

**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 Final receiver BE GROUP OY AB, LAPUA	621352-21.12.17	430144-001	1/...
A05	Established inspecting body DH	A07.1 No. P056218 A07.2 No.		B01 Product HEAVY PLATES	
B02/	Steel design. <b>S690QL+DILLIMAX690T</b>				
B03	Any suppl. requirements EN-10025-6:09/DILLING-E04:16				

**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
			MM		KG				
01	1	60,00	x 2450	x 6000	7056	Q+A	452492	38982-01	2100923890
05	1	15,00	x 2450	x 6000	1764	Q+A	452651	45882-01	2100922300
05	1	15,00	x 2450	x 6000	1764	Q+A	452651	45882-02	2100922300
05	1	15,00	x 2450	x 6000	1764	Q+A	452651	45882-03	2100922300
05	1	15,00	x 2450	x 6000	1764	Q+A	452651	45882-04	2100922300
**	4				7056				
06	1	16,00	x 2450	x 6000	1882	Q+A	452651	45890-02	2100922510
06	1	16,00	x 2450	x 6000	1882	Q+A	452651	45890-03	2100922510
06	1	16,00	x 2450	x 6000	1882	Q+A	452651	45890-04	2100922510
**	3				5646				
07	1	50,00	x 2450	x 6000	5880	Q+A	452493	38992-01	2100923645
07	1	50,00	x 2450	x 6000	5880	Q+A	452493	38992-02	2100923645
**	2				11760				
08	1	70,00	x 2450	x 6000	8232	Q+A	452492	38983-01	2100923985
***	11				39750				

**B06 Marking of the product**

**ITEM NO. : 01,05-08**  
**STEEL DESIGNATION S690QL DILLIMAX690T**  
**HEAT NO. / TRADEMARK / ROLLED PLATE NO. - TEST NO. / INSPECTOR'S STAMP**

A04	Manufacturer's mark	Z01/Z02/Z03 We hereby certify, that the above mentioned materials have been delivered in accordance with the terms of order.	Inspector's stamp  B. BALDAUF Test House Manager	AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department 	Date 21.12.17	PP 1
A01						

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A05	Established Inspecting body DH	A06 Purchaser BE GROUP OY AB, LAHTI	621352-21.12.17	430144-001	2/...
	Final receiver BE GROUP OY AB, LAPUA	A07.1 No. P056218 A07.2 No.		B01 Product HEAVY PLATES	
B02/	Steel design. <b>S690QL+DILLIMAX690T</b>				
B03	Any suppl. requirements EN-10025-6:09/DILLING-E04:16				

**C-10-C29 Tensile test**

B14 Item No.	B07.2 Heat No.	B07.1 Rol.plate/ Test No.	B05 Reference (heat) treatment	C01	C02/ C01	C03 GR.C	C10 GR.C	C11 MPA RP02	REH	C12 RM	C13	A % LO=5D	C14-C15
01	452492	38982		K4 Q	Q	RT		745	816			16	
06	452651	45890		K4 Q	Q	RT		845	865			18	
07	452493	38992		K4 Q	Q	RT		782	839			16	
08	452492	38983		K4 Q	Q	RT		735	811			18	

**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 GR.C	C41 Width of test piece	C40 Type of test piece	C44 Testing method	C45 Energy Joule	C42 Individual values AV=J	C43 Mean value
01	452492	38982		K4	QV	-40	-40	CHP-V		600	41	79
06	452651	45890		K4	QO	-40	-40	CHP-V		600	98	100
07	452493	38992		K4	QV	-40	-40	CHP-V		600	161	179
08	452492	38983		K4	QV	-40	-40	CHP-V		600	54	71

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

B07.2 Heat	C70	C	SI	MN	P	S	N	CU	MO	NI	CR	VB	TI	B
452492	Y	0,157	0,283	1,274	0,011	0,0007	0,0042	0,022	0,220	0,114	0,307	0,001	0,023	0,0015
452493	Y	0,161	0,293	1,290	0,010	0,0005	0,0051	0,038	0,220	0,116	0,314	0,001	0,024	0,0015
452651	Y	0,139	0,257	1,432	0,014	0,0009	0,0031	0,037	0,058	0,031	0,310	0,002	0,023	0,0020
B07.2 Heat	C70	ZR	AL-T											
452492	Y	0,0002	0,070											
452493	Y	0,0002	0,077											
452651	Y	0,0002	0,027											

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			621352-21.12.17	430144-001	3/...
A05	Established Inspecting body DH	A06 Purchaser BE GROUP OY AB, LAHTI	A07.1 No.	Product HEAVY PLATES	
		Final receiver BE GROUP OY AB, LAPUA	A07.2 No.		
B02/	Steel design. <b>S690QL+DILLIMAX690T</b>				
B03	Any suppl. requirements	EN-10025-6:09/DILLING-E04:16			

### C94 Heat analysis Carbon equivalent / Alloying restrictions

<b>B07.2</b>	<b>Heat</b>								
	452492	FO-02=	0,48	FO-51=	0,02	FO-C4=	0,33		
	452493	FO-02=	0,49	FO-51=	0,03	FO-C4=	0,33		
	452651	FO-02=	0,46	FO-51=	0,03	FO-C4=	0,31		

### 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. : 01, 07-08

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. : 05-06

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

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			621352-21.12.17		430144-001	4 / ...	
A05	Established Inspecting body DH	A06 Purchaser BE GROUP OY AB, LAHTI	A07.1 No.	A07.2 No.	B01 Product HEAVY PLATES		
		Final receiver BE GROUP OY AB, LAPUA	P 056218				
B02/	Steel design.	<b>S690QL+DILLIMAX690T</b>					
B03	Any suppl. requirements	EN-10025-6:09/DILLING-E04:16					

### D02 Non-destructive tests - Ultrasonic testing

**ITEM NO. : 01,05-08**  
 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 ISO 9712  
 THE TEST RESULTS MEET THE REQUIREMENTS OF THE ORDER.

### Z04 Environmental product declaration for structural steel

**ITEM NO. : 01,05-08**  
 For structural steel plates from Dillinger Hütte a validated environmental product declaration according to ISO 14025 and EN 15804 was established: BFS-20130094-IBGI-EN+RC1. Further information can be found under [www.dillinger.de/EPD-E/](http://www.dillinger.de/EPD-E/).

A04	 Manufacturer's mark	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	 Inspector's stamp	AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department	A01 Date 21.12.17 PP 1
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<p>A05 Established inspecting body DH</p>	<p>A06 Purchaser BE GROUP OY AB, LAHTI A07.1 No. P056218 Final receiver BE GROUP OY AB, LAPUA A07.2 No.</p>	<p>B01 Product HEAVY PLATES</p>	
<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.: 01,05-08

<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

A04



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

A01

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

*B. Baldauf*



Manufacturer's mark

B. BALDAUF  
Test House Manager

Inspector's stamp

Date 21.12.17

PP 1