

For Hot Rolled stainless steel the old BS1449 and BS1501 standards have been replaced by EN Standards:

EN10088-2 Replaces BS1449-Part 2: 1983

EN10028-7 Replaces BS1501-Part 3: 1990

EN10095 Covers Heat Resisting Grades

EN10259 & ISO 9445: Tolerances for COLD Rolled material (Sheets, plate, coil) up to 6.5mm thick

EN10029 & ISO 18286: Tolerances for 'Quarto' Hot Rolled Plate 3mm thick and above

EN10051 & Now ISO 9445 / 9444: Tolerances for Continuously Produced (CPP) Hot Rolled Plate

FLATNESS - QUARTO PLATE

Thickness (mm)	Tols (mm) over Given Length (mm)	Tols (mm) over Given Length (mm)
	1000	2000
3 to 4.9	9	14
5 to 7.9	8	12
8 to 14.9	7	11
15 to 24.9	7	10
25 to 39	6	9
40 to 250	5	8

LENGTH - QUARTO PLATE

Length (mm)	Tolerance in (mm)	Tolerance in (mm)
Under 4000	-0	+20
4000 to 5999	-0	+30
6000 to 7999	-0	+40

WIDTH - QUARTO PLATE

Nominal Thickness (mm)	Tolerance (mm)	Tolerance (mm)
Up to 40	-0	+20
40 to 150	-0	+25
150 to 400	-0	+30

THICKNESS - QUARTO PLATE

Thickness (mm)	Tolerance (mm) CLASS B	Tolerance (mm) CLASS B
	Minus	Plus
3 to 4.9	0.3	0.7
5 to 7.9	0.3	0.9
8 to 14.9	0.3	1.1
15 to 24.9	0.3	1.3
25 to 39.9	0.3	1.7
40 to 79.9	0.3	2.3
80 to 149	0.3	2.9
150 to 250	0.3	3.3

FLATNESS - CPP

For CPP there are 3 categories of tolerances according to the grade where:

B = Ferritic and Martensitic Grades

C = Austenitic Grades without Mo

D = Austenitic Grades with Mo

* These flatness tolerances only apply for thicknesses up to 25mm

** To be agreed at the time of enquiry and order

Width (mm)	Tols* for given category		
	B	C	D**
Up to 1200	18	23	**
1200 to 1500	23	30	**
Over 1500	28	38	**

LENGTH - CPP

Length (mm)	Tolerance (mm)	Tolerance (mm)
Under 2000	-0	+20
2000 to 7999	-0	0.05 x Length

WIDTH - CPP

Length (mm)	Plus Tols (mm) (-0)	Plus Tols (mm) (-0)
Up to 1200	+20	+3
1201 to 1850	+20	+5
Over 1850	+25	+6

THICKNESS - CPP

These figures must be increased for stainless steel by:
15% for Ferritic & Martensitic
30% for Austenitic
40% for Moly Grades

Thickness (mm)	Tols +/- (mm) for given width	Tols +/- (mm) for given width	Tols +/- (mm) for given width	Tols +/- (mm) for given width
	Up to 1200	1201 to 1500	1501 to 1800	Over 1800
Up to 2.0	0.17	0.19	0.21	-
2.01 to 2.5	0.18	0.21	0.23	0.25
2.51 to 3.0	0.20	0.22	0.24	0.26
3.01 to 4.0	0.22	0.24	0.26	0.27
4.01 to 5.0	0.24	0.26	0.28	0.29
5.01 to 6.0	0.26	0.28	0.29	0.31
6.01 to 8.0	0.29	0.30	0.31	0.35
8.01 to 10.0	0.32	0.33	0.34	0.40
10.01 to 12.50	0.35	0.36	0.37	0.43
12.51 to 15.0	0.37	0.38	0.40	0.46
15.01 to 25.0	0.40	0.42	0.45	0.50

WIDTH - CPP

TOLERANCES

For Cold Rolled Plate please refer to the datasheet on cold rolled

Note that in this Datasheet there are two sets of tolerances tables – One set for Quarto Plate to EN10029 and one set for CPP plate to EN10051

For CPP there are 3 categories of tolerances according to the grade where:

B = Ferritic & Martensitic Grades

C = Austenitic Grades without Mo

D = Austenitic Grades with Mo

MATERIAL CERTIFICATION

Where multi-certification is required, a combination of EN10088-2, EN10028-7, EN10029 or 10051 will appear together with the appropriate ASTM Standards.

CONTACT

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REVISION HISTORY

Datasheet Updated	18 July 2019
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