

## TECHNICAL SHEET



## COLD DRAWN SQUARE BARS

**Definition**

Cold drawn square bars are a cold worked product without metal removal, therefore it can show some surface defect. Sizes up to 25 are drawn by wire, the bigger sizes are hot rolled in bars and drawn bar to bar.

**Steel grade :** 303/1 – F304 – F304L – F316 – F316L

**Specification :** CASE : EN 10088/3 – EN 10272 – PED 97/23/CE – ASTM

CASDW2 : ADW2 – ADW10 – AD 2000

**Size**

10 – 11 – 12 – 13 – 14 – 15 – 16 – 17 – 18 – 19 – 22 – 24

**Size tolerance**

ISO h 11 – DIN 178. Other tolerance available on request. Max IT9

**Lengths and tolerances**

| <i>Size **</i> | <i>Length</i> | <i>Tolerance STD ***</i> | <i>Tolerance Extra STD</i> | <i>Short bars</i> |
|----------------|---------------|--------------------------|----------------------------|-------------------|
| 6 ÷ 24         | 3 m           | +50 – 0                  | +25 – 0                    | 5%                |

\*\*\* Available ± 25 mm

**Other characteristics**

|           | <i>Twist</i> | <i>Straightness</i> | <i>Ends</i>                     |
|-----------|--------------|---------------------|---------------------------------|
| STD       | 4° / m       | 1,5 mm ‰            | Cold sheared                    |
| Extra STD | 4° / m       | 1 mm ‰              | 1 Chamfer 45°<br>1 Cold sheared |

**Surface defects**

| <i>Size</i> | <i>Depth of the defect</i> | <i>Corner radius</i> |
|-------------|----------------------------|----------------------|
| ≤ 15        | Max 0,30 mm                | Max 0,3 mm           |
| >15 ≤ 25    | Max 0,02 mm x d            | Max 0,5 mm           |

Defects such as pitting and drawing scratching are not included.  
Surface defects controlled by Defectomat.

**Packaging**

Bundle Kg 500 min size up to 24 – Kg 1000 size > 24 mm  
Plastic cardboard and containing caps at the ends COGNE code ES2  
Wooden box if required COGNE code ES3