

Datasheet: EN 1.4307/304L – Austenite Quarto Plates - Stainless Steel Alumeco ApS 03-12-2024					Internal alloy name:1.4307 Alloy type:Austenite Chemical Symbol:X2CrNi18-9 EN:EN 1.4307 AISI:304L UNS:S30403 SS:2352 JIS:SUS304L GB:S30403																								
Main usage: - Food and beverage industry equipment - Chemical and pharmaceutical industry equipment - Heat exchangers - Storage tanks and containers - Pipes - Flanges and valves			Important norms and literature: General Standards: EN 10088-1: List of stainless Steel Product standards: EN 10088-2: Technical delivery conditions for sheet/plate and strip of corrosion resisting steels for general purposes EN 10028-7: Flat products made of steels for pressure purposes - Part 7: Stainless steels Geometric Tolerance: EN 18286: Hot rolled stainless-steel plates -Tolerances on dimensions & shape Bending Tolerance: DIN 6935:2011-10: Cold bending of flat rolled steel Surface condition: EN 10088-2: Technical delivery conditions for sheet/plate and strip of corrosion resisting steels for general purposes																										
Main properties: - Excellent weldability - Good stability against corrosion - Good formability, both cold and hot - Resistance to intergranular corrosion (EN 10088-3)																													
Chemical composition in %: EN 10088-1 <table><tr><td>C</td><td>Si</td><td>Mn</td><td>P</td><td>S</td><td>Cr</td><td>Mo</td><td>Ni</td><td>Remarks</td><td>Rest</td></tr><tr><td>≤ 0,030</td><td>≤ 1,00</td><td>≤ 2,00</td><td>≤ 0,045</td><td>≤ 0,030*</td><td>17,5-19,5</td><td>-</td><td>8,0-10,5</td><td>N ≤ 0,10</td><td>Fe</td></tr></table> * For machinability, a controlled sulfur content of 0,015%-0,030% is recommended & permitted. For weldability a controlled sulfur content of 0,008%- 0,030% is recommended & permitted. For polishability, a controlled sulfur content of 0,015% is recommended.										C	Si	Mn	P	S	Cr	Mo	Ni	Remarks	Rest	≤ 0,030	≤ 1,00	≤ 2,00	≤ 0,045	≤ 0,030*	17,5-19,5	-	8,0-10,5	N ≤ 0,10	Fe
C	Si	Mn	P	S	Cr	Mo	Ni	Remarks	Rest																				
≤ 0,030	≤ 1,00	≤ 2,00	≤ 0,045	≤ 0,030*	17,5-19,5	-	8,0-10,5	N ≤ 0,10	Fe																				
Mechanical properties: EN 10088-3 <table><tr><td>Dim. range (mm)</td><td>Temper</td><td>Rm MPa</td><td>Rp_{0,2} MPa</td><td>Rp_{1,0} MPa</td><td>Elongation (Longitudinal) A%</td><td>Impact energy (Longitudinal) KV₂</td><td>Hardness* HB</td></tr><tr><td>15-150</td><td>Hot rolled</td><td>500 - 700</td><td>Min. 200</td><td>Min. 240</td><td>45</td><td>100</td><td>Max. 215</td></tr></table> * Information values only;										Dim. range (mm)	Temper	Rm MPa	Rp _{0,2} MPa	Rp _{1,0} MPa	Elongation (Longitudinal) A%	Impact energy (Longitudinal) KV ₂	Hardness* HB	15-150	Hot rolled	500 - 700	Min. 200	Min. 240	45	100	Max. 215				
Dim. range (mm)	Temper	Rm MPa	Rp _{0,2} MPa	Rp _{1,0} MPa	Elongation (Longitudinal) A%	Impact energy (Longitudinal) KV ₂	Hardness* HB																						
15-150	Hot rolled	500 - 700	Min. 200	Min. 240	45	100	Max. 215																						
Physical properties: <table><tr><td>Density g/cm³</td><td>Electrical resistivity Ω mm² / m</td><td>Thermal conductivity W/m K</td><td>Thermal expansion (µm m⁻¹ K⁻¹)</td><td>Specific heat (J kg⁻¹ K⁻¹)</td><td>E - modulus (N / mm²)</td><td>Magnetizable</td><td>PREN (Min.)</td></tr><tr><td>7,9</td><td>0,73</td><td>15</td><td>16,0</td><td>500</td><td>200.000</td><td>No</td><td>17,5</td></tr></table>										Density g/cm ³	Electrical resistivity Ω mm ² / m	Thermal conductivity W/m K	Thermal expansion (µm m ⁻¹ K ⁻¹)	Specific heat (J kg ⁻¹ K ⁻¹)	E - modulus (N / mm²)	Magnetizable	PREN (Min.)	7,9	0,73	15	16,0	500	200.000	No	17,5				
Density g/cm ³	Electrical resistivity Ω mm ² / m	Thermal conductivity W/m K	Thermal expansion (µm m ⁻¹ K ⁻¹)	Specific heat (J kg ⁻¹ K ⁻¹)	E - modulus (N / mm²)	Magnetizable	PREN (Min.)																						
7,9	0,73	15	16,0	500	200.000	No	17,5																						
Typical Alumeco products with this alloy Plates - Dim: 15-150 mm x Length: >1500/(2000) mm																													
Surface definition: Hot rolled (HR) – 1D <table><tr><td>Surface finish</td><td>Free of scale</td></tr><tr><td>Type of process route</td><td>Hot rolled, heat treated, pickled.</td></tr><tr><td>Notes</td><td>Usually standard for most steel types to ensure good corrosion resistance; also common finish for further processing. It is permissible for grinding marks to be present. Not as smooth as 2D or 2B.</td></tr><tr><td>Typical Roughness Ra</td><td>3,26 µm</td></tr></table>										Surface finish	Free of scale	Type of process route	Hot rolled, heat treated, pickled.	Notes	Usually standard for most steel types to ensure good corrosion resistance; also common finish for further processing. It is permissible for grinding marks to be present. Not as smooth as 2D or 2B.	Typical Roughness Ra	3,26 µm												
Surface finish	Free of scale																												
Type of process route	Hot rolled, heat treated, pickled.																												
Notes	Usually standard for most steel types to ensure good corrosion resistance; also common finish for further processing. It is permissible for grinding marks to be present. Not as smooth as 2D or 2B.																												
Typical Roughness Ra	3,26 µm																												

Tolerances for Quarto Plates for EN 1.4307:

Tolerances on thickness				
Nominal thickness t (mm)	Width w (mm)			
	$w < 2100$	$2100 \leq w < 3000$	$3000 \leq w < 3600$	$w \geq 3600$
$t < 10$	+1,15	+1,30	+2,15	-
$10 \leq t < 20$	+1,40	+1,55	+2,15	+2,30
$20 \leq t < 25$	+1,55	+1,65	+2,15	+2,55
$25 \leq t < 50$	+1,80	+1,90	+2,40	+2,95
$50 \leq t < 75$	+2,55	+2,75	+2,95	+3,15
$75 \leq t < 100$	+2,75	+2,95	+3,15	+3,35
$100 \leq t < 150$	+2,95	+3,15	+3,35	+3,55

* Values are referred from Table 1 of ISO 18286:2008

Tolerance on width and length
At the time of enquiry and purchase order, the purchaser shall specify which width and length tolerance class is applicable to the purchased material. The choice of the trimming procedure is left to the manufacturer's discretion, unless otherwise stated in the purchase order.

Tolerances on width for Class A	
Nominal width w (mm)	Tolerances
$600 \leq w < 2000$	0 +15
$2000 \leq w < 3000$	0 +20
$w \geq 3000$	0 +25

* Values are referred from Table 2 of ISO 18286:2008

Tolerances on length for Class A	
Nominal width L (mm)	Tolerances
$600 \leq L < 4000$	0 +20
$4000 \leq L < 6000$	0 +30
$6000 \leq L < 8000$	0 +40
$8000 \leq L < 10000$	0 +50
$10000 \leq L < 15000$	0 +75
$15000 \leq L \leq 20000$	0 +100

* Values are referred from Table 3 of ISO 18286:2008

Tolerances on width and length for Class B (i.e. flame-cut plate)	
Nominal thickness t (mm)	Tolerances (mm)
$t \leq 50$	0 +10
$50 < t \leq 75$	0 +13
$75 < t \leq 150$	0 +19

* Values are referred from Table 4 of ISO 18286:2008

Tolerances on width and length for Class C (i.e. abrasive-cut plate)	
Nominal thickness t (mm)	Tolerances (mm)
$t \leq 25$	3,2
$25 < t \leq 50$	4,8
$50 < t \leq 75$	6,4
$75 < t \leq 100$	7,9

* Values are referred from Table 5 of ISO 18286:2008

Normal tolerances for flatness		
Nominal thickness t (mm)	Tolerances (mm)	
	Measuring length	
	1000	2000
$4 \leq t < 5$	9	14
$5 \leq t < 8$	8	12
$8 \leq t < 15$	7	10
$15 \leq t < 25$	7	10
$25 \leq t < 40$	6	9
$40 \leq t \leq 250$	5	8

* Values are referred from Table 6 of ISO 18286:2008

Cold bending of flat rolled steel according to DIN 6935:2011																									
To obtain uniform bends on bending rails, it is recommended that only bending radii from the series below be selected. The values printed in bold are to be preferred. (Dimensions in millimetres)																									
<i>r</i>	1	1,2	1,6	2	2,5	3	4	5	6	8	10	12	16	20	25	28	32	36	40	45	50	63	80	100	

* Values are referred from DIN 6935:2011-10

Minimum permissible bending radius r according to DIN 6935:2011																
Steel Grades	For bending transverse or parallel to the rolling direction	Minimum permissible bending radius r for thicknesses s (mm)														
		s	1	1,5	2,5	3	4	5	6	7	8	10	12	14	16	18
		$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	
		1	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	$\leq$	
		1	1,5	2,5	3	4	5	6	7	8	10	12	14	16	18	20
S 355 J2	Transverse	1,6	2,5	4	5	6	8	10	12	16	20	25	32	36	45	50
	Parallel	1,6	1,6	4	5	8	10	12	16	20	25	32	36	40	50	63

* Values are referred from Table 1 of DIN 6935:2011-10 (S = Structural; XXX = Min. yield strength in MPa; J2 = Steel sub-grade).

Permissible deviations for minimum bending radii r according to DIN 6935:2011			
Steel Grades	Permissible deviations for minimum bending radii r for thicknesses s		
	≤ 3	$3 < s \leq 8$	$8 < s \leq 20$
S 355 JR	+1 0	+2 0	+3 0

* Values are referred from Table 2 of DIN 6935:2011-10