

SWT
STAHLWERK
THÜRINGEN

A03 Certificate No. 2565/6-2019 1 / 2

Advice No. A190621025

A02 Inspection Certificate 3.1

according to EN 10204:2004/3.1



A01 Stahlwerk Thüringen GmbH
A05 Quality Assurance Department
Kronacher Straße 6
07333 Unterwellenborn
Germany

A04
A06

OY KONTINO AB
P.O. Box 27
01301 Vantaa
FINLAND

A08 Our Order No.: 0020001097

A07 Your Order No.: 1112979

B02 Quality: S355J2+M
according to: EN 10025-2/2004

Pos.	Heat No.	Dimension	According to	Length	Pieces	Theoretical Weight
A10	B07	B01		B09	B08	B12
001	26764	HE 160B	EN 10365	12000 mm	33	16 869 kg
003	26811	HE 180B	EN 10365	12000 mm	12	7 372 kg
003	26812	HE 180B	EN 10365	12000 mm	3	1 843 kg

Heat Analysis [%]										
Heat No.	C	Si	Mn	P	S	N	Al	Nb	V	Cr
B07	C71	C72	C73	C74	C75	C76	C77	C78	C79	C80
max	0.20	0.25	1.60	0.030	0.030					
min		0.14								
26764	0.08	0.21	1.44	0.019	0.005	0.010	0.015	0.038	0.008	0.09
26811	0.07	0.18	1.41	0.017	0.017	0.009	0.015	0.037	0.007	0.08
26812	0.07	0.18	1.41	0.017	0.017	0.009	0.015	0.037	0.007	0.08

Heat Analysis [%]					
Heat No.	Cu	Ni	Mo	Ti	CEV1
B07	C81	C82	C83	C84	C93
max	0.55				0.46
min					
26764	0.28	0.12	0.03	0.022	0.37
26811	0.24	0.14	0.04	0.022	0.35
26812	0.24	0.14	0.04	0.022	0.35

Tensile test (ISO 6892-1)				
Heat No.	Yield stress [N/mm ²]	Tensile strength [N/mm ²]	Elongation 5.65VSo [%]	Ys/Ts
B07	C11	C12	C13	C14
max		630		
min	355	470	22.0	
26764	409	555	27.0	0.74
26811	437	515	29.0	0.85
26812	424	502	30.0	0.84

Z03 Works inspector
René Merbach

Z02 Jun 21, 2019

Z04



0769
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032 CPR 2014-09-11 SWT



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 according to: EN 10025-2/2004

Impact test (ISO148-1)

Heat No.	Type	Temperature	L C02				M
			1	2	3		
			[J]				
B07	C40/C41	C03	C42	C42	C42	C43	
min			19			27	
26764	KV 450	-20°C	121	96	117	111	
26811	KV 450	-20°C	162	159	147	156	
26812	KV 450	-20°C	218	215	192	208	

Z01
 - electric arc melting
 - surface condition according to DIN EN 10163-3, class C, subclass 1

Material number: 1.0577

General technical terms of delivery for hot rolled structural steel products: EN 10025-1

Intended uses: Welded, bolted and riveted structures

Expressed as indicated in the DoP:

Tolerances / Tensile strength / Yield strength / Elongation
 Impact strength / Weldability / Durability

Tolerances on dimensions and shape:

HE / IPE / UB / UC / UBP / HP according to EN 10034

UPN / UPE / PFC according to EN 10279

The delivered products do not exceed the limit values of surface contamination according to the German Radiation Protection Ordinance.

We confirm herewith that the delivered material complies with the terms of the order.

Z03 Works inspector
 René Merbach

Z02 Jun 21, 2019



**DECLARATION OF PERFORMANCE
in acc. with EU-regulation 305/2011, Annex III**

No. 032 CPR 2014-09-11 SWT

1. Unique identification code of the product-type:

Hot rolled constructional steel products: 1.0577

2. Type, batch or serial number or any other element allowing identification of the construction products as required under Article 11(4):

Section S355J2 according to EN 10025-2

3. Intended use or uses of the construction product, in accordance with the applicable harmonised technical specification, as foreseen by the manufacturer:

Welded, bolted and riveted structures

4. Name, registered trade name or registered trade mark and contact address of the manufacturer as required pursuant Article 11(5):

Stahlwerk Thüringen GmbH
Kronacher Straße 6
D-07333 Unterwellenborn
E-Mail: info@stahlwerk-thueringen.de

5. System or systems of assessment and verification of constancy of performance of the construction product as set out in Annex V:

System 2+

6. In case of the declaration of performance concerning a construction product covered by a harmonised standard:

Notified factory production control certification body No. 0769

KIT Karlsruher Institut für Technologie
Versuchsanstalt für Stahl, Holz und Steine
Kaiserstraße 12
D-76128 Karlsruhe

performed the initial inspection of the manufacturing plant and of factory production control and the continuous surveillance, assessment and evaluation of factory production control and issued the certificate of conformity of the factory production control.

7. Declared performance:

Essential characteristic	Performance				Harmonised technical specification
Tolerances on dimensions	HE / IPE / UB / UC / BP / HP	according to EN 10034:1993			EN 10025-1:2004
	U / UPE / PFC	according to EN 10279:2000			
Yield strength	Nominal thickness (mm)		Values		
	>	≤	min (MPa)		
		16	355		
	16	40	345		
Tensile strength	Nominal thickness (mm)		Values		
	≥	≤	min (MPa)	max (MPa)	
	3	100	470	630	
Elongation $L_0 = 5,65 \sqrt{S_0}$	Nominal thickness (mm)		Values		
	≥	≤	min (%)		
	3	40	22		
Impact strength	Nominal thickness (mm)		Values		
	>	≤	min (J)		
		100	27 at -20°C		
Weldability CEV	Nominal thickness (mm)		Values		
	>	≤		max (%)	
		30		0,45	
	30	40		0,47	
Durability	Nominal thickness (mm)		Values		
	>	≤		max (%)	
		30		C*: 0,20 Si: 0,55 Mn: 1,60 Cu: 0,55 P: 0,030 S: 0,030	
	* For nominal thickness > 30 mm max. 0,22 % C				

8. The performance of the product identified in points 1 and 2 is in conformity with the declared performance in point 7.

This declaration of performance is issued under the sole responsibility of the manufacturer identified in point 4. Signed for and on behalf of the manufacturer by:

Unterwellenborn, 11th of September 2014



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 Udo Wicke
 Quality Manager
 Stahlwerk Thüringen GmbH