



## **RELIABLE PIPES & TUBES LTD.**

Government Recognized Export House | OHSAS 18001:2007 | ISO 14001:2004 | PED Approved Company.

Phone : +91 22 4343 1313 (25 Lines) | Fax : +91 22 2389 4311  
Email : [export@reliablepipes.com](mailto:export@reliablepipes.com) | [domestic@reliablepipes.com](mailto:domestic@reliablepipes.com)

# Hot rolled products of structural steels —

## Part 3: Technical delivery conditions for normalized/normalized rolled weldable fine grain structural steels

The European Standard EN 10025-3:2004 has the status of a  
British Standard

ICS 77.140.10; 77.140.50

## National foreword

This British Standard is the official English language version of EN 10025-3:2004. BS EN 10025-3:2004 together with BS EN 10025-1:2004 and BS EN 10025-4:2004 supersedes BS EN 10113-1:1993, and BS EN 10025-3:2004 together with BS EN 10025-1:2004 supersedes BS EN 10113-2:1993, which are withdrawn.

The UK participation in its preparation was entrusted to Technical Committee ISE/12, Structural steels, which has the responsibility to:

- aid enquirers to understand the text;
- present to the responsible international/European committee any enquiries on the interpretation, or proposals for change, and keep the UK interests informed;
- monitor related international and European developments and promulgate them in the UK.

A list of organizations represented on this committee can be obtained on request to its secretary.

### Cross-references

The British Standards which implement international or European publications referred to in this document may be found in the *BSI Catalogue* under the section entitled “International Standards Correspondence Index”, or by using the “Search” facility of the *BSI Electronic Catalogue* or of British Standards Online.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

**Compliance with a British Standard does not of itself confer immunity from legal obligations.**

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 17 November 2004

### Summary of pages

This document comprises a front cover, an inside front cover, the EN title page, pages 2 to 24, an inside back cover and a back cover.

The BSI copyright notice displayed in this document indicates when the document was last issued.

### Amendments issued since publication

Amd. No.	Date	Comments

© BSI 17 November 2004

ISBN 0 580 44780 4

English version

## Hot rolled products of structural steels - Part 3: Technical delivery conditions for normalized/normalized rolled weldable fine grain structural steels

Produits laminés à chaud en aciers de construction - Partie 3: Conditions techniques de livraison pour les aciers de construction soudables à grains fins à l'état normalisé/laminage normalisé

Warmgewalzte Erzeugnisse aus Baustählen - Teil 3: Technische Lieferbedingungen für normalgeglühte/normalisierend gewalzte schweißgeeignete Feinkornbaustähle

This European Standard was approved by CEN on 1 April 2004.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard 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.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



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

Management Centre: rue de Stassart, 36 B-1050 Brussels

**Contents**

Page

Foreword..... 4

1 Scope .....5

2 Normative references .....5

2.1 General standards .....5

2.2 Standards on dimensions and tolerances (see 7.7.1).....6

2.3 Standards on testing .....6

3 Terms and definitions.....6

4 Classification and designation .....7

4.1 Classification.....7

4.1.1 Main quality classes .....7

4.1.2 Grades and qualities .....7

4.2 Designation .....7

5 Information to be supplied by the purchaser .....8

5.1 Mandatory information .....8

5.2 Options .....8

6 Manufacturing process .....8

6.1 Steel making process .....8

6.2 Grain structure .....8

6.3 Delivery conditions .....8

7 Requirements .....9

7.1 General.....9

7.2 Chemical composition.....9

7.3 Mechanical properties .....9

7.3.1 General.....9

7.3.2 Impact properties .....9

7.3.3 Improved deformation properties perpendicular to the surface.....10

7.4 Technological properties .....10

7.4.1 Weldability .....10

7.4.2 Formability.....10

7.4.3 Suitability for hot-dip zinc-coating..... 11

7.5 Surface properties .....11

7.5.1 Strip .....11

7.5.2 Plates and wide flats.....12

7.5.3 Sections .....12

7.5.4 Bars and rods.....12

7.6 Internal soundness .....12

7.7 Dimensions, tolerances on dimensions and shape, mass.....12

8 Inspection .....12

8.1 General.....12

8.2 Type of inspection and inspection document .....13

8.3 Frequency of testing.....13

8.3.1 Sampling.....13

8.3.2 Test units .....13

8.3.3 Verification of chemical composition ..... 13

8.4 Tests to be carried out for specific inspection ..... 13

9 Preparation of samples and test pieces ..... 14

9.1 Selection and preparation of samples for chemical analysis .....14

9.2	Location and orientation of samples and test pieces.....	14
9.2.1	General .....	14
9.2.2	Preparation of samples.....	14
9.2.3	Preparation of test pieces.....	14
9.2.4	Impact test pieces .....	14
9.3	Identification of samples and test pieces .....	14
10	Test methods .....	14
10.1	Chemical analysis .....	14
10.2	Mechanical tests.....	14
10.3	Ultrasonic testing .....	14
10.4	Retests.....	14
11	Marking, labelling, packaging .....	15
12	Complaints .....	15
13	Options (see 5.2).....	15
Annex A (informative)	List of corresponding former designations .....	22
Annex B (informative)	List of national standards which correspond with EURONORMS referenced .....	23
Bibliography	.....	24

## **Foreword**

This document (EN 10025-3:2004) has been prepared by Technical Committee ECISS/TC 10 “Structural steels - Grades and qualities”, the secretariat of which is held by NEN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 2005, and conflicting national standards shall be withdrawn at the latest by May 2005.

This document supersedes together with EN 10025-1:2004, EN 10113-1:1993, *Hot-rolled products in weldable fine grain structural steels - Part 1: General delivery conditions* and EN 10113-2:1993 *Hot-rolled products in weldable fine grain structural steels - Part 2: Delivery conditions for normalized/normalized rolled steels*.

The titles of the other parts of this document are:

*Part 1: General technical delivery conditions;*

*Part 2: Technical delivery conditions for non-alloy 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.*

This document has been prepared under Mandate M/120 given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of the EU Construction Products Directive (89/106/EEC). For relationship with the EU Construction Products Directive, see informative Annex ZA of EN 10025-1:2004.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

## 1 Scope

Part 3 of this document, in addition to part 1, specifies requirements for flat and long products of hot rolled weldable fine grain structural steels in the normalized/normalized rolled delivery condition in the grades and qualities given in Tables 2 to 4 (chemical composition) and Tables 5 to 7 (mechanical properties) in thickness  $\leq 250$  mm for grades S275, S355 and S420 and in thickness  $\leq 200$  mm for grade S460.

In addition to EN 10025-1:2004 the steels specified in this document are especially intended for use in heavily loaded parts of welded structures such as, bridges, flood gates, storages tanks, water supply tanks, etc., for service at ambient and low temperatures.

## 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.

### 2.1 General standards

EN 1011-2, *Welding – Recommendations for welding of metallic materials - Part 2: Arc welding of ferritic steels.*

EN 10020, *Definition and classification of grades of steel.*

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, principal symbols.*

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

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: Plates 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 10221, *Surface quality classes for hot-rolled bars and rods - Technical delivery conditions.*

CR 10260, *Designation systems for steels - Additional symbols.*



## **2.2 Standards on dimensions and tolerances (see 7.7.1)**

EN 10017, *Non-alloy 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, shape and mass.*

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 uncoated plate, sheet and 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.*

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 10162, *Cold rolled steel sections - Technical delivery conditions - Dimensional and cross-sectional tolerances.*

EN 10279, *Hot rolled steel channels - Tolerances on shape and dimensions.*

## **2.3 Standards on testing**

EN 10160, *Ultrasonic testing of steel flat product of thickness equal to 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 643, *Steels – Micrographic determination of the apparent grain size (ISO 643:2003).*

## **3 Terms and definitions**

For the purposes of this document, the terms and definitions given in EN 10025-1:2004 and the following apply.

**3.1****normalizing rolling**

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 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****fine grained steels**

steels with fine grain structure with an equivalent index of ferritic grain size  $\geq 6$  determined in accordance with EN ISO 643

**4 Classification and designation****4.1 Classification****4.1.1 Main quality classes**

The steel grades S275 and S355 specified in this document shall be classified as non-alloy quality steels and the steel grades S420 and S460 specified in this document shall be classified as alloy special steels according to EN 10020.

**4.1.2 Grades and qualities**

This document specifies four steel grades S275, S355, S420 and S460.

All the steel grades may be supplied in the following qualities as specified at the time of the enquiry and order:

- with specified minimum values of impact energy at temperatures not lower than  $-20\text{ }^{\circ}\text{C}$ , designated as N;
- with specified minimum values of impact energy at temperatures not lower than  $-50\text{ }^{\circ}\text{C}$ , designated as NL.

**4.2 Designation**

**4.2.1** The designation shall be in accordance with EN 10025-1.

NOTE For a list of corresponding former designations and the former designations from EN 10113-2:1993 see Annex A, Table A.1.

**4.2.2** The designation shall consist of:

- number of this document (EN 10025-3);
- steel name or the steel number; the steel name consisting of:
  - symbol S (for structural steel);
  - indication of the minimum specified yield strength for thickness  $\leq 16\text{ mm}$  expressed in  $\text{MPa}^1$ ;

---

1)  $1\text{ MPa} = 1\text{ N/mm}^2$ .

## EN 10025-3:2004 (E)

- delivery condition N;
- capital letter L for the quality with specified minimum values of impact energy at temperatures not lower than -50 °C.

EXAMPLE Normalized structural steel (S) with a specified minimum yield strength at ambient temperature of 355 MPa<sup>1)</sup>, and with a specified minimum value of impact energy at -50 °C:

Steel EN 10025-3 - S355NL

or

Steel EN 10025-3 - 1.0546

## 5 Information to be supplied by the purchaser

### 5.1 Mandatory information

The information that shall be supplied by the purchaser at the time of the order is specified in EN 10025-1.

In addition to EN 10025-1 the following information shall be supplied by the purchaser at the time of the order:

- g) the type of inspection document (see 8.2).

### 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.

## 6 Manufacturing process

### 6.1 Steel making process

The steel making process shall be in accordance with EN 10025-1. If specified at the time of the order the steel making process shall be reported to the purchaser.

See option 1.

### 6.2 Grain structure

The steels shall have a fine grain structure containing sufficient amounts of nitrogen binding elements (see Table 2).

### 6.3 Delivery conditions

The products shall be supplied normalized or in an equivalent condition obtained by normalizing rolling as defined in Clause 3.

---

1) 1 MPa = 1 N/mm<sup>2</sup>.

## 7 Requirements

### 7.1 General

The following requirements apply when sampling, preparation of test pieces and testing specified in Clauses 8, 9 and 10 are carried out.

### 7.2 Chemical composition

**7.2.1** The chemical composition determined by ladle analysis shall comply with the specified values of Table 2. On special request of the purchaser the manufacturer shall inform the purchaser at the time of the enquiry and order which of the alloying elements appropriate to the steel grade required will be deliberately added to the material to be delivered.

See option 29.

**7.2.2** The limits applicable for the product analysis are given in Table 3. The manufacturer shall inform the purchaser at the time of the enquiry and order which of the alloying elements appropriate to the steel grade required will be deliberately added to the material to be delivered. The product analysis shall be carried out when specified at the time of the order.

See option 2.

**7.2.3** The maximum carbon equivalent values based on the ladle analysis, given in Table 4 shall apply. For the carbon equivalent value formula see 7.2.3 of EN 10025-1:2004.

**7.2.4** When products are supplied with a control on Si e.g. for hot-dip zinc-coating so that there could be a need to increase the content of other elements like C and Mn to achieve the required tensile properties, the maximum carbon equivalent values of Table 4 shall be increased as follows:

- for  $\text{Si} \leq 0,030 \%$ , increase CEV by 0,02 %;
- for  $\text{Si} \leq 0,25 \%$ , increase CEV by 0,01 %.

### 7.3 Mechanical properties

#### 7.3.1 General

**7.3.1.1** Under the inspection and testing conditions as specified in Clauses 8, 9 and 10 and in the delivery condition as specified in 6.3 as well as after normalizing by heat treatment after delivery the mechanical properties shall comply with the values given in Tables 5 to 7.

**7.3.1.2** For flat products the nominal thickness applies. For long products of irregular section the nominal thickness of that part from which the samples are taken applies (see Annex A of EN 10025-1:2004).

#### 7.3.2 Impact properties

**7.3.2.1** The verification of the impact energy value shall be carried out in accordance with EN 10025-1.

Furthermore the verification of the impact energy value shall be carried out, unless otherwise agreed (see 7.3.2.2 and 7.3.2.3) with longitudinal test pieces for:

- N at  $-20 \text{ }^\circ\text{C}$ ;
- NL at  $-50 \text{ }^\circ\text{C}$ .

**7.3.2.2** Another temperature (given in Tables 6 and 7) may be agreed at the time of the order.

See option 3.

**7.3.2.3** If agreed at the time of the enquiry and order transverse impact energy values as given in Table 7 shall apply instead of longitudinal values.

See option 30.

### **7.3.3 Improved deformation properties perpendicular to the surface**

If agreed at the time of the order flat and long products shall comply with one of the requirements of EN 10164.

See option 4.

## **7.4 Technological properties**

### **7.4.1 Weldability**

The steels specified in this document shall be suitable for welding.

General requirements for arc welding of the steels specified in this document shall be as given in EN 1011-2

**NOTE** With increasing product thickness and strength level cold cracking can occur. Cold cracking is caused by the following factors in combination:

- the amount of diffusible hydrogen in the weld metal;
- a brittle structure of the heat affected zone;
- significant tensile stress concentrations in the welded joint.

### **7.4.2 Formability**

**NOTE** Recommendations regarding hot and cold forming are laid down in ECSC IC 2.

#### **7.4.2.1 Hot forming**

The products shall comply with the requirements of Tables 5 to 7 if hot forming is carried out after delivery (see 7.3.1.1).

#### **7.4.2.2 Cold formability**

##### **7.4.2.2.1 General**

**NOTE** Cold forming leads to reduction in the ductility. Furthermore it is necessary to draw the attention to the risk of brittle fracture in connection with hot-dip zinc-coating.

##### **7.4.2.2.2 Flangeability**

If specified at the time of the order plate, sheet, strip and wide flats ordered and supplied in the normalized condition with a nominal thickness  $\leq 16$  mm shall be suitable for flanging without cracking with the following minimum bend radii:

- 2 times the nominal thickness with the axis of the bend in transverse direction and 2,5 times the nominal thickness in longitudinal direction for the steel grades S275 and S355;

- 4 times the nominal thickness with the axis of the bend in transverse direction and 5 times the nominal thickness in longitudinal direction for the steel grades S420 and S460.

See option 11a.

#### 7.4.2.2.3 Roll forming

If specified at the time of the order plate, sheet and strip with a nominal thickness  $\leq 8$  mm shall be suitable for the production of sections by cold rolling (for example according to EN 10162), with the same minimum bend radii as given in 7.4.2.2.1.

See option 12.

NOTE The products suitable for roll forming are also suitable for the manufacture of cold-finished square and rectangular hollow sections.

#### 7.4.3 Suitability for hot-dip zinc-coating

Hot-dip zinc-coating requirements shall be agreed between manufacturer and purchaser.

EN ISO 1461 and EN ISO 14713 should be used to set these coating requirements. The definition of suitability classes based upon chemical analysis limitations as laid down in Table 1 can be used for guidance purposes.

**Table 1 - Classes for the suitability for hot-dip zinc-coating based on the ladle analysis (for guidance)**

Classes	Elements % by mass		
	Si	Si + 2,5 P	P
Class 1	$\leq 0,030$	$\leq 0,090$	-
Class 2 <sup>a</sup>	$\leq 0,35$	-	-
Class 3	$0,14 \leq \text{Si} \leq 0,25$	-	$\leq 0,035$

<sup>a</sup> Class 2 applies only for special zinc alloys.

For class 1 the maximum carbon equivalent value of Table 4 shall be increased by 0,02. For class 3 the maximum carbon equivalent value of Table 4 shall be increased by 0,01 (see 7.2.4).

See option 5.

NOTE Product shape, composition of the zinc bath, other hot-dip treatment settings and other factors should be considered when agreeing upon hot-dip zinc-coating requirements.

### 7.5 Surface properties

#### 7.5.1 Strip

The surface condition should not impair an application appropriate to the steel grade if adequate processing of the strip is applied.

## EN 10025-3:2004 (E)

### 7.5.2 Plates and wide flats

EN 10163 parts 1 and 2 shall apply for the permissible surface discontinuities and for the repair of surface defects by grinding. Class A, subclass 1 of EN 10163-2 shall apply. Class B regarding grinding or subclasses 2 or 3 regarding repair by welding can be agreed at the time of the order.

See option 15.

### 7.5.3 Sections

EN 10163 parts 1 and 3 shall apply for the permissible surface discontinuities and for the repair of surface defects by grinding. Class C, subclass 1 of EN 10163-3 shall apply. Class D regarding grinding or subclasses 2 or 3 regarding repair by welding can be agreed at the time of the order.

See option 16.

### 7.5.4 Bars and rods

EN 10221 applies for the permissible surface discontinuities and for the repair of surface defects by grinding. Class A of EN 10221 shall apply, unless otherwise agreed at the time of the order.

See option 17.

## 7.6 Internal soundness

The permissible level of internal imperfections shall be in accordance with EN 10025-1.

See option 6 (for flat products).

See option 7 (for H beams with parallel flanges and IPE beams).

See option 8 (for bars).

## 7.7 Dimensions, tolerances on dimensions and shape, mass

**7.7.1** Dimensions, tolerances on dimensions and shape shall be in accordance with the requirements given in the order by reference to the relevant documents according to 2.2 and according to 2.2 and 7.7.1 of EN 10025-1:2004.

For hot rolled plate tolerances the basic requirements shall be in accordance with EN 10029, including thickness tolerances to class A, unless otherwise agreed at the time of the order.

See option 18.

For plates cut from continuously hot rolled strip, the thickness tolerances shall be in accordance with EN 10051.

**7.7.2** The nominal mass shall comply with EN 10025-1.

## 8 Inspection

### 8.1 General

The products shall be delivered with specific inspection and testing to indicate compliance with the order and this document.

## 8.2 Type of inspection and inspection document

The type of inspection document shall comply with EN 10025-1.

See option 9.

## 8.3 Frequency of testing

### 8.3.1 Sampling

The verification of the mechanical properties shall be carried out by cast.

### 8.3.2 Test units

**8.3.2.1** The test unit shall contain products of the same form, grade and of the same thickness range as specified in Table 5 for the yield strength.

For verifying the mechanical properties the following test unit shall apply:

- 40 tonnes or part thereof.

**8.3.2.2** If specified at the time of the order for flat products the impact properties only or the impact properties and the tensile properties shall be verified out of each parent plate or coil.

See option 13.

See option 14.

### 8.3.3 Verification of chemical composition

The verification of the chemical composition shall be in accordance with EN 10025-1.

See option 2.

## 8.4 Tests to be carried out for specific inspection

**8.4.1** The following tests shall be carried out:

- for all products the ladle analysis;
- for all products the tensile test;
- for all products the impact test.

**8.4.2** At the time of the order the following additional tests can be agreed:

- a) for all products the impact test at another temperature or on transverse test pieces (see 7.3.2.2 and 7.3.2.3);

See option 3.

See option 30.

- b) the product analysis (see 8.3.3.2 of EN 10025-1:2004).

See option 2.



## 9 Preparation of samples and test pieces

### 9.1 Selection and preparation of samples for chemical analysis

The preparation of samples for product analysis shall be in accordance with EN 10025-1.

### 9.2 Location and orientation of samples and test pieces for mechanical tests

#### 9.2.1 General

The location and orientation of samples and test pieces for mechanical tests shall be in accordance with EN 10025-1.

#### 9.2.2 Preparation of samples

In addition to EN 10025-1 the samples shall be taken:

- from any product of the test unit.

#### 9.2.3 Preparation of test pieces

The preparation of test pieces for mechanical tests shall be in accordance with EN 10025-1.

#### 9.2.4 Impact test pieces

In addition to EN 10025-1 the following requirement applies:

- impact test pieces shall be taken from  $\frac{1}{4}t$  position for plates with nominal thickness  $\geq 40$  mm.

### 9.3 Identification of samples and test pieces

The identification of samples and test pieces shall be in accordance with EN 10025-1.

## 10 Test methods

### 10.1 Chemical analysis

The chemical analysis shall be in accordance with EN 10025-1.

### 10.2 Mechanical tests

The mechanical tests shall be in accordance with EN 10025-1.

### 10.3 Ultrasonic testing

Ultrasonic testing shall be carried out in accordance with EN 10025-1.

### 10.4 Retests

The retests shall be in accordance with EN 10025-1.

## 11 Marking, labelling, packaging

The marking, labelling and packaging shall be in accordance with EN 10025-1.

See option 10.

In addition to EN 10025-1 if specified at the time of the enquiry and order there shall be either no die stamping or only die stamping in positions indicated by the purchaser.

See option 31.

## 12 Complaints

Any complaints shall be dealt with in accordance with EN 10025-1.

## 13 Options (see 5.2)

The following options of EN 10025-1:2004 apply:

- 1) The steel making process shall be indicated (see 6.1).
- 2) Product analysis shall be carried out; the number of samples and the elements to be determined shall be as agreed (see 7.2.2, 8.3.3 and 8.4.2).
- 3) At which temperature the impact properties shall be verified (see 7.3.2.2 and 8.4.2).
- 4) Products shall comply with one of the improved properties perpendicular to the surface of EN 10164 (see 7.3.3).
- 5) The product shall be suitable for hot-dip zinc-coating (see 7.4.3).
- 6) For flat products in thickness  $\geq 6$  mm the freedom from internal defects shall be verified in accordance with EN 10160 (see 7.6 and 10.3).
- 7) For H beams with parallel flanges and IPE beams the freedom from internal defects shall be verified in accordance with EN 10306 (see 7.6 and 10.3).
- 8) For bars the freedom from internal defects shall be verified in accordance with EN 10308 (see 7.6 and 10.3).
- 9) Inspection of surface condition and dimensions shall be witnessed by the purchaser at the manufacturer's works (see 8.2).
- 10) The type of marking required (see Clause 11).

In addition to the options of EN 10025-1:2004 the following options apply to products according to EN 10025-3:

- 11a) Sheet, plate, strip and wide flats with a nominal thickness  $\leq 16$  mm shall be suitable for flanging without cracking (see 7.4.2.2.1).
- 12) Plate, sheet and strip with nominal thickness  $\leq 8$  mm shall be suitable for the production of sections by cold rolling with bend radii given in 7.4.2.2.1 (see 7.4.2.2.2).

- 13) For flat products out of each parent plate or coil the impact properties only shall be verified (see 8.3.2.2).
- 14) For flat products out of each parent plate or coil the impact properties and the tensile properties shall be verified (see 8.3.2.2).
- 15) For plates and wide flats the permissible surface discontinuities and for the repair of surface defects by grinding and/or welding another class than class A, subclass 1 of EN 10163-2 applies (see 7.5.2).
- 16) For sections the permissible surface discontinuities and for the repair of surface defects by grinding and/or welding another class than class C, subclass 1 of EN 10163-3 applies (see 7.5.3).
- 17) For bars and rods the permissible surface discontinuities and for the repair of surface defects by grinding and/or welding another class than class A of EN 10221 applies (see 7.5.4).
- 18) Other tolerances than class A of EN 10029 for hot rolled plates apply (see 7.7.1).
- 29) The manufacturer shall inform the purchaser at the time of the enquiry and order which of the alloying elements appropriate to the steel grade required will be deliberately added to the material to be delivered (see 7.2.1).
- 30) The impact properties shall be verified on transverse V-notch test pieces (see 7.3.2.3 and 8.4.2).
- 31) Die stamping is not allowed or the position for die stamping shall be as indicated by the purchaser (see Clause 11).
- 32) For railway applications a maximum S content of 0,010 % for ladle analysis and 0,012 % for product analysis is required (see Tables 2 and 3, footnote<sup>b</sup>).

Table 2 - Chemical composition of the ladle analysis for normalized steel

Designation		C % max.	Si % max.	Mn %	P % max. a	S % max. a b ,	Nb % max.	V % max.	Al <sub>total</sub> % min. c	Ti % max.	Cr % max.	Ni % max.	Mo % max.	Cu % max. d	N % max.
According EN 10027-1 and CR 10260	According EN 10027-2														
S275N	1.0490	0,18	0,40	0,50 - 1,50	0,030	0,025	0,05	0,05	0,02	0,05	0,30	0,30	0,10	0,55	0,015
S275NL	1.0491	0,16			0,025	0,020									
S355N	1.0545	0,20	0,50	0,90 - 1,65	0,030	0,025	0,05	0,12	0,02	0,05	0,30	0,50	0,10	0,55	0,015
S355NL	1.0546	0,18			0,025	0,020									
S420N	1.8902	0,20	0,60	1,00 - 1,70	0,030	0,025	0,05	0,20	0,02	0,05	0,30	0,80	0,10	0,55	0,025
S420NL	1.8912				0,025	0,020									
S460N <sup>e</sup>	1.8901 <sup>e</sup>	0,20	0,60	1,00 - 1,70	0,030	0,025	0,05	0,20	0,02	0,05	0,30	0,80	0,10	0,55	0,025
S460NL <sup>e</sup>	1.8903 <sup>e</sup>				0,025	0,020									

<sup>a</sup> For long products the P and S content can be 0,005 % higher.

<sup>b</sup> For railway applications a maximum S content of 0,010 % may be agreed at the time of enquiry and order.  
See option 32.

<sup>c</sup> If sufficient other N-binding elements are present the minimum total Al content does not apply.

<sup>d</sup> Cu content above 0,40 % may cause hot shortness during hot forming.

<sup>e</sup> V + Nb + Ti ≤ 0,22 % and Mo + Cr ≤ 0,30 %.

Table 3 - Chemical composition of the product analysis based on Table 2

Designation		C % max.	Si % max.	Mn %	P % max. a	S % max. a, b	Nb % max.	V % max.	Al <sub>total</sub> % min. c	Ti % max.	Cr % max.	Ni % max.	Mo % max.	Cu % max. d	N % max.
According EN 10027-1 and CR 10260	According EN 10027-2														
S275N	1.0490	0,20	0,45	0,45 - 1,60	0,035	0,030	0,06	0,07	0,015	0,06	0,35	0,35	0,13	0,60	0,017
S275NL	1.0491	0,18			0,030	0,025									
S355N	1.0545	0,22	0,55	0,85 - 1,75	0,035	0,030	0,06	0,14	0,015	0,06	0,35	0,55	0,13	0,60	0,017
S355NL	1.0546	0,20			0,030	0,025									
S420N	1.8902	0,22	0,65	0,95 - 1,80	0,035	0,030	0,06	0,22	0,015	0,06	0,35	0,85	0,13	0,60	0,027
S420NL	1.8912				0,030	0,025									
S460N <sup>e</sup>	1.8901 <sup>e</sup>	0,22	0,65	0,95 - 1,80	0,035	0,030	0,06	0,22	0,015	0,06	0,35	0,85	0,13	0,60	0,027
S460NL <sup>e</sup>	1.8903 <sup>e</sup>				0,030	0,025									

<sup>a</sup> For long products the P and S content can be 0,005 % higher.

<sup>b</sup> For railway applications a maximum S content of 0,012 % may be agreed at the time of enquiry and order.  
See option 32.

<sup>c</sup> If sufficient other N-binding elements are present the minimum total Al content does not apply.

<sup>d</sup> Cu content above 0,45 % may cause hot shortness during hotforming.

<sup>e</sup> V + Nb + Ti ≤ 0,26 % and Mo + Cr ≤ 0,38 %.

Table 4 - Maximum CEV based on the ladle analysis for normalized steel

Designation		Maximum CEV in % for nominal product thickness in mm		
According EN 10027-1 and CR 10260	According EN 10027-2	≤ 63	> 63 ≤ 100	> 100 ≤ 250
S275N <sup>a</sup>	1.0490 <sup>a</sup>	0,40	0,40	0,42
S275NL <sup>a</sup>	1.0491 <sup>a</sup>			
S355N <sup>a</sup>	1.0545 <sup>a</sup>	0,43	0,45	0,45
S355NL <sup>a</sup>	1.0546 <sup>a</sup>			
S420N	1.8902	0,48	0,50	0,52
S420NL	1.8912			
S460N	1.8901	0,53	0,54	0,55
S460NL	1.8903			
<sup>a</sup> For the optional increase of elements which influence the CEV see 7.4.3.				

Table 5 - Mechanical properties at ambient temperature for normalized steel

Designation		Minimum yield strength $R_{eH}^a$ MPa <sup>b</sup>								Tensile strength $R_m^a$ MPa <sup>b</sup>			Minimum percentage elongation after fracture <sup>a</sup> %					
		Nominal thickness mm								Nominal thickness mm			$L_0 = 5,65 \sqrt{S_0}$ Nominal thickness mm					
According EN 10027-1 and CR 10260	According EN 10027-2	≤ 16	>16 ≤ 40	>40 ≤ 63	> 63 ≤ 80	> 80 ≤ 100	> 100 ≤ 150	> 150 ≤ 200	> 200 ≤ 250	≤ 100	> 100 ≤ 200	> 200 ≤ 250	≤ 16	>16 ≤ 40	>40 ≤ 63	> 63 ≤ 80	> 80 ≤ 200	> 200 ≤ 250
S275N	1.0490	275	265	255	245	235	225	215	205	370 to 510	350 to 480	350 to 480	24	24	24	23	23	23
S275NL	1.0491																	
S355N	1.0545	355	345	335	325	315	295	285	275	470 to 630	450 to 600	450 to 600	22	22	22	21	21	21
S355NL	1.0546																	
S420N	1.8902	420	400	390	370	360	340	330	320	520 to 680	500 to 650	500 to 650	19	19	19	18	18	18
S420NL	1.8912																	
S460N	1.8901	460	440	430	410	400	380	370	-	540 to 720	530 to 710	-	17	17	17	17	17	-
S460NL	1.8903																	

<sup>a</sup> For plate, strip and wide flats with widths ≥ 600 mm the direction transverse (t) to the rolling direction applies. For all other products the values apply for the direction parallel (l) to the rolling direction.

<sup>b</sup> 1 MPa = 1 N/mm<sup>2</sup>

**Table 6 - Minimum values of impact energy for impact tests on longitudinal V-notch test pieces for normalized steel**

Designation		Minimum values of impact energy in J at test temperatures, in °C						
According to EN 10027-1 and CR 10260	According to EN 10027-2	+ 20	0	- 10	- 20	- 30	- 40	- 50
S275N S355N S420N S460N	1.0490 1.0545 1.8902 1.8901	55	47	43	40 <sup>a)</sup>	-	-	-
S275NL S355N L S460NL	1.0491 1.0546 1.8912 1.8903	63	55	51	47	40	31	27
<sup>a</sup> This value corresponds with 27J at - 30 °C (see Eurocode 3).								

**Table 7 - Minimum values of impact energy for impact tests on transverse V-notch test pieces for normalized steel, when the impact test on transverse test pieces is agreed at the time of the order**

See option 30

Designation		Minimum values of impact energy in J at test temperatures, in °C						
According to EN 10027-1 and CR 10260	According to EN 10027-2	+ 20	0	- 10	- 20	- 30	- 40	- 50
S275N S355N S420N S460N	1.0490 1.0545 1.8902 1.8901	31	27	24	20	-	-	-
S275NL S355N L S460NL	1.0491 1.0546 1.8912 1.8903	40	34	30	27	23	20	16



## Annex A (informative)

### List of corresponding former designations

**Table A.1 - List of corresponding former designations**

Designation according EN 10025-3		Equivalent former designations in							
		According EN 10113-2:1993		According EU 113-72		Germany according to DIN	France according to NF A 36-201	United Kingdom according to BS 4360	Italy according to UNI
S275N	1.0490	S275N	1.0490	Fe E 275 KG N	StE285	-	-	Fe E 275 KG N	-
S275NL	1.0491	S275NL	1.0491	Fe E 275 KT N	TStE285	-	43EE	Fe E 275 KT N	-
S355N	1.0545	S355N	1.0545	Fe E 355 KG N	StE355	E 355 R	-	Fe E 355 KG N	2134-01
S355NL	1.0546	S355NL	1.0546	Fe E 355 KT N	TStE355	E 355 FP	50EE	Fe E 355 KT N	2135-01
S420N	1.8902	S420N	1.8902	Fe E 420 KG N	StE420	E 420 R	-	-	-
S420NL	1.8912	S420NL	1.8912	Fe E 420 KT N	TStE420	E 420 FP	-	-	-
S460N	1.8901	S460N	1.8901	Fe E 460 KG N	StE460	E 460 R	-	Fe E 460 KG N	-
S460NL	1.8903	S460NL	1.8903	Fe E 460 KT N	TStE460	E 460 FP	55EE	Fe E 460 KT N	-

## Annex B (informative)

### List of national standards which correspond with EURONORMS referenced

Until the following EURONORMS are transformed into European Standards, they may be either implemented or reference made to the corresponding national standards as listed in Table B.1.

NOTE Standards listed in Table B.1 are not supposed to be strictly similar although they deal with the same subjects.

**Table B.1 — EURONORMS with corresponding national standards**

EURONORM	Corresponding national standard in									
	Germany	France	United Kingdom	Spain	Italy	Belgium	Portugal	Sweden	Austria	Norway
19 <sup>a</sup>	DIN 1025 T5	NF A 45 205	BS 4	UNE 36-526	UNI 5398	NBN 533	NP-2116	SS 21 27 40	M 3262	-
53 <sup>a</sup>	DIN 1025 T2 DIN 1025 T3 DIN 1025 T4	NF A 45 201	BS 4	UNE 36-527 UNE 36-528 UNE 36-529	UNI 5397	NBN 633	NP-2117	SS 21 27 50 SS 21 27 51 SS 21 27 52	-	NS 1907 NS 1908
54 <sup>a</sup>	DIN 1026-1	NF A 45 007	BS 4	UNE 36-525	UNI-EU 54	NBN A 24-204	NP-338	-	M 3260	-
ECSC IC 2	SEW 088	NF A 36 000	BS 5135	-	-	-	-	SS 06 40 25	-	-
<sup>a</sup> This EURONORM is formally withdrawn, but there are no corresponding EN's.										

## Bibliography

- [1] EN ISO 1461, *Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods (ISO 1461:1999)*.
- [2] EN ISO 14713, *Protection against corrosion of iron and steel structures – Zinc and aluminium coatings – Guidelines (ISO 14713:1999)*.
- [3] ECSC IC 2 (1983)<sup>2)</sup>, *Weldable fine-grained structural steels - Recommendations for processing, in particular for welding*.

---

<sup>2)</sup> Until ECSC IC 2 is transformed into a CEN Technical Report, it can either be implemented or reference made to the corresponding national standards, the list of which is given in Annex B to this document.

© 2011 BSI

---

---

## BSI — British Standards Institution

BSI is the independent national body responsible for preparing British Standards. It presents the UK view on standards in Europe and at the international level. It is incorporated by Royal Charter.

### Revisions

British Standards are updated by amendment or revision. Users of British Standards should make sure that they possess the latest amendments or editions.

It is the constant aim of BSI to improve the quality of our products and services. We would be grateful if anyone finding an inaccuracy or ambiguity while using this British Standard would inform the Secretary of the technical committee responsible, the identity of which can be found on the inside front cover. Tel: +44 (0)20 8996 9000. Fax: +44 (0)20 8996 7400.

BSI offers members an individual updating service called PLUS which ensures that subscribers automatically receive the latest editions of standards.

### Buying standards

Orders for all BSI, international and foreign standards publications should be addressed to Customer Services. Tel: +44 (0)20 8996 9001. Fax: +44 (0)20 8996 7001. Email: [orders@bsi-global.com](mailto:orders@bsi-global.com). Standards are also available from the BSI website at <http://www.bsi-global.com>.

In response to orders for international standards, it is BSI policy to supply the BSI implementation of those that have been published as British Standards, unless otherwise requested.

### Information on standards

BSI provides a wide range of information on national, European and international standards through its Library and its Technical Help to Exporters Service. Various BSI electronic information services are also available which give details on all its products and services. Contact the Information Centre. Tel: +44 (0)20 8996 7111. Fax: +44 (0)20 8996 7048. Email: [info@bsi-global.com](mailto:info@bsi-global.com).

Subscribing members of BSI are kept up to date with standards developments and receive substantial discounts on the purchase price of standards. For details of these and other benefits contact Membership Administration. Tel: +44 (0)20 8996 7002. Fax: +44 (0)20 8996 7001. Email: [membership@bsi-global.com](mailto:membership@bsi-global.com).

Information regarding online access to British Standards via British Standards Online can be found at <http://www.bsi-global.com/bsonline>.

Further information about BSI is available on the BSI website at <http://www.bsi-global.com>.

### Copyright

Copyright subsists in all BSI publications. BSI also holds the copyright, in the UK, of the publications of the international standardization bodies. Except as permitted under the Copyright, Designs and Patents Act 1988 no extract may be reproduced, stored in a retrieval system or transmitted in any form or by any means – electronic, photocopying, recording or otherwise – without prior written permission from BSI.

This does not preclude the free use, in the course of implementing the standard, of necessary details such as symbols, and size, type or grade designations. If these details are to be used for any other purpose than implementation then the prior written permission of BSI must be obtained.

Details and advice can be obtained from the Copyright & Licensing Manager. Tel: +44 (0)20 8996 7070. Fax: +44 (0)20 8996 7553. Email: [copyright@bsi-global.com](mailto:copyright@bsi-global.com).

BSI  
389 Chiswick High Road  
London  
W4 4AL