

For Cold rolled stainless steel the old BS1449 standard has been replaced by two EN Standards:

EN10088-2 Replaces BS1449-Part 2: 1983

EN10059 - Covers Heat Resisting Grades

EN10259 & Now ISO 9445: Tolerances for COLD Rolled material

MATERIAL CERTIFICATION

Where multi-certification is required, a combination of EN10088-2, EN10029 or 10051 will appear together with the appropriate ASTM Standards.

THICKNESS TOLERANCES - EN10259

| Thickness (mm) | Tols (+/- mm) for given width in mm | Tols (+/- mm) for given width in mm | Tols (+/- mm) for given width in mm |
|----------------|-------------------------------------|-------------------------------------|-------------------------------------|
| | 1000 | 1250 | 1500 |
| Under 0.30 | 0.03 | - | - |
| 0.30 to 0.49 | 0.04 | 0.04 | - |
| 0.50 to 0.59 | 0.045 | 0.05 | - |
| 0.6 to 0.79 | 0.05 | 0.05 | - |
| 0.8 to 0.99 | 0.055 | 0.06 | 0.06 |
| 1.0 to 1.19 | 0.06 | 0.07 | 0.07 |
| 1.2 to 1.49 | 0.07 | 0.08 | 0.08 |
| 1.5 to 1.99 | 0.08 | 0.09 | 0.10 |
| 2.0 to 2.49 | 0.09 | 0.10 | 0.11 |
| 2.5 to 2.99 | 0.11 | 0.12 | 0.12 |
| 3.0 to 3.99 | 0.13 | 0.14 | 0.14 |

FLATNESS TOLERANCES

| Nominal Length (L) (mm) | Normal Tolerance (mm) |
|-------------------------|-----------------------|
| Up to 3000 | 10 |
| Over 3000 | 12 |

LENGTH TOLERANCES

| Nominal Length (L) (mm) | Normal Tolerance (mm) |
|-------------------------|-----------------------|
| Up to 2000 | +5 / -0 |
| Over 2000 | +0.0025 x L / -0 |

WIDTH TOLERANCES

| Thickness (mm) | All Plus Tols (mm) for Given Width in (mm) | All Plus Tols (mm) for Given Width in (mm) |
|----------------|--------------------------------------------|--------------------------------------------|
| | 1000 | 1250 & 1500 |
| Under 1.5 | +1.5 | +2.0 |
| 1.5 to 2.49 | +2.0 | +2.5 |
| 2.5 to 3.49 | +3.0 | +3.0 |
| 3.5 and Over | +4.0 | +4.0 |

FINISHES ACCORDING TO BS EN 10088-2 / 10028-7

| BS EN Finish | Old BS Finish | Description |
|--------------|---------------|--------------------------------------------------|
| | | Hot Rolled |
| 1C | 0 | Hot rolled, heat treated, not descaled |
| 1E | 1 | Hot rolled, heat treated, mechanically descaled |
| 1D | 1 | Hot Rolled, heat treated, pickled |
| 1U | - | Hot rolled, not heat treated, not descaled |
| | | Cold Rolled |
| 2C | - | Cold rolled, heat treated, not descaled |
| 2E | - | Cold rolled, heat treated, mechanically descaled |
| 2D | 2D | Cold Rolled, heat treated, pickled |
| 2B | 2B | Cold Rolled, heat treated, pickled, skin passed |
| 2R | 2A / (BA) | Cold Rolled bright annealed |
| 2Q | - | Cold Rolled, hardened & tempered, scale free |

FINISHES ACCORDING TO BS EN 10088-2 / 10028-7

*NOTE: Special finishes indicate hot rolled (1) and cold rolled (2) sheets, e.g.: Ground polished hot rolled sheets + 1G / Ground polished cold rolled sheets = 2G

For more information on stainless steel finishes please refer to the AALco technical datasheet on this subject.

| BS EN Finish | Old BS Finish | Special Finishes - Description | Typical Grit | Typical Ra |
|--------------|---------------|--------------------------------------------------------------------------|--------------|------------|
| 1G or 2G | - | Ground Grit | 120 | 2.5 to 2.0 |
| 1J or 2J | 3B | Brushed - Unidirectional | 180 | 1.2 to 1.0 |
| 1J or 2J | 4 | Dull Polished - Unidirectional | 240 | 0.6 |
| 1K or 2K | 5 | Satin Polished - Unidirectional | 320 | 0.5 Max |
| 1P or 2P | 7 | Bright Polished - Non-Directional with a high degree of image clarity | 600 | 0.1 |
| 1P or 2P | 8 | Mirror Finish - Non-Directional with a very high degree of image clarity | 800 | 0.05 |
| 1M or 2M | - | Patterned | | |
| 2L | - | Coloured | | |
| 2W | - | Corrugated | | |
| 1S or 2S | - | Surface Coated (Metallic coatings such as tin, lead or aluminium) | | |

CONTACT

Address: Please make contact directly with your local service centre, which can be found via the Locations page of our web site
Web: www.aalco.co.uk

REVISION HISTORY

Datasheet Updated 18 July 2019

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