

**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	A10	Advice of dispatch No./ Date of dispatch	A08/ Manufacturer's order/ A03 Certificate No.	Sheet
	INSPECTION CERTIFICATE 3.1 AS PER ISO 10474:2013		797488-28.11.22	48349-001	1/....
	MATERIAL TEST REPORT (MTR)				

A05	Established Inspecting body DH	A06	Purchaser BE GROUP OY AB, LAHTI	A07.1	No. P100900
			Final receiver BE GROUP OY AB, LAPUA	A07.2	No.

B02/	Steel design.	<b>DILLIMAX690T/S690QL</b>			
B03	Any suppl. requirements	DILLING-04:20/EN-10025-6:19			

**B01-B99 Description of the product**

B14	B08	B09	B10	B11	B12	B04	B04	B07.2	B07.1	A09
Item No.	Number of pieces	Thickness	Width	Length	Theoretical mass KG	Product delivery condition	Heat No.	Roll.plate No./ Test No.	Purchaser article number	
01	1	25,00	x 2450	x 6000	2940	Q+A	520863	09329-01	2100923000	
01	1	25,00	x 2450	x 6000	2940	Q+A	520863	09329-02	2100923000	
01	1	25,00	x 2450	x 6000	2940	Q+A	520863	09329-03	2100923000	
01	1	25,00	x 2450	x 6000	2940	Q+A	520863	09329-04	2100923000	
01	1	25,00	x 2450	x 6000	2940	Q+A	520863	09330-01	2100923000	
01	1	25,00	x 2450	x 6000	2940	Q+A	520863	09330-02	2100923000	
01	1	25,00	x 2450	x 6000	2940	Q+A	520863	09330-03	2100923000	
01	1	25,00	x 2450	x 6000	2940	Q+A	520863	09330-04	2100923000	
**	8				23520					
**	8				23520					

**B06 Marking of the product**

<b>ITEM NO.:</b>	<b>01</b>
STEEL DESIGNATION	<b>DILLIMAX690T S690QL</b>
HEAT NO. / TRADEMARK / ROLLED PLATE NO.-TEST NO. / INSPECTOR'S STAMP	

**C10-C29 Tensile test**

B14	B07.2	B07.1	B05	C01	C02/	C03	C10	C11	C12	C13	C14-C15
Item No.	Heat No.	Roll.plate No./ Test No.	Reference (heat) treatment	Temp. GR.C	MPA	REH	RM	A %			
01	520863	09329	K4 Q	RT	860	860	881	L0=5D 18			

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	29.11.22	AG der Dillinger Hüttenwerke	Postfach 1580, D-66748 Dillingen/Saar	Inspection department	MM	1
	Manufacturer's mark			B. BALDAUF	Test House Manager							

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A05	Established Inspecting body DH	797488-28.11.22	483449-001	B01 Product HEAVY PLATES	2 / ...
A06	Purchaser BE GROUP OY AB, LAHTI	A07.1 No.	P100900		
A07	Final receiver BE GROUP OY AB, LAPUA	A07.2 No.			

B02/ Steel design. **DILLIMAX690T/S690QL**  
 B03 Any suppl. DILLING-04:20/EN-10025-6:19 requirements

**C40-C49 Impact test**

B14 Item No.	B07.2 Heat No.	B07.1 Rol.plate No./ 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 2	C42 Individual values AV=J	C43 Mean value
01	520863	09329	K4	IO	-40		CHP-V		750	128	145	137	137

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

B07.2 Heat	C70	C	SI	MN	P	S	N	CU	MO	NI	CR	V	NB	TI	B
520863	Y	0,183	0,478	1,571	0,012	0,0007	0,0030	0,025	0,018	0,029	0,030	0,001	0,023	0,016	0,0014
B07.2 Heat	C70	ZR	AL-T												
520863	Y	0,0002	0,032												

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

B07.2 Heat 520863 FO-02= 0,46 FO-51= 0,02 FO-A1= 11 FO-C4= 0,35

**C94 Carbon equivalent formula / Alloying restrictions**

FO-02 = C + (MN/6) + (CR+MO+V) / 5 + (NI+CU) / 15  
 FO-51 = V +NB  
 FO-A1 = AT/N  
 FO-C4 = C + (MN+MO) / 10 + (CR+CU) / 20 + NI / 40

A04		Z01/Z02/Z03 We hereby certify, that the above mentioned materials have been delivered in accordance with the terms of order.		AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department	A01
	Manufacturer's mark		B. BALDAUF Test House Manager	Inspector's stamp	MM 1
				Date 29.11.22	

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

B02/ Steel design. **DILLIMAX690T/S690QL**  
 B03 Any suppl. DILLING-04:20/EN-10025-6:19  
 requirements

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

**ITEM NO.: 01**

EXAMINATION OF MARKING, SURFACE, SHAPE AND DIMENSIONS: THE RESULTS MEET THE REQUIREMENTS.  
 SURFACE AS PER EN-10163-2 CLASS B SUBCLASS 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**

UT-SPECIFICATION : EN-10160 CLASS S1 AND E1  
 SCANNING PLAN BODY : LONGITUDINALLY SCAN LINES SPACING 100 MM  
 EDGES : 100 MM  
 PERSONNEL QUALIFICATION : LEVEL 2 ACC.TO ISO 9712 OR SNT-TC-1A  
 THE TEST RESULTS MEET THE REQUIREMENTS OF THE ORDER.

**Z04 Environmental product declaration for structural steel**

**ITEM NO.: 01**

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/](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*

B. BALDAUF  
Test House Manager



Inspector's stamp

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

Date 29.11.22

MM 1

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A05	Established inspecting body DH	A06 Purchaser BE GROUP OY AB, LAHTI	A07.1 No. P100900	B01 Product HEAVY PLATES	
B02/	Steel design. <b>DILLIMAX690T/S690QL</b>	Final receiver BE GROUP OY AB, LAPUA			
B03	Any suppl. requirements DILLING-04:20/EN-10025-6:19				

**Z04 Conformity marking**

ITEM NO.: 01

 0769	 0836	<b>EN 10025-1:2004</b>  Plate S690QL / 1.8928  to be used in welded, bolted and riveted structures
<b>DILLINGER</b>  AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar  22	Tolerance on dimensions and shape: Elongation Tensile strength Yield strength Impact strength Weldability Durability (chemical composition)	expressed as declared in the DoP  S690QL_EN10025-6-19_A_230101E1

The declaration of performance can be downloaded from [www.dillinger.de/dop/S690QL\\_EN10025-6-19\\_A\\_230101E1.pdf](http://www.dillinger.de/dop/S690QL_EN10025-6-19_A_230101E1.pdf)

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 Date 29.11.22	MM 1
AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department			