
**Continuously cold-rolled stainless
steel — Tolerances on dimensions and
form —**

**Part 2:
Wide strip and plate/sheet**

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*Acier inoxydable laminé à froid en continu — Tolérances sur les
dimensions et la forme —
Partie 2: Larges bandes et tôles*

[ISO 9445-2:2009](#)

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 9445-2 was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 4, *Heat treatable and alloy steels*.

This first edition of ISO 9445-2, together with ISO 9445-1, cancels and replaces ISO 9445:2002, the contents of which have been technically revised and separated into two parts.

ISO 9445 consists of the following parts, under the general title *Continuously cold-rolled stainless steel — Tolerances on dimensions and form*:

— *Part 1: Narrow strip and cut lengths*

— *Part 2: Wide strip and plate/sheet*

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Continuously cold-rolled stainless steel — Tolerances on dimensions and form —

Part 2: Wide strip and plate/sheet

1 Scope

This part of ISO 9445 specifies the tolerances on dimensions and form for continuously cold-rolled stainless steel wide strip and plate/sheet, in thicknesses from 0,30 mm to 8,0 mm and in rolling widths from 600 mm to 2 100 mm. It also applies to slit cold-rolled wide strip in widths less than 600 mm manufactured from wide strip by longitudinal slitting and to cut lengths manufactured from such strip.

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.

ISO 6929, *Steel products — Definitions and classification*
<https://standards.iso.org/standards/catalog/standards/siv/97f1b698-f470-41c7-8e9e-410802af084c/iso-9445-2-2009>

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 6929 apply.

4 Information to be supplied by the purchaser

4.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for products under this specification. Such requirements to be considered include, in the order listed, but are not limited to, the following:

- a) the type of delivery [see 5.2 a) to 5.2 d)];
- b) the number of this International Standard, i.e. ISO 9445-2;
- c) the thickness in millimetres (if necessary accurate to two decimal places) and, if required, including the relevant code letter (S) for a special tolerance;
- d) the measurement of the thickness method to be used, either method A in accordance with 17.2 and tolerances according to Table 1 with the relevant code letter (A) or method B in accordance with 17.3 and tolerances according to Table 2 with the relevant code letter (B);
- e) the width in millimetres and, if required, including the relevant code letter (S) for a special tolerance;

- f) for cold-rolled wide strip and plate/sheet, whether mill (M) or trimmed (T) edges are required. The other products will normally have trimmed edges (see 5.3);
- g) for plate/sheet and cut lengths, the length in millimetres and, if a special tolerance is required, the code letter S;
- h) for cold-rolled plate/sheet and cut lengths, the code letter FS where a special tolerance is required for flatness.

EXAMPLE 1 Cut length obtained from slit cold-rolled wide strip according to this part of ISO 9445 with a specified thickness of 1,5 mm, special thickness tolerance (S), measuring method A, with a specified width of 200 mm, special tolerance on width (S), with a specified length of 500 mm, special tolerance on length (S) and a special tolerance on flatness (FS).

Cut length from slit cold-rolled wide strip ISO 9445-2 – 1,5SA x 200S x 500S-FS

EXAMPLE 2 Cold-rolled wide strip according to this part of ISO 9445 with a specified thickness of 0,8 mm, normal tolerance, measuring method B, width 1 250 mm, with trimmed edges (T).

Cold-rolled wide strip ISO 9445-2 – 0,80B x 1250T

4.2 In the absence of information in the order concerning special requirements for tolerances on dimension and shape [see 4.1 c), e), g) and h)], flat products covered by this part of ISO 9445 will be delivered according to the basic specifications of this part of ISO 9445, i.e. with normal tolerances.

5 Type of delivery and delivery condition
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5.1 General

In the absence of agreements at the time of enquiry and order concerning special requirements for the delivery conditions given in 5.3, flat products covered by this part of ISO 9445 will be delivered according to the basic specifications of this part of ISO 9445.

5.2 Type of delivery

Flat products according to this part of ISO 9445 can be supplied as

- a) cold-rolled wide strip (strip in rolled widths equal to or greater than 600 mm);
- b) cold-rolled plate/sheet [cut from cold-rolled wide strip according to item 5.2 a)];
- c) slit cold-rolled wide strip [manufactured by longitudinal slitting of wide strip according to item 5.2 a)];
- d) cut lengths from slit cold-rolled wide strip [cut from slit cold-rolled wide strip according to item 5.2 c)].

5.3 Delivery condition of cold-rolled wide strip and products obtained from cold-rolled wide strip

Cold-rolled wide strip and plate/sheet cut from cold-rolled wide strip are supplied with either mill (M) or trimmed (T) edges. Slit cold-rolled wide strip and cut lengths obtained from slit cold-rolled wide strip normally have trimmed edges.

6 Preferred thicknesses

For cold-rolled wide strip and the products obtained from cold-rolled wide strip [see 5.2 a), 5.2 b), 5.2 c) and 5.2 d)], the following preferred thicknesses exist:

0,30 mm; 0,40 mm; 0,50 mm; 0,60 mm; 0,70 mm; 0,80 mm; 1,00 mm; 1,20 mm; 1,50 mm; 2,00 mm; 2,50 mm; 3,00 mm; 4,00 mm; 5,00 mm; 6,00 mm; 8,00 mm.

7 Tolerances on thickness for cold-rolled wide strip and products obtained from cold-rolled wide strip

The tolerances on thickness can be taken from Table 1 (see 17.2 – method A) or Table 2 (see 17.3 – method B).

NOTE The two tables are necessary to recognize different “custom and practice” in different countries with respect to measurement methods.

Table 1 — Tolerances on specified thickness for cold-rolled wide strip, plate/sheet cut from cold-rolled wide strip, slit cold-rolled wide strip and cut lengths obtained from slit cold-rolled wide strip

Dimensions in millimetres

Specified thickness t	Normal tolerances for a rolled width of		Special tolerances (S) for a rolled width of	
	$w \leq 2\ 100$	$w \leq 1\ 000$	$1\ 000 < w \leq 1\ 300$	$1\ 300 < w \leq 2\ 100$
$0,30 \leq t < 0,50$	$\pm 0,04$	$\pm 0,025$	$\pm 0,030$	—
$0,50 \leq t < 0,60$	$\pm 0,05$	$\pm 0,030$	$\pm 0,035$	—
$0,60 \leq t < 0,80$	$\pm 0,05$	$\pm 0,035$	$\pm 0,040$	—
$0,80 \leq t < 1,00$	$\pm 0,06$	$\pm 0,040$	$\pm 0,045$	$\pm 0,050$
$1,00 \leq t < 1,20$	$\pm 0,07$	$\pm 0,045$	$\pm 0,045$	$\pm 0,050$
$1,20 \leq t < 1,50$	$\pm 0,08$	$\pm 0,050$	$\pm 0,055$	$\pm 0,060$
$1,50 \leq t < 2,00$	$\pm 0,09$	$\pm 0,055$	$\pm 0,060$	$\pm 0,070$
$2,00 \leq t < 2,50$	$\pm 0,10$	—	—	—
$2,50 \leq t < 3,00$	$\pm 0,12$	—	—	—
$3,00 \leq t < 4,00$	$\pm 0,14$	—	—	—
$4,00 \leq t < 5,00$	$\pm 0,15$	—	—	—
$5,00 \leq t < 6,50$	$\pm 0,15$	—	—	—
$6,50 \leq t \leq 8,00$	$\pm 0,17$	—	—	—

NOTE The tolerances are measured in accordance with 17.2 – method A.

Table 2 — Tolerances on specified thickness for cold-rolled wide strip, plate/sheet cut from cold-rolled wide strip, slit cold-rolled wide strip and cut lengths obtained from slit cold-rolled wide strip

Dimensions in millimetres

Specified thickness <i>t</i>	Normal tolerances for a specified width of			Special tolerances (S) for a specified width of		
	$w \leq 1\,000$	$1\,000 < w \leq 1\,300$	$1\,300 < w \leq 2\,100$	$w \leq 1\,000$	$1\,000 < w \leq 1\,300$	$1\,300 < w \leq 2\,100$
$t < 0,30$	± 0,030	—	—	± 0,030	—	—
$0,30 \leq t < 0,40$	± 0,04	± 0,04	—	± 0,030	± 0,035	—
$0,40 \leq t < 0,50$	± 0,04	± 0,04	—	± 0,035	± 0,035	—
$0,50 \leq t < 0,60$	± 0,045	± 0,05	—	± 0,035	± 0,035	—
$0,60 \leq t < 0,80$	± 0,05	± 0,05	—	± 0,040	± 0,040	—
$0,80 \leq t < 1,00$	± 0,055	± 0,06	± 0,07	± 0,040	± 0,050	± 0,050
$1,00 \leq t < 1,20$	± 0,06	± 0,07	± 0,08	± 0,050	± 0,055	± 0,060
$1,20 \leq t < 1,50$	± 0,08	± 0,08	± 0,10	± 0,055	± 0,060	± 0,060
$1,50 \leq t < 2,00$	± 0,08	± 0,09	± 0,11	± 0,065	± 0,070	± 0,080
$2,00 \leq t < 2,50$	± 0,09	± 0,11	± 0,13	—	—	—
$2,50 \leq t < 3,00$	± 0,11	± 0,13	± 0,15	—	—	—
$3,00 \leq t < 4,00$	± 0,14	± 0,15	± 0,16	—	—	—
$4,00 \leq t < 5,00$	± 0,15	± 0,17	± 0,19	—	—	—
$5,00 \leq t < 6,00$	± 0,17	± 0,20	± 0,23	—	—	—
$6,00 \leq t \leq 8,00$	± 0,17	± 0,22	± 0,25	—	—	—

NOTE The tolerances are measured in accordance with 17.3 — method B.

8 Tolerances on width for cold-rolled wide strip and products obtained from cold-rolled wide strip

The tolerances on width are given in Table 3 (mill edges) and Table 4 (trimmed edges).

Table 3 — Tolerances on width for cold-rolled wide strip and sheet/plate cut from cold-rolled wide strip with mill edges

Dimensions in millimetres

Tolerances for a specified width of	
$600 \leq w < 1\,000$	$1\,000 \leq w \leq 2\,100$
+25 0	+30 0

Table 4 — Tolerances on width for cold-rolled wide strip, plate/sheet cut from cold-rolled wide strip, slit cold-rolled wide strip and cut lengths obtained from slit cold-rolled wide strip with trimmed edges

Dimensions in millimetres

Specified thickness t	Normal tolerances ^a for a specified width of					Special tolerances (S) ^a for a specified width of		
	$w \leq 125$ b	$125 < w \leq 250$ b	$250 < w < 600$ b	$600 \leq w \leq 1\,000$ b	$1\,000 < w \leq 2\,100$ b	$w \leq 125$	$125 < w \leq 250$	$250 < w < 600$
$t < 1,00$	+0,5 0	+0,5 0	+0,7 0	+1,5 0	+2,0 0	+0,3 0	+0,3 0	+0,6 0
$1,00 \leq t < 1,50$	+0,7 0	+0,7 0	+1,0 0	+1,5 0	+2,0 0	+0,4 0	+0,5 0	+0,7 0
$1,50 \leq t < 2,50$	+1,0 0	+1,0 0	+1,2 0	+2,0 0	+2,5 0	+0,6 0	+0,7 0	+0,9 0
$2,50 \leq t < 3,50$	+1,2 0	+1,2 0	+1,5 0	+3,0 0	+3,0 0	+0,8 0	+0,9 0	+1,0 0
$3,50 \leq t \leq 8,00$	+2,0 0	+2,0 0	+2,0 0	+4,0 0	+4,0 0	—	—	—

^a By special agreement, products can be supplied with permissible undersizes on the specified width. In this case, the values in this table apply as the oversize plus undersize range.

^b For material with edges re-cut by shearing, the tolerances on width may by agreement be increased to 5 mm.

9 Preferred coil inner diameters for cold-rolled wide strip and slit cold-rolled wide strip

The inside diameter of the coil should be decided by mutual agreement. Preferred inside diameters of coils are approximately 500 mm and approximately 600 mm; in the case of slit cold-rolled wide strip, approximately 400 mm may also be available.

10 Tolerances on length for plate/sheet cut from cold-rolled wide strip and for cut lengths obtained from slit cold-rolled wide strip

The tolerances on length are given in Table 5.

Table 5 — Length tolerances for plate/sheet cut from cold-rolled wide strip and for cut lengths obtained from slit cold-rolled wide strip

Dimensions in millimetres

Specified length l	Tolerances	
	Normal	Special (S)
$l \leq 2\,000$	+5 0	+3 0
$2\,000 < l$	+0,002 5 l 0	+0,0015 l 0