

QM-System: Certification as per ISO 9001



DILLINGER HÜTTE

Erläuterungen siehe Rückseite/Explications voir au verso/See reverse for explanations (www.dillinger.de/certificate)

A02	INSPECTION CERTIFICATE 3.1 AS PER EN 10204:2004 INSPECTION CERTIFICATE 3.1 AS PER ISO 10474:2013 MATERIAL TEST REPORT (MTR)	A10	Advice of dispatch No./ Date of dispatch	A08/ Manufacturer's order/ A03 Certificate No.	Sheet
A05	Established inspecting body DH	537125-17.07.15	404471-001	B01 Product HEAVY PLATES	2/...
B02/	Steel design. S690QL+DILLIMAX690T	A06 Purchaser	A07.1 No. P032649		
B03	Any suppl. requirements	Final receiver	A07.2 No. SA2766/15		
	EN-10025-6:09/DILLING-E04:13				

B06 Marking of the product

ITEM NO. : 02-06
 STEEL DESIGNATION **S690QL DILLIMAX690T**
 HEAT NO. / TRADEMARK / ROLLED PLATE NO. - TEST NO. / INSPECTOR'S STAMP

C10-C29 Tensile test

B14 Item No.	B07.2 Heat No.	B07.1 Rol.plate/ Test No.	B05 Reference (heat) treatment	C01 C02/ C01	C03 Temp. GR.C	C10 C11	MPA REH	RP02	C12 RM	C13	A % L0=5D	C14-C15
02	421668	96570	K4 Q RT	K4 Q	RT	811	804	842	17			
04	421549	04207	K4 QV RT	K4 QV	RT	811	760	855	18			
05	421240	83644	K4 QV RT	K4 QV	RT	804	804	833	19			
06	420869	73419	K4 QV RT	K4 QV	RT	804	804	856	19			


C40-C49 Impact test


B14 Item No.	B07.2 Heat No.	B07.1 Rol.plate/ Test No.	B05 Reference (heat) treatment	C01 C02/ C01	C03 Temp. GR.C	C41 Width of test piece	C40 Type of test piece	C44 Testing method	C46 Energy Joule	C45 AV=J	C42 Individual values AV=J	C43 Mean value
02	421668	96570	K4 Q	K4 Q	-40	CHP-V	CHP-V	750	750	130	129	134
04	421549	04207	K4 QV	K4 QV	-40	CHP-V	CHP-V	750	750	145	153	148
05	421240	83644	K4 QV	K4 QV	-40	CHP-V	CHP-V	750	750	140	148	135
06	420869	73419	K4 QV	K4 QV	-40	CHP-V	CHP-V	750	750	188	173	177

C70-C99 Chemical composition % - Heat analysis

B07.2 Heat	C70	C	SI	MN	P	S	N	CU	MO	NI	CR	VB	TI	B
420869	Y	0,173	0,305	1,30	0,011	0,0006	0,0037	0,041	0,329	0,225	0,673	0,002	0,003	0,0018
421240	Y	0,159	0,292	1,30	0,011	0,0014	0,0066	0,044	0,260	0,113	0,308	0,002	0,003	0,0017
421549	Y	0,160	0,289	1,30	0,016	0,0005	0,0023	0,048	0,248	0,124	0,322	0,002	0,004	0,0016
421668	Y	0,153	0,277	1,30	0,012	0,0008	0,0042	0,028	0,116	0,034	0,040	0,002	0,003	0,0018

A04 Z01/Z02/Z03 We hereby certify, that the above mentioned materials have been delivered in accordance with the terms of order.


B. BALDAUF
 Test House Manager


AG der Dillinger Hüttenwerke
 Postfach 1580, D-66748 Dillingen/Saar
 Inspection department

Inspector's stamp
 Date 17.07.15
 PP 1



Manufacturer's mark

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A05	Established inspecting body DH	537125-17.07.15	404471-001	B01 Product HEAVY PLATES	3/...
A06	Purchaser A06 Purchaser	BE GROUP OY AB, LAHTI	A07.1 No. P032649		
A07	Final receiver	BE GROUP OY AB, LAPUA	A07.2 No. SA2766/15		
B02/	Steel design. S690QL+DILLIMAX690T				
B03	Any suppl. requirements EN-10025-6:09/DILLING-E04:13				

C70-C99 Chemical composition % - Heat analysis

B07.2 Heat	C70	ZR	AL-T
420869	Y	0,0002	0,074
421240	Y	0,0002	0,070
421549	Y	0,0002	0,075
421668	Y	0,0002	0,070

C94 Heat analysis Carbon equivalent / Alloying restrictions

B07.2 Heat	FO-02=	0,61	FO-51=	0,03
420869	FO-02=	0,50	FO-51=	0,03
421240	FO-02=	0,50	FO-51=	0,03
421549	FO-02=	0,41	FO-51=	0,03
421668	FO-02=	0,41	FO-51=	0,03

C94 Carbon equivalent formula / Alloying restrictions

FO-02 = $C + (Mn/6) + (Cr+Mo+V) / 5 + (Ni+Cu) / 15$
FO-51 = V + Nb

D01 Marking and identification, surface appearance, shape and dimensional properties

ITEM NO. : 02-03

EXAMINATION OF MARKING, SURFACE, SHAPE AND DIMENSIONS: THE RESULTS MEET THE REQUIREMENTS.

SURFACE AS PER EN-10163-D3

THICKNESS AS PER EN-10029:10-A

LENGTH AND WIDTH AS PER EN-10029:10

FLATNESS AS PER EN-10029:10-T5H

A04	Z01/Z02/Z03 We hereby certify, that the above mentioned materials have been delivered in accordance with the terms of order.	Inspector's stamp	Date	PP	1
			17.07.15		
	Manufacturer's mark	Test House Manager			
		AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department			

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A05	Established Inspecting body DH	A06 Purchaser BE GROUP OY AB, LAHTI	537125-17.07.15	404471-001	4/...
	Final receiver	A07.1 No. P032649 BE GROUP OY AB, LAPUA		B01 Product HEAVY PLATES	
B02/	Steel design. S690QL+DILLIMAX690T				
B03	Any suppl. requirements EN-10025-6:09/DILLING-E04:13				

D01 Marking and identification, surface appearance, shape and dimensional properties

ITEM NO. : 04-06

EXAMINATION OF MARKING, SURFACE, SHAPE AND DIMENSIONS: THE RESULTS MEET THE REQUIREMENTS.
 SURFACE AS PER EN-10163-B3
 THICKNESS AS PER EN-10029:10-A
 LENGTH AND WIDTH AS PER EN-10029:10
 FLATNESS AS PER EN-10029:10-T4H

Z04 Environmental product declaration for structural steel

ITEM NO. : 02-06

For structural steel plates from Dillinger Hutte a validated environmental product declaration according to ISO 14025 and EN 15804 was established: BFS-20130094-IBG1-EN+RC1. Further information can be found under www.dillinger.de/EPD-E/.

A04



Z01/Z02/Z03 We hereby certify, that the above mentioned materials have been delivered in accordance with the terms of order.

B. Baldauf

B. BALDAUF
Test House Manager



Inspector's stamp

AG der Dillinger Hüttenwerke
Postfach 1580, D-66748 Dillingen/Saar
Inspection department

Date 17.07.15

A01

PP 1

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A05 Established inspecting body DH	A06 Purchaser BE GROUP OY AB, LAHTI	B01 Product HEAVY PLATES	
A07.1 No. P032649	A07.2 No. SA2766/15		
B02/ Steel design. S690QL+DILLIMAX690T	EN-10025-6:09/DILLING-E04:13		
B03 Any suppl. requirements			

Z04 CE-marking

ITEM NO.: 02-06

 <p>0769</p>	<p>EN 10025-1:2004</p> <p>Plate S690QL / 1.8928</p> <p>to be used in welded, bolted and riveted structures</p>	
 <p>DILLINGER HÜTTE</p> <p>AG der Dillinger Hüttenwerke</p> <p>Postfach 1580, D-66748 Dillingen/Saar</p> <p>15</p> <p>S690QL_EN10025-6-04_A_130701E1</p>	<p>Tolerances on dimensions and shape</p> <p>Elongation</p> <p>Tensile strength</p> <p>Yield strength</p> <p>Impact strength</p> <p>Weldability</p> <p>Durability (chemical composition)</p>	<p>expressed as declared in the DoP</p> <p>S690QL_EN10025-6-04_A_130701E1</p>

The declaration of performance can be downloaded from www.dillinger.de/dop/S690QL_EN10025-6-04_A_130701E1.pdf

Z01/Z02/Z03 We hereby certify, that the above mentioned materials have been delivered in accordance with the terms of order.

A04



Manufacturer's mark

B. Baldauf



AG der Dillinger Hüttenwerke
Postfach 1580, D-66748 Dillingen/Saar
Inspection department

B. BALDAUF
Test House Manager

Inspector's stamp

Date 17.07.15

PP 1

A01