
Structural steels —

Part 1:

**General technical delivery conditions for
hot-rolled products**

Aciers de construction —

*Partie 1: Conditions générales techniques de livraison pour les produits
laminés à chaud*

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Contents

Page

Foreword	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Classification and designation	3
4.1 Classification	3
4.2 Designation	3
5 Information to be supplied by the purchaser	3
5.1 Mandatory information	3
5.2 Options	3
6 Requirements	4
6.1 Steel-making process	4
6.2 Delivery condition	4
6.3 Chemical composition	4
6.4 Mechanical properties	5
6.5 Surface condition	5
6.6 Internal soundness	5
6.7 Dimensions, tolerances on dimensions and shape, and mass	5
7 Inspection	5
7.1 Types of inspection and inspection documents	5
7.2 Tests to be carried out	6
7.3 Retests	6
8 Sampling	6
8.1 General	6
8.2 Frequency of testing	6
8.3 Selection and preparation of samples and test pieces	7
9 Test methods	7
9.1 Chemical analysis	7
9.2 Tensile test	7
9.3 Impact test	7
9.4 Through-thickness characteristics	8
9.5 Ultrasonic test	8
10 Marking	8
Annex A (informative) Applicable standards on dimensions, tolerances, shape and mass	9
Bibliography	10

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 630-1 was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 3, *Steels for structural purposes*.

This first edition cancels and replaces ISO 630:1995 and ISO 630:1995/Amd 1:2003.

ISO 630 consists of the following parts, under the general title *Structural steels*:

- *Part 1: General technical delivery conditions for hot-rolled products*
- *Part 2: Technical delivery conditions for structural steels for general purposes*
- *Part 3: Technical delivery conditions for fine grain structural steels*
- *Part 4: Technical delivery conditions for high yield strength quenched and tempered structural steel plates*

Technical delivery conditions for structural steels with improved atmospheric corrosion resistance will form the subject of a future Part 5.

Technical delivery conditions for seismic improved structural steels for building will form the subject of a future Part 6.

Structural steels —

Part 1: General technical delivery conditions for hot-rolled products

1 Scope

This part of ISO 630 specifies the general technical delivery conditions for steel flat and long products (plate/sections/wide flats and bars) used principally for general-purpose structural steels. The steels specified in this part of ISO 630 are intended for use in welded or bolted structures.

The specific requirements for structural steels are given in the individual parts of ISO 630.

This part of ISO 630 does not include the following structural steels, some of which are covered by other International Standards:

- sheet and strip: refer to ISO TC 17/SC 12 “Continuous mill flat rolled products”;
- tubular products: refer to ISO TC 5/SC 1 “Steel tubes”.

NOTE Lists of standards covered by ISO TC 17/SC 12 and ISO TC 5/SC 1 are available on the ISO Web site.

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

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

ISO 404, *Steel and steel products — General technical delivery requirements*

ISO 630-2, *Structural steels — Part 2: Technical delivery conditions for structural steels for general purposes*

ISO 630-3, *Structural steels — Part 3: Technical delivery conditions for fine grain structural steels*

ISO 630-4, *Structural steels — Part 4: Technical delivery conditions for high yield strength quenched and tempered structural steel plates*

ISO 657-1, *Hot-rolled steel sections — Part 1: Equal-leg angles — Dimensions*

ISO 657-2, *Hot-rolled steel sections — Part 2: Unequal-leg angles — Dimensions*

ISO 657-5, *Hot-rolled steel sections — Part 5: Equal-leg angles and unequal-leg angles — Tolerances for metric and inch series*

ISO 657-11, *Hot-rolled steel sections — Part 11: Sloping flange channel sections (Metric series) — Dimensions and sectional properties*

ISO 657-15, *Hot-rolled steel sections — Part 15: Sloping flange beam sections (Metric series) — Dimensions and sectional properties*

ISO 657-16, *Hot-rolled steel sections — Part 16: Sloping flange column sections (Metric series) — Dimensions and sectional properties*

ISO 630-1:2011(E)

ISO 657-19, *Hot-rolled steel sections — Part 19: Bulb flats (metric series) — Dimensions, sectional properties and tolerances*

ISO 657-21, *Hot-rolled steel sections — Part 21: T-sections with equal depth and flange width — Dimensions*

ISO 1035-1, *Hot-rolled steel bars — Dimensions of round bars*

ISO 1035-2, *Hot-rolled steel bars — Dimensions of square bars*

ISO 1035-3, *Hot-rolled steel bars — Dimensions of flat bars*

ISO 1035-4, *Hot-rolled steel bars — Tolerances*

ISO 2566-1, *Steel — Conversion of elongation values — Part 1: Carbon and low alloy steels*

ISO 4885, *Ferrous products — Heat treatments — Vocabulary*

ISO 4948-1, *Steels — Classification — Part 1: Classification of steels into unalloyed and alloy steels based on chemical composition*

ISO 4948-2, *Steels — Classification — Part 2: Classification of unalloyed and alloy steels according to main quality classes and main property or application characteristics*

ISO/TS 4949, *Steel names based on letter symbols*

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

ISO 6929, *Steel products — Definitions and classification*

ISO 7452, *Hot-rolled structural steel plates — Tolerances on dimensions and shape*

ISO 7778, *Steel plate with specified through-thickness characteristics*

ISO 7788, *Steel — Surface finish of hot-rolled plates and wide flats — Delivery requirements*

ISO 9034, *Hot-rolled structural steel wide flats — Tolerances on dimensions and shapes*

ISO 9443, *Heat-treatable and alloy steels — Surface quality classes for hot-rolled round bars and wire rods — Technical delivery conditions*

ISO/TS 9769, *Steel and iron — Review of available methods of analysis*

ISO 10474, *Steel and steel products — Inspection documents*

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

ISO 17577, *Steel — Ultrasonic testing for steel flat products of thickness equal to or greater than 6 mm*

ISO 20723, *Structural steels — Surface condition of hot-rolled sections — Delivery requirements*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 4885, ISO 4948-1, ISO 4948-2 and ISO 6929 and the following apply.

3.1

non-specific inspection

inspection carried out by the manufacturer in accordance with his own procedures to assess whether products defined by the same product specification, and made by the same manufacturing process, are in compliance with the requirements of the order or not

NOTE The products inspected may not necessarily be the products actually supplied.

3.2**specific inspection**

inspection carried out, before delivery, according to the product specification, on the products to be supplied or on test units of which the products supplied are part, in order to verify that these products are in compliance with the requirements of the order

4 Classification and designation**4.1 Classification**

The classification of the steel grades in accordance with ISO 4948-1 and ISO 4948-2 is given in the individual parts of ISO 630, depending on the steel-grade chemical composition and treatment condition.

4.2 Designation

The steel grades specified in the individual parts of ISO 630 are designated with steel names in accordance with ISO/TS 4949.

NOTE To distinguish the grades in Annex A and Annex B in the individual parts of ISO 630, an additional letter G is used for the grades in Annex B.

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 enquiry and order:

- a) the quantity required; [ISO 630-1:2011](https://standards.iteh.ai/catalog/standards/sist/188c4fea-0cf0-4493-a6b0-fee7a1f8e48e/iso-630-1-2011)
- b) the type of product; <https://standards.iteh.ai/catalog/standards/sist/188c4fea-0cf0-4493-a6b0-fee7a1f8e48e/iso-630-1-2011>
- c) the nominal dimensions and tolerances on dimensions and shape of the product;
- d) the number of the relevant part of ISO 630;
- e) the steel name (grade);
- f) all required options (see 5.2);
- g) inspection document to be issued (see 7.1).

5.2 Options

A number of options for agreement between the manufacturer and purchaser are specified in this part of ISO 630 and listed below. If the purchaser does not specify any of these options at the time of enquiry and order, the products shall be supplied in accordance with the basic specification (see 5.1):

- a) specification of the steel-making process (see 6.1);
- b) deviating delivery condition (see 6.2);
- c) product analysis (see 6.3.2);
- d) mechanical properties after additional heat treatment (see 6.4.1);
- e) specification of special classes for the reduction of area (see 6.4.3);
- f) additional tests (see 6.6 and 7.2.2);
- g) deviating frequency of testing (see 8.2);

- h) specification of an analytical method (see 9.1);
- i) deviating testing temperature for the impact test (see 9.3);
- j) marking method (see Clause 10);
- k) information to be given by marking (see Table 1);
- l) suitability for hot-dip galvanizing upon agreement with a referenced standard;
- m) ultrasonic testing upon agreement with a referenced standard;
- n) alternative weldability formula (see 6.3.3).

6 Requirements

6.1 Steel-making process

6.1.1 Unless a special steel-making process has been agreed upon at the time of enquiry and order, the steel-making process for steels in accordance with this part of ISO 630 shall be at the discretion of the manufacturer. If a special steel-making process has been specified, this shall be reported in the inspection document.

6.1.2 The method of deoxidation shall be as given in the individual parts of ISO 630.

6.2 Delivery condition

The delivery conditions are given in the individual parts of ISO 630.

6.3 Chemical composition

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6.3.1 Heat analysis

The heat analysis reported by the steel producer shall comply with the requirements of the individual parts of ISO 630 and shall be included in the relevant inspection document.

6.3.2 Product analysis

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

The permissible product analysis tolerances on the limiting values given for the cast analysis are specified in the individual parts of ISO 630.

6.3.3 Carbon-equivalent value

For determining the carbon-equivalent value (CEV), the following IIW (International Institute for Welding) formula shall be used.

$$CEV = C + Mn/6 + (Cr + Mo + V)/5 + (Ni + Cu)/15$$

NOTE If agreed upon at the time of enquiry and order [see 5.2 n)], other formulae for the CEV and for weld-crack sensitivity composition (P_{CM}) can be used.

The following formula for P_{CM} should be used:

$$P_{CM} = C + Si/30 + Mn/20 + Cu/20 + Ni/60 + Cr/20 + Mo/15 + V/10 + 5B$$

6.4 Mechanical properties

6.4.1 General

Under the inspection and testing conditions specified in Clauses 7, 8 and 9, and in the delivery condition as specified in 6.2, mechanical properties shall comply with the relevant requirements given in the individual parts of ISO 630. Agreement shall be reached, where appropriate, at the time of enquiry and order about the mechanical properties to be adhered to after additional heat treatment such as stress relief [see option 5.2 d)].

6.4.2 Impact properties

Impact properties shall comply with the requirements of the individual parts of ISO 630. If specified, the products over 12 mm in thickness shall be tested with a full-size test piece in accordance with 9.3. If agreed upon at the time of enquiry and order, sub-sized test pieces shall be used in the case of nominal product thicknesses of $6 \leq t \leq 12$ mm. Impact tests shall not be required for nominal thickness $t < 6$ mm. For sections, thickness refers to the part thickness where test pieces are prepared as specified in ISO 377.

6.4.3 Through-thickness characteristics

By agreement, products of the grades and qualities specified in the individual parts of ISO 630 shall comply with one of the improved deformation properties perpendicular to the surface of the product as specified in ISO 7778.

6.5 Surface condition

The surface properties shall be in accordance with ISO 7788 for plates and wide flats, ISO 20723 for sections and ISO 9443 for bars. Other surface-condition standards may be used if agreed upon at the time of enquiry and order.

6.6 Internal soundness

By agreement, ultrasonic requirements together with the conditions of their verification shall be specified. See 9.5.

6.7 Dimensions, tolerances on dimensions and shape, and mass

6.7.1 Dimensions, and tolerances on dimensions and shape

The nominal dimensions and tolerances on dimensions for the products shall be agreed upon at the time of enquiry and order, with reference to the dimensional standards listed below:

- a) for hot-rolled flat products, see ISO 7452 for plates and ISO 9034 for wide flats;
- b) for hot-rolled long products, see ISO 657-1, ISO 657-2, ISO 657-5, ISO 657-11, ISO 657-15, ISO 657-16, ISO 657-19 and ISO 657-21 for sections, or ISO 1035-1 to ISO 1035-4 for bars.

NOTE By agreement, the relevant standards shown in Annex A may be used.

6.7.2 Calculation of mass

A density of 7 850 kg/m³ shall be used as the basis for the calculation of the nominal mass from the nominal dimensions of all steels in the individual parts of ISO 630.

7 Inspection

7.1 Types of inspection and inspection documents

The products shall be delivered either with specific or non-specific inspection (see ISO 404) as specified in the individual parts of ISO 630 to confirm compliance with the order and this part of ISO 630.