

Technical delivery conditions

valid from 01.04.2022

I. Plate surfaces

1. Shot blasted surfaces: We point out the fact that if shot blasted plates, but not primed, are ordered, the customer may count with rusty surfaces. We cannot defray the damages / costs caused by rust.
If shot blasted surfaces are ordered, we supply shot blasted surfaces according to SA 2,5.
2. As our plates are, unless otherwise agreed, not packaged, the surfaces are not protected from damages during transportation.

II. Material properties and fabrication

1. Dillinger verifies and certifies that the delivered plates fulfill the requirements of the order (according to EN 10204). The certificate refers to the date of dispatch of the plate. For the further processing at the customer's site, it is necessary to meet certain requirements, this falls to the responsibility of the customer. [Example: the hardness in the heat-affected zone (HAZ) or the weld falls into the responsibility of the fabricator who has to choose the welding parameters, the filler metal as well as the post weld heat treatment parameters.]]
2. We do not take any guarantee either for the mechanical or the HIC-/SSC-properties of the plates after any forming or heat treatment by our customer, as far as we have no influence on the process parameters.

III. Testing and Inspection documents

1. If testing per plate, without further specification, is demanded, testing per each plate-as-rolled (each parent plate) is agreed (for quenched & tempered plates: each plate-as-heat treated).
2. Ultrasonic testing and Ultrasonic reports: we don't establish a separate report for Ultrasonic testing, but we certify the UT criteria and the level of the UT-inspector in the mill certificate. As for ultrasonic testing according to ASTM/ASME A/SA 435/577/578, the UT-personnel is qualified in accordance with ASNT-TC-1A or an equivalent standard (i.e. ISO 9712). Operator's qualifications can be shown for inspection in our test house, but we decline to send copies of the operator's qualifications.
3. If requirements to the chemical composition, without further specification, are demanded, it is agreed that they apply per heat analysis.
4. A product analysis will only be conducted, if it is required by the material standard or explicitly ordered.
5. Certificates are usually sent within 1-3 working days after the dispatch of the plates from the plate mill. Before dispatch of the plates, no certificates will be send for approval.
6. "Free access" to production or test units can be granted in individual cases only under the condition that neither our knowhow nor the health & safety of the delegate of the customer are affected.
7. Unless otherwise agreed or requested, we are free to carry out a simulated heat treatment on a sample from the production batch, similar to the heat treatment that would be carried out on the plates of this batch, in accordance with the specification. The results of the tests carried out on these heat-treated samples may, if they comply with the specifications, be used to release the plates belonging to the same production batch and having undergone a heat treatment with identical parameters.
8. If not otherwise agreed, the rules for retesting, sorting and reprocessing in the 2013 edition of ISO 404 which are identical to the 2006 edition of EN 10021 apply.

IV. Longitudinally profiled plates

Regarding tolerances on the nominal thickness the class A is generally agreed (compare EN 10029). The respective tolerance for the maximum thickness of the plate applies to the whole plate.

V. Cut-to-shape plates

(apart from rectangular plates)

1. All chapters of these Technical delivery conditions, except clause IV. also apply for cut-to-shape plates.
2. If not otherwise agreed, cutting tolerances acc. to ISO 9013-442 apply.
3. In case of shotblasted surfaces, the shot blasting will be applied on the original plates.

VI. Marking

1. Dillinger heavy plates bear as standard a punched marking applied using the low stress dot-matrix technique, and / or paint markings.
2. The marking of the die stamp is carried out either [i] by one dot on the left and on the right or [ii] by encircling it with white paint.
3. The location of the stamping and the paint marking including identification paint for the stamping are chosen as per mill practice. The orientation of the paint marking will be parallel to the rolling direction. The die stamping will be transverse to the rolling direction.

VII. Test coupons

If the customer needs test coupons for own tests, plates with overlength need to be ordered and the customer needs to extract the test coupons from the overlength. The ordered plates with overlength need to be checked by Dillinger with respect to deliverable dimensions.

VIII. Decision rules for conformity assessment

According to ISO/IEC 17025:2017, accredited testing laboratories are required to define and apply decision rules for conformity assessment (release) and to report them to the customer.

DILLINGER's decision rule for conformity assessment is that the release of the product is granted unconditionally if the determined results of measurements and tests meet the contractually agreed requirements. This means that the agreed acceptance limits are not adjusted by the measurement uncertainty budget.

Decision rules for conformity assessment given in standards, specifications or customer's documents are applied if and in the way they are agreed in the respective contract.

IX. Quality assurance

Due to our quality assurance system (handwritten) modifications or additions to specifications can only be accepted, if the number of revision is adjusted.