

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.	DILLIMAX690T/S690QL			
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

ITEM NO.:	01
STEEL DESIGNATION	DILLIMAX690T S690QL
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 %	L0=5D		
01	520863	09329	K4 Q	RT	860	860	881	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
	Manufacturer's mark			B. BALDAUF Test House Manager			MM 1
					AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department		

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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	

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

B07.2 Heat	ZR	AL-T
520863	Y	0,0002 0,032

C94 Heat analysis Carbon equivalent / Alloying restrictions

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	Date 29.11.22	MM 1
	Manufacturer's mark		B. BALDAUF Test House Manager	Inspector's stamp		

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

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

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/.

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		Inspector's stamp B. BALDAUF Test House Manager	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. DILLIMAX690T/S690QL	Final receiver BE GROUP OY AB, LAPUA	A07.2 No.		
B03	Any suppl. requirements DILLING-04:20/EN-10025-6:19				

Z04 Conformity marking

ITEM NO.: 01

<p>0769</p>	<p>0836</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 Postfach 1580, D-66748 Dillingen/Saar</p> <p>22</p> <p>S690QL_EN10025-6-19_A_230101E1</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_EN10025-6-19_A_230101E1</p>

The declaration of performance can be downloaded from 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.

<p>Manufacturer's mark</p>		<p>Inspector's stamp</p> <p>Date 29.11.22</p>	<p>MM 1</p>
<p>AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department</p>			

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A05	Established inspecting body DH	A06 Purchaser	797488-28.11.22	483449-001	2 / ...
		BE GROUP OY AB, LAHTI		B01 Product	
		BE GROUP OY AB, LAPUA		HEAVY PLATES	

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	LO	-40		CHP-V		750		128	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

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	Manufacturer's mark		B. BALDAUF Test House Manager	Inspector's stamp	MM 1
				Date 29.11.22	

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A05	Established Inspecting body DH	A06 Purchaser BE GROUP OY AB, LAHTI	A07.1 No. P100900	B01 Product HEAVY PLATES	
	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

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SCANNING PLAN BODY : LONGITUDINALLY SCAN LINES SPACING 100 MM
EDGES : 100 MM
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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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B02/	Steel design. DILLIMAX690T/S690QL	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	EN 10025-1:2004 Plate S690QL / 1.8928 to be used in welded, bolted and riveted structures
DILLINGER 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)	
S690QL_EN10025-6-19_A_230101E1	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

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
A04	The declaration of performance can be downloaded from www.dillinger.de/dop/S690QL_EN10025-6-19_A_230101E1.pdf		A01
AG der Dillinger Hüttenwerke Postfach 1580, D-66748 Dillingen/Saar Inspection department			