

# SVENSK STANDARD

## SS-EN 10025-3:2019



Fastställt/Approved: 2019-08-20  
Utgåva/Edition: 2  
Språk/Language: engelska/English  
ICS: 77.140.10;77.140.50

---

### **Varmvalsade konstruktionsstål – Del 3: Tekniska leveransbestämmelser för normaliserade/normaliservalsade finkornstål**

### **Hot rolled products of structural steels – Part 3: Technical delivery conditions for normalized/normalized rolled weldable fine grain structural steels**

This preview is downloaded from [www.sis.se](http://www.sis.se). Buy the entire standard via <https://www.sis.se/std-80014170>

# Standarder får världen att fungera

*SIS (Swedish Standards Institute) är en fristående ideell förening med medlemmar från både privat och offentlig sektor. Vi är en del av det europeiska och globala nätverk som utarbetar internationella standarder. Standarder är dokumenterad kunskap utvecklad av framstående aktörer inom industri, näringsliv och samhälle och befrämjar handel över gränser, bidrar till att processer och produkter blir säkrare samt effektiviserar din verksamhet.*

## Delta och påverka

Som medlem i SIS har du möjlighet att påverka framtida standarder inom ditt område på nationell, europeisk och global nivå. Du får samtidigt tillgång till tidig information om utvecklingen inom din bransch.

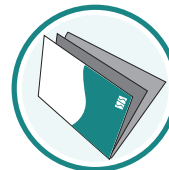
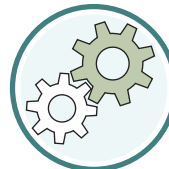
## Ta del av det färdiga arbetet

Vi erbjuder våra kunder allt som rör standarder och deras tillämpning. Hos oss kan du köpa alla publikationer du behöver – allt från enskilda standarder, tekniska rapporter och standardpaket till handböcker och onlinetjänster. Genom vår webbtjänst e-nav får du tillgång till ett lättnavigerat bibliotek där alla standarder som är aktuella för ditt företag finns tillgängliga. Standarder och handböcker är källor till kunskap. Vi säljer dem.

## Utveckla din kompetens och lyckas bättre i ditt arbete

Hos SIS kan du gå öppna eller företagsinterna utbildningar kring innehåll och tillämpning av standarder. Genom vår närhet till den internationella utvecklingen och ISO får du rätt kunskap i rätt tid, direkt från källan. Med vår kunskap om standarders möjligheter hjälper vi våra kunder att skapa verklig nytta och lönsamhet i sina verksamheter.

**Vill du veta mer om SIS eller hur standarder kan effektivisera din verksamhet är du välkommen in på [www.sis.se](http://www.sis.se) eller ta kontakt med oss på tel 08-555 523 00.**



# Standards make the world go round

*SIS (Swedish Standards Institute) is an independent non-profit organisation with members from both the private and public sectors. We are part of the European and global network that draws up international standards. Standards consist of documented knowledge developed by prominent actors within the industry, business world and society. They promote cross-border trade, they help to make processes and products safer and they streamline your organisation.*

## Take part and have influence

As a member of SIS you will have the possibility to participate in standardization activities on national, European and global level. The membership in SIS will give you the opportunity to influence future standards and gain access to early stage information about developments within your field.

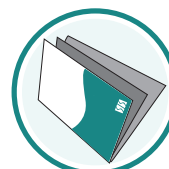
## Get to know the finished work

We offer our customers everything in connection with standards and their application. You can purchase all the publications you need from us - everything from individual standards, technical reports and standard packages through to manuals and online services. Our web service e-nav gives you access to an easy-to-navigate library where all standards that are relevant to your company are available. Standards and manuals are sources of knowledge. We sell them.

## Increase understanding and improve perception

With SIS you can undergo either shared or in-house training in the content and application of standards. Thanks to our proximity to international development and ISO you receive the right knowledge at the right time, direct from the source. With our knowledge about the potential of standards, we assist our customers in creating tangible benefit and profitability in their organisations.

**If you want to know more about SIS, or how standards can streamline your organisation, please visit [www.sis.se](http://www.sis.se) or contact us on phone +46 (0)8-555 523 00**



Europastandarden EN 10025-3:2019 gäller som svensk standard. Detta dokument innehåller den officiella engelska versionen av EN 10025-3:2019.

Denna standard ersätter SS-EN 10025-3:2004, utgåva 1.

The European Standard EN 10025-3:2019 has the status of a Swedish Standard. This document contains the official version of EN 10025-3:2019.

This standard supersedes the SS-EN 10025-3:2004, edition 1.

© Copyright/Upphovsrätten till denna produkt tillhör SIS, Swedish Standards Institute, Stockholm, Sverige. Användningen av denna produkt regleras av slutanvändarlicensen som återfinns i denna produkt, se standardens sista sidor.

© Copyright SIS, Swedish Standards Institute, Stockholm, Sweden. All rights reserved. The use of this product is governed by the end-user licence for this product. You will find the licence in the end of this document.

*Upplysningar om sakinnehållet i standarden lämnas av SIS, Swedish Standards Institute, telefon 08-555 520 00. Standarder kan beställas hos SIS som även lämnar allmänna upplysningar om svensk och utländsk standard.*

*Information about the content of the standard is available from the Swedish Standards Institute (SIS), telephone +46 8 555 520 00. Standards may be ordered from SIS, who can also provide general information about Swedish and foreign standards.*

Denna standard är framtagen av kommittén för Konstruktionsstål, SIS/TK 142.

Har du synpunkter på innehållet i den här standarden, vill du delta i ett kommande revideringsarbete eller vara med och ta fram andra standarder inom området? Gå in på [www.sis.se](https://www.sis.se) - där hittar du mer information.



EUROPEAN STANDARD

EN 10025-3

NORME EUROPÉENNE

EUROPÄISCHE NORM

August 2019

ICS 77.140.10; 77.140.50

Supersedes EN 10025-3:2004

English Version

## Hot rolled products of structural steels - Part 3: Technical delivery conditions for normalized/normalized rolled weldable fine grain structural steels

Produits laminés à chaud en aciers de construction -  
Partie 3 : Conditions techniques de livraison pour les  
aciers de construction soudable à l'état  
normalisé/laminage normalisant

Warmgewalzte Erzeugnisse aus Baustählen - Teil 3:  
Technische Lieferbedingungen für  
normalgeglühte/normalisierend gewalzte  
schweißgeeignete Feinkornbaustähle

This European Standard was approved by CEN on 16 June 2019.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

**SS-EN 10025-3:2019 (E)**

<b>Contents</b>	<b>Page</b>
European foreword .....	3
<b>1 Scope</b> .....	<b>5</b>
<b>2 Normative references</b> .....	<b>5</b>
<b>3 Terms and definitions</b> .....	<b>7</b>
<b>4 Classification and designation</b> .....	<b>8</b>
4.1 Classification.....	8
4.2 Designation .....	8
<b>5 Information to be supplied by the purchaser</b> .....	<b>9</b>
5.1 Mandatory information .....	9
5.2 Options.....	9
<b>6.1 Steel making process</b> .....	<b>9</b>
<b>6.2 Deoxidation and grain structure</b> .....	<b>9</b>
<b>6.3 Delivery conditions</b> .....	<b>9</b>
<b>7 Requirements</b> .....	<b>10</b>
7.1 General.....	10
7.2 Chemical composition .....	10
7.3 Mechanical properties .....	10
7.4 Technological properties.....	11
7.5 Surface properties .....	13
7.6 Internal soundness.....	13
7.7 Dimensions, tolerances on dimensions and shape, mass.....	13
<b>8 Inspection</b> .....	<b>14</b>
8.1 Type of inspection and inspection document.....	14
8.2 Content of inspection document.....	14
8.3 Tests to be carried out .....	14
<b>9 Frequency of testing and preparation of samples and test pieces</b> .....	<b>15</b>
9.1 Frequency of testing .....	15
9.2 Preparation of samples and test pieces.....	15
9.3 Identification of samples and test pieces .....	16
<b>10 Test methods</b> .....	<b>17</b>
10.1 Chemical analysis.....	17
10.2 Mechanical tests .....	17
10.3 Ultrasonic testing.....	18
10.4 Retests.....	18
<b>11 Marking, labelling, packaging</b> .....	<b>18</b>
<b>12 Complaints</b> .....	<b>18</b>
<b>13 Options</b> .....	<b>19</b>
<b>Annex A (normative) Locations of samples and test pieces</b> .....	<b>26</b>
<b>Annex B (informative) List of Options of EN 10025 2 to –6</b> .....	<b>29</b>
<b>Bibliography</b> .....	<b>31</b>

## European foreword

This document (EN 10025-3:2019) has been prepared by Technical Committee CEN/TC 459/SC 3 “Structural steels other than reinforcements”, the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by February 2020 and conflicting national standards shall be withdrawn at the latest by February 2020.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 10025-3:2004

*steels:*

- *Part 1: General technical delivery conditions*
- *Part 2: Technical delivery conditions for non-alloy structural steels*
- *Part 3: Technical delivery conditions for normalized/normalized rolled weldable fine grain structural steels*
- *Part 4: Technical delivery conditions for thermomechanical rolled weldable fine grain structural steels*
- *Part 5: Technical delivery conditions for structural steels with improved atmospheric corrosion resistance*
- *Part 6: Technical delivery conditions for flat products of high yield strength structural steels in the quenched and tempered condition*

For a short transition period there will be a coexistence of EN 10025-1:2004 with EN 10025-2:2018 to –6:2018, since the new EN 10025-1 has to fulfil the requirements of the CPR and will therefore be published later. For this short transition period up-to-the publication of the next edition of part 1 the following are to be taken into account for EN 10025-1:2004:

- a) all dated and undated references to EN 10025-1:2004 to –6:2004 are unchanged to this version with following exception: In 9.2.2.1 the references are 8.3.1 and 8.3.2 instead of 8.4.1 and 8.4.2,
- b) Clauses 5, 12 and 13 of EN 10025-1:2004 are no longer relevant.

The main changes with respect to the previous edition are listed below:

- a) part 3 is now a stand-alone standard for technical delivery conditions including the preparation of samples and test pieces, the test methods, the marking, labelling and packaging and the drawings;
- b) for applications under the CPR this document and part 1 are used together;
- c) requirements for elements not defined were added to 7.2.1 and 7.2.2;
- d) Option 33 was added, Option 3 was renumbered to Option 24 and Option 9 was deleted;
- e) Si-content in 7.2.4 was changed;
- f) 7.4.3 concerning hot-dip zinc coating was modified;

**SS-EN 10025-3:2019 (E)**

- g) key to Figure A.1 was updated;
- h) Annex B concerning the corresponding EURONORMS was deleted;
- i) references were updated and the document was editorially revised.

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Republic of North Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.



## 1 Scope

This document specifies technical delivery conditions for flat and long products of hot rolled weldable fine grain structural steels in the normalized/normalized rolled delivery condition in the grades and qualities given in Tables 1 to 3 (chemical composition) and Tables 4 to 6 (mechanical properties) in thickness  $\leq 250$  mm.

The steels specified in this document are especially intended for use in heavily loaded parts of welded structures such as, bridges, flood gates, storages tanks, water supply tanks, etc., for service at ambient and low temperatures.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

### *ferritic steels*

EN 10017, *Steel rod for drawing and/or cold rolling — Dimensions and tolerances*

EN 10020:2000, *Definition and classification of grades of steel*

EN 10021, *General technical delivery conditions for steel products*

EN 10024, *Hot rolled taper flange I sections — Tolerances on shape and dimensions*

EN 10025-1, *Hot rolled products of structural steels — Part 1: General technical delivery conditions*

EN 10027-1, *Designation systems for steels — Part 1: Steel names*

EN 10027-2, *Designation systems for steels — Part 2: Numerical system*

EN 10029, *Hot-rolled steel plates 3 mm thick or above — Tolerances on dimensions and shape*

EN 10034, *Structural steel I and H sections — Tolerances on shape and dimensions*

EN 10048, *Hot rolled narrow steel strip — Tolerances on dimensions and shape*

EN 10051, *Continuously hot-rolled strip and plate/sheet cut from wide strip of non-alloy and alloy steels — Tolerances on dimensions and shape*

EN 10055, *Hot rolled steel equal flange tees with radiused root and toes — Dimensions and tolerances on shape and dimensions*

EN 10056-1, *Structural steel equal and unequal leg angles — Part 1: Dimensions*

EN 10056-2, *Structural steel equal and unequal leg angles — Part 2: Tolerances on shape and dimensions*

EN 10058, *Hot rolled flat steel bars and steel wide flats for general purposes — Dimensions and tolerances on shape and dimensions*

**SS-EN 10025-3:2019 (E)**

EN 10059, *Hot rolled square steel bars for general purposes — Dimensions and tolerances on shape and dimensions*

EN 10060, *Hot rolled round steel bars for general purposes — Dimensions and tolerances on shape and dimensions*

EN 10061, *Hot rolled hexagon steel bars for general purposes — Dimensions and tolerances on shape and dimensions*

EN 10067, *Hot rolled bulb flats — Dimensions and tolerances on shape, dimensions and mass*

EN 10079, *Definition of steel products*

EN 10160, *Ultrasonic testing of steel flat product of thickness equal or greater than 6 mm (reflection method)*

— *Part 1: General requirements*

EN 10163-2, *Delivery requirements for surface condition of hot-rolled steel plates, wide flats and sections — Part 2: Plate and wide flats*

EN 10163-3, *Delivery requirements for surface condition of hot-rolled steel plates, wide flats and sections — Part 3: Sections*

EN 10164, *Steel products with improved deformation properties perpendicular to the surface of the product — Technical delivery conditions*

EN 10168, *Steel products — Inspection documents — List of information and description*

EN 10204, *Metallic products — Types of inspection documents*

EN 10279, *Hot rolled steel channels — Tolerances on shape, dimensions and mass*

EN 10306, *Iron and steel — Ultrasonic testing of H beams with parallel flanges and IPE beams*

EN 10308, *Non destructive testing — Ultrasonic testing of steel bars*

EN 10315, *Routine method for analysis of high alloy steel by X-ray Fluorescence Spectrometry (XRF) by using a near by technique*

CR 10320, *Optical emission analysis of low alloy steels (routine method) — Method for determination of C, Si, S, P, Mn, Cr, Ni and Cu*

CEN/TR 10347, *Guidance for forming of structural steels in processing*

EN 10363, *Continuously hot-rolled patterned steel strip and plate/sheet cut from wide strip — Tolerances on dimensions and shape*

EN 10365, *Hot rolled steel channels, I and H sections — Dimensions and masses*

EN ISO 148-1, *Metallic materials — Charpy pendulum impact test — Part 1: Test method (ISO 148-1)*

EN ISO 377, *Steel and steel products — Location and preparation of samples and test pieces for mechanical testing (ISO 377)*

EN ISO 2566-1, *Steel — Conversion of elongation values — Part 1: Carbon and low alloy steels (ISO 2566-1)*

EN ISO 6892-1:2016, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature (ISO 6892-1:2016)*

EN ISO 9443, *Surface quality classes for hot-rolled bars and wire rod (ISO 9443)*

EN ISO 14284, *Steel and iron — Sampling and preparation of samples for the determination of chemical composition (ISO 14284)*

EN ISO 14713-2:2009, *Zinc coatings — Guidelines and recommendations for the protection against corrosion of iron and steel in structures Part 2: Hot dip galvanizing (ISO 14713 2:2009)*

EN ISO 15350, *Steel and iron — Determination of total carbon and sulfur content — Infrared absorption method after combustion in an induction furnace (routine method) (ISO 15350)*

### 3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 10079 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

#### 3.1

##### **normalized rolled**

rolling process in which the final deformation is carried out in a certain temperature range leading to a material condition equivalent to that obtained after normalizing so that the specified values of the mechanical properties are retained even after normalizing

Note 1 to entry: In international publications for both the normalizing rolling, as well as the thermomechanical rolling, the expression “controlled rolling” may be found. However in view of the different applicability of the products a distinction of the terms is necessary.

#### 3.2

##### **normalizing**

heat treatment consisting of austenitizing followed by air cooling

#### 3.3

##### **fine grain steels**

steels with fine grain structure with an equivalent index of ferritic grain size  $\geq 6$

Note 1 to entry: For the determination of grain sizes see EN ISO 643.