

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 672522-26.03.19	A08/ Manufacturer's order/ A03 Certificate No. 444774-002	Sheet 1/....
A05	Established inspecting body DH A06 Purchaser BE GROUP OY AB, LAHTI A07.1 No. P068484 Final receiver BE GROUP OY AB, TURKU 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 Rol.plate No./ Test No.	A09 Purchaser article number
01	1	15,00	x 2450	x 6000	1764	Q+A	468836	33680-03	2190921010
02	1	25,00	x 2450	x 6000	2940	Q+A	468838	33695-01	2190921025
02	1	25,00	x 2450	x 6000	2940	Q+A	468838	33695-02	2190921025
02	1	25,00	x 2450	x 6000	2940	Q+A	468838	33695-03	2190921025
**	3				8820				
04	1	16,00	x 2450	x 6000	1882	Q+A	468835	33658-01	2190921015
04	1	16,00	x 2450	x 6000	1882	Q+A	468835	33658-02	2190921015
04	1	16,00	x 2450	x 6000	1882	Q+A	468835	33658-04	2190921015
**	3				5646				
05	1	12,00	x 2450	x 6000	1411	Q+A	467310	28758-02	2190921005
05	1	12,00	x 2450	x 6000	1411	Q+A	467310	28758-03	2190921005
05	1	12,00	x 2450	x 6000	1411	Q+A	467310	28758-04	2190921005
**	3				4233				
**	10				20463				

B06 Marking of the product

ITEM NO. : 01-02,04-05
 STEEL DESIGNATION **S690QL DILLIMAX690T**
 HEAT NO. / TRADEMARK / ROLLED PLATE NO.-TEST NO. / INSPECTOR'S STAMP

A04	<p>Manufacturer's mark</p>	<p>AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department</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>Inspector's stamp Date 27.03.19</p>	<p>PP 1</p>
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A05	Established inspecting body DH	A06 Purchaser BE GROUP OY AB, LAHTI	A07.1 No.	P068484	
	Final receiver BE GROUP OY AB, TURKU	A07.2 No.			

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

C10-C29 Tensile test

B14 Item No.	B07.2 Heat No.	B07.1 Rol.plate No./ Test No.	B05 Reference (heat) treatment	C01 C02/ C03 C01	C10 Temp. GR.C	C11 MPA REH	C12 RM	C13 A %	C14-C15 L0=5D
01	468836	33692 *		K4 Q	RT	834	859	16	
02	468838	33695		K4 Q	RT	781	823	18	
04	468835	33657 *		K4 Q	RT	845	865	16	
05	467310	28758		K4 Q	RT	816	827	18	

C40-C49 Impact test

B14 Item No.	B07.2 Heat No.	B07.1 Rol.plate No./ Test No.	B05 Reference (heat) treatment	C01 C02/ C03 C01	C40 Type of test piece	C41 Width of test piece	C43 Energy Joule	C44 Testing method	C45 AV=J	C46 Individual values	C43 Mean value
01	468836	33692 *		K4 Q0	CHP-V	-40	750	87	108	101	101
02	468838	33695		K4 Q0	CHP-V	-40	750	92	99	96	96
04	468835	33657 *		K4 Q0	CHP-V	-40	750	124	138	134	134
05	467310	28758		K4 Q0	CHP-V	-40	750	172	183	192	192

C70-C99 Chemical composition % - Heat analysis

B07.2 Heat	C70	C	SI	MN	P	S	N	CU	MO	NI	CR	V	TI	B
467310	Y	0,144	0,310	1,437	0,010	0,0005	0,0036	0,037	0,070	0,040	0,331	0,002	0,026	0,0020
468835	Y	0,141	0,305	1,448	0,007	0,0004	0,0039	0,041	0,069	0,047	0,332	0,001	0,025	0,0022
468836	Y	0,142	0,307	1,438	0,009	0,0008	0,0034	0,046	0,061	0,079	0,328	0,001	0,025	0,0020
468838	Y	0,146	0,306	1,441	0,010	0,0006	0,0032	0,027	0,070	0,064	0,320	0,001	0,025	0,0019

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

AG der Dillinger Hüttenwerke
 Postfach 1580, D-66748 Dillingen/Saar
 Inspection department
 Date 27.03.19
 Inspector's stamp
 Test House Manager
 PP 1

QM-System: Certification as per ISO 9001



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A05	Established Inspecting body DH	A06 Purchaser BE GROUP OY AB, LAHTI	A07.1 No.	P068484	
	Final receiver	BE GROUP OY AB, TURKU	A07.2 No.		

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

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

C70-C99 Chemical composition % - Heat analysis

	C70	ZR	AL-T
B07.2 Heat	Y	0,0002	0,033
467310	Y	0,0002	0,032
468835	Y	0,0002	0,029
468836	Y	0,0002	0,032

C94 Heat analysis Carbon equivalent / Alloying restrictions

B07.2 Heat	FO-02 = 0,47	FO-51 = 0,03	FO-C4 = 0,31
467310	FO-02 = 0,47	FO-51 = 0,03	FO-C4 = 0,31
468835	FO-02 = 0,47	FO-51 = 0,03	FO-C4 = 0,31
468836	FO-02 = 0,47	FO-51 = 0,03	FO-C4 = 0,32

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. : 01,04-05
 EXAMINATION OF MARKING, SURFACE, SHAPE AND DIMENSIONS: THE RESULTS MEET THE REQUIREMENTS.
 SURFACE AS PER EN-10163-2 KLASSE B UNTERKLASSE 3
 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 27.03.19	AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department	PP 1
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A05	Established Inspecting body DH A06 Purchaser BE GROUP OY AB, LAHTI A07.1 No. P068484 Final receiver BE GROUP OY AB, TURKU A07.2 No.				
B02/	Steel design. S690QL+DILLIMAX690T				
B03	Any suppl. EN-10025-6:09/DILLING-E04:16 requirements				

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-10163-2 KLASSE B UNTERKLASSE 3
THICKNESS AS PER EN-10029:10-A
LENGTH AND WIDTH AS PER EN-10029:10
FLATNESS AS PER EN-10029:10-T4H

D02 Non-destructive tests - Ultrasonic testing

ITEM NO. : 01-02,04-05

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. : 01-02,04-05

For structural steel plates from Dillinger a validated environmental product declaration according to ISO 14025 and EN 15804 was established: EPD-BFS-20180116-IBG2-EN. Further information can be found under 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

Date 27.03.19

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)

A05 Established inspecting body
DH

A06 Purchaser BE GROUP OY AB, LAHTI A07.1 No. P068484

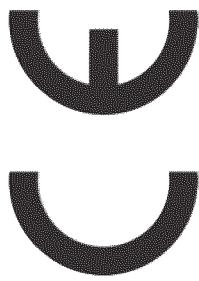

Final receiver BE GROUP OY AB, TURKU A07.2 No.

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

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

Z04 CE-marking

ITEM NO.: 01-02, 04-05

 <p style="font-size: 24pt; margin: 0;">CE</p> <p style="font-size: 18pt; margin: 0;">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</p> <p>AG der Dillinger Hüttenwerke</p> <p>Postfach 1580, D-66748 Dillingen/Saar</p> <p>19</p> <p>S690QL_EN10025-6-09_A_130701E1</p>	<p>Tolerance 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_EN10025-6-09_A_130701E1</p>

The declaration of performance can be downloaded from www.dillinger.de/dop/S690QL_EN10025-6-09_A_130701E1.pdf

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

B. BALDAUF
Test House Manager



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

Inspector's stamp Date 27.03.19

PP 1



A08/ Manufacturer's order/
A03 Certificate No. 444774-002

A10 Advice of dispatch No./
Date of dispatch 672522-26.03.19

Sheet 5

B01 Product
HEAVY PLATES

A01

A04