



TECHNICAL SHEET



HIGH TENSILE ROUND BARS

Definition

The cold drawn bars (solid bars) are a cold worked product without metal removal, therefore it can show some surface defect. Cold drawn bars always shows some residual hard work, so it cannot be used for applications where maximum softening is required.

Steel grade and Specification CAS EC700 CAS EC800

303/1: EN 10088/3 Grade 1.4305–C700/C800; BS 6105 Grade A1 cl.70/80.
F304; F304L: EN 10088/3 Grade 1.4301–C700/C800; BS 6105 Grade A2 cl.70/80.
F316; F316L: EN 10088/3 Grade 1.4401/4404–C700/C800–BS 6105 Grade A4 cl.70/80.
321/3: EN 10088/3 Grade 1.4541–C700/C800
316T/1: EN 10088/3 Grade 1.4571–C700/C800–BS 6105 Grade A4 cl.70/80.

Steel grade and Specification CAS ACL2

303/1: ASTM A320 Grade B8F CL. 2.
F304; F304L: ASTM A193 Grade B8 CL. 2; ASTM A320 Grade B8 CL. 2.
F316; F316L: ASTM A193 Grade B8M CL. 2; ASTM A320 Grade B8M CL. 2.
321/3: ASTM A193 Grade B8T CL. 2; ASTM A320 Grade B8T CL. 2.
316T/1: ASTM A193 Grade B8M CL. 2; ASTM A320 Grade B8M CL. 2.

Diameters and Size Tolerances

<i>Diameter</i>	<i>Tolerance *</i>	<i>Ovalization</i>
5 - 60	h9 - h10 -h11	1/3 of the tolerance

* Other tolerance available on request

Lengths and Tolerances

<i>Diameter **</i>	<i>Length</i>	<i>Tolerance STD</i>	<i>Tolerance Extra STD</i>	<i>Short bars</i>
5,00÷8,00	3 m	+100 - 0	On request	10 %
8,01÷60,00	3- 4 - 6 m	+200 - 0	On request	10 %

** Diameter in Inches are available.

Other characteristics

<i>Diameters</i>	<i>Roughness</i>	<i>Straightness</i>	<i>End bars</i>
STD	3 Ra	1 ‰	2 Square sheared
Extra STD	3 Ra	1 ‰	1 Chamfer 45° 1 Square sheared

**** Double chamfering is available upon request

Surface defects

<i>Diameter</i>	<i>Depth of the defect</i>	<i>Minimum removal for zero defect</i>
≤ 20	Max 0,2 mm	
>20 ≤ 60	Max 0,01 x D	

Defects such as pittings and drawing scratchings are not included. As extra STD it can be required "0 defect". In this case the material in diamension range 20 to 60 mm will be previously peeled

Packaging

Bundle Kg 500 for diam up to 25, lage diam 1000 Kg
 Plastic cardboard and containing caps at the ends ES2
 Wooden box if required code COGNE ES3