


DECLARATION OF PERFORMANCE		
NR C3013		Rev. 0
Product Identification Code	Hot rolled steel product for Structural Use. Grade S355J2 according to EN10025-2:2004	
Identification	According to the information stated on the ID label with barcode / bundle number and bundle number in the inspection certificate.	
Destiny and scope of application of product	Flat product for use in metal structures or in metal complexes and concrete structures.	
Manufacturer (registered office)	Marcegaglia Poland Sp.zo.o. Ul. Kaliska 72, 46-320 Praszka - Poland	
Production Plant	Ligota Dolna Ul. Przemysłowa 1, 46-320 Kluczbork - Poland	
System of assessment and verification of the continuity of performance of the construction product	2+	
Name and ID number of the notified Body	RINA Service S.p.A. – Via Corsica, 12 – 16128 Genova - Italia 0474	
Certificates of Conformity for the control of the plant production have been issued for the following elements: <ul style="list-style-type: none"> • initial inspection of the production plant and of the factory production control. • surveillance, evaluation and regular audits of the factory production control. 		
DECLARED PERFORMANCE		
Main Features	Performance	Harmonised specification
Dimensional Tolerances	As per Table 2	EN10051:2010
Elongation	As per Table 1	EN10025-1:2004 EN10025-2:2004
Tensile strength		
Yield strength		
Impact strength		
Weldability (CEV)	0.45% max	
Durability	N.P.D.	
This declaration of performance is issued under the sole responsibility of the manufacturer identified above.		
Signed for and on behalf of Marcegaglia Poland Sp.zo.o:		
 Filippo Nicoli <i>Plant Director</i>		<i>Ligota Dolna, 01.07.2013</i>
This declaration of performance is valid only in presence of the product identification label and delivery document or of the inspection certificate issued at the delivery.		

TABLE 1 - MECHANICAL CHARACTERISTICS

Mechanical properties for steel grades quality groups with impact strength values specified														
STEEL GRADE	ReH ^(a) MPa ^(b) Min	Rm ^(a) MPa ^(b)		Min. Percentage elongation after break % ^(a)							Impact strength KV			
				L _o = 80 (mm)							L _o = 5,65√S _o	Temp. (°C)	Min energy (J)	
				Nominal Thickness (mm)										
				≤ 16	< 3	≥ 3 ≤ 100	^{a)}	≤ 1	> 1 ≤ 1,5	> 1,5 ≤ 2	> 2 ≤ 2,5	> 2,5 < 3	≥ 3 ≤ 40	> 6 ≤ 150
S355J2	355	510 + 680	470 ÷ 630	l	14	15	16	17	18	22	-20	27		
				t	12	13	14	15	16	20				

a) For sheets and strips ≥ 600 mm wide, these values relate to samples taken in a direction transverse (t) to the rolling direction. For all other products, the values for samples taken in parallel (l) to rolling direction are applied

b) MPa = 1N/mm²

TABLE 2 - DIMENSIONAL TOLERANCES

Tolerance on Thickness – dimension				
NOMINAL THICKNESS	Tolerances for nominal width			
	≤ 1200	> 1200 ≤ 1500	> 1500 ≤ 1800	> 1800
≤ 2,00	± 0,20	± 0,22	± 0,24	-
> 2,00 ≤ 2,50	± 0,21	± 0,24	± 0,26	± 0,29
> 2,50 ≤ 3,00	± 0,23	± 0,25	± 0,28	± 0,30
> 3,00 ≤ 4,00	± 0,25	± 0,28	± 0,30	± 0,31
> 4,00 ≤ 5,00	± 0,28	± 0,30	± 0,32	± 0,33
> 5,00 ≤ 6,00	± 0,30	± 0,32	± 0,33	± 0,36
> 6,00 ≤ 8,00	± 0,33	± 0,35	± 0,36	± 0,40
> 8,00 ≤ 10,00	± 0,37	± 0,38	± 0,39	± 0,46
> 10,00 ≤ 12,50	± 0,40	± 0,41	± 0,43	± 0,49
> 12,50 ≤ 15,00	± 0,43	± 0,44	± 0,46	± 0,53
> 15,00 ≤ 25,00	± 0,46	± 0,48	± 0,52	± 0,58

Tolerance on width - dimension (mm)		
NOMINAL WIDTH	Raw edges	Trimmed edges
≤ 1200	-0 / +20	-0 / +3
> 1200 ≤ 1850	-0 / +20	-0 / +5
> 1850	-0 / +25	-0 / +6

Tolerances on products with trimmed edges apply up to nominal thickness 10mm
 For thickness over 10mm the values of + deviation must be agreed upon order placement

Tolerance on Length - dimension (mm)		
NOMINAL LENGHT	Lower	Upper
< 2000	-0	+10
≥ 2000 < 8000	-0	+0,005 x nominal length
≥ 8000	-0	+40

Tolerance on Flatness - dimension (mm)				
NOMINAL THICKNESS	Nominal width	Flatness tolerances	Special flatness tolerance	
	≤ 25	≤ 1200		18
		> 1200 ≤ 1500		23
> 1500		28		

Flatness requirements for strips must be agreed upon order placement

Tolerance on longitudinal edge camber or straightness
SHEETS with nominal length < 5000 mm, q = 0,5% of length
SHEETS with nominal length ≥ 5000 mm, width ≥ 600 mm and with mill edges, q = 20 mm max for any length of 5000mm
SHEETS with nominal length ≥ 5000 mm, width ≥ 600 mm and trimmed edges, q = 15 mm max for any length of 5000mm
STRIPS with width ≥ 600, the edge camber shall not exceed 20mm for any length of 5000mm in case of mill edges and 15mm in case of trimmed edges. For strips with width < 600, the tolerances shall be agreed at the time of inquiry or order.

Out-of-squareness
The out-of-squareness for sheets is the orthogonal projection of a transverse edge over a longitudinal one and must not exceed 1% of actual width of the sheet.