



Drawn square steel bars

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Revision 07/2019



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STEEL RANGE

Structural steels EN 10025-2-3-5
Free cutting non-alloyed steels EN 10087
Case hardening steels EN 10084
Steels for quenching and tempering EN 10083-2-3
Hot-rolled steels for quenched and tempered springs EN 10089
Cold-finished steels EN 10277-2-3-4-5
Steels for cold heading and cold extrusion EN 10263
Micro-alloyed steels EN 10267
Steels for pressure purposes EN 10273 - ASTM A105 - ASTM A 350

Notes: possibility of supplying steels in accordance with Customer specifications, to be agreed upon at the order stage.

PRODUCTION RANGE

STANDARD MANUFACTURING SIZES

Drawn square bars: 30 ÷ 101.6 mm with 0,01 mm progression
Delivery of "radiused" or "bevelled" drawn flat steel products possible upon agreement with the operational unit.

Notes: 1 ÷ 4 inch sizes may be accepted.

BAR LENGTH

2.8 ÷ 6.8 m (including length+ tolerance)
Commercial length with range ≤ 1 m
Extra Standard Fixed Length with range -0/+200 mm or ± 100 mm
Extra Standard Fixed Length with range ≥ 50 mm
Extra Standard Fixed Length with range ≥ 20 mm

Note: crop end, if agreed upon at the order, ≥ 3 m for ≤ 10% of the ordered weight. It will be included in the supply if hot-rolled and separately wrapped if cold-rolled.

Note: possibility of supplying sandblasted drawn sections with length 2.8 ÷ 6.8 m (including the length+ tolerance).

DIMENSIONAL TOLERANCES - UNI EN 10277; UNI EN ISO 286; ASTM A108; BS 970

Standard	IT11
Extra Standard	IT10

Notes: full-length tolerances will have to be agreed upon at the order acquisition stage.
For heat-treated products after drawing + sandblasting IT13

STRAIGHTNESS

Standard	Camber ≤ 1‰ L
Extra Standard	-

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ROUGHNESS

Standard	Ra ≤ 3.2 μm
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END APPEARANCE

Standard	Shear cutting for cutting cross-section < 55 mm or with one-end sawing machine for cutting cross-section ≥ 55 mm
Extra Standard	Cutting with sawing machine at both ends of the measure.

SUPERFICIAL DEFECTS

Standard	Class 2 EN 10277 (Statistical)
Extra Standard	Class 2 - 3 EN 10277 with NDT 100%

Notes: Note: semi-products can be previously subjected to US testing in accordance with standard EN 10308 Max Class 3

DECARBURAZIONE

Standard	Max. 1% of the cross-section, with a minimum equal to 0.2 mm.
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NON-METALLIC INCLUSIONS

Standard	Macro-purity at grade ≤ 2 as per S.E.P. 1584 standard. Micro-purity at grade ≤ 2.5 as per ASTM E 45 standard or with K method at the values of the EN 10083/06-1 standard, App E. Macro-segregation ≤ C3-R2-S2 as per ASTM E 381 standard
Extra Standard	Through the vacuum degassing (VD) process it is possible to obtain macro-inclusions falling into grade 0 of the S.E.P. 1584 standard.

BANDING

Standard:	Maximum guaranteed banding as per Grade IV of the UNI 8449 standard.
Extra Standard	Through the vacuum degassing (VD) process, maximum guaranteed banding as per Grade III of the UNI 8449 standard.

AUSTENITE GRAIN REFINING FOR SPECIAL STEELS

Standard	5 ÷ 8 austenite grain as per ASTM E112 or ISO 643 guaranteed. This grain size range is not guaranteed for general purpose structural steels, with the exception of the J2 types envisaged in the EN 10025-2 table.
Extra Standard	With extra standard process, 6 or finer austenite grain can be guaranteed.

MECHANICAL CHARACTERISTICS AND HARDENABILITY

Standard	In accordance with the standardisation table mentioned in the order. On request, all steels can be produced with hardenability restricted to 2/3 of the H standard band, i.e. in the HL (lower 2/3) and HH (upper 2/3) types. Reference for Jominy test: EN ISO 642 standard.
Extra Standard	In accordance with Customer specification, to be evaluated at the order acceptance stage.

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MAGNETIC RETENTIVITY

Standard	Not guaranteed.
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PACKAGING

Standard	<ul style="list-style-type: none">- Anti-corrosion oiling- 4 straps for 2.8÷5 m bundles. N° 4/6 straps for 5.5÷7.2 m.- 1 Tag per bundle- Certified metal lifting rings
Extra Standard	<p>Peculiar conditions besides the previous ones, to be evaluated at the order acceptance stage.</p> <ul style="list-style-type: none">- 2 tags, 1 at the front and 1 at the rear of the bundle- Bundle packaging with polythene-jute cloth- Plates at the ends- Packaging in crates- Additional oiling and protective paper at the shipment stage.

HEAT TREATMENTS

Our products can be supplied with the following heat treatments:

- Softening annealing +A
- +AC Globular annealing globular level guaranteed $\geq 70\%$
- Stress-free annealing +SR
- Annealing for ferrite-pearlite structure +FP
- Normalising +N
- Shearability annealing +S
- Hardening field annealing +TH

BUNDLE WEIGHT

Standard	1,000 ÷ 1,600 kg
Extra standard	500 Kg

OTHER INFORMATION

Torsion	Max 1°/m
Radius of sharp edges	Sharp edges, radius tolerance ≤ 0.2 mm
Hardness	Steels with hardness exceeding 245 HB must be previously annealed
Manufacturing times	40÷60 days
Product certificate	Compliant with EN 10204
Minimum batch size	5 tons.
Weight tolerance with respect with the ordered amount	$\pm 20\%$ up to 5 tons. $\pm 10\%$ > 5 tons.