



# Drawn and ground round steel bars

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Revision 08/2014



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## DIMENSIONS (DIAMETER)

10 up to 40 mm, tolerances according to DIN EN 10278, IT 6 or higher

## LENGTHS AND LENGTH TOLERANCES BRIGHT STEEL, DRAWN OR GROUND

Production lengths	4500 up to 6500 mm $\pm$ 500 mm Other lengths upon agreement
Stock lengths	3000 mm -0, +200 mm 6000 mm -0, +200 mm
Precision lengths	3000 up to 6500 mm with tolerances +/- 100 mm up to +/- 5 mm upon agreement Lengths up to 7000 mm and smaller lengths tolerances upon agreement Other bar lengths from 800 up to 7200 mm on request

## BAR END FINISHING

Sheared (standard)

Chamfered, flattened, chamfered and flattened, on one or on both sides

Definition of the chamfer:

- chamfer angle: 30°, 45°, 60°
- chamfer eccentricity: max. 0.2 mm
- chamfer width: max. 10 mm

## STRAIGHTNESS

10 to 18 mm max. 1.0 mm/m  
> 18 mm max. 0.5 mm/m

Smaller tolerances upon agreement

## TECHNICAL TERMS OF SUPPLY

According to DIN EN 10277-1 -5

Bright steel products

## GRADES

Steel grades are supplied according to following standards:

DIN EN 10277-1 -5	Bright steel products
EN 10016-1 -4	Non-alloy steel for drawing and/or cold rolling
EN 10025-1 -6	Hot rolled products of structural steels
EN 10083-1 -3	Steels for quenching and tempering
EN 10084	Case hardening steels
EN 10085	Nitriding steel
EN 10087	Free cutting steels
EN 10089	Hot rolled steels for quenched and tempered springs
EN 10113	Hot-rolled products in weldable fine grain structural steels
EN 10263	Steel rod, bars and wire for cold heading and cold extrusion
EN 10269	Steels and nickel alloys for fasteners with specified elevated and/or low temperature properties
EN 10273	Hot rolled weldable steel bars for pressure purposes with specified elevated temperature properties
DIN 17212	Flame and Induction Hardening Steels

Other grades upon agreement, even modified and/or without standard.  
Electromagnetically stirred steel (mould stirring) is supplied on request.



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## QUALITY TESTS

Surface defects	Eddy-current testing (8 up to 80 mm), bars only Defect detection: Depth $\geq 0.2$ mm Length $\geq 10.0$ mm 100 % visual inspection (8 up to 80 mm)
Core defects and near-surface defects	Supersonic test ( $\geq 18$ mm) Defect detection: Diameter $\geq 0.7$ mm Length $\geq 10.0$ mm The probe-to-specimen contact occurs with water and corrosion inhibiting additives.
Identity control	Spectroscopy Spark test Eddy-current testing

## ACCEPTANCE, TEST CERTIFICATES

Test certificates according to EN 10204
Acceptance by institutions like TÜV; Germanischer Lloyd; SGS; Lloyd's Register of Shipping; Deutsche Bahn AG

## WEIGHTS

Bars (in bundles): 1000 up to 2000 kg
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## CONSERVATION

Temporary protection against corrosion through slushing oil
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## BINDING, PACKAGING

Binding	with steel strap 32 x 0.8 mm with PE foil or crêpe-paper underneath
Packaging	- PE-foil, crêpe-paper and fibre-reinforced, crack resistant foil - in crates
Packaging upon agreement only	

## LABELLING

Each bundle has two labels with the following data: customer, order number, bundle number, steel grade, state of supply, heat number, diameter, tolerance, length (only for bars), weight.
Different data upon agreement.
Colour-marking of bar end faces upon agreement.