



SLOVENSKI STANDARD
SIST EN 10147:1997/A1:1997
01-maj-1997

Kontinuirno vroče cinkana pločevina in trakovi iz konstrukcijskega jekla - Tehnični dobavni pogoji

Continuously hot-dip zinc coated structural steel strip and steel - Technical delivery conditions

Kontinuierlich feuerverzinktes Band und Blech aus Baustählen - Technische Lieferbedingungen

Bandes et tôles en acier de construction galvanisées a chaud en continu - Conditions techniques de livraison

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Ta slovenski standard je istoveten z: EN 10147:1991/A1:1995

ICS:

| | | |
|-----------|--|---------------------------------------|
| 77.140.50 | Ploščati jekleni izdelki in polizdelki | Flat steel products and semi-products |
|-----------|--|---------------------------------------|

SIST EN 10147:1997/A1:1997 **en**

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EUROPEAN STANDARD

EN 10147:1991/A1

NORME EUROPÉENNE

EUROPÄISCHE NORM

June 1995

ICS 77.140.50

Descriptors: Iron and steel products, metal plates, steel strips, structural steels, unalloyed steels, hot dip galvanizing, continuous coating, delivery condition, designation, classification, inspection, tests, marking

English version

Continuously hot-dip zinc coated structural steel strip and steel - Technical delivery conditions

Bandes et tôles en acier de construction galvanisées à chaud en continu - Conditions techniques de livraison

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This amendment 1 modifies the European Standard EN 10147:1991. This amendment was approved by CEN on 1995-05-10. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this amendment the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

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Foreword

This Amendment 1 to the European Standard EN 10147 has been prepared by Technical Committee ECISS/TC 27 "Surface coated steel flat products" of which the secretariat is held by DIN.

During the 14th COCOR-meeting on 27. and 28. May 1993 in Brussels ECISS/TC 27 was charged to prepare an Amendment of EN 10147 in order to work in the new designations according to EN 10027 Part 1 and ECISS Information Circular IC 10 as well as the steel numbers according to EN 10027 Part 2.

It is intended to issue a second version of EN 10147 as soon as this Amendment is adopted.

This Amendment to European Standard EN 10147 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by December 1995, and conflicting national standards shall be withdrawn at the latest by December 1995.

According to the CEN/CENELEC Internal Regulations, the following countries are bound to implement this Amendment 1 to European Standard EN 10147: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, United Kingdom.

Amendment 1 to EN 10147**General:**

1. The designations in the text shall be substituted by the designations according to EN 10027 part 1 and Information Circular IC 10.
2. The missing steel numbers shall be inserted according to EN 10027 part 2.
3. The normative references shall be up-dated by adaption of the concerned references.
4. Particular clauses shall be adapted to the PNE-Rules.

Title

The title shall be amended as follows:

"Continuously hot-dip zinc coated structural steel strip and sheet" (Alignment to prEN 10214, prEN 10215 and prEN 10154).

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2 Normative references

The list of normative references shall be up-dated as follows:

| | |
|------------|---|
| EN 10002-1 | Metallic materials - Tensile testing - Part 1: Method of testing (at ambient temperature) |
| EN 10020 | Definition and classification of grades of steel |
| EN 10021 | General technical delivery requirements for steels and steel products |
| 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 10079 | Definition of steel products |

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| | |
|---------------------------|--|
| EN 10143 | Continuously hot-dip metal coated steel sheet and strip - tolerances on dimensions and shape |
| EN 10204 | Metallic products - types of inspection documents |
| ECISS IC 10 | Designation systems for steel - additional symbols for steel names |
| EURONORM 12 ¹⁾ | Bend test for steel sheet and strip less than 3 mm thick |

4 Designation

The following additional introducing subclause 4.1 shall be inserted:

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"4.1 The steel names are allocated in accordance with EN 10027-1 and ECISS Information Circular IC 10; the steel numbers are allocated in accordance with EN 10027-2."

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The former subclause 4.1 shall become 4.2.

In subclause 4.2 (new) item c) shall be replaced by the following wording: "c) Steel name or number and symbol for the type of hot-dip coating as given in table 1".

The examples for the designation shall be amended and extended as follows:

Strip EN 10147-S250GD+Z275-N-A-C
or Strip EN 10147-1.0242+Z275-N-A-C

Sheet EN 10147-S320GD+ZF100-R-B-O
or Sheet EN 10147-1.0250+ZF100-R-B-O

¹⁾ Until it is transformed into an European Standard, either EURONORM 12 or the corresponding national standard may be applied.

5 Classification of grades and types of delivery

Tables 1, 2 and 3 shall be substituted by the following tables 1, 2 and 3.

Table 1: Steel grades and mechanical properties of steels (for thicknesses ≤ 3 mm)

| Designation | | Symbol for the type of hot-dip coating | Yield strength R_e N/mm ² min. | Tensile strength R_m N/mm ² min. | Elongation A_{90} % min. ¹⁾ |
|-------------|--------------|--|--|--|---|
| Steel name | Steel number | | | | |
| S220GD | 1.0241 | + Z | 220 | 300 | 20 |
| S220GD | 1.0241 | + ZF | | | |
| S250GD | 1.0242 | + Z | 250 | 330 | 19 |
| S250GD | 1.0242 | + ZF | | | |
| S280GD | 1.0244 | + Z | 280 | 360 | 18 |
| S280GD | 1.0244 | + ZF | | | |
| S320GD | 1.0250 | + Z | 320 | 390 | 17 |
| S320GD | 1.0250 | + ZF | | | |
| S350GD | 1.0529 | + Z | 350 | 420 | 16 |
| S350GD | 1.0529 | + ZF | | | |
| S550GD | 1.0531 | + Z | 550 | 560 | |
| S550GD | 1.0531 | + ZF | | | |

1) For product thicknesses $\leq 0,7$ mm (including zinc coating) the minimum elongation values (A_{90}) shall be reduced by 2 units.

Table 2: Available coatings, finishes and surface qualities for zinc coatings (Z)

| Steel grade | Coating 1) 2) | Coating finish | | | |
|-------------|---------------------|----------------|----------------------|---|---|
| | | N | M | | |
| | | | Surface qualities 2) | | |
| A | A | B | C | | |
| All | 100 | X | X | X | X |
| | 140 | X | X | X | X |
| | 200 | X | X | X | X |
| | 225 | X | X | X | X |
| | 275 | X | X | X | X |
| | 350 | X | X | - | - |
| | (450) | (X) | - | - | - |
| | (600) ³⁾ | (X) | - | - | - |

1) See also 5.2.2.

2) The coating designations and surface qualities given in brackets are available on agreement.

3) Not for steel grade S550GD+Z

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 Table 3: Available coatings, finishes and surface qualities for zinc-iron alloy coatings (ZF)

| Steel grade | Coating 1) | Coating finish | | |
|-------------|---------------|-------------------|---|---|
| | | R | | |
| | | Surface qualities | | |
| A | B | C | | |
| All | 100 | X | X | X |
| | 140 | X | X | - |

1) See also 5.2.2.

6 Requirements

Table 4 shall be substituted by the following table 4.

Table 4: Coating masses

| Coating 1) | Minimum coating mass in g/m ² including both surfaces ²⁾ | |
|---------------|---|-----------------------------------|
| | Triple spot test ³⁾ | Single spot test ³⁾ |
| 100 | 100 | 85 |
| 140 | 140 | 120 |
| 200 | 200 | 170 |
| 225 | 225 | 195 |
| 275 | 275 | 235 |
| 350 | 350 | 300 |
| 450 | 450 | 385 |
| 600 | 600 | 510 |

1) The coatings available for the individual steel grades are given in tables 2 and 3.

2) The coating mass of 100 mg/m² (including both surfaces) corresponds to a coating thickness of approximately 7,1 µm on each surface.

3) See 7.4.4 and 7.5.3.