

# OFL-S

## Plates with high surface quality for exposed concrete boardings

### Specification DH-E34-E, edition April 2016<sup>1</sup>

This specification describes the requirements on plates with special surface quality, generally used for exposed concrete boardings. For this special application Dillinger offers a surface quality called OFL-S.

### Product Description

The plates of surface quality OFL-S are delivered in the descaled state (steel grid blasted on both sides) to secure highest requirements on surface quality. The descaling degree after shot blasting is SA 2<sup>1/2</sup> according to ISO 8501-1, if not otherwise agreed. The shot blasted plates can additionally be ordered in preserved condition (primered). The process of shot blasting and priming is according to EN 10238 Please respect also section „Stocking and transportation“.

### Marking and range of application

The surface requirement is only valid for the marked upper surface of the delivered plate.

The specification OFL-S is valid for the steel grade S235JR according to EN 10025-2.

OFL-S-plates can be delivered in the following dimensions:

Plate thickness t [mm (inches)]	Width [mm (inches)]	Length [mm (inches)]
8 (0.32) <sup>a</sup> ≤ t < 10 (0.39) <sup>a</sup>	≤ 4 200 (165) <sup>a</sup>	≤ 16 000 (630) <sup>a</sup>
10 (0.39) <sup>a</sup> ≤ t ≤ 12 (0.47) <sup>a</sup>	≤ 4 500 (177) <sup>a</sup>	≤ 16 000 (630) <sup>a</sup>

<sup>a</sup> The approximately converted values in brackets are for information only.

Other steel grades and dimensions may be possible on request.

### Order example

Steel EN 10025 – S235JR + DH-E34-E, OFL-S

In order to secure the high surface quality of the produced plates particular measures are necessary during fabrication. Therefore, we kindly ask you to coordinate the desired plate quantity with Dillinger prior to ordering.

<sup>1</sup> The current version of this specification can be also found on <http://www.dillinger.de>.

## General technical delivery requirements

If not otherwise agreed, the general technical delivery requirements are according to EN 10021.

## Flatness tolerances

If not otherwise agreed, the tolerances are according to EN 10029, with Class B for the thickness and with the flatness restriction of 1.5 mm (0.059 in.)<sup>2</sup> / 1 m (39 in.)<sup>2</sup> respectively 3 mm (0.118 in.)<sup>2</sup> / 2 m (79 in.)<sup>2</sup>.

## Surface quality

Permissible surface imperfections (only marked upper surface)	
Isolated indentations, Rolled-in scale	<p>Permitted are:</p> <p>Imperfections with a depth <math>\leq 0.2</math> mm (0.008 in.)<sup>a</sup> or imperfections with a depth <math>\leq 2</math> mm (0.079 in.)<sup>a</sup>, if the number per plate <math>&lt; 5</math> and <math>\varnothing \leq 5</math> mm (0.2 in.)<sup>a</sup>.</p> <p>Note: If the number of imperfections is, against all expectation, <math>&gt; 5</math> or the imperfections are bigger than described above, the acceptance of the plate has to be clarified with the customer.</p> <p>Imperfections are marked on plate by colour. The marking of the imperfections will be executed after shot blasting respectively priming (the latter, if ordered).</p>
Grooves, scratches and gouges	Permitted, if not sharp edged and depth $\leq 0.2$ mm (0.008 in.) <sup>a</sup> .
Cracks, shells and shell-like defects	Not permitted.
Further surface requirements	<p>On the upper surface no grinding or welding works will be carried out by the producer (except little grinding works at the plate ends, which will only be carried out with a flexible belt sander).</p> <p>The plates are not marked (stamp, painting). The marking will be on the upper plate surface, by labels, if not otherwise agreed.</p> <p>The surface is free from grease and oil.</p>

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## Stocking and transportation

The surfaces of OFL-S plates are very sensitive. Therefore, particular measures have to be carried out during transportation and when stocking the plates (especially, if no preservation is ordered).

For plate stocking, the following measurements are recommended by the producer:

- Protection against ground-wetness with wood beams.
- Covering of the plates (if possible, stocking in the shop).
- Stocking with little inclination in order to avoid banking-up of the water (if stocked outside).
- Separation of OFL-S-plates from other plates.

For transportation, we recommend to use railway or truck and to cover the plates or to order covering of the plates. Please note, that by railway transport plate width over 3 000 mm (118 in.)<sup>3</sup> and by truck transport plate width over 2 500 mm (98 in.)<sup>3</sup> could not be covered and that the risk of corrosion for steel grid blasted (descaled) plates, which are not preserved (primered), is higher. Even if the plates are covered the risk of corrosion can not be excluded (condensation of water). In order to get optimized conditions when plates according to the specification OFL-S are stocked, charged and dispatched, we recommend to entrust Dillinger with the transport. The covering of the plates is carried out one-sided.

However, should you prefer to transport the plates by yourself, despite of the recommendations above, this has to be done at the latest three days after you are informed, in order to secure the high surface quality as agreed.

## General Note

If special requirements, which are not covered in this specification, are to be met by the steel due to its intended use or processing, these requirements are to be agreed before placing the order.

The information in this specification is a product description. This specification is updated if necessary. The latest version is available from the mill or as download at [www.dillinger.de](http://www.dillinger.de).

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<sup>3</sup> The approximately converted values in brackets are for information only.

## Contact

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