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PRETORIA METAL PRESSINGS
a division of Denel (Pty) Ltd

SPECIFICATION FOR BAR STEEL Ø10,82mm BASED ON WN 1.3505

INFORMATION

DATE 2023-6-13

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AMENDMENT HISTORY

Issue	Details	Job No	Done by	Date
1	Specification updated and type in word format.	E2/255/09SA	I.P. <u>[Signature]</u>	2009-11-19

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1. SCOPE

- 1.1 This specification covers bar steel based on WN 1.3505 that conforms to this specification.

2. APPLICABLE DOCUMENTS

- 2.1 ASTM E45

3. REQUIREMENTS

3.1 General material requirements

The material shall be supplied as bright bar in the spheroidized annealed condition.

3.1.1 Product characteristics

- 3.1.1.1 The material shall be supplied as bright bar with chamfered ends (1-2mm x 45°) in lengths of 3 m \pm 0,2 m.

- 3.1.1.2 The diameter shall be 10,82 mm +0,05 mm.
-0,00 mm.

- 3.1.1.3 Straightness deviation shall not exceed 1,5 mm/meter.

- 3.1.1.4 Roundness deviation shall not exceed 0,025 mm.

3.1.2 Chemical, mechanical and metallurgical properties

3.1.2.1 Chemical composition (Cast Analysis)

ELEMENT	SPECIFICATION (%)
Carbon (C)	0,90 - 1,05
Silicon (Si)	0,15 - 0,35
Manganese (Mn)	0,25 - 0,45
Phosphorus (P)	0,030 maximum
Sulphur (S)	0,025 maximum
Chromium (Cr)	1,35 - 1,65
Nickle (Ni)	0,30 maximum
Copper (Cu)	0,30 maximum

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3.1.2.2 Mechanical properties

Hardness (HB30): 240 maximum

3.1.2.3 Metallurgical properties

The maximum acceptable inclusion count will be 2, according to ASTM E45, method A. The micro structure shall be spheroidized and homogeneous.

3.1.3 Workmanship

3.1.3.1 The material must be free from piping, cracks, laps, porosity and macroscopic inclusions. *Compliance to this requirement must be included in the Certificate of Conformance.*

3.1.3.2 The material must be free from rust, kinks and handling marks.

4. QUALITY ASSURANCE PROVISIONS4.1 Responsibility for inspection

4.1.1 Unless otherwise specified in the contract or order, the supplier is responsible for the performance of all inspection requirements as specified herein.

4.1.2 Except as otherwise specified, the supplier may use his own or any other facilities suitable for the performance of the inspection requirements.

4.1.3 The purchaser or his representative reserves the right of inspection of Laboratory Certificates of raw materials and components used for the manufacture of the material.

4.1.4 The supplier shall be responsible for making available to the purchaser all facilities necessary if required, for inspection of the material.

4.1.5 The supplier will be responsible for the implementation of an applicable quality management system to assure the appropriate quality of the product. The purchaser reserves the right to audit the supplier's production facilities at all times to ascertain whether quality requirements are being met.

4.2 Special tests and examinations

Not applicable.

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4.3 Quality conformance inspection

4.3.1 Lot information

A lot shall consist of one or more batches of material produced by one manufacturer in accordance with the same specifications under one continuous set of operating conditions. All material must be of the same cast or heat.

If the quantity is such that more than one cast is required, material of the same cast shall be grouped together. Each case or bundle shall be clearly identifiable as to the relevant cast number.

The supplier shall ensure that all deliveries to the end user are fully traceable by lot number and that identification records be supplied to the end user to match lot numbers with inspection records.

4.4 Test methods

4.4.1 Diameter and roundness shall be measured with a 60° V-micrometer.

4.4.2 Inclusion count in accordance with ASTM E45.

5. PREPARATION FOR DELIVERY

5.1 Packing

5.1.1 To be strapped in bundles suitable for forklift handling using 4 evenly spaced steel straps. The maximum mass shall not exceed 1 000 kg unless otherwise agreed between the supplier and purchaser.

5.1.2 In the case of an overseas supplier the bundles shall be packed in a seaworthy condition using suitable wooden boxes secured by steel straps. The gross mass of the strapped boxes may not exceed 1 100 kg.

5.1.3 If containers are used for transportation of the material, open top containers must be used. The wooden boxes must be properly stacked in the container with spaces of ± 150 mm between them.

5.2 Package marking

All bundles, boxes and/or containers to be legibly and durably marked with the following details on suitable labels:

5.2.1 Document and order number.

5.2.2 Name of supplier.

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5.3 Documentation for delivery

The following documents must be forwarded with each consignment of material:

- 5.3.1 The original specification, which accompanied the order in the case of a single consignment or the final consignment of, staggered deliveries.
- 5.3.2 A certificate of conformance/analysis stating all the results of the tests conducted by the supplier during manufacture and final acceptance.
- 5.3.3 Certificate of acceptance issued by the end user or his duly representative or a letter from the end user for the release of the consignment for shipment in the case of an overseas supplier.
- 5.3.4 The supplier's delivery note shall clearly state the relevant order and document number.

6. NOTES

If the supplier of the material is not the original manufacturer, the full name and address of the manufacturer must be supplied in writing during tender.

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