

DILLIMAX 690 T

HIGH-STRENGTH STRUCTURAL STEEL (QUENCHED AND TEMPERED)

— **DILLIMAX 690** is a high strength quenched and tempered, fine grained structural steel with a minimum yield strength of 690 MPa in its delivery condition (referring to the lowest thickness range). Its mechanical properties are achieved by water quenching followed by tempering.

— **DILLIMAX 690** is preferentially used for welded steel structures within mechanical constructions, plant constructions and structural steel works, such as machines for structural engineering, conveying plants, hoists, cranes, flood gates, bridges and frameworks.

Product description

— **Designation and range of application:**

DILLIMAX 690 can be delivered in three qualities:

→ **DILLIMAX 690 B**

Steel number 1.8931 - S690Q according to EN 10025-6 with minimum impact values down to -20 °C

→ **DILLIMAX 690 T**

Steel number 1.8928 - S690QL according to EN 10025-6 with minimum impact values down to -40 °C

→ **DILLIMAX 690 E**

Steel number 1.8988 - S690QL1 according to EN 10025-6 with minimum impact values down to -60 °C

— **DILLIMAX 690** can be delivered as basic grade (B)

or tough grade (T) in thicknesses from 6 to 250 mm, as extra tough grade (E) in thicknesses from 6 to 200 mm according to the dimensional program. Dimensions, which deviate from the usual dimensional program, may be possible on request.

— **DILLIMAX 690** fulfils the requirements of EN 10025-6.

Chemical composition & delivery conditions

Th. (mm)	C	Si	Mn	P	S	Cr	Ni	Mo	B	V + Nb
≤ 200	≤ 0.20	≤ 0.50	≤ 1.60	≤ 0.020	≤ 0.010	≤ 1.50	≤ 1.80	≤ 0.60	≤ 0.004	≤ 0.10
> 200	≤ 0.18	≤ 0.50	≤ 1.60	≤ 0.020	≤ 0.010	≤ 1.50	≤ 2.60	≤ 0.10	≤ 0.004	≤ 0.10

The steel is fine grained through sufficient aluminium content.

— The limiting CEV³⁾ values are lower than the values given in EN 10025-6:

Plate thickness (mm)	C	Si
th. ≤ 25	0.50	0.65
25 < th. ≤ 50	0.55	0.65
50 < th. ≤ 100	0.67	0.77
100 < th. ≤ 150	0.75	0.83
50 < th. ≤ 250	0.78	

Lower carbon equivalent values may be agreed on request.

— **Surface quality**

Unless otherwise agreed, the specifications will be in accordance with EN 10163-2, class A2.

— **Supply conditions:**

Water quenched and tempered according to EN 10025-6.

— Unless otherwise agreed, the general technical delivery requirements in accordance with EN 10021 apply.

— **Tolerances:**

Unless otherwise agreed, the tolerances will be in accordance with EN 10029, with class A for thickness and table 4, steel group H, for the maximum flatness deviation. Smaller flatness deviations may be possible on request prior to order.

Mechanical properties in delivery condition

— Tensile test at ambient temperature

Thickness (mm)	Ys (MPa)	UTS (MPa)	E (%)	Kv -40 °C (J)
≤ 65	690	770 - 940	14	30/27
> 65 - ≤ 100	670	770 - 940	14	30/27
> 100 - ≤ 150	630	720 - 900	14	30/27
> 150 - ≤ 200	610	700 - 880	14	30/27
> 200 - ≤ 250	600	690 - 870	14	30/27

— Testing

Tensile and impact tests will be performed according to EN 10025-6 once per heat and 40 t. Tests on every heat treated plate may be possible on request. The test pieces are taken and prepared according to part 1 and 6 of EN 10025.

The tensile test is carried out on specimens of gauge length $L_0 = 5.65 \cdot \sqrt{S_0}$ respectively $L_0 = 5 \cdot d_0$, in accordance with EN ISO 6892- 1. Tensile tests according to ASTM A370 may be agreed. The impact test will be carried out on Charpy-V-specimens in accordance with EN ISO 148-1 using a 2 mm striker. Unless otherwise agreed, the test will be performed at the lowest temperature of the corresponding quality on transverse test pieces.

Unless otherwise agreed, the test results are documented in an inspection certificate 3.1 in accordance with EN 10204.

— Identification of plates

Unless otherwise agreed, the marking is carried out via steel stamps with at least the following information:

- steel grade (e.g. **DILLIMAX 690 B, T or E**);
- heat number;
- number of mother plate and individual plate;
- the manufacturer's symbol;
- authorized inspection representative's sign.

Processing

— The entire processing and application techniques are of fundamental importance to the reliability of products made from this steel. The user should ensure that his design, construction and processing methods are aligned with the material, correspond to the state-of-the-art that the fabricator has to comply with and are suitable for the intended use. The customer is responsible for the selection of the material.

— The recommendations of the EN 1011-2 (Welding) and CEN/TR 10347 (Forming) as well as recommendations regarding job safety in accordance with national rules should be observed.

— Hot forming

If the temperature of 560 °C is exceeded, the initial tempering will be altered so that the mechanical properties are affected.

To regain the initial properties new quenching and tempering become necessary. However, water quenching of a formed workpiece or component will often be less effective than the original quenching in the plate mill so that the fabricator may not be able to reestablish the properties required and therefore hot forming may not be suitable. In this respect we recommend you to contact the steel producer prior to ordering, in all cases where hot forming is required.

Finally, it is the fabricator's responsibility to obtain the required values of the steel through an appropriate heat treatment.

— Cold forming

Cold forming means forming below the maximum allowable stress relief temperature (560 °C). **DILLIMAX 690** can be cold formed with regard to its high yield strength. Flame cut or sheared edges in the bending area should be ground before cold forming. Cold forming is related to a hardening of the steel and to a decrease in toughness. Some codes may limit the maximum permissible strain during cold forming. Depending on the relevant code this can result in the need of larger bending radiuses than indicated in the chart. For larger cold forming amounts we recommend you to consult the steel producer prior to ordering.

During the processing, the necessary safety measures have to be taken, so that nobody will be exposed to a danger by a possible fracture of the work piece during the forming process.

The following geometries can usually be achieved by cold forming without the formation of surface defects (where t is the plate thickness):

Thickness (mm)	Min. bending radius	Min. die width
Transverse direction	2 × th.	7 × th.
Longitudinal direction	3 × th.	9 × th.

— **Welding and flame cutting:**

Due to its high yield strength, **DILLIMAX 690** requires special care during plate processing. For flame cutting, the following minimum preheating temperatures are recommended : 25 °C for plate thickness up to 20 mm, 50 °C for plate thickness up to 50 mm, 100 °C for plate thickness up to 100 mm, 150 °C for plate thickness up to 200 mm and 180 °C for thicker plates.

For general welding instructions, please consult the EN 1011. In order to ensure that the tensile strength of the weld metal fulfils the requirements of the base metal, the heat input and interpass temperature must be limited during welding. Experience has shown that the welding conditions should be chosen so that the cooling time $t_{8/5}$ does not exceed 20 seconds. This is applicable when using suitable filler materials of a corresponding yield strength class.

The high yield strength of the base material must be taken into account when choosing the filler materials. It should be considered that increased heat input leads to lower tensile properties in the weld metal. If a stress relieving heat treatment is planned during or after plate processing, this must also be considered when selecting the filler materials. To avoid hydrogen-induced cold cracking, only filler materials, which add very little hydrogen to the base metal, may be used. Therefore, shielded arc welding should be preferred.

For manual arc welding, electrodes with basic coating (type HD < 5 ml / 100 g in accordance with ISO 3690), and dried according to the manufacturer's instructions, should be used.

— **Heat treatment:**

If a stress relieving has to be considered because of constructional regulations, constructive reasons or because it is necessary for the fabrication, please consult us. The properties of structural components can be altered by a stress relief heat treatment.

General note

— If further informations are required, please request a copy of our technical guide.

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