

**QM-System: Certification as per ISO 9001**



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	A06 Purchaser BE GROUP OY AB, LAHTI	605375-07.07.17	424155-006	1/...
A05	Final receiver BE GROUP OY AB, TURKU	A07.1 No. P050461 A07.2 No.		B01 Product HEAVY PLATES	

**B02/ Steel design. S690QL+DILLIMAX690T**

B03 Any suppl. EN-10025-6:09/DILLING-E04:16 requirements

**B01-B99 Description of the product**

B14 Item No.	B08 Number of pieces	B09 Thickness	B10 Width	B11 Length	B12 Theoretical mass	B04 Product delivery condition	B07.2 Heat No.	B07.1 Rolled plate No./ Test No.	A09 Purchaser article number
05	1	10,00	x 2450	x 6000	1176	Q+A	444599	58268-01	2100921770
05	1	10,00	x 2450	x 6000	1176	Q+A	444599	58268-02	2100921770
05	1	10,00	x 2450	x 6000	1176	Q+A	444853	21146-01	2100921770
05	1	10,00	x 2450	x 6000	1176	Q+A	444853	21146-02	2100921770
**	4				4704				
06	1	16,00	x 2450	x 6000	1882	Q+A	446227	62410-01	2100922510
06	1	16,00	x 2450	x 6000	1882	Q+A	446227	62410-02	2100922510
**	2				3764				
***	6				8468				

**B06 Marking of the product**

ITEM NO.: 02, 04-06

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/ C03 C01	C10 Temp. GR.C	C11 MPA REH	C12 RM	C13 A % L0=5D	C14-C15
02	446227	62389	*	K4 Q	RT	810	838	17	
04	444599	58270	*	K4 Q	RT	847	881	16	
04	444853	28134	*	K4 Q	RT	830	863	16	
06	446227	62410		K4 Q	RT	894	908	15	

A04



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*B Baldauf*



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

Manufacturer's mark

B. BALDAUF  
Test House Manager

Inspector's stamp

Date 10.07.17

PP 1

A01

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	Final receiver BE GROUP OY AB, TURKU	A07.1	No. P050461	B01	Product HEAVY PLATES
B02/	Steel design. <b>S690QL+DILLIMAX690T</b>				
B03	Any suppl. requirements EN-10025-6:09/DILLING-E04:16				

**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	446227	62389 *		K4	Q0	-40	-40	CHP-V		750	AV 2	124	133	185	147
04	444599	58270 *		K4	Q0	-40	7,5	CHP-V		750	AV 2	58	56	69	61
04	444853	28134 *		K4	Q0	-40	7,5	CHP-V		750	AV 2	51	64	65	60
06	446227	62410		K4	Q0	-40	-40	CHP-V		600	AV 2	124	105	99	109

**C70-C99 Chemical composition % - Heat analysis**

B07.2 Heat	C70	C	SI	MN	P	S	N	CU	MO	NI	CR	V	NB	TI	B
444599	Y	0,143	0,284	1,44	0,013	0,0007	0,0039	0,027	0,060	0,036	0,321	0,001	0,024	0,011	0,0020
444853	Y	0,149	0,262	1,43	0,014	0,0005	0,0036	0,044	0,058	0,065	0,319	0,001	0,025	0,010	0,0020
446227	Y	0,153	0,279	1,443	0,015	0,0010	0,0043	0,021	0,064	0,034	0,320	0,001	0,025	0,009	0,0019

**C94 Heat analysis Carbon equivalent / Alloying restrictions**

B07.2 Heat	FO-02=	FO-51=	FO-C4=
444599	0,46	0,03	0,31
444853	0,47	0,03	0,32
446227	0,47	0,03	0,32

A04



Manufacturer's mark

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*B. Baldauf*

B. BALDAUF  
Test House Manager



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

Inspector's stamp

Date 10.07.17

PP 1

A01

## QM-System: Certification as per ISO 9001

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<p>A02 INSPECTION CERTIFICATE 3.1 AS PER EN 10204 : 2004 INSPECTION CERTIFICATE 3.1 AS PER ISO 10474 : 2013 MATERIAL TEST REPORT (MTR)</p>	<p>A10 Advice of dispatch No./ Date of dispatch 605375-07.07.17</p>	<p>A08/ Manufacturer's order/ A03 Certificate No. 424155-006</p> <p style="text-align: right;">Sheet 3/...</p>
<p>A05 Established Inspecting body DH</p>	<p>A06 Purchaser BE GROUP OY AB, LAHTI</p> <p>A07.1 No. P050461</p>	<p>B01 Product HEAVY PLATES</p>
<p>B02/ Steel design. <b>S690QL+DILLIMAX690T</b></p>	<p>Final receiver BE GROUP OY AB, TURKU</p> <p>A07.2 No.</p>	
<p>B03 Any suppl. requirements EN-10025-6:09/DILLING-E04:16</p>		

### C94 Carbon equivalent formula / Alloying restrictions

FO-02 = C+(MN/6) + (CR+MO+V) / 5+ (NI+CU) / 15  
FO-51 = V +NB  
FO-C4 = C+ (MN+MO) / 10+ (CR+CU) / 20+NI / 40

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

#### ITEM NO. : 02

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

#### 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-T5H

### D02 Non-destructive tests - Ultrasonic testing

#### ITEM NO. : 02, 04-06

UT-SPECIFICATION : EN-10160 CLASS S1 AND E1  
SCANNING PLAN BODY : LONGITUDINALLY SCAN LINES SPACING 100 MM  
EDGES : 100 MM

PERSONNEL QUALIFICATION : LEVEL 2 IN ACCORDANCE TO EN 473 / ISO 9712  
THE TEST RESULTS MEET THE REQUIREMENTS OF THE ORDER.

<p>A04</p>	<p>Z01/Z02/Z03 We hereby certify, that the above mentioned materials have been delivered in accordance with the terms of order.</p>	<p style="text-align: center;">                   Manufacturer's mark             </p>
<p style="text-align: center;">                   B. BALDAUF                  Test House Manager             </p>	<p style="text-align: center;">                   AG der Dillinger Hüttenwerke                  Postfach 1580, D-66748 Dillingen/Saar                  Inspection department             </p>	<p style="text-align: right;">                 Inspector's stamp                  Date 10.07.17                  PP 1             </p>
<p style="text-align: right;">A01</p>	<p style="text-align: right;">                 AG der Dillinger Hüttenwerke                  Postfach 1580, D-66748 Dillingen/Saar                  Inspection department             </p>	

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<p>B02/ Steel design. <b>S690QL+DILLIMAX690T</b> B03 Any suppl. requirements EN-10025-6:09/DILLING-E04:16</p>			

**Z04 Environmental product declaration for structural steel**

**ITEM NO. : 02,04-06**

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

A04



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*B. Baldauf*

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Test House Manager



AG der Dillinger Hüttenwerke  
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Inspection department

Inspector's stamp

Date 10.07.17

PP 1

A01

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<p>B02/ Steel design. <b>S690QL+DILLIMAX690T</b> B03 Any suppl. EN-10025-6:09/DILLING-E04:16 requirements</p>			

**Z04 CE-marking**

ITEM NO.: 02,04-06

<p style="font-size: 48px; text-align: center;"><b>CE</b></p> <p style="text-align: center;"><b>0769</b></p>	<p style="text-align: center;"><b>EN 10025-1:2004</b></p> <p style="text-align: center;"><b>Plate S690QL / 1.8928</b></p> <p style="text-align: center;"><b>to be used in welded, bolted and riveted structures</b></p>
<p style="text-align: center;"><b>DILLINGER</b></p> <p style="text-align: center;"><b>AG der Dillinger Hüttenwerke</b> <b>Postfach 1580, D-66748 Dillingen/Saar</b></p> <p style="text-align: center;"><b>17</b></p> <p style="text-align: center;"><b>S690QL_EN10025-6-09_A_130701E1</b></p>	<p style="text-align: center;"><b>Tolerances on dimensions and shape</b></p> <p style="text-align: center;"><b>Elongation</b></p> <p style="text-align: center;"><b>Tensile strength</b></p> <p style="text-align: center;"><b>Yield strength</b></p> <p style="text-align: center;"><b>Impact strength</b></p> <p style="text-align: center;"><b>Weldability</b></p> <p style="text-align: center;"><b>Durability (chemical composition)</b></p> <p style="text-align: center;"><b>expressed as declared in the DoP</b></p> <p style="text-align: center;"><b>S690QL_EN10025-6-09_A_130701E1</b></p>

The declaration of performance can be downloaded from www.dillinger.de/dop/S690QL\_EN10025-6-09\_A\_130701E1.pdf

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A01

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Inspection department

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Manufacturer's mark

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Test House Manager

Inspector's stamp

Date 10.07.17

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