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Steel — Surface finish of hot-rolled plates and wide flats — Delivery requirements

Acier — État de surface des tôles et larges-plats laminés à chaud — Conditions de livraison

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Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

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

This second edition cancels and replaces the first edition (ISO 7788:1985), which has been technically revised.

The main changes compared to the previous edition are as follows:

- updated normative reference;
- new definitions added and definitions in former [Annex A](#) added to [Clause 3](#);
- deletion of distinction concerning boilers and pressure vessel applications ([Clause 4](#));
- new definition of two classes and three subclasses added ([Clause 5](#));
- new [Clause 6](#) on “depth and determination of affected areas”, “repair requirements” and “repair procedures”;
- new [Annex B](#) with classes and subclasses for surface conditions with their respective requirements;
- deletion of [Annex A](#).

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Steel — Surface finish of hot-rolled plates and wide flats — Delivery requirements

1 Scope

This document specifies delivery requirements applicable to the surface finish of hot-rolled plates rolled on reversing mills and wide flats, with a nominal thickness ≥ 3 mm and ≤ 400 mm.

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.

ISO 6929, *Steel products — Vocabulary*

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

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

ISO 9606-1, *Qualification testing of welders — Fusion welding — Part 1: Steels*

ISO 15607, *Specification and qualification of welding procedures for metallic materials — General rules*

3 Terms and definitions

ISO/FDIS 7788

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

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

— ISO Online browsing platform: available at <https://www.iso.org/obp>

— IEC Electropedia: available at <http://www.electropedia.org/>

3.1

imperfection

surface discontinuity other than a *crack* (3.3), a *shell and seam* (3.4) with a depth and/or an area equal to or less than a specified limiting value

Note 1 to entry: Discontinuities that are required to be repaired are regarded as defects.

3.2

defect

surface discontinuity with a depth and/or area greater than a specified limiting value and any *crack* (3.3), *shell and seam* (3.4), irrespective of its depth or/and area

3.3

crack

localized discontinuity of varying length and varying orientation related to the rolling direction in the region of the surface, and which can less frequently occur as crazing

Note 1 to entry: Cracks are due mainly to material stresses which arise during the cooling process.

Note 2 to entry: Cracks are always considered as defects, see 6.2.1.2.3.

3.4

shell and seam

overlapping material being irregularly distributed over areas of the rolled product and being only partially connected with the base material

Note 1 to entry: The overlapping portions of the surface varying in shape and extent. There is a preponderance of non-metallic inclusions and/or scale among the shell. Shell can originate during casting or because of the shifting or sliding of layers of the material during hot rolling. Seams are caused mainly when defects in the semi-product parallel to the rolling direction, for instance, flame-cutting burrs, are overlapped during rolling.

Note 2 to entry: To get information about other surface of defects on the flat products, refer to valid references, including Reference [3].

Note 3 to entry: Shell and seams are always considered defects, see [6.2.1.2.3](#).

4 General

For plates with a nominal thickness greater than 400 mm and for special applications for which a different surface condition is required, special agreements shall be made at the time of enquiry and order.

Responsibility for the required surface condition, whether the product is delivered descaled or not, rests with the material producer, who has to take the necessary precautions. The producer can only take account of discontinuities that are visible to the naked eye. Rolling or heat-treatment scale can conceal surface discontinuities.

If the purchaser needs to be sure that all discontinuities visible to the naked eye have been identified, assessed and where necessary, repaired before delivery, products should be ordered descaled.

If, during the subsequent descaling or working operations by the user, the material is found to be defective because of faulty rolling or processing by the producer, the producer shall be given opportunity to repair the product, provided that this is not in conflict with the appropriate material or product standard.

5 Classification

The surface requirements and repair conditions are subdivided into 2 classes. Each class is further subdivided into 3 sub classes: (see also [Annex B](#)).

Class A: The surface condition shall conform to the requirements of [6.2.1](#) and [6.3.1.1](#). The remaining thickness of the affected area (see [6.1.2](#)) under the discontinuities and of the repaired ground areas may be less than the minimum thickness as specified in the appropriate tolerance standard.

Class B: The surface condition shall conform to the requirements of [6.2.2](#) and [6.3.1.2](#). The remaining thickness of the affected area under the discontinuities and of the repaired ground areas shall not be less than the minimum thickness as specified in the appropriate tolerance standard.

Subclass 1: Repair by chipping and/or grinding followed by welding is permitted in accordance with [6.3.2.2](#).

Subclass 2: Repair by welding is only permitted if agreed at the time of the order and under agreed conditions (see [6.3.2.3](#)).

Subclass 3: Repair by welding is not allowed.

The required class and subclass are specified in the appropriate material or product standard. If this is not the case, the class and subclass shall be class A and subclass 1 unless otherwise specified at the time of order.

6 Requirements

6.1 Depth and affected area of discontinuities

6.1.1 Depth

To differentiate the surface discontinuities in terms of imperfections and defects, the depth of representative surface discontinuities shall be measured when necessary. The measurement shall be carried out from the surface of the product. The depth of the discontinuities chosen as the representative ones shall be determined after the discontinuity has been removed by grinding.

6.1.2 Affected area

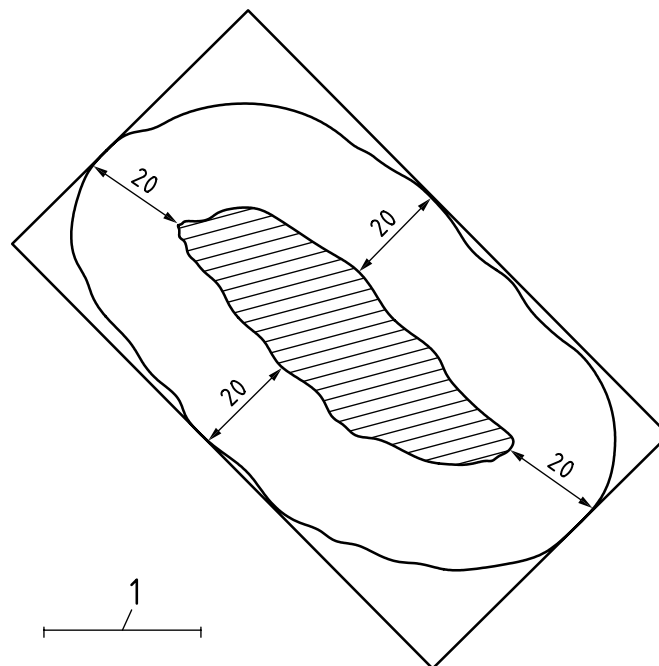
When necessary, areas affected by surface discontinuities shall be determined as follows:

- for isolated discontinuities (Figure 1), the affected area is obtained by drawing a continuous line that follows the circumference of the discontinuity at a distance of 20 mm or by drawing a rectangle whose sides are 20 mm from the edges of the discontinuity.
- For discontinuities appearing in a cluster (Figure 2), the affected area is obtained by drawing a continuous line that follows the circumference of the cluster at a distance of 20 mm or by drawing a rectangle whose sides are 20 mm from the continuous line that follows the cluster or by the product edge if it is closer.
- For discontinuities appearing in a line (Figure 3), the affected area is obtained by drawing a rectangle whose sides are 20 mm in the longitudinal direction and 20 mm in the transverse direction from the edge of the discontinuity or by the product edge if it is closer.

Multiple appearing discontinuities whose edges are closer together than 40 mm shall be considered as one cluster.

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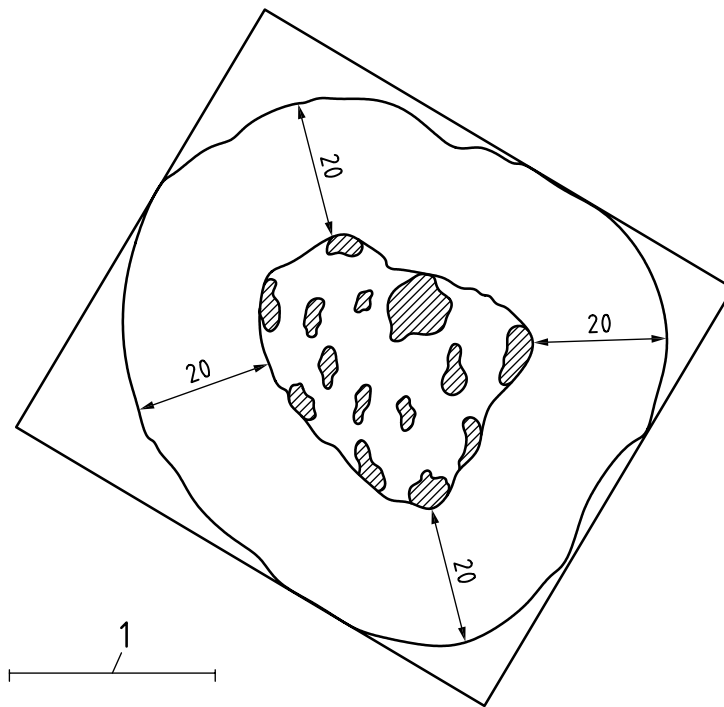
Dimensions in millimetres



Key

- 1 horizontal line

Figure 1 — Determination of the affected area due to an isolated discontinuity



Key
1 horizontal line

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Figure 2 — Determination of the affected areas due to clustered discontinuities

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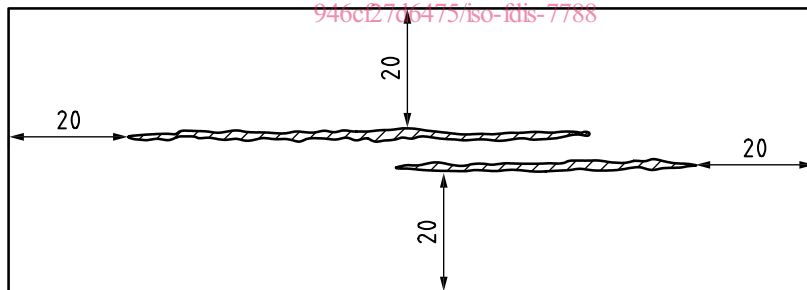


Figure 3 — Determination of the affected areas due to aligned single or multiple discontinuities

6.2 Repair requirements

The actions to undertake in function of the nature and the geometrical characteristics of discontinuities can be found in [Figure A.1](#) and [Table A.1](#).

6.2.1 Class A

6.2.1.1 Imperfections

6.2.1.1.1 Discontinuities other than cracks, shell and seams (see 6.2.1.2.3) not exceeding the limits of Table 1 are regarded as being inherent of the manufacturing process and are permissible irrespective of their number.

A surface area with discontinuities within the limits of Table 1 but with a remaining thickness under the discontinuities less than the minimum thickness as specified in ISO 7452 and ISO 9034 is permissible with a maximum of 15 % of the inspected surface.

Table 1 — Maximum permissible depth of imperfections

Nominal thickness of the product t mm	Maximum permissible depth of imperfections mm
$3 \leq t < 8$	0,2
$8 \leq t < 25$	0,3
$25 \leq t < 40$	0,4
$40 \leq t < 80$	0,5
$80 \leq t < 250$	0,7
$250 \leq t < 400$	1,3

6.2.1.1.2 Discontinuities other than cracks, shell and seams (see 6.2.1.2.3) with a depth exceeding the limits of Table 1 but not exceeding the limits of Table 2 and of which the sum of affected areas does not exceed 5 % of the inspected surface may be left unrepaired.

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Table 2 — Maximum permissible depth of discontinuities

Nominal thickness of the product t mm	Maximum permissible depth of discontinuities mm
$3 \leq t < 8$	0,4
$8 \leq t < 25$	0,5
$25 \leq t < 40$	0,6
$40 \leq t < 80$	0,8
$80 \leq t < 150$	0,9
$150 \leq t < 250$	1,2
$250 \leq t < 400$	1,5

A surface area with a remaining thickness under the discontinuities less than the minimum thickness as specified in ISO 7452 and ISO 9034 is permissible with a maximum of 2 % of the area of the inspected surface.

6.2.1.2 Defects

6.2.1.2.1 Discontinuities with a depth exceeding the limits of Table 1 but not exceeding the limits of Table 2, but with an affected surface are of more than 5 % of the inspected surface shall be repaired.

6.2.1.2.2 Discontinuities with a depth exceeding the limits of Table 2 shall be repaired, irrespective of their number.

6.2.1.2.3 Discontinuities such as cracks, shell and seams, which are in general deep and sharp, and therefore impair the use of the products, shall always be repaired irrespective of their depth and number.

6.2.2 Class B

The requirements of 6.2.1.1 and 6.2.1.2 shall apply, except that the remaining thickness under the discontinuities and repair ground areas shall not be less than the minimum permissible thickness as specified in ISO 7452 and ISO 9034 (or in another agreed dimensional standard).

6.3 Repair procedures

The repair possibilities in function of the class and nominal thickness of the product are represented in Figure A.2 and Table A.1.

6.3.1 Grinding

If a discontinuity must be repaired, it shall be removed completely by grinding to its full depth. The ground areas shall have a smooth transition to the surrounding surface of the product. In case of dispute, complete elimination of the defect may be demonstrated by magnetic particle or dye penetrant test techniques.

The producer shall be allowed to repair the entire surface by grinding to the minimum thickness specified in ISO 7452 and ISO 9034 (or in another agreed dimensional standard).

Grinding of defects shall be carried out subject to the following conditions.

6.3.1.1 Class A

6.3.1.1.1 The maximum permissible depth of ground areas is given in Tables 3 and 4.

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Table 3 — Maximum permissible depth of ground areas with a maximum of 15 % of the inspected area

Nominal thickness of the product <i>t</i> mm	Permitted grinding depth allowances below the minimum thickness as specified in ISO 7452 and ISO 9034 mm
$3 \leq t < 8$	0,3
$8 \leq t < 15$	0,4
$15 \leq t < 25$	0,5
$25 \leq t < 40$	0,6
$40 \leq t < 60$	0,7
$60 \leq t < 80$	0,8
$80 \leq t < 150$	1,0
$150 \leq t < 250$	1,2
$250 \leq t \leq 400$	1,4

Table 4 — Maximum permissible depth of ground areas with a maximum of 2 % of the inspected area

Nominal thickness of the product <i>t</i> mm	Permitted grinding depth allowances below the minimum thickness as specified in ISO 7452 and ISO 9034 mm
$3 \leq t < 8$	0,4
$8 \leq t < 15$	0,5