



S355ML

Fine-grain structural steels,
thermomechanically-rolled

Material no.	1.8834
analogic	DIN EN 10025-4
Tensile strength class	B

General

The series of thermomechanically-rolled fine-grain structural steels is characterised by good weldability and high resistance to brittle cracking. They are used above all for highly stressed welded structures in the construction of bridges and steel structures.

The cryogenic grades S...ML are available for special applications at temperatures below -20 °C.

The user of these steel grades must make sure that his calculation, design and processing methods are appropriate for the material. The welding technique used must be suitable for the intended application and comply with the state-of-the-art.

The steel grades of this series offer excellent cold-forming properties. Cold-bordering, cold-flanging, coldbending and cold-folding are possible.

Chemical composition¹⁾ (in percent by weight)

	min. in %	max. in %
C		0.14
Si		0.50
Mn		1.60
P		0.025
S		0.020 ²⁾
N		0.015
Al _{total}	0.02 ³⁾	
Nb		0.05
V		0.10
Ti		0.05
Cr		0.30
Ni		0.50
Mo		0.10
Cu		0.55 ⁴⁾
C _{EV}		0.39 ⁵⁾

1) Heat analysis

2) A sulphur content of 0.010 % max. can be agreed in the order or all products (e. g. railway construction).

3) The minimum value for the Al_{total} content shall not apply if the steel contains sufficient quantities of nitrogen-fixing elements.

4) Copper contents higher than 0.40 % can cause exfoliation corrosion.

5) Max. carbon equivalent value:

$$C_{EV} = C + Mn/6 + (Cr + Mo + V)/5 + (Cu + Ni)/15.$$

Tensile strength R_m in MPa

470 – 630

Total elongation A₇ in %

≥ 22

Temperature in °C

Temperature in °C	Notch impact energy ⁸⁾ in J	
	longitud.	transverse

+ 20	≥ 63	≥ 40
0	≥ 55	≥ 34
- 10	≥ 51	≥ 30
- 20	≥ 47	≥ 27
- 30	≥ 40	≥ 23
- 40	≥ 31	≥ 20
- 50	≥ 27	≥ 16

The samples for the tensile test are taken at right angles to rolling direction unless the product width is opposed to this.

6) The tensile test values given in the table to longitudinal samples; in case of strip and sheet steel of widths of ≥ 600 mm they apply to transverse samples.

7) The values for product thicknesses < 3 mm have to be agreed at the moment of the inquiry or the order.

8) Average values of 3 samples; one individual value may fall short of the required minimum value by not more than 30 %. The sample width shall equal the product thickness if the latter is between 5 and 10 mm, the tests being performed using samples which are similar to Charpy-V samples. The values specified in the table above are to be reduced proportionally to the sample width.

Mechanical properties⁶⁾

Nom. thick. e in mm	Yield strength R _{eH} in MPa
≤ 16	≥ 355
> 16	≥ 345

Bending radius

Bending axis	Bending radius
transversely	2 x nominal thickness
longitudinal	2.5 x nominal thickness



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Available dimensions

Hot-rolled coils unpickled, mill edge

Thickness in mm	Width in mm
2.00 - 2.24	900 - 1,400
2.25 - 2.49	900 - 1,450
2.50 - 2.99	900 - 1,500
3.00 - 3.99	900 - 1,680
4.00 - 4.99	900 - 1,750
5.00 - 19.99	900 - 1,900

Thicknesses \leq 25 mm on request.

Widths \leq 2,000 mm on request.

Hot-rolled coils pickled, mill edge

Thickness in mm	Width in mm
2.00 - 2.24	900 - 1,400
2.25 - 2.49	900 - 1,450
2.50 - 2.99	900 - 1,500
3.00 - 3.99	900 - 1,680
4.00 - 6.00	900 - 1,750
6.01 - 12.70	900 - 1,900
6.00 - 12.49	900 - 1,530

Hot-rolled coils pickled, trimmed edge

Thickness in mm	Width in mm
2.00 - 2.24	900 - 1,380
2.25 - 2.49	900 - 1,430
2.50 - 2.99	900 - 1,480
3.00 - 3.99	900 - 1,660
4.00 - 4.99	900 - 1,730
5.00 - 5.99	900 - 1,880
6.00 - 6.99	900 - 1,510

Hot-rolled coils, slit lengthwise

Thickness in mm	Width in mm
2.00 - 2.24	100 - 690
2.25 - 2.49	100 - 715
2.50 - 2.99	100 - 740
3.00 - 4.60	100 - 800
4.61 - 6.00	116 - 800
6.01 - 7.00	175 - 800
7.01 - 8.00	233 - 800

Widths $<$ 100 mm on request

Welding

The fine-grain structural steel grades of this series can be perfectly welded both manually and using automatic equipment by means of all known welding processes, not least due to their reduced carbon content and the low carbon equivalent value.

In general, pre-heating prior to welding is not necessary due to the low tendency to cold-cracking. However, the quality of the weld joint depends on the welding process, the welding conditions and the selection of the correct filler metals. Gas welding should not be used.

The welding wires and electrodes approved in this strength category must be used as filler metals. Basic coated electrodes are recommended for manual welding.

These fine-grain structural steel grades are not suitable for heat treatment above 580 °C. Stress relief annealing (530 - 580 °C) is required only if called for in the regulations or if manufacturing conditions make a reduction of the residual welding stresses appear useful. The holding time should be between 30 and 60 minutes.

Condition of delivery, scope of testing and certificate

The provisions of DIN EN 10025-4 shall apply for delivery and inspection, chapters 6.3 and 8. The products are thermomechanically-rolled and delivered.

Test certificates according to DIN EN 10204 can be supplied as follows: EDP, remote data transmission, fax, e-mail, paper.

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