Manufacturer, Exporter, Stockiest, Supplier, Trader for Carbon Steel, Stainless Steel, Alloy Steel And High Nickel Alloy, Nickel Alloy Plate, Sheets And Coils.
Hot rolled products of structural steels —

Part 2: Technical delivery conditions for non-alloy structural steels

The European Standard EN 10025-2:2004 has the status of a British Standard
National foreword

This British Standard is the official English language version of EN 10025-2:2004. BS EN 10025-2:2004 together with BS EN 10025-1:2004 supersedes BS EN 10025:1993, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee ISE/12, Structural steels, which has the responsibility to:

— aid enquirers to understand the text;
— present to the responsible international/European committee any enquiries on the interpretation, or proposals for change, and keep the UK interests informed;
— monitor related international and European developments and promulgate them in the UK.

A list of organizations represented on this committee can be obtained on request to its secretary.

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Hot rolled products of structural steels - Part 2: Technical delivery conditions for non-alloy structural steels

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Foreword

This document (EN 10025-2:2004) has been prepared by Technical Committee ECISS/TC 10 “Structural steels - Grades and qualities”, the secretariat of which is held by NEN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 2005, and conflicting national standards shall be withdrawn at the latest by May 2005.


The titles of the other Parts of this European Standard are:

Part 1: General technical delivery conditions;

Part 3: Technical delivery conditions for normalized/normalized rolled weldable fine grain structural steels;

Part 4: Technical delivery conditions for thermomechanical rolled weldable fine grain structural steels;

Part 5: Technical delivery conditions for structural steels with improved atmospheric corrosion resistance;

Part 6: Technical delivery conditions for flat products of high yield strength structural steels in the quenched and tempered condition.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of the EU Construction Products Directive (89/106/EEC). For relationship with the EU Construction Products Directive, see informative Annex ZA of EN 10025-1:2004.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.
1 Scope

Part 2 of this document, in addition to Part 1, specifies the technical delivery conditions for flat and long products and semi-finished products which are meant for further processing to flat and long products of hot rolled non-alloy quality steels in the grades and qualities given in Tables 2 to 6 (chemical composition) and Tables 7 to 9 (mechanical properties) in the delivery conditions as given in 6.3. Three engineering steels are also specified in this document (see Tables 3 and 5) (chemical composition) and Table 8 (mechanical properties). This document does not apply to structural hollow sections and tubes (see EN 10210-1 and EN 10219-1).

The technical delivery conditions apply to thicknesses $\geq 3$ mm and $\leq 150$ mm for long products of steel grade S450J0. The technical delivery conditions apply to thicknesses $\leq 250$ mm for flat and long products of all other grades and qualities. In addition for flat products of qualities J2 and K2 the technical conditions apply to thicknesses $\leq 400$ mm.

Products made of steel grades S185, E295, E335 and E360 cannot be CE marked.

The steels specified in this Part 2 are not intended to be heat treated except products delivered in delivery condition $+N$. Stress relief annealing is permitted (see also the NOTE in 7.3.1.1 of EN 10025-1:2004). Products delivered in $+N$ condition can be hot formed and/or normalized after delivery (see Clause 3).

NOTE 1 Semi-finished products which are to be converted to rolled finished products conforming to this document should be the subject of special agreement at the time of the enquiry and order. The chemical composition can also be agreed at the time of the order, however the values should be within the limits of Tables 2 and 3.

NOTE 2 For certain grades and product forms suitability for particular applications may be specified at the time of the enquiry and order (see 7.4.2, 7.4.3 and Table 10).

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

2.1 General standards


EN 10020, Definition and classification of grades of steel.


EN 10027-1, Designation systems for steels - Part 1: Steel names, principal symbols.

EN 10027-2, Designation systems for steels - Part 2: Numerical system.

EN 10163-1, Delivery requirements for surface condition of hot-rolled steel plates, wide flats and sections – Part 1: General requirements.

EN 10163-2, Delivery requirements for surface condition of hot-rolled steel plates, wide flats and sections – Part 2: Plates and wide flats.

EN 10163-3, Delivery requirements for surface condition of hot-rolled steel plates, wide flats and sections – Part 3: Sections.
EN 10164, Steel products with improved deformation properties perpendicular to the surface of the product - Technical delivery conditions.

EN 10221, Surface quality classes for hot-rolled bars and rods - Technical delivery conditions.

CR 10260, Designation systems for steels - Additional symbols.

2.2 Standards on dimensions and tolerances (see 7.7.1)

EN 10017, Non-alloy steel rod for drawing and/or cold rolling – Dimensions and tolerances.

EN 10024, Hot rolled taper flange I sections - Tolerances on shape and dimensions.

EN 10029, Hot rolled steel plates 3 mm thick or above - Tolerances on dimensions, shape and mass.

EN 10034, Structural steel I and H sections - Tolerances on shape and dimensions.

EN 10048, Hot rolled narrow steel strip - Tolerances on dimensions and shape.

EN 10051, Continuously hot-rolled uncoated plate, sheet and strip of non-alloy and alloy steels - Tolerances on dimensions and shape.

EN 10055, Hot-rolled steel equal flange tees with radiused root and toes - Dimensions and tolerances on shape and dimensions.

EN 10056-1, Structural steel equal and unequal leg angles - Part 1: Dimensions.

EN 10056-2, Structural steel equal and unequal leg angles - Part 2: Tolerances on shape and dimensions.

EN 10058, Hot rolled flat steel bars for general purposes - Dimensions and tolerances on shape and dimensions.

EN 10059, Hot rolled square steel bars for general purposes - Dimensions and tolerances on shape and dimensions.

EN 10060, Hot rolled round steel bars for general purposes - Dimensions and tolerances on shape and dimensions.

EN 10061, Hot rolled hexagon steel bars for general purposes - Dimensions and tolerances on shape and dimensions.

EN 10067, Hot rolled bulb flats - Dimensions and tolerances on shape, dimensions and mass.

EN 10162, Cold rolled steel sections - Technical delivery conditions - Dimensional and cross-sectional tolerances.

EN 10279, Hot rolled steel channels - Tolerances on shape and dimensions.
2.3 Standards on testing

EN 10160, Ultrasonic testing of steel flat product of thickness equal to or greater than 6 mm (reflection method).

EN 10306, Iron and steel - Ultrasonic testing of H beams with parallel flanges and IPE beams.

EN 10308, Non-destructive testing - Ultrasonic testing of steel bars.


3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 10025-1:2004 and the following apply.

3.1 normalizing rolling
rolling process in which the final deformation is carried out in a certain temperature range leading to a material condition equivalent to that obtained after normalizing so that the specified values of the mechanical properties are retained even after normalizing.

The abbreviated form of this delivery condition is +N

NOTE In international publications for both the normalizing rolling, as well as the thermo-mechanical rolling, the expression "controlled rolling" may be found. However in view of the different applicability of the products a distinction of the terms is necessary.

3.2 as-rolled
delivery condition without any special rolling and/or heat treatment condition.

The abbreviated form of this delivery condition is +AR

3.3 thermomechanical rolling
rolling process in which the final deformation is carried out in a certain temperature range leading to a material condition with certain properties which cannot be achieved or repeated by heat treatment alone

NOTE 1 Subsequent heating above 580 °C may lower the strength values. If temperatures above 580 °C are needed reference should be made to the supplier.

NOTE 2 Thermomechanical rolling leading to the delivery condition M can include processes with an increasing cooling rate with or without tempering including self-tempering but excluding direct quenching and quenching and tempering.

NOTE 3 In some publications the word TMCP (Thermomechanical Control Process) is also used.

4 Classification and designation

4.1 Classification

4.1.1 Main quality classes

The steel grades specified in this document shall be classified as non-alloy quality steels according to EN 10020.
4.1.2 Grades and qualities

This document specifies eight steel grades S185, S235, S275, S355, S450, E295, E335 and E360. They differ in their mechanical properties.

The steel grades S235 and S275 may be supplied in qualities JR, J0 and J2. The steel grade S355 may be supplied in qualities JR, J0, J2 and K2. The steel grade S450 is supplied in quality J0.

The qualities differ in specified impact energy requirements.

4.2 Designation

4.2.1 The designation shall be in accordance with EN 10025-1.


4.2.2 The designation shall consist of:

- number of this document (EN 10025-2);
- steel name or the steel number; the steel name consisting of:
  - symbol S (for structural steel) or E (for engineering steel);
  - indication of the minimum specified yield strength for thickness ≤ 16 mm expressed in MPa\(^{1}\);
  - if applicable, the quality designation (see 4.1.2) in respect of specified impact energy values;
  - if applicable, the additional symbol C for the suitability for the particular application (see Tables 10, 11, 12 and 13).

indication "+N or +AR", when the products are ordered and delivered in the condition +N or +AR (see 3.1, 3.2 and 6.3). The indication "+N or +AR" shall also be added to the steel number.

EXAMPLE Structural steel (S) with a specified minimum yield strength at ambient temperature of 355 MPa\(^{1}\), with a minimum impact energy value of 27 J at 0 °C (J0) and suitable for cold flanging (C), delivery condition normalized rolled (or as rolled):

Steel EN 10025-2 - S355J0C+N (or +AR)

or

Steel EN 10025-2 - 1.0554+N (or +AR)

5 Information to be supplied by the purchaser

5.1 Mandatory information

The information that shall be supplied by the purchaser at the time of the order is specified in EN 10025-1.

In addition to EN 10025-1 the following information shall be supplied by the purchaser at the time of the order:

\[^{1}\] 1 MPa = 1 N/mm\(^2\).
g) whether products have to be submitted to specific or non-specific inspection and testing and which inspection document is required (see 8.2);

h) whether the verification of the mechanical properties for the quality JR and the steel grades E295, E335 and E360 has to be carried out by cast or by lot (see 8.3.1.1).

5.2 Options

A number of options are specified in Clause 13. In the event that the purchaser does not indicate his wish to implement any of these options, the supplier shall supply in accordance with the basic specification.

6 Manufacturing process

6.1 Steel making process

The steel making process shall be in accordance with EN 10025-1. If specified at the time of the order the steel making process shall be reported to the purchaser, with the exception of steel S185.

See option 1.

6.2 Deoxidation

6.2.1 The method of deoxidation shall be as given in Tables 2 and 3.

6.2.2 The deoxidation methods are designated as follows:

a) Optional - Method at the manufacturer's discretion;

b) FN - Rimming steel not permitted;

c) FF - Fully killed steel containing nitrogen binding elements in amounts sufficient to bind the available nitrogen (for example min. 0.020 % total aluminium). The usual guideline is a minimum aluminium to nitrogen ratio of 2:1, when no other nitrogen binding elements are present. Such other elements shall be reported in the inspection document.

6.3 Delivery conditions

The delivery condition of long products and continuous mill flat products can be +AR, +N or +M at the manufacturer's discretion. The delivery condition of quarto mill products can only be +AR or +N at the manufacturer's discretion.

The delivery condition +AR or +N can be ordered.

See option 19A.

If an inspection document is required (see 8.2) the delivery condition shall be indicated in it with its specific symbol (+N, +AR or +M). In case the products are ordered in the delivery condition +N or +AR the specific symbol (+N or +AR) shall be added to the designation (see 4.2.2).
7 Requirements

7.1 General
The following requirements apply when sampling, preparation of test pieces and testing specified in Clauses 8, 9 and 10 are carried out.

7.2 Chemical composition

7.2.1 The chemical composition determined by ladle analysis shall comply with the specified values of Tables 2 and 3.

7.2.2 The upper limits applicable for the product analysis are given in Tables 4 and 5.

The product analysis shall be carried out when specified at the time of the order.

See option 2.

7.2.3 The maximum carbon equivalent values for the grades S235, S275, S355 and S450, based on the ladle analysis, given in Table 6 shall apply. For the carbon equivalent value formula see 7.2.3 of EN 10025-1:2004.

7.2.4 For all S235, S275 and S355 qualities the following additional chemical requirement can be agreed at the time of the order:

- Copper-content between 0,25 % and 0,40 % on ladle analysis and between 0,20 % and 0,45 % on product analysis. In this case the maximum carbon equivalent value of Table 6 shall be increased by 0,02 %.

See option 20.

7.2.5 When products of grade S275 and S355 are supplied with a control on Si e.g. for hot-dip zinc-coating so that there could be a need to increase the content of other elements like C and Mn to achieve the required tensile properties, the maximum carbon equivalent values of Table 6 shall be increased as follows:

- for \( \text{Si} \leq 0,030 \% \), increase CEV by 0,02 %;

- for \( \text{Si} \leq 0,25 \% \), increase CEV by 0,01 %.

7.3 Mechanical properties

7.3.1 General

7.3.1.1 Under the inspection and testing conditions as specified in Clauses 8, 9 and 10 and in the delivery condition as specified in 6.3 the mechanical properties shall comply with the values given in Tables 7, 8 and 9.

7.3.1.2 For products ordered and supplied in the normalized or normalized rolled condition (see 6.3) the mechanical properties shall comply with Tables 7, 8 and 9 in the normalized or normalized rolled condition as well as after normalizing by heat treatment after delivery.

7.3.1.3 For products supplied as-rolled for normalizing by the purchaser the samples shall be normalized, if requested at the time of the order. The values obtained from the normalized samples shall comply with this document. The results shall be reported in the inspection document.

NOTE The results of these tests do not represent the properties of the supplied products but indicate the properties which can be achieved after correct normalizing.
7.3.1.4 For flat products the nominal thickness applies. For long products of irregular section the nominal thickness of that part from which the samples are taken applies (see Annex A of EN 10025-1:2004).

7.3.2 Impact properties

7.3.2.1 The verification of the impact energy value shall be carried out in accordance with EN 10025-1.

7.3.2.2 The impact properties of quality JR products are verified only when specified at the time of the order.

See option 3.

7.3.2.3 For products of quality J2 and K2 with nominal thickness < 6 mm the ferritic grain size shall be ≥ 6, verified by the method as described in EN ISO 643, if specified at the time of the order.

See option 21.

When aluminum is used as the grain refining element, the grain size requirement shall be deemed to be fulfilled if on ladle analysis the aluminum content is not less than 0.020 % total aluminum or alternatively, 0.015 % acid soluble aluminum. In this case verification of the grain size is not required, but the aluminum content shall be indicated in the inspection document.

7.3.3 Improved deformation properties perpendicular to the surface

If agreed at the time of the order products of qualities J2 and K2 shall comply with one of the requirements of EN 10164.

See option 4.

7.4 Technological properties

7.4.1 Weldability

7.4.1.1 General requirements for welding of the steels of the qualities JR, J0, J2 and K2 shall be given in EN 1011-2.

NOTE With increasing product thickness and strength level cold cracking can occur. Cold cracking is caused by the following factors in combination:

– the amount of diffusible hydrogen in the weld metal;
– a brittle structure of the heat affected zone;
– significant tensile stress concentrations in the welded joint.

7.4.1.2 This document gives no information concerning the weldability of the steel grades S185, E295, E335 and E360 because the chemical composition is not specified.

7.4.2 Formability

NOTE Recommendations regarding hot and cold forming are laid down in ECSC IC 2. Although ECSC IC2 is specially meant for fine grain steels, these recommendations can also apply for the steel grades of EN 10025-2:2004.

7.4.2.1 Hot forming

Only products ordered and supplied in the normalized or normalized rolled condition shall comply with the requirements of Tables 7, 8 and 9 if hot forming is carried out after delivery (see 7.3.1.2).
7.4.2.2 Cold formability

7.4.2.2.1 General

Grades and qualities suitable for cold forming and engineering steels suitable for cold drawing shall be designated by the appropriate steel name (including symbol C or GC) or the appropriate steel number as indicated in Tables 10 to 13 (see 4.2.2).

NOTE Cold forming leads to reduction in the ductility. Furthermore it is necessary to draw the attention to the risk of brittle fracture in connection with hot-dip zinc-coating.

7.4.2.2.2 Flangeability

If specified at the time of the order plate, sheet, strip, wide flats and flats (width < 150 mm) with a nominal thickness \( \leq 30 \text{ mm} \) shall be suitable for flanging without cracking with the minimum recommended bend radii given in Table 12. The grades and qualities to which this applies are given in Table 10.

See option 11.

7.4.2.2.3 Roll forming

If specified at the time of the order plate, sheet and strip with a nominal thickness \( \leq 8 \text{ mm} \) shall be suitable for the production of sections by cold rolling (for example according to EN 10162). The suitability is applicable for bend radii given in Table 13. The grades and qualities concerned are given in Table 10.

See option 12.

7.4.2.2.4 Drawing of bars

If specified at the time of the order, bars shall be suitable for cold drawing. The grades and qualities to which this applies are given in Tables 10 and 11.

See option 22.

7.4.3 Suitability for hot-dip zinc-coating

Hot-dip zinc-coating requirements shall be agreed between manufacturer and purchaser.

EN ISO 1461 and EN ISO 14713 should be used to set these coating requirements. The definition of suitability classes based upon chemical analysis limitations as laid down in Table 1 can be used for guidance purposes.

Table 1 - Classes for the suitability for hot-dip zinc-coating based on the ladle analysis (for guidance)

<table>
<thead>
<tr>
<th>Classes</th>
<th>Elements % by mass</th>
<th>Si</th>
<th>Si + 2,5 P</th>
<th>P</th>
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<tr>
<td>Class 1</td>
<td>( \leq 0,030 )</td>
<td>( \leq 0,090 )</td>
<td>-</td>
<td></td>
</tr>
<tr>
<td>Class 2a</td>
<td>( \leq 0,35 )</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Class 3</td>
<td>( 0,14 \leq \text{Si} \leq 0,25 )</td>
<td>-</td>
<td>( \leq 0,035 )</td>
<td></td>
</tr>
</tbody>
</table>

*a Class 2 applies only for special zinc alloys.
For class 1 the maximum carbon equivalent value of Table 6 shall be increased by 0.02. For class 3 the maximum carbon equivalent value of Table 6 shall be increased by 0.01. These increases apply for S275 and S355 (see 7.2.5).

See option 5.

NOTE Product shape, composition of the zinc bath, other hot-dip treatment settings and other factors should be considered when agreeing upon hot-dip zinc-coating requirements.

7.4.4 Machinability

All steel grades and qualities are machinable with common operations.

NOTE Due to the good ductility of qualities JR, J0, J2 and K2 problems can occur in the chip formation and in surface finish quality. Generally a higher S content improves machinability. A proper Ca treatment applicable for long products gives better machining properties (see footnote ° of Table 2 and footnote ° of Table 3).

7.5 Surface properties

7.5.1 Strip

The surface condition should not impair an application appropriate to the steel grade if adequate processing of the strip is applied.

7.5.2 Plates and wide flats

EN 10163 parts 1 and 2 shall apply for the permissible surface discontinuities and for the repair of surface defects by grinding and/or welding. Class A, subclass 1 of EN 10163-2 shall apply, unless otherwise agreed at the time of the order.

See option 15.

7.5.3 Sections

EN 10163 parts 1 and 3 shall apply for the permissible surface discontinuities and for the repair of surface defects by grinding and/or welding. Class C, subclass 1 of EN 10163-3 shall apply, unless otherwise agreed at the time of the order.

See option 16.

7.5.4 Bars and rods

EN 10221 applies for the permissible surface discontinuities and for the repair of surface defects by grinding and/or welding. Class A of EN 10221 shall apply, unless otherwise agreed at the time of the order.

See option 17.

7.6 Internal soundness

The permissible level of internal imperfections shall be in accordance with EN 10025-1.

See option 6 (for flat products).

See option 7 (for H beams with parallel flanges and IPE beams).

See option 8 (for bars).
7.7 Dimensions, tolerances on dimensions and shape, mass

7.7.1 Dimensions, tolerances on dimensions and shape shall be in accordance with the requirements given in the order by reference to the relevant documents according to 2.2 and according to 2.2 and 7.7.1 of EN 10025-1:2004.

For hot rolled plate tolerances the basic requirements shall be in accordance with EN 10029, including thickness tolerances to class A, unless otherwise agreed at the time of the order.

See option 18.

For plates cut from continuously hot rolled strip, the thickness tolerances shall be in accordance with EN 10051.

7.7.2 The nominal mass shall comply with EN 10025-1.

8 Inspection

8.1 General

The products shall be delivered either with specific or non-specific inspection and testing to indicate compliance with the order and this document (see 5.1).

8.2 Type of inspection and inspection document

The type of inspection and inspection document required shall comply with EN 10025-1.

See option 9.

In addition to the requirements of EN 10025-1 products of steel S185 shall only be submitted to non-specific inspection and testing and only certificates of compliance with the order shall be supplied when specified at the time of the order.

See option 23.

8.3 Frequency of testing

8.3.1 Sampling

8.3.1.1 The verification of the mechanical properties shall be carried out:

by cast or by lot as specified at the time of the order for the quality JR and the steel grades E295, E335 and E360;

see option 24;

by cast for the qualities J0, J2 and K2.

8.3.1.2 If it is specified at the time of the order that sampling should be by lot, it is permissible for the manufacturer to substitute sampling by cast, if the products are delivered by cast.

8.3.2 Test units

8.3.2.1 The test unit shall contain products of the same form, grade and quality, delivery condition and of the same thickness range as specified in Table 7 for the yield strength and shall be:
by lot: 20 tonnes or part thereof;
— by cast: 40 tonnes or part thereof;
   60 tonnes or part thereof for heavy sections with a mass > 100 kg/m;
   80 tonnes or part thereof for all sections if the mass of the cast exceeds 200 tonnes.

8.3.2.2 If specified at the time of the order for flat products of quality J2 and K2 the impact properties only
or the impact properties and the tensile properties shall be verified out of each parent plate or coil.

See option 13.
See option 14.

8.3.3 Verification of chemical composition

The verification of the chemical composition shall be in accordance with EN 10025-1.
See option 2.

8.4 Tests to be carried out for specific inspection

8.4.1 The following tests shall be carried out:
— for all products the ladle analysis;
— for all products the tensile test;
   for all products of quality J0, J2 and K2 the impact test.

8.4.2 At the time of the order the following additional tests can be agreed:

a) for all products of quality JR the impact test (see 7.3.2.2);
See option 3.

b) the product analysis if the products are delivered per cast (see 8.3.3.2 of EN 10025-1:2004).
See option 2.

9 Preparation of samples and test pieces

9.1 Selection and preparation of samples for chemical analysis

The preparation of samples for product analysis shall be in accordance with EN 10025-1.

9.2 Location and orientation of samples and test pieces for mechanical tests

9.2.1 General

The location and orientation of samples and test pieces for mechanical tests shall be in accordance with
EN 10025-1.
9.2.2 Preparation of samples

In addition to EN 10025-1 the samples shall be taken:

- from the thickest product in the test unit;

- from any product of the test unit for products in delivery condition +N (see 3.1).

In addition to EN 10025-1 the preparation of samples for semi-finished products, when the order specifies the requirement for testing the mechanical properties, in addition to chemical composition, shall be agreed at the time of the order.

See option 25

9.2.3 Preparation of test pieces

The preparation of test pieces for mechanical tests shall be in accordance with EN 10025-1.

9.3 Identification of samples and test pieces

The identification of samples and test pieces shall be in accordance with EN 10025-1.

10 Test methods

10.1 Chemical analysis

The chemical analysis shall be in accordance with EN 10025-1.

10.2 Mechanical tests

The mechanical tests shall be in accordance with EN 10025-1.

10.3 Ultrasonic testing

Ultrasonic testing shall be carried out in accordance with EN 10025-1.

10.4 Retests

The retests shall be in accordance with EN 10025-1.

11 Marking, labelling, packaging

The marking, labelling and packaging shall comply with EN 10025-1.

See option 10.

12 Complaints

Any complaints shall be dealt with in accordance with EN 10025-1.
13 Options (see 5.2)

The following options of EN 10025-1:2004 apply:

1) The steel making process of the relevant quality shall be indicated (see 6.1).

2) Product analysis shall be carried out; the number of samples and the elements to be determined shall be as agreed (see 7.2.2, 8.3.3 and 8.4.2).

3) The impact properties of quality JR shall be verified (see 7.3.2.2 and 8.4.2).

4) Products of the relevant quality shall comply with one of the improved properties perpendicular to the surface of EN 10164 (see 7.3.3).

5) The product shall be suitable for hot-dip zinc-coating (see 7.4.3).

6) For flat products in thickness ≥ 6 mm the freedom from internal defects shall be verified in accordance with EN 10160 (see 7.6 and 10.3).

7) For H beams with parallel flanges and IPE beams the freedom from internal defects shall be verified in accordance with EN 10306 (see 7.6 and 10.3).

8) For bars the freedom from internal defects shall be verified in accordance with EN 10308 (see 7.6 and 10.3).

9) Inspection of surface condition and dimensions shall be witnessed by the purchaser at the manufacturer’s works (see 8.2).

10) The type of marking required (see Clause 11).

In addition to the options of EN 10025-1:2004 the following options apply to products according to EN 10025-2:

11) Sheet, plate, strip, wide flats and flats (width < 150 mm) with a nominal thickness ≤ 30 mm shall be suitable for flanging without cracking (see 7.4.2.2.2).

12) Plate and strip with nominal thickness ≤ 8 mm shall be suitable for the production of sections by cold rolling with bend radii given in Table 13 (see 7.4.2.2.3).

13) For flat products of quality J2 and K2 out of each parent plate or coil the impact properties only shall be verified (see 8.3.2.2).

14) For flat products of quality J2 and K2 out of each parent plate or coil the impact properties and the tensile properties shall be verified (see 8.3.2.2).

15) For plates and wide flats the permissible surface discontinuities and for the repair of surface defects by grinding and/or welding another class than class A, subclass 1 of EN 10163-2 applies (see 7.5.2).

16) For sections the permissible surface discontinuities and for the repair of surface defects by grinding and/or welding another class than class C, subclass 1 of EN 10163-3 applies (see 7.5.3).

17) For bars and rods the permissible surface discontinuities and for the repair of surface defects by grinding and/or welding another class than class A of EN 10221 applies (see 7.5.4).

18) Other tolerances than class A of EN 10029 for hot rolled plates apply (see 7.7.1).

19A) The delivery condition +N or +AR is required (see 6.3).
19B) The delivery condition +AR is required with a verification of the mechanical properties on normalized samples (see 7.3.1.3).

20) A copper content between 0.25 % and 0.40 % on ladle analysis and between 0.20 % and 0.45 % on product analysis for all S235, S275 and S355 qualities is required (see 7.2.4).

21) The grain size shall be verified for products of quality J2 and K2 with nominal thickness < 6 mm (see 7.3.2.3).

22) Bars shall be suitable for cold drawing (see 7.4.2.2.4).

23) A certificate of compliance with the order shall be supplied for the grade S185 (see 8.2).

24) The verification of the mechanical properties for the quality JR and the steel grades E295, E335 and E360 shall be carried out by lot or by cast (see 5.1.h) and 8.3.1.1).

25) The preparation of samples shall be agreed for semi-finished products, when the order specifies the requirement for testing the mechanical properties, in addition to chemical composition (see 9.2.2).

26) The limitation of the maximum carbon content shall be provided for sections with nominal thickness > 100 mm (see Tables 2 and 4).

27) For long products the max. S content can be increased for improved machinability by 0.015 % if the steel is treated to modify the sulphide morphology and the chemical composition shows min. 0.0020 % Ca (see Tables 2 to 5).

28) The minimum impact values shall be provided for sections with a nominal thickness > 100 mm (see Table 9).
### Table 2 - Chemical composition of the ladle analysis for flat and long products of steel grades and qualities with values for the impact strength *

<table>
<thead>
<tr>
<th>Designation</th>
<th>Method of decollement</th>
<th>C in % max. for nominal product thickness in mm</th>
<th>Si % max.</th>
<th>Mn % min.</th>
<th>P % max. d</th>
<th>S % max. f</th>
<th>N % max.</th>
<th>Cu % max.</th>
<th>Other % max.</th>
</tr>
</thead>
<tbody>
<tr>
<td>According EN 10027-1 and CR 10260</td>
<td>According EN 10027-2</td>
<td>≤ 16</td>
<td>&gt; 16</td>
<td>&gt; 40</td>
<td>≤ 40</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S235 JR</td>
<td>1.0036</td>
<td>FN</td>
<td>0,17</td>
<td>0,20</td>
<td>1,40</td>
<td>0,035</td>
<td>0,042</td>
<td>0,55</td>
<td>-</td>
</tr>
<tr>
<td>S235 JD</td>
<td>1.0114</td>
<td>FN</td>
<td>0,17</td>
<td>0,17</td>
<td>1,40</td>
<td>0,003</td>
<td>0,042</td>
<td>0,55</td>
<td>-</td>
</tr>
<tr>
<td>S235 LJ</td>
<td>1.0117</td>
<td>FF</td>
<td>0,17</td>
<td>0,17</td>
<td>1,40</td>
<td>0,025</td>
<td>0,042</td>
<td>0,55</td>
<td>-</td>
</tr>
<tr>
<td>S275 JR</td>
<td>1.0044</td>
<td>FN</td>
<td>0,21</td>
<td>0,22</td>
<td>1,50</td>
<td>0,035</td>
<td>0,042</td>
<td>0,55</td>
<td>-</td>
</tr>
<tr>
<td>S275 JD</td>
<td>1.0143</td>
<td>FN</td>
<td>0,18</td>
<td>0,18</td>
<td>1,50</td>
<td>0,030</td>
<td>0,042</td>
<td>0,55</td>
<td>-</td>
</tr>
<tr>
<td>S275 LJ</td>
<td>1.0146</td>
<td>FF</td>
<td>0,18</td>
<td>0,18</td>
<td>1,50</td>
<td>0,025</td>
<td>0,042</td>
<td>0,55</td>
<td>-</td>
</tr>
<tr>
<td>S355 JR</td>
<td>1.0245</td>
<td>FN</td>
<td>0,24</td>
<td>0,24</td>
<td>0,55</td>
<td>1,60</td>
<td>0,035</td>
<td>0,042</td>
<td>0,55</td>
</tr>
<tr>
<td>S355 JD</td>
<td>1.0553</td>
<td>FN</td>
<td>0,24</td>
<td>0,22</td>
<td>0,55</td>
<td>1,60</td>
<td>0,030</td>
<td>0,042</td>
<td>0,55</td>
</tr>
<tr>
<td>S355 LJ</td>
<td>1.0577</td>
<td>FF</td>
<td>0,24</td>
<td>0,22</td>
<td>0,55</td>
<td>1,60</td>
<td>0,025</td>
<td>0,042</td>
<td>0,55</td>
</tr>
<tr>
<td>S355K2</td>
<td>1.0596</td>
<td>FF</td>
<td>0,24</td>
<td>0,22</td>
<td>0,55</td>
<td>1,60</td>
<td>0,025</td>
<td>0,042</td>
<td>0,55</td>
</tr>
<tr>
<td>S460A</td>
<td>1.0590</td>
<td>FF</td>
<td>0,20</td>
<td>0,22</td>
<td>0,55</td>
<td>1,70</td>
<td>0,030</td>
<td>0,025</td>
<td>0,55</td>
</tr>
</tbody>
</table>

---

*See 7.2.*

**FN** = rimming steels not permitted; **FF** = fully killed steel (see 6.2.2).

For sections with nominal thickness > 1000 mm the C content by agreement.

See option 26.

For long products the P and S content can be 0.005 % higher.

For long products the max. S content can be increased for improved machinability by 0.015% by agreement if the steel is treated to modify the sulphide morphology and the chemical composition allows min. 0.002% C3a.

See option 27.

The max. value for nitrogen does not apply if the chemical composition allows a minimum total Al content of 0.020 % or alternatively min. 0.015 % acid soluble Al or if sufficient other N binding elements are present. In this case the % binding elements shall be mentioned in the inspection document.

Cu content above 0.40 % may cause hot shortness during hot forming.

If other elements are added, they shall be mentioned on the inspection document.

For nominal thickness > 150 mm: C = 0.20 % max...

For grades suitable for cold roll forming (see 7.4.2.2.3.): C = 0.22 % max...

For nominal thickness > 300 mm: C = 0.22 % max...

Applicable for long products only.

The steel may show a Nb content of max. 0.005 %, as Well content of max. 0.103 % and or Ti content of max. 0.055 %.
Table 3 - Chemical composition of the ladle analysis for flat and long products of steel grades with no values for the impact strength *

<table>
<thead>
<tr>
<th>Designation</th>
<th>Method of deoxidation</th>
<th>P % max.</th>
<th>S % max.</th>
<th>N % max.</th>
</tr>
</thead>
<tbody>
<tr>
<td>According EN 10027-1 and CR 10260</td>
<td>According EN 10027-2</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S185</td>
<td>1.0035</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>E295</td>
<td>1.0050</td>
<td>FN</td>
<td>0.045</td>
<td>0.045</td>
</tr>
<tr>
<td>E335</td>
<td>1.0060</td>
<td>FN</td>
<td>0.045</td>
<td>0.045</td>
</tr>
<tr>
<td>E360</td>
<td>1.0070</td>
<td>FN</td>
<td>0.045</td>
<td>0.045</td>
</tr>
</tbody>
</table>

* See 7.2.

b opt. = method at the manufacturer's discretion; FN = rimming steels not permitted (see 6.2.2).

c For long products the max. S content can be increased for improved machinability by 0.010 % by agreement if the steel is treated to modify the sulphide morphology and the chemical composition shows min. 0.0020 % Ca.

See option 27.

d The max. value for nitrogen does not apply if the chemical composition shows a minimum total Al content of 0.020 % or if sufficient other N binding elements are present. In this case the N binding elements shall be mentioned in the inspection document.
Table 4 - Chemical composition of the product analysis based on Table 2

<table>
<thead>
<tr>
<th>Designation</th>
<th>Method of decarburization</th>
<th>C in % max. for nominal product thickness in mm</th>
<th>Si % max.</th>
<th>Mn % max.</th>
<th>P % max.</th>
<th>S % max.</th>
<th>N % max.</th>
<th>Cu % max.</th>
<th>Other % max.</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>According EN 10027-1 and CR 10260</td>
<td>≤ 18</td>
<td>&gt; 18</td>
<td>&gt; 40</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S235JR</td>
<td>FN</td>
<td>0,19</td>
<td>0,19</td>
<td>0,23</td>
<td>-</td>
<td>1,50</td>
<td>0,045</td>
<td>0,045</td>
<td>0,014</td>
</tr>
<tr>
<td>S235JO</td>
<td>FN</td>
<td>0,19</td>
<td>0,19</td>
<td>0,19</td>
<td>-</td>
<td>1,50</td>
<td>0,040</td>
<td>0,040</td>
<td>0,014</td>
</tr>
<tr>
<td>S235J2</td>
<td>FF</td>
<td>0,19</td>
<td>0,19</td>
<td>0,19</td>
<td>-</td>
<td>1,50</td>
<td>0,035</td>
<td>0,035</td>
<td>-</td>
</tr>
<tr>
<td>S275JR</td>
<td>FN</td>
<td>0,24</td>
<td>0,24</td>
<td>0,25</td>
<td>-</td>
<td>1,60</td>
<td>0,045</td>
<td>0,045</td>
<td>0,014</td>
</tr>
<tr>
<td>S275J0</td>
<td>FN</td>
<td>0,21</td>
<td>0,21</td>
<td>0,21</td>
<td>-</td>
<td>1,60</td>
<td>0,040</td>
<td>0,040</td>
<td>0,014</td>
</tr>
<tr>
<td>S275J2</td>
<td>FF</td>
<td>0,21</td>
<td>0,21</td>
<td>0,21</td>
<td>-</td>
<td>1,60</td>
<td>0,035</td>
<td>0,035</td>
<td>-</td>
</tr>
<tr>
<td>S355JR</td>
<td>FN</td>
<td>0,27</td>
<td>0,27</td>
<td>0,27</td>
<td>0,60</td>
<td>1,70</td>
<td>0,045</td>
<td>0,045</td>
<td>0,014</td>
</tr>
<tr>
<td>S355J2</td>
<td>FF</td>
<td>0,23</td>
<td>0,23</td>
<td>0,23</td>
<td>0,60</td>
<td>1,70</td>
<td>0,035</td>
<td>0,035</td>
<td>-</td>
</tr>
<tr>
<td>S355K2</td>
<td>FF</td>
<td>0,23</td>
<td>0,23</td>
<td>0,23</td>
<td>0,60</td>
<td>1,70</td>
<td>0,035</td>
<td>0,035</td>
<td>-</td>
</tr>
<tr>
<td>S450JD</td>
<td>FF</td>
<td>0,23</td>
<td>0,23</td>
<td>0,24</td>
<td>0,60</td>
<td>1,80</td>
<td>0,040</td>
<td>0,040</td>
<td>0,027</td>
</tr>
</tbody>
</table>

\[ a \] See 7.2.
\[ b \] FN = rimming steels not permitted; FF = fully killed steel (see 6.2.2).
\[ c \] For sections with nominal thickness > 100 mm the C content by agreement.

See option 26.
\[ d \] For long products the P and S content can be 0,005 % higher.
\[ e \] For long products the max. S content can be increased for improved machinability by 0,015 % by agreement if the steel is treated to modify the sulphide morphology and the chemical composition shows min. 0,0020 % C.

See option 27.
\[ f \] The max. value for nitrogen does not apply if the chemical composition shows a minimum total Al content of 0,015 % or alternatively min. 0,013 % acid soluble Al or if sufficient other % binding elements are present. In this case the N binding elements shall be mentioned in the inspection document.
\[ g \] Cu content above 0,45 % may cause hot shortness during hot forming.
\[ h \] If other elements are added, they shall be mentioned in the inspection document.
\[ \text{For nominal thickness } > 150 \text{ mm: } C = 0,22 \text{ % max.} \]
\[ \text{For grades suitable for cold roll forming (see 7.4.2.2.3): } C = 0,24 \text{ % max.} \]
\[ \text{For nominal thickness } > 300 \text{ mm: } C = 0,24 \text{ % max.} \]
\[ \text{Applicable for long products only.} \]
\[ m \] The steel may show a Ni content of max. 0,06 %, a V content of max. 0,15 % and a Ti content of max. 0,08 %.

\[ n \]
### Table 5 - Chemical composition of the product analysis based on Table 3

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Acc. EN 10027-1 and CR 10260</td>
<td>Acc. EN 10027-2</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S185</td>
<td>opt.</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>E295</td>
<td>FN</td>
<td>0,055</td>
<td>0,055</td>
<td>0,014</td>
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<tr>
<td>E335</td>
<td>FN</td>
<td>0,055</td>
<td>0,055</td>
<td>0,014</td>
</tr>
<tr>
<td>E360</td>
<td>FN</td>
<td>0,055</td>
<td>0,055</td>
<td>0,014</td>
</tr>
</tbody>
</table>

- **a** See 7.2.
- **b** opt. = method at the manufacturer’s discretion; FN = rimming steels not permitted (see 6.2.2).
- **c** For long products the max. S content can be increased for improved machinability by 0,010 % by agreement if the steel is treated to modify the sulphide morphology and the chemical composition shows min. 0,0020 % Ca.
- **d** See option 27.
- **d** The max. value for nitrogen does not apply if the chemical composition shows a minimum total Al content of 0,015 % or if sufficient other N binding elements are present. In this case the N binding elements shall be mentioned in the inspection document.
Table 6 - Maximum CEV based on the ladle analysis

<table>
<thead>
<tr>
<th>Designation</th>
<th>Method of deoxidation</th>
<th>Maximum CEV in % for nominal product thickness in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>≤ 30</td>
</tr>
<tr>
<td>S235JR</td>
<td>FN</td>
<td>0.35</td>
</tr>
<tr>
<td>S235J0</td>
<td>FN</td>
<td>0.35</td>
</tr>
<tr>
<td>S235J2</td>
<td>FF</td>
<td>0.35</td>
</tr>
<tr>
<td>S275JR</td>
<td>FN</td>
<td>0.40</td>
</tr>
<tr>
<td>S275J0</td>
<td>FN</td>
<td>0.40</td>
</tr>
<tr>
<td>S275J2</td>
<td>FF</td>
<td>0.40</td>
</tr>
<tr>
<td>S355JR</td>
<td>FN</td>
<td>0.45</td>
</tr>
<tr>
<td>S355J0</td>
<td>FN</td>
<td>0.45</td>
</tr>
<tr>
<td>S355J2</td>
<td>FF</td>
<td>0.45</td>
</tr>
<tr>
<td>S355K2</td>
<td>FF</td>
<td>0.45</td>
</tr>
<tr>
<td>S450J0d</td>
<td>FF</td>
<td>0.47</td>
</tr>
</tbody>
</table>

a For the optional increase of elements which influence the CEV see 7.2.4 and 7.2.5.
b FN = rimming steels not permitted; FF = fully killed steel (see 6.2.2).
c For long products a maximum CEV of 0.54 applies.
d Applicable for long products only.
Table 7 - Mechanical properties at ambient temperature for flat and long products of steel grades and qualities with values for the impact strength

<table>
<thead>
<tr>
<th>Designation</th>
<th>According EN 10027-1 and CR 10260</th>
<th>According EN 10027-2</th>
<th>Minimum yield strength $R_{p0.2}$ MPa$^b$</th>
<th>Tensile strength $R_m$ MPa$^a$</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>≤ 16</td>
<td>&gt; 16</td>
<td>≤ 40</td>
<td>&gt; 40</td>
</tr>
<tr>
<td>S235JR</td>
<td>1.0038</td>
<td>235</td>
<td>225</td>
<td>215</td>
</tr>
<tr>
<td>S235J0</td>
<td>1.0114</td>
<td>235</td>
<td>225</td>
<td>215</td>
</tr>
<tr>
<td>S235J2</td>
<td>1.0117</td>
<td>235</td>
<td>225</td>
<td>215</td>
</tr>
<tr>
<td>S275JR</td>
<td>1.0044</td>
<td>275</td>
<td>265</td>
<td>255</td>
</tr>
<tr>
<td>S275J0</td>
<td>1.0143</td>
<td>275</td>
<td>265</td>
<td>255</td>
</tr>
<tr>
<td>S275J2</td>
<td>1.0145</td>
<td>275</td>
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<td>255</td>
</tr>
<tr>
<td>S355JR</td>
<td>1.0045</td>
<td>355</td>
<td>345</td>
<td>335</td>
</tr>
<tr>
<td>S355J0</td>
<td>1.0553</td>
<td>355</td>
<td>345</td>
<td>335</td>
</tr>
<tr>
<td>S355J2</td>
<td>1.0577</td>
<td>355</td>
<td>345</td>
<td>335</td>
</tr>
<tr>
<td>S355K2</td>
<td>1.0596</td>
<td>355</td>
<td>345</td>
<td>335</td>
</tr>
<tr>
<td>S450J0$^d$</td>
<td>1.0590</td>
<td>450</td>
<td>430</td>
<td>410</td>
</tr>
</tbody>
</table>

$^a$ For plate, strip and wide flats with widths ≥ 600 mm the direction transverse (t) to the rolling direction applies. For all other products the values apply for the direction parallel (l) to the rolling direction.

$^b$ 1 MPa = 1 N/mm$^2$.

$^c$ The values apply to flat products.

$^d$ Applicable for long products only.

(To be continued)
Table 7 - Mechanical properties at ambient temperature for flat and long products of steel grades and qualities with values for the impact strength
(concluded)

<table>
<thead>
<tr>
<th>Designation</th>
<th>Position of test pieces</th>
<th>Minimum percentage elongation after fracture&lt;sup&gt;a&lt;/sup&gt;</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>( L_0 = 80 \text{ mm} ) Nominal thickness mm</td>
</tr>
<tr>
<td></td>
<td>( \leq 1 )</td>
<td>( &gt; 1 )</td>
</tr>
<tr>
<td>According EN 10027-1 and CR 10280</td>
<td>According EN 10027-2</td>
<td>%</td>
</tr>
<tr>
<td>S235JR</td>
<td>1.0038</td>
<td>L</td>
</tr>
<tr>
<td>S235J0</td>
<td>1.0114</td>
<td>L</td>
</tr>
<tr>
<td>S235J2</td>
<td>1.0117</td>
<td>T</td>
</tr>
<tr>
<td>S275JR</td>
<td>1.0044</td>
<td>L</td>
</tr>
<tr>
<td>S275J0</td>
<td>1.0143</td>
<td>L</td>
</tr>
<tr>
<td>S275J2</td>
<td>1.0145</td>
<td>T</td>
</tr>
<tr>
<td>S355JR</td>
<td>1.0045</td>
<td>L</td>
</tr>
<tr>
<td>S355J0</td>
<td>1.0553</td>
<td>L</td>
</tr>
<tr>
<td>S355J2</td>
<td>1.0577</td>
<td>L</td>
</tr>
<tr>
<td>S355K2</td>
<td>1.0596</td>
<td>T</td>
</tr>
<tr>
<td>S450JO&lt;sup&gt;d&lt;/sup&gt;</td>
<td>1.0590</td>
<td>l</td>
</tr>
</tbody>
</table>

<sup>a</sup> For plate, strip and wide flats with widths \( \geq 600 \text{ mm} \) the direction transverse (T) to the rolling direction applies. For all other products the values apply for the direction parallel (L) to the rolling direction.

<sup>b</sup> The values apply to flat products.

<sup>d</sup> Applicable for long products only.
Table 8 - Mechanical properties at ambient temperature for flat and long products of steel grades with no values for the impact strength

<table>
<thead>
<tr>
<th>Designation</th>
<th>Minimum yield strength $R_{y0.2}^a$ MPa&lt;sup&gt;b&lt;/sup&gt;</th>
<th>Tensile strength $R_m^a$ MPa&lt;sup&gt;b&lt;/sup&gt;</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Nominal thickness mm</td>
<td>&lt; 16</td>
</tr>
<tr>
<td>S185</td>
<td>According EN 10027-1 and CR 10260</td>
<td>According EN 10027-2</td>
</tr>
<tr>
<td>E295&lt;sup&gt;c&lt;/sup&gt;</td>
<td>1.0050&lt;sup&gt;c&lt;/sup&gt;</td>
<td>295</td>
</tr>
<tr>
<td>E335&lt;sup&gt;c&lt;/sup&gt;</td>
<td>1.0060&lt;sup&gt;c&lt;/sup&gt;</td>
<td>335</td>
</tr>
<tr>
<td>E360&lt;sup&gt;c&lt;/sup&gt;</td>
<td>1.0070&lt;sup&gt;c&lt;/sup&gt;</td>
<td>360</td>
</tr>
</tbody>
</table>

<sup>a</sup> For plate, strip and wide flats with widths ≥ 600 mm the direction transverse (t) to the rolling direction applies. For all other products the values apply for the direction parallel (l) to the rolling direction.

<sup>b</sup> 1 MPa = 1 N/mm<sup>2</sup>.

<sup>c</sup> These steels are normally not used for channels, angles and sections.

(To be continued)
Table 8 - Mechanical properties at ambient temperature for flat and long products of steel grades with no values for the impact strength *(concluded)*

<table>
<thead>
<tr>
<th>Designation</th>
<th>Position of test pieces</th>
<th>Minimum percentage elongation after fracture a</th>
<th>$L_o = 80 \text{ mm}$</th>
<th>$L_o = 5.65 \sqrt{S_o}$</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Percentage</td>
<td>Nominal thickness</td>
<td>mm</td>
</tr>
<tr>
<td></td>
<td>According EN 10027-1 and CR 10280</td>
<td>According EN 10027-2</td>
<td>$\leq 1$</td>
<td>$&gt; 1 \leq 1.5$</td>
</tr>
<tr>
<td>S185</td>
<td>l</td>
<td>1</td>
<td>10</td>
<td>8</td>
</tr>
<tr>
<td>E295°</td>
<td>t</td>
<td>1</td>
<td>12</td>
<td>10</td>
</tr>
<tr>
<td>E335°</td>
<td>l</td>
<td>1</td>
<td>8</td>
<td>6</td>
</tr>
<tr>
<td></td>
<td>t</td>
<td>1</td>
<td>4</td>
<td>3</td>
</tr>
</tbody>
</table>

a For plate, strip and wide flats with widths $\geq 600 \text{ mm}$ the direction transverse (t) to the rolling direction applies. For all other products the values apply for the direction parallel (l) to the rolling direction.

E These steels are normally not used for channels, angles and sections.
### Table 9 - Mechanical properties - impact strength KV longitudinal for flat and long products\(^a\)

<table>
<thead>
<tr>
<th>Designation</th>
<th>According EN 10027-1 and CR 10260</th>
<th>According EN 10027-2</th>
<th>Temperature (\degree C)</th>
<th>Minimum energy (\text{J}) Nominal thickness (\text{mm})</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>(\leq 150)</td>
<td>(&gt; 150)</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>(\leq 250)</td>
<td>(&gt; 250)</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>(\leq 400)</td>
<td></td>
</tr>
<tr>
<td>S235JR</td>
<td>1.0038</td>
<td>20</td>
<td>27</td>
<td>27</td>
</tr>
<tr>
<td>S235J0</td>
<td>1.0114</td>
<td>0</td>
<td>27</td>
<td>27</td>
</tr>
<tr>
<td>S235J2</td>
<td>1.0117</td>
<td>-20</td>
<td>27</td>
<td>27</td>
</tr>
<tr>
<td>S275JR</td>
<td>1.0044</td>
<td>20</td>
<td>27</td>
<td>27</td>
</tr>
<tr>
<td>S275J0</td>
<td>1.0143</td>
<td>0</td>
<td>27</td>
<td>27</td>
</tr>
<tr>
<td>S275J2</td>
<td>1.0145</td>
<td>-20</td>
<td>27</td>
<td>27</td>
</tr>
<tr>
<td>S355JR</td>
<td>1.0045</td>
<td>20</td>
<td>27</td>
<td>27</td>
</tr>
<tr>
<td>S355J0</td>
<td>1.0553</td>
<td>0</td>
<td>27</td>
<td>27</td>
</tr>
<tr>
<td>S355J2</td>
<td>1.0577</td>
<td>-20</td>
<td>27</td>
<td>27</td>
</tr>
<tr>
<td>S355K2</td>
<td>1.0596</td>
<td>-20</td>
<td>40(^d)</td>
<td>33</td>
</tr>
<tr>
<td>S450J0(^e)</td>
<td>1.0590</td>
<td>0</td>
<td>27</td>
<td>-</td>
</tr>
</tbody>
</table>

\(^a\) For nominal thicknesses \(\leq 12\) mm see 7.3.2.1 of EN 10025-1:2004.

\(^b\) For sections with a nominal thickness > 100 mm the values shall be agreed.

See option 28.

\(^c\) The values apply to flat products.

\(^d\) This value corresponds with 27J at -30 \(\degree C\) (see Eurocode 3).

\(^e\) Applicable for long products only.
Table 10 - Technological properties for flat and long products of steel grades and qualities with values for the impact strength

<table>
<thead>
<tr>
<th>Designation</th>
<th>Cold flanging</th>
<th>Cold roll forming</th>
<th>Cold drawing</th>
</tr>
</thead>
<tbody>
<tr>
<td>According EN 10027-1 and CR 10260</td>
<td>According EN 10027-2</td>
<td></td>
<td></td>
</tr>
<tr>
<td>S235JRC</td>
<td>1.0122</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>S235J0C</td>
<td>1.0115</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>S235J2C</td>
<td>1.0119</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>S275JRC</td>
<td>1.0128</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>S275J0C</td>
<td>1.0140</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>S275J2C</td>
<td>1.0142</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>S355JRC</td>
<td>1.0551</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>S355J0C</td>
<td>1.0554</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>S355J2C</td>
<td>1.0579</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>S355K2C</td>
<td>1.0594</td>
<td>x</td>
<td>x</td>
</tr>
</tbody>
</table>

Table 11 - Technological properties for flat and long products of steel grades with no values for the impact strength

<table>
<thead>
<tr>
<th>Designation</th>
<th>According EN 10027-1 and CR 10260</th>
<th>According EN 10027-2</th>
<th>Suitability for cold drawing</th>
</tr>
</thead>
<tbody>
<tr>
<td>E295GC</td>
<td>1.0533</td>
<td>x</td>
<td></td>
</tr>
<tr>
<td>E335GC</td>
<td>1.0543</td>
<td>x</td>
<td></td>
</tr>
<tr>
<td>E360GC</td>
<td>1.0633</td>
<td>x</td>
<td></td>
</tr>
<tr>
<td>Designation</td>
<td>According EN 10027-1 and CR 10260</td>
<td>Bending direction</td>
<td>Minimum recommended inside bend radius (a) for nominal thicknesses in mm</td>
</tr>
<tr>
<td>-------------</td>
<td>----------------------------------</td>
<td>-------------------</td>
<td>-------------------------------------------------</td>
</tr>
<tr>
<td></td>
<td>According EN 10027-2</td>
<td>(t)</td>
<td>(&gt; 1) (\leq 1.5)</td>
</tr>
<tr>
<td>S235JRC</td>
<td>1.0122</td>
<td>(t)</td>
<td>1.6</td>
</tr>
<tr>
<td>S235J0C</td>
<td>1.0115</td>
<td>(l)</td>
<td>1.6</td>
</tr>
<tr>
<td>S235J2C</td>
<td>1.0119</td>
<td>(l)</td>
<td>2.0</td>
</tr>
<tr>
<td>S275JRC</td>
<td>1.0128</td>
<td>(t)</td>
<td>2.0</td>
</tr>
<tr>
<td>S275J0C</td>
<td>1.0140</td>
<td>(l)</td>
<td>2.0</td>
</tr>
<tr>
<td>S275J2C</td>
<td>1.0142</td>
<td>(l)</td>
<td>2.0</td>
</tr>
<tr>
<td>S355J0C</td>
<td>1.0554</td>
<td>(t)</td>
<td>2.5</td>
</tr>
<tr>
<td>S355J2C</td>
<td>1.0579</td>
<td>(l)</td>
<td>2.5</td>
</tr>
<tr>
<td>S355K2C</td>
<td>1.0594</td>
<td>(l)</td>
<td>2.5</td>
</tr>
</tbody>
</table>

\(a\): transverse to the rolling direction.

\(l\): parallel to the rolling direction.

\(b\): The values are applicable for bend angles \(\leq 90^\circ\).
<table>
<thead>
<tr>
<th>Designation</th>
<th>According EN 10027-1 and CR 10260</th>
<th>According EN 10027-2</th>
<th>Minimum recommended inside bend radii $^a$ for nominal thicknesses $t$ in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>$t \leq 4$</td>
</tr>
<tr>
<td>S235JRC</td>
<td>1.0122</td>
<td></td>
<td>$1t$</td>
</tr>
<tr>
<td>S235J0C</td>
<td>1.0115</td>
<td></td>
<td></td>
</tr>
<tr>
<td>S235J2C</td>
<td>1.0119</td>
<td></td>
<td></td>
</tr>
<tr>
<td>S275JRC</td>
<td>1.0128</td>
<td></td>
<td>$1t$</td>
</tr>
<tr>
<td>S275J0C</td>
<td>1.0140</td>
<td></td>
<td></td>
</tr>
<tr>
<td>S275J2C</td>
<td>1.0142</td>
<td></td>
<td></td>
</tr>
<tr>
<td>S355J0C</td>
<td>1.0554</td>
<td></td>
<td>$1t$</td>
</tr>
<tr>
<td>S355J2C</td>
<td>1.0579</td>
<td></td>
<td></td>
</tr>
<tr>
<td>S355K2C</td>
<td>1.0594</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

$^a$ The values are applicable for bend angles $\leq 90^\circ$.  

Table 13 - Cold roll forming of flat products
# Annex A

## List of corresponding former designations

<table>
<thead>
<tr>
<th>Designation according EN 10025-2:2004</th>
<th>According to EN 10025:1990</th>
<th>According to DIN 17100</th>
<th>Germany according to NF A 35-501</th>
<th>France according to BS 4360</th>
<th>United Kingdom according to UNI 35-080</th>
<th>Italy according to NBN A 21-101</th>
<th>Belgium according to SS 14 followed by number steel grade</th>
<th>Sweden according to NP 1729</th>
<th>Portugal according to M 3116</th>
<th>Austria according to number steel grade</th>
<th>Norway according to number steel grade</th>
</tr>
</thead>
<tbody>
<tr>
<td>S185 0035</td>
<td>S185 0035</td>
<td>Fe 310.0</td>
<td>St 33</td>
<td>A 33</td>
<td>Fe 320</td>
<td>Fe 320</td>
<td>3 00-00</td>
<td>Fe 310.0</td>
<td>St 320</td>
<td></td>
<td></td>
</tr>
<tr>
<td>S235JR 1 0038</td>
<td>S235JR 1 0038</td>
<td>Fe 360 B</td>
<td>St 37-2</td>
<td>E 24-2</td>
<td>Fe 360</td>
<td>AE 235-B</td>
<td>13 11-00</td>
<td>Fe 360-B</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S235J0 1 0114</td>
<td>S235J0 1 0114</td>
<td>Fe 360 C</td>
<td>St 37-3 U</td>
<td>E 24-3</td>
<td>Fe 360</td>
<td>AE 235 B-FU</td>
<td>13 12-00</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S235JR 1 0114</td>
<td>S235JR 1 0114</td>
<td>Fe 360 C</td>
<td>St 37-3 U</td>
<td>E 24-3</td>
<td>Fe 360</td>
<td>AE 235 B-FU</td>
<td>13 12-00</td>
<td></td>
<td></td>
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<td></td>
</tr>
<tr>
<td>S235J0 1 0114</td>
<td>S235J0 1 0114</td>
<td>Fe 360 C</td>
<td>St 37-3 U</td>
<td>E 24-3</td>
<td>Fe 360</td>
<td>AE 235 B-FU</td>
<td>13 12-00</td>
<td></td>
<td></td>
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<tr>
<td>S235J2 1 0117</td>
<td>S235J2 1 0117</td>
<td>Fe 360 C</td>
<td>St 37-3 N</td>
<td>E 24-4</td>
<td>Fe 360</td>
<td>AE 235 B</td>
<td>13 14-00</td>
<td></td>
<td></td>
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<tr>
<td>S275JR 1 0044</td>
<td>S275JR 1 0044</td>
<td>Fe 430 B</td>
<td>St 44-2</td>
<td>E 28-2</td>
<td>Fe 430</td>
<td>AE 275 B</td>
<td>14 12-00</td>
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<td>S275J0 1 0143</td>
<td>Fe 430 C</td>
<td>St 44-3 U</td>
<td>E 28-3</td>
<td>Fe 430</td>
<td>AE 275 C</td>
<td>14 12-00</td>
<td></td>
<td></td>
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<td>S275J2 1 0145</td>
<td>Fe 430 D</td>
<td>St 44-3 N</td>
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<td>Fe 430</td>
<td>AE 275 D</td>
<td>14 14-00</td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>S355JR 1 0045</td>
<td>S355JR 1 0045</td>
<td>Fe 510 B</td>
<td>St 52-3 U</td>
<td>E 36-2</td>
<td>Fe 510</td>
<td>AE 355 B</td>
<td>15 00-00</td>
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<td></td>
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<tr>
<td>S355J0 1 0553</td>
<td>S355J0 1 0553</td>
<td>Fe 510 C</td>
<td>St 52-3 N</td>
<td>E 36-3</td>
<td>Fe 510</td>
<td>AE 355 C</td>
<td>15 00-00</td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>S355J2 1 0577</td>
<td>S355J2 1 0577</td>
<td>Fe 510 D</td>
<td>St 52-3 N</td>
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<td>Fe 510</td>
<td>AE 355-D</td>
<td>16 55-00</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S355K2 1 0596</td>
<td>S355K2 1 0596</td>
<td>Fe 510 DD</td>
<td>St 52-3 N</td>
<td>E 36-4</td>
<td>Fe 510</td>
<td>AE 355-D</td>
<td>16 55-00</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S450J0 1 0590</td>
<td>S450J0 1 0590</td>
<td>Fe 490-2</td>
<td>St 50-2</td>
<td>A 50-2</td>
<td>Fe 490</td>
<td>A 490-2</td>
<td>Fe 490-2</td>
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<td>E265 1 0050</td>
<td>E265 1 0050</td>
<td>Fe 490-2</td>
<td>St 50-2</td>
<td>A 50-2</td>
<td>Fe 490</td>
<td>A 490-2</td>
<td>Fe 490-2</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
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<td>E350 1 0060</td>
<td>E350 1 0060</td>
<td>Fe 590-2</td>
<td>St 60-2</td>
<td>A 60-2</td>
<td>Fe 590</td>
<td>A 590-2</td>
<td>16 50-00</td>
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<td>E360 1 0070</td>
<td>E360 1 0070</td>
<td>Fe 690-2</td>
<td>St 70-2</td>
<td>A 70-2</td>
<td>Fe 690</td>
<td>A 690-2</td>
<td>16 55-00</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

* When a product is delivered in the N condition +N shall be added to the designation (see 4.2.2).
## Annex B
(informative)

### List of national standards which correspond with EURONORMS referenced

Until the following EURONORMS are transformed into European Standards, they may be either implemented or reference made to the corresponding national standards as listed in Table B.1.

**NOTE** Standards listed in Table B.1 are not supposed to be strictly similar although they deal with the same subjects.

### Table B.1 — EURONORMS with corresponding national standards

<table>
<thead>
<tr>
<th>EURONORM</th>
<th>Germany</th>
<th>France</th>
<th>United Kingdom</th>
<th>Spain</th>
<th>Italy</th>
<th>Belgium</th>
<th>Portugal</th>
<th>Sweden</th>
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\(^a\) This EURONORM is formally withdrawn, but there are no corresponding EN's.
Bibliography


\(^2\) Until ECSC IC 2 is transformed into a CEN Technical Report, it can either be implemented or reference made to the corresponding national standards, the list of which is given in Annex B to this document.
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