

**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 Final receiver	654873-19.10.18	438662-002	1/....
B02/	Steel design. <b>S690QL+DILLIMAX690T</b>	A07.1 No. P063913		B01 Product	
B03	Any suppl. requirements	BE GROUP OY AB, LAHTI BE GROUP OY AB, TURKU		HEAVY PLATES	
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 KG	B04 Product delivery condition	B07.2 Heat No.	B07.1 Rolled plate No./ Test No.	A09 Purchaser article number
04	1	16,00	x 2450	x 6000	1882	Q+A	463498	38228-01	2190921015
04	1	16,00	x 2450	x 6000	1882	Q+A	463498	38228-02	2190921015
04	1	16,00	x 2450	x 6000	1882	Q+A	463498	38228-03	2190921015
04	1	16,00	x 2450	x 6000	1882	Q+A	463498	38228-04	2190921015
04	1	16,00	x 2450	x 6000	1882	Q+A	463498	38304-01	2190921015
04	1	16,00	x 2450	x 6000	1882	Q+A	463498	38304-02	2190921015
**	6				11292				
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38678-01	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38678-02	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38678-03	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38685-01	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38685-02	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38703-01	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38703-02	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38703-04	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38704-01	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38704-02	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38704-03	2190921020
05	1	20,00	x 2450	x 6000	2352	Q+A	463501	38704-04	2190921020
**	12				28224				
06	1	25,00	x 2450	x 6000	2940	Q+A	463500	38562-11	2190921025
06	1	25,00	x 2450	x 6000	2940	Q+A	463500	38562-12	2190921025
**	2				5880				

A04	Z01/Z02/Z03 We hereby certify, that the above mentioned materials have been delivered in accordance with the terms of order.	 Manufacturer's mark		 B. BALDAUF Test House Manager	Inspector's stamp Date 22.10.18	AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department	Date 22.10.18 PP 1
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A05	Established Inspecting body DH	A06 Purchaser BE GROUP OY AB, LAHTI	654873-19.10.18	438662-002	2/...
A05	Final receiver BE GROUP OY AB, TURKU	A07.1 No. P063913		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
07	1	30,00	x 2450	x 6000	3528	Q+A	462263	84677-01	2190921030
07	1	30,00	x 2450	x 6000	3528	Q+A	462263	84677-02	2190921030
07	1	30,00	x 2450	x 6000	3528	Q+A	462263	84677-03	2190921030
**	3				10584				
***	23				55980				

**B06 Marking of the product**

ITEM NO.: 04-07

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 Temp. GR.C	C01 C01	C10 C11 MPA RP02	REH	C12 RM	C13	A % L0=5D	C14-C15
04	463498	38228		K4 Q RT		865	865	885		14	
05	463501	38657 *		K4 Q RT		915	915	921		16	
05	463501	38703		K4 Q RT		854	877	877		15	
06	463500	38562		K4 Q RT		818	854	854		17	
07	462263	84677		K4 Q RT		857	892	892		16	

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*

B. BALDAUF  
Test House Manager



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

Inspector's stamp Date 22.10.18

PP 1

A01

## QM-System: Certification as per ISO 9001

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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  654873-19.10.18	A08/ Manufacturer's order/ A03 Certificate No.  438662-002  B01 Product HEAVY PLATES
A05 Established inspecting body DH A06 Purchaser BE GROUP OY AB, LAHTI Final receiver BE GROUP OY AB, TURKU	A07.1 No. P063913 A07.2 No.	
B02/ Steel design. <b>S690QL+DILLIMAX690T</b> B03 Any suppl. EN-10025-6:09/DILLING-E04:16 requirements		

### 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	C43 Mean value
04	463498	38228		K4	Q0	-40	-40	CHP-V		750	AV 2	91 86	91
05	463501	38657	*	K4	Q0	-40	-40	CHP-V		750	AV 2	98 74	85
05	463501	38703		K4	Q0	-40	-40	CHP-V		750	AV 2	88 86	91
06	463500	38562		K4	Q0	-40	-40	CHP-V		750	AV 2	91 100	96
07	462263	84677		K4	Q0	-40	-40	CHP-V		750	AV 2	196 187	189

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

B07.2 Heat	C70	C70													
		C	SI	MN	P	S	N	CU	MO	NI	CR	V	NB	TI	B
462263	Y	0,152	0,181	0,905	0,015	0,0006	0,0028	0,019	0,208	0,040	0,677	0,002	0,028	0,011	0,0021
463498	Y	0,142	0,308	1,474	0,013	0,0004	0,0030	0,025	0,067	0,037	0,327	0,001	0,024	0,014	0,0019
463500	Y	0,141	0,306	1,465	0,014	0,0006	0,0040	0,017	0,071	0,036	0,335	0,002	0,024	0,013	0,0020
463501	Y	0,140	0,310	1,464	0,014	0,0006	0,0036	0,019	0,065	0,029	0,325	0,001	0,024	0,014	0,0021

B07.2 Heat 462263 463498 463500 463501	ZR 0,0002 0,0002 0,0002 0,0002	AL-T 0,035 0,033 0,033 0,034	A04  Manufacturer's mark	A01 AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department  B. BALDAUF Test House Manager Date 22.10.18 Inspector's stamp PP 1
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Z01/Z02/Z03 We hereby certify, that the above mentioned materials have been delivered in accordance with the terms of order.

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A05 Established Inspecting body DH A06 Purchaser BE GROUP OY AB, LAHTI Final receiver BE GROUP OY AB, TURKU	A07.1 No. P063913 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>				
462263	FO-02=	0, 48	FO-51=	0, 03	FO-C4= 0, 30
463498	FO-02=	0, 47	FO-51=	0, 03	FO-C4= 0, 31
463500	FO-02=	0, 47	FO-51=	0, 03	FO-C4= 0, 31
463501	FO-02=	0, 47	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. : 04-05

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

#### ITEM NO. : 06-07

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

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<p>A05 Established Inspecting body DH A06 Purchaser BE GROUP OY AB, LAHTI Final receiver BE GROUP OY AB, TURKU</p>	<p>A07.1 No. P063913 A07.2 No.</p>		
<p>B02/ Steel design. <b>S690QL+DILLIMAX690T</b> B03 Any suppl. EN-10025-6:09/DILLING-E04:16 requirements</p>			

**D02 Non-destructive tests - Ultrasonic testing**

**ITEM NO. : 04-07**  
 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. : 04-07**  
 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/.

<p>A04</p>  <p>Manufacturer's mark</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>B. BALDAUF Test House Manager</p>  <p>Inspector's stamp</p>	<p>AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department</p> <p>Date 22.10.18</p> <p>PP 1</p>
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<p>A05 Established Inspecting body DH</p>	<p>A06 Purchaser BE GROUP OY AB, LAHTI A07.1 No. P063913</p> <p>Final receiver BE GROUP OY AB, TURKU 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.: 04-07

<p style="font-size: 48pt; text-align: center;"><b>CE</b></p> <p style="text-align: right; font-weight: bold;">0769</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>18</b></p> <p style="text-align: center;"><b>S690QL_EN10025-6-09_A_130701E1</b></p>	<p><b>Tolerances on dimensions and shape</b></p> <p>Elongation</p> <p>Tensile strength</p> <p>Yield strength</p> <p>Impact strength</p> <p>Weldability</p> <p><b>Durability (chemical composition)</b></p> <p>expressed as declared in the DoP <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*



Inspector's stamp

B. BALDAUF  
Test House Manager

Date 22.10.18

PP 1