
Vroče valjani izdelki iz konstrukcijskih jekel - 2. del: Tehnični dobavni pogoji za nelegirana konstrukcijska jekla

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

Warmgewalzte Erzeugnisse aus Baustählen - Teil 2: Technische Lieferbedingungen für unlegierte Baustähle

Produits laminés à chaud en aciers de construction - Partie 2 : Conditions techniques de livraison pour les aciers de construction non alliés

Ta slovenski standard je istoveten z: prEN 10025-2

ICS:

77.140.10	Jekla za toplotno obdelavo	Heat-treatable steels
77.140.45	Nelegirana jekla	Non-alloyed steels
77.140.50	Ploščati jekleni izdelki in polizdelki	Flat steel products and semi-products

oSIST prEN 10025-2:2018**en,fr,de**

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

DRAFT
prEN 10025-2

June 2018

ICS 77.140.10; 77.140.45; 77.140.50

Will supersede EN 10025-2:2004

English Version

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Baustähle

This draft European Standard is submitted to CEN members for second enquiry. It has been drawn up by the Technical Committee ECISS/TC 103.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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SIST EN 10025-2:2019

<https://standards.iteh.ai/catalog/standards/sist/bc1b1cb5-113a-4eb6-8062-c4a4219d3c04/sist-en-10025-2-2019>

European foreword

This document (prEN 10025-2:2018) has been prepared by Technical Committee ECISS/TC 103 “Structural steels other than reinforcement”, the secretariat of which is held by DIN.

This document is currently submitted to the second CEN Enquiry.

This document will supersede EN 10025-2:2004.

This European Standard consists of the following parts, under the general title *Hot rolled products of structural steels*:

Part 1: General

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

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

For a short transition period there will be a coexistence of EN 10025-1:2004 with EN 10025-2:2018 to EN 10025-6:2018, since the new EN 10025-1 has to fulfil the requirements of the CPR and will therefore be published later. For this short transition period up-to-the publication of the next edition of part 1 the following has to be taken into account for EN 10025-1:2004:

- a) all dated and undated references to EN 10025-1:2004 to EN 10025-6:2004 are unchanged to this version with following exception: In 9.2.2.1 the reference must be 8.3.1 and 8.3.2 instead of 8.4.1 and 8.4.2;
- b) Clauses 5, 12 and 13 of EN 10025-1:2004 are no longer relevant.

The main changes with respect to the previous edition are listed below:

- a) part 2 is now a stand-alone standard for technical delivery conditions including the preparation of samples and test pieces, the test methods, the marking, labelling and packaging and the drawings;
- b) for construction purposes this standard and part 1 must be used together;
- c) requirements for elements not defined were added to 7.2.1 and 7.2.2;
- d) Option 33 was added, Options 9 and 21 were deleted;
- e) Si-content in 7.2.5 was changed;
- f) 7.4.3 concerning hot-dip zinc coating was modified;
- g) key to Figure A.1 was updated;

- h) steel grade S450 was deleted and steel grades S460 and S500 were added;
- i) Annex B was deleted;
- j) references were updated and the document was editorially revised.

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SIST EN 10025-2:2019

<https://standards.iteh.ai/catalog/standards/sist/bc1b1cb5-113a-4eb6-8062-c4a4219d3c04/sist-en-10025-2-2019>

1 Scope

This document specifies the technical delivery conditions for flat and long products as well as 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 1 to 5 (chemical composition) and Tables 6 to 8 (mechanical properties) in the usual delivery conditions as given in 6.3. Three engineering steels are also specified in this document (see Tables 2 and 4) (chemical composition) and Table 7 (mechanical properties). This document does not apply to structural hollow sections (see EN 10210-1 and EN 10219-1) and tubes.

The technical delivery conditions apply to:

- thicknesses ≥ 3 mm and ≤ 150 mm for long products of steel grade S460JR, J0, J2, K2 and S500J0;
- thicknesses ≤ 400 mm for flat products of qualities JR, J0, J2 and K2;
- thicknesses ≤ 250 mm for flat and long products of all other grades and qualities.

The steels specified in this document are not intended to be heat treated except products delivered in the delivery condition +N. Stress relieving is permitted. Products delivered in +N condition can be hot formed and/or normalized after delivery (see Clause 3).

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 order. The chemical composition can also be agreed at the time of the order, however the values should be within the limits of Tables 1 and 2.

For certain grades and product forms suitability for particular applications may be specified at the time of the order (see 7.4.2, 7.4.3 and Table 9).

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 1011-2, *Welding — Recommendations for welding of metallic materials — Part 2: Arc welding of ferritic steels*

EN 10020:2000, *Definition and classification of grades of steel*

EN 10021, *General technical delivery conditions for steel products*

EN 10025-1:2004, *Hot rolled products of structural steels — Part 1: General technical delivery conditions*

EN 10027-1, *Designation systems for steels — Part 1: Steel names*

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

EN 10079, *Definition of steel products*

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: Plate 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 10168, *Steel products — Inspection documents — List of information and description*

EN 10204, *Metallic products — Types of inspection documents*

CEN/TR 10347, *Guidance for forming of structural steels in processing*

CR 10320, *Optical emission analysis of low alloy steels (routine method) — Method for determination of C, Si, S, P, Mn, Cr, Ni and Cu*

FprEN ISO 9443:2018, *Surface quality classes for hot-rolled bars and wire rod (ISO/FDIS 9443:2018)*

EN ISO 14713-2:2009, *Zinc coatings — Guidelines and recommendations for the protection against corrosion of iron and steel in structures — Part 2: Hot dip galvanizing (ISO 14713-2:2009)*

2.2 Standards on dimensions and tolerances

EN 10017, *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 and shape*

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 strip and plate/sheet cut from wide 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*

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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 10279, *Hot rolled steel channels — Tolerances on shape, dimensions and mass*

EN 10363, *Continuously hot-rolled patterned steel strip and plate/sheet cut from wide strip — Tolerances on dimensions and shape*

EN 10365, *Hot rolled steel channels, I and H sections — Dimensions and masses*

2.3 Standards on testing

EN 10160, *Ultrasonic testing of steel flat product of thickness equal 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*

EN ISO 148-1, *Metallic materials — Charpy pendulum impact test — Part 1: Test method (ISO 148-1)*

EN ISO 377, *Steel and steel products — Location and preparation of samples and test pieces for mechanical testing (ISO 377)*

EN ISO 643, *Steels — Micrographic determination of the apparent grain size (ISO 643)*

EN ISO 6892-1:2016, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature (ISO 6892-1:2016)*

EN ISO 14284, *Steel and iron — Sampling and preparation of samples for the determination of chemical composition (ISO 14284)*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 10079 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

3.1**normalized rolled**

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

Note 1 to entry: The abbreviated form of this delivery condition is +N.

Note 2 to entry: In international publications for both the normalizing rolling, as well as the thermomechanical 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**

conventional hot rolling without any normalized rolling or thermomechanical rolling and/or heat treatment like normalizing or quenching

Note 1 to entry: 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 to entry: The abbreviated form of this delivery condition is +M.

Note 2 to entry: 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 to entry: In some publications the word TMCP (Thermomechanical Control Process) is also used.

3.4**normalizing**

heat treatment consisting of austenitizing followed by air cooling

Note 1 to entry: The abbreviated form of this delivery condition is +N.

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 nine steel grades S185, S235, S275, S355, S460, S500, E295, E335 and E360.

The steel grades S235 and S275 may be supplied in qualities JR, J0 and J2. The steel grades S355 and S460 may be supplied in qualities JR, J0, J2 and K2. The steel grade S500 may be supplied in quality J0.

The qualities differ in specified impact energy requirements.

For steel grades S185, E295 to E360 no requirements for impact energy are specified.

4.2 Designation

4.2.1 For the steel grades covered by this document the steel names shall be allocated in accordance with EN 10027-1; the steel numbers shall be allocated in accordance with EN 10027-2.

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:

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- symbol S (for structural steel) or E (for engineering steel);
- indication of the minimum specified yield strength for thickness ≤ 16 mm expressed in MPa;
- 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 9, 10, 11 and 12);
- indication “+N”, “+AR” or “+M”, when the products are ordered and delivered in the condition +N, +AR or +M (see 3.1, 3.2, 3.3, 3.4 and 6.3). The indication “+N”, “+AR” or “+M” shall also be added to the steel name or the steel number.

EXAMPLE Structural steel (S) with a specified minimum yield strength at room temperature of 355 MPa with a minimum impact energy of 27 J at 0 °C (J0) and suitable for cold flanging (C), delivery condition +N (Option 19):

EN 10025-2 - S355J0C+N

or

EN 10025-2 - 1.0554+N

5 Information to be supplied by the purchaser

5.1 Mandatory information

The following information shall be supplied by the purchaser at the time of the order:

- a) quantity to be delivered;
- b) product form and the number of the standard for dimensions and tolerances (see 2.2);
- c) nominal dimensions and tolerances on dimensions and shape (see 7.7.1);
- d) steel designation (see 4.2.2);
- e) additional requirements of inspection and testing and all required options (see 5.2 and Clause 13);
- f) type of inspection document according to EN 10204 (see 8.1);

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, see 5.1 a) to d) and f).

6 Manufacturing process

6.1 Steel making process

The steel making process is at the discretion of the manufacturer with the exclusion of the open hearth (Siemens-Martin) process.

See **Option 1** (details of manufacturing process).

6.2 Deoxidation and grain structure

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.

The method of deoxidation shall be as given in Tables 1 and 2.

6.3 Delivery conditions

Unless otherwise agreed the delivery condition of long products and hot rolled strip can be +AR, +N or +M at the manufacturer's discretion, the delivery condition for quarto plates can only be +AR or +N at the manufacturer's discretion.

See **Option 19** (delivery condition +AR, +N or +M for long products and strip, +AR, +N for quarto plates).

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

NOTE The requirements on the mechanical properties of the steel grades according to this standard are not depending on the delivery condition.

7 Requirements

7.1 General

The requirements in 7.2 and 7.3 apply for sampling, preparation of test pieces and testing specified in Clauses 9 and 10.

7.2 Chemical composition

7.2.1 The chemical composition determined by ladle analysis shall comply with the specified values of Tables 1 and 2.

For elements not defined in tables for the chemical composition for ladle analysis, limit values of Table 1 of EN 10020:2000 shall apply as maximum values.

7.2.2 The upper limits applicable for the product analysis are given in Tables 3 and 4.

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

See **Option 2** (product analysis).

For elements not defined in tables for the chemical composition for product analysis, limit values of Table 1 of EN 10020:2000 shall apply as maximum values.

7.2.3 The maximum carbon equivalent values for the grades S235, S275, S355, S460 and S500 based on the ladle analysis, given in Table 5 shall apply.

For determining the carbon equivalent value the following IIW (International Institute of Welding) formula shall be used:

$$CEV = C + \frac{Mn}{6} + \frac{Cr + Mo + V}{5} + \frac{Ni + Cu}{15}$$