	1 +1	1	—
16″	—	1	1	3	1 +2	—	3	—	—	1 +1	3	—	—	3	1	1 +1	1	1
18″	—	—	—	2	1 +2	—	3	—	—	—	3	—	—	3	1	2 +1	1	1
20″	—	—	—	1	1	—	1	—	—	—	1	—	—	1	—	1	1	1
24″	—	—	—	—	—	—	1	—	—	—	1	—	—	1	—	1	1	1
28″	—	—	—	—	—	—	—	—	—	—	1	—	—	1	—	1	1	1

Note: Producers sometimes report wall thicknesses with minor variations in the thousandths of an inch. For ease of use, three such cases in this table have been consolidated under their nominal fractional value: 7/16″ (0.437″ or 0.4375″), 19/32″ (0.593″ or 0.594″), 11/16″ (0.687″ or 0.69″).

RECTANGULAR HSS — A500

Rows = size (long × short), columns = wall thickness. Split into three tiers by long-side dimension.

SMALL RECTANGLES

Long side less than 5″

See legend on page 2

Wall thickness → / Size ↓	0.065″	0.083″	0.095″	0.1″	0.109″	0.1181″	0.12″	1/8″	0.134″	0.165″	0.18″	3/16″	0.1969″	0.2362″	1/4″	5/16″	3/8″
1½″ × 1″	—	1 +3	—	1	—	—	2 +2	1	—	—	—	—	—	—	—	—	—
1.97″ × 1.57″	—	—	—	—	—	1 +1	—	—	—	—	—	—	—	2	—	—	—
2″ × 1″	—	2 +3	1	2 +3	1	—	3 +2	2 +3	—	2	—	1 +1	—	—	—	—	—
2″ × 1½″	—	1	—	—	—	—	1	2 +3	—	2	—	1 +2	—	—	—	—	—
2.36″ × 1.57″	—	—	—	—	—	3	—	—	—	—	—	—	—	2	—	—	—
2½″ × 1″	—	—	—	—	—	—	1	4	—	—	—	2	—	—	—	—	—
2½″ × 1½″	1	1	—	1 +1	—	—	4 +3	3 +4	1 +5	5	—	6 +1	—	—	4 +1	—	—
2½″ × 2″	—	—	—	—	—	—	—	4	—	3	—	4	—	—	4	—	—
3″ × 1″	1	2 +1	—	1	—	—	1 +1	4 +2	—	2	—	1 +2	—	—	1	—	—
3″ × 1½″	—	3 +3	—	1 +1	—	—	3	5 +2	—	1 +3	1 +4	6	—	—	4	—	—
3″ × 2″	—	4 +1	2	1 +1	1 +1	—	6 +2	6 +2	—	1 +4	—	8	—	—	8	2 +2	—
3″ × 2½″	—	—	—	—	—	—	—	3	—	—	—	3	—	—	3	1	—
3.15″ × 2.36″	—	—	—	—	—	3	—	—	—	—	—	—	—	3	—	—	—
3½″ × 1½″	—	—	—	—	—	—	—	2 +5	—	6	—	2 +5	—	—	2 +2	1	—
3½″ × 2″	—	—	—	—	—	—	—	3	—	—	—	3	—	—	3	—	—
3½″ × 2½″	—	—	—	—	—	—	4 +3	4 +4	—	6	—	7 +1	—	—	6 +2	2	1 +1
3.94″ × 1.97″	—	—	—	—	—	2	—	—	—	—	—	—	1 +1	2	—	—	—
4″ × 1″	—	1	—	—	1	—	1	—	—	—	—	—	—	—	—	—	—
4″ × 1½″	—	—	—	—	—	—	—	1 +3	—	3	—	1 +1	—	—	—	—	—
4″ × 2″	—	2	1 +1	—	2	—	5 +3	5 +3	—	5	—	8	—	—	8	5 +1	4
4″ × 2½″	—	—	—	—	—	—	1	2	—	—	—	3	—	—	3	—	—
4″ × 3″	—	—	2	—	2	—	5 +3	6 +2	—	—	—	8	—	—	8	5 +1	4

MEDIUM RECTANGLES

Long side 5″ to 9″

See legend on page 2

Wall thickness → / Size ↓	0.095″	0.109″	0.1181″	0.12″	1/8″	0.165″	3/16″	0.1969″	1/4″	5/16″	3/8″	0.3937″	1/2″	5/8″
5″ × 2″	2	—	—	5 +3	6 +2	—	8	—	8	5	4	—	—	—
5″ × 2½″	—	—	—	—	1 +2	2	2 +1	—	1 +2	—	—	—	—	—
5″ × 3″	2	2	—	5 +2	4 +4	—	8	—	8	5 +2	6	—	5	—
5″ × 4″	—	—	—	2 +2	3 +2	—	5 +2	—	5 +2	4 +3	5 +2	—	3 +3	—
5.51″ × 3.15″	—	—	2	—	—	—	—	—	—	—	—	2	—	—
5.91″ × 3.94″	—	—	2	—	—	—	—	1 +1	—	—	—	3	—	—
6″ × 2″	—	—	—	5 +3	6 +2	1	8	—	8	5 +1	4	—	—	—
6″ × 3″	—	—	—	4 +2	4 +4	—	8	—	8	5 +2	7	—	4 +2	—
6″ × 4″	—	—	—	4 +2	4 +4	—	8	—	8	6 +2	8	—	8	—
6″ × 5″	—	—	—	1 +3	2 +4	—	3 +4	—	3 +4	2 +5	3 +4	—	3 +3	—
7″ × 2″	—	—	—	—	1 +2	—	1 +3	—	3	—	—	—	—	—
7″ × 3″	—	—	—	1 +4	3 +3	—	3 +4	—	3 +4	3 +3	3 +3	—	3 +1	—
7″ × 4″	—	—	—	—	4 +1	—	5 +2	—	6 +1	4 +3	6 +1	—	5 +2	—
7″ × 5″	—	—	—	3 +2	3 +4	—	7 +1	—	7 +1	5 +3	6 +2	—	6 +2	1
7.87″ × 3.94″	—	—	2	—	—	—	—	—	—	—	—	1 +2	—	—
8″ × 2″	—	—	—	2 +3	3 +3	—	8	—	8	5	5	—	1 +1	—
8″ × 3″	—	—	—	2 +3	4 +2	—	7 +1	—	7 +1	5 +2	6 +1	—	5 +1	—
8″ × 4″	—	—	—	2 +3	2 +5	1	8	—	8	8	8	—	8	2
8″ × 5″	—	—	—	—	2	—	2	—	2	1	1	—	1	—
8″ × 6″	—	—	—	2	2	—	8	—	8	7 +1	8	—	8	2 +2
9″ × 3″	—	—	—	—	—	—	1 +2	—	1 +2	1 +1	1 +1	—	1 +1	—
9″ × 5″	—	—	—	—	—	—	1 +3	—	1 +3	1 +3	1 +3	—	1 +3	2 +2
9″ × 7″	—	—	—	—	—	—	2 +4	—	2 +4	1 +5	1 +5	—	1 +5	1 +2

LARGE RECTANGLES

Long side greater than 9″

See legend on page 2

Wall thickness → / Size ↓	1/8″	0.134″	3/16″	1/4″	5/16″	3/8″	1/2″	5/8″	3/4″	7/8″	1″
10″ × 2″	1 +3	—	5 +2	4 +2	4	4	1	—	—	—	—
10″ × 3″	2	1 +1	2	2	1	1	—	—	—	—	—
10″ × 3½″	2	2	2	2	1	1	—	—	—	—	—
10″ × 4″	2	—	7 +1	8	6 +2	8	7 +1	2	—	—	—
10″ × 5″	—	—	1 +1	2 +1	1 +2	2 +1	1 +1	1	—	—	—
10″ × 6″	—	—	7 +1	8	7 +1	8	8	2 +2	—	—	—
10″ × 8″	—	—	6 +1	6 +2	6 +2	6 +2	6 +2	2 +2	—	—	—
12″ × 2″	—	—	5 +1	6	2	1 +1	—	—	—	—	—
12″ × 3″	—	—	1 +1	2	1	1	—	—	—	—	—
12″ × 4″	—	—	7 +1	8	7 +1	8	8	2	—	—	—
12″ × 6″	—	—	5 +1	7 +1	6 +2	7 +1	7 +1	2 +2	—	—	—
12″ × 8″	—	—	6 +1	8	6 +2	8	8	3 +1	2	—	—
12″ × 10″	—	—	—	1 +1	2	1 +1	1 +1	2	—	—	—
14″ × 4″	—	—	1 +1	2 +1	2 +1	2 +1	2 +1	2	—	—	—
14″ × 6″	—	—	3	4	4	4	4	3 +1	—	—	—
14″ × 10″	—	—	—	2 +1	2 +1	2 +1	2 +1	2 +1	1	—	—
16″ × 4″	—	—	1	3	3	3	3	2	—	—	—
16″ × 8″	—	—	—	2 +1	2 +1	3	3	3	1 +1	—	—
16″ × 12″	—	—	—	—	3	3	3	3	2	1	1
18″ × 6″	—	—	—	2 +1	2 +1	3	3	3	—	—	—
18″ × 10″	—	—	—	—	1	1	1	1	1	—	—
20″ × 4″	—	—	—	1	1	1	1	—	—	—	—
20″ × 8″	—	—	—	—	2	2	2	2	1 +1	1	1
20″ × 12″	—	—	—	—	1	1	1	1	1	1	1
20″ × 16″	—	—	—	—	—	1	1	1	1	1	1
22″ × 18″	—	—	—	—	—	1	1	1	1	1	1
24″ × 12″	—	—	—	—	—	1	1	1	1	1	1
24″ × 16″	—	—	—	—	—	1	1	1	1	1	1
30″ × 10″	—	—	—	—	—	1	1	1	1	1	1
34″ × 10″	—	—	—	—	—	—	1	1	1	1	1

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The information in this guide is based on the STI Capability Tool and represents regular-schedule and on-demand production capability reported by STI member producers. Mill offerings change; for current real-time availability, consult the STI Capability Tool or confirm directly with the producer or distributor before specifying. While the information presented is believed to be accurate, it should not be used or relied upon for any specific application without competent professional examination and verification.