
Structural steels —

**Part 3:
Technical delivery conditions for fine-
grain structural steels**

Aciers de construction —

*Partie 3: Conditions techniques de livraison pour aciers de
construction à grains fins*

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Published in Switzerland

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 17, Steel, Subcommittee SC 3, Steel for structural purposes.

This second edition cancels and replaces the first edition (ISO 630-3:2012), which has been technically revised. The main changes compared to the previous edition are as follows:

- grades S390N, S390M, S500M and pertaining requirements have been added;
- applicable thickness ranges have been added in the scope;
- additional terms and definitions concerning heat treatments have been deleted because ISO 4885 is in normative references of ISO 630-1;
- quality E has been renamed L (impact testing at -50 °C) to keep quality E for impact testing at -40 °C in all parts;
- quality E (impact testing at -40 °C) has been added
- quality F (impact testing at -60 °C) has been added to S355N and S355M;
- list of options has been integrated in ISO 630-1;
- the formula for CEV has been deleted because given in ISO 630-1;
- test units have been updated;
- in Tables, the designation concerning thickness have been changed into “nominal thickness”;
- order of listing chemical elements has been updated for grades of [Annex A](#) in accordance with ISO 6306;
- bibliography has been updated;
- the content of the document has been updated to harmonize with all parts of ISO 630.

A list of all parts in the ISO 630 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

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Structural steels —

Part 3:

Technical delivery conditions for fine-grain structural steels

1 Scope

This document specifies requirements for flat and long products of hot-rolled weldable fine-grain structural steels in the as-rolled (for SG grades only), normalized/normalized rolled and thermomechanical processed delivery conditions. It applies to steel plates rolled on a reversing mill, wide flats, hot-rolled sections and bars, which are intended for use in heavily loaded parts of welded or bolted structures.

This document covers 13 grades and 6 qualities. Grades S275, S355, S390, S420, S460 and S500 are covered in [Annex A](#). Grades SG245, SG290, SG325, SG345, SG365, SG415 and SG460 are covered in [Annex B](#). Not all grades are available in all qualities, and some qualities have Charpy V-notch requirements.

The steels specified in this document are applicable to hot-rolled plates, wide flats, sections and bars with a minimum nominal thickness of 3 mm and a maximum nominal thickness of 250 mm for grades S275N, S355N, S390N, S420N and S460N, a maximum nominal thickness of 150 mm for grades S275M, S355M, S390M, S420M, S460M, and S500M, a maximum nominal thickness of 200 mm for grades SG245, SG325 and SG415, a maximum nominal thickness of 100 mm for grades SG345, SG365 and SG460, and a maximum nominal thickness of 40 mm for grade SG290.

This document does not include the following structural steels, some of which are covered by other International Standards:

- Sheet and strip — refer to ISO TC 17/SC 12, *Continuous mill flat rolled products*;
- Tubular products — refer to ISO TC 5/SC 1, *Steel tubes*.

NOTE 1 Lists of standards covered by ISO/TC 17/SC 12 and ISO/TC 5/SC 1 are available on the ISO website.

NOTE 2 In all parts of ISO 630, the term of "thickness" is considered as "nominal thickness", unless otherwise stated.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 630-1, *Structural steels — Part 1: General technical delivery conditions for hot-rolled products*

ISO 643, *Steels — Micrographic determination of the apparent grain size*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 630-1 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>

— IEC Electropedia: available at <http://www.electropedia.org/>

3.1 fine-grain steel
steel with fine-grain structure with an equivalent index of grain size ≥ 6 determined in accordance with ISO 643

Note 1 to entry: See [6.1](#).

4 Classification and designation

4.1 Classification

The steel grades specified in this document shall be classified as unalloyed or alloy steels.

4.2 Designation (grades and qualities)

This document specifies 13 steel grades. Grades S275, S355, S390, S420, S460 and S500 are covered in [Annex A](#). Grades SG245, SG290, SG325, SG345, SG365, SG415 and SG460 are covered in [Annex B](#).

Each grade is available in up to 6 qualities. These grades and qualities differ in their specified mechanical properties and impact energy requirements. All S grades require impact testing. SG grades require impact testing upon agreement at the time of ordering:

- Quality A: no impact testing;
- Quality C: impact testing at 0 °C;
- Quality D: impact testing at -20 °C;
- Quality E: impact testing at -40 °C;
- Quality L: impact testing at -50 °C;
- Quality F: impact testing at -60 °C.

4.3 Normative annexes

The requirements of [Annex A](#) or [Annex B](#) are to be regarded separately. Each annex is independent of the other without combining in any way.

5 Information to be supplied by the purchaser

5.1 Mandatory information

The information that shall be supplied by the purchaser at the time of the order is specified in ISO 630- 1.

5.2 Options

The options of ISO 630-1 may apply. If the purchaser does not indicate a wish to implement any of these options at the time of the order, the products shall be supplied in accordance with the basic specification (see [5.1](#)).

6 Requirements

6.1 Steelmaking process

See ISO 630-1.

If a special steelmaking process has been specified, this shall be reported in the inspection document.

The steels shall contain sufficient amount of nitrogen-binding elements and have a fine-grain structure.

The steels specified in this specification shall be fully killed.

6.2 Delivery condition

The products covered by this document are delivered in the as-rolled (for SG grades only), normalized rolled, normalized (including normalized + tempered) or thermomechanical processed (including thermomechanical processed + tempered) condition. The delivery condition shall be indicated in the inspection document.

6.3 Chemical composition

6.3.1 Heat analysis

The chemical composition determined by heat analysis shall conform with the values given in [Table A.1](#) or [Table A.2](#) or [Table B.1](#).

6.3.2 Product analysis

The product analysis of grades S275, S355, S390, S420, S460 and S500 shall conform with the values given in [Table A.3](#) or [Table A.4](#).

The permitted deviations on analysis of grades SG245, SG290, SG325, SG345, SG365, SG415 and SG460, relative to the values for heat analysis, are given in [Table B.2](#).

6.3.3 Carbon equivalent value

The maximum carbon equivalent value (CEV) requirements for [Annex A](#) grades are given in [Tables A.5](#) or [Table A.6](#), and for [Annex B](#) grades in [Table B.3](#).

6.4 Mechanical properties

6.4.1 Tensile properties

The tensile properties at room temperature shall conform with the values specified in [Table A.7](#) or [Table A.8](#) or [Table B.4](#).

6.4.2 Charpy V-notch impact properties

The impact properties of Charpy V-notch test pieces shall conform with the values specified in [Table A.9](#) or [Table A.10](#) or [Table A.11](#) or [Table A.12](#) or [Table B.5](#). The orientation of the specimens shall be longitudinal unless a transverse orientation is agreed between the purchaser and manufacturer (see [5.2](#), ISO 630-1 and the values in [Table A.10](#)).

6.5 Surface condition

See ISO 630-1.

6.6 Internal soundness

See ISO 630-1.

6.7 Dimensions, tolerances on dimensions and shape, mass

See ISO 630-1.

7 Inspection

Specific inspection shall be required for all grades. Refer to ISO 630-1.

8 Sampling - Frequency of testing

8.1 Verification

The verification of mechanical properties shall be by heat.

8.2 Test units

8.2.1 [Annex A](#)

The test unit shall contain products of the same form, grade, quality, delivery condition and thickness range as specified in [Table A.7](#) for the yield strength, and shall be by heat and:

- 60 tonnes or part thereof;
- 80 tonnes or part thereof for heavy sections with a mass > 200 kg/m;
- 80 tonnes or part thereof for all sections if the mass of the cast exceeds 200 tonnes.

By agreement at the time of ordering, two tests by heat may be used.

8.2.2 [Annex B](#)

The test unit shall contain products of the same form, grade, quality, delivery condition, and thickness range as specified in [Table B.4](#) for the yield strength, and shall be by heat and 50 tonnes or part thereof. By agreement at the time of ordering, two tests by heat may be used.

9 Test methods

See ISO 630-1.

10 Marking

See ISO 630-1.

Annex A
(normative)

**Steel grades S275, S355, S390, S420, S460 and S500: Chemical
composition and mechanical properties**

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Table A.1 — Chemical composition % by mass (heat analysis) for normalized or normalized rolled steel

Designation	Grade	Quality	C	Si	Mn	P	S	Cr	Ni	Mo	N	Al _{total}	Cu	Nb	Ti	V
			% max.	% max.	%	% max. ^a	% max. ^{ab}	% max.	% max.	% max.	% max.	% min. ^c	% max. ^d	% max.	% max.	% max.
S275N	D		0,18	0,40	0,50–1,50	0,030	0,025	0,30	0,30	0,10	0,015	0,02	0,55	0,05	0,05	0,05
	E, L		0,16			0,025	0,020									
S355N	D		0,20	0,50	0,90–1,65	0,030	0,025	0,30	0,50	0,10	0,015	0,02	0,55	0,05	0,05	0,12
	E, L		0,18			0,025	0,020									
	F		0,16			0,020	0,010									
S390N	D		0,20	0,50	0,90–1,70	0,030	0,025	0,30	0,50	0,10	0,015	0,02	0,55	0,05	0,05	0,20
	E, L		0,20			0,025	0,020									
S420N	D		0,20	0,60	1,00–1,70	0,030	0,025	0,30	0,80	0,10	0,025	0,02	0,55	0,05	0,05	0,20
	E, L		0,20			0,025	0,020									
S460N ^e	D		0,20	0,60	1,00–1,70	0,030	0,025	0,30	0,80	0,10	0,025	0,02	0,55	0,05	0,05	0,20
	E, L		0,20			0,025	0,020									

^a For long products, the P and S content can be 0,005% higher.

^b For some applications, e.g. railways, a maximum S content of 0,010% may be agreed at the time of the order.

^c If sufficient other N-binding elements are present, the minimum total Al content does not apply.

^d Cu content above 0,40% may cause hot shortness during hot forming.

^e V + Nb + Ti ≤ 0,22% and Mo + Cr ≤ 0,30%.

Table A.2 — Chemical composition % by mass (heat analysis) for thermomechanical processed steel

Designation		C	Si	Mn	P	S	Cr	Ni	Mo	N	Al _{total}	B	Cu	Nb	Ti	V
Grade	Quality	% max.	% max.	% max.	% max. ^a	% max. ^{ab}	% max.	% max.	% max.	% max.	% min. ^c	% max. ^d				
		S275M	D	0,13 ^e	0,50	1,50	0,030	0,025	0,30	0,30	0,10	0,015	0,02	—	0,55	0,05
E, L					0,025	0,020										
S355M	D				0,030	0,025										
	E, L	0,14 ^e	0,50	1,60	0,025	0,020	0,30	0,50	0,10	0,015	0,02	—	0,55	0,05	0,05	0,10
	F				0,020	0,010										
S390M	D	0,15 ^e	0,50	1,70	0,030	0,025	0,30	0,50	0,10	0,015	0,02	—	0,55	0,05	0,05	0,12
	E, L				0,025	0,020										
S420M	D	0,16 ^f	0,50	1,70	0,030	0,025	0,30	0,80	0,20	0,025	0,02	—	0,55	0,05	0,05	0,12
	E, L				0,025	0,020										
S460M	D	0,16 ^f	0,60	1,70	0,030	0,025	0,30	0,80	0,20	0,025	0,02	—	0,55	0,05	0,05	0,12
	E, L				0,025	0,020										
S500M	D	0,16	0,60	1,70	0,030	0,025	0,30	0,80	0,20	0,025	0,02	0,004	0,55	0,05	0,05	0,12
	E, L				0,025	0,020										

^a For long products, the P and S content can be 0,005% higher.

^b For some applications, a maximum S content of 0,005% may be agreed at the time of the order.

^c If sufficient other N-binding elements are present, the minimum total Al content does not apply.

^d Cu content above 0,40% may cause hot shortness during hot forming.

^e For long products, a maximum C content of 0,15% for grade S275, a maximum C content of 0,16% for grade S355 and a maximum C content of 0,17% for grade S390 applies.

^f For long products, a maximum C content of 0,18% for grades S420 and S460 applies.

Table A.3 — Chemical composition % by mass (product analysis) based on Table A.1

Grade	Designation	C % max.	Si % max.	Mn %	P % max. ^a	S % max. ^{ab}	Cr % max.	Ni % max.	Mo % max.	N % max.	Al _{total} % min. ^c	Cu % max. ^d	Nb % max.	Ti % max.	V % max.
S275N	D	0,20	0,45	0,45- 1,60	0,035	0,030	0,35	0,35	0,13	0,017	0,015	0,60	0,06	0,06	0,07
	E, L	0,18		0,025											
S355N	D	0,22	0,55	0,85- 1,75	0,035	0,030	0,35	0,55	0,13	0,017	0,015	0,60	0,06	0,06	0,14
	E, L	0,20			0,030	0,025									
S390N	F	0,18	0,65	0,95- 1,80	0,025	0,015	0,35	0,85	0,13	0,027	0,015	0,60	0,06	0,06	0,22
	D	0,22			0,035	0,030									
S420N	E, L	0,22	0,65	0,95- 1,80	0,030	0,025	0,35	0,85	0,13	0,027	0,015	0,60	0,06	0,06	0,22
	D	0,22			0,035	0,030									
S460N ^e	D	0,22	0,65	0,95- 1,80	0,035	0,030	0,35	0,85	0,13	0,027	0,015	0,60	0,06	0,06	0,22
	E, L	0,22			0,030	0,025									

^a For long products, the P and S content can be 0,005% higher.

^b For some applications, e.g. railways, a maximum S content of 0,012% may be agreed at the time of the order.

^c If sufficient other N-binding elements are present, the minimum total Al content does not apply.

^d Cu content above 0,45% may cause hot shortness during hot forming.

^e V+Nb+Ti ≤ 0,26% and Mo+Cr ≤ 0,38%.

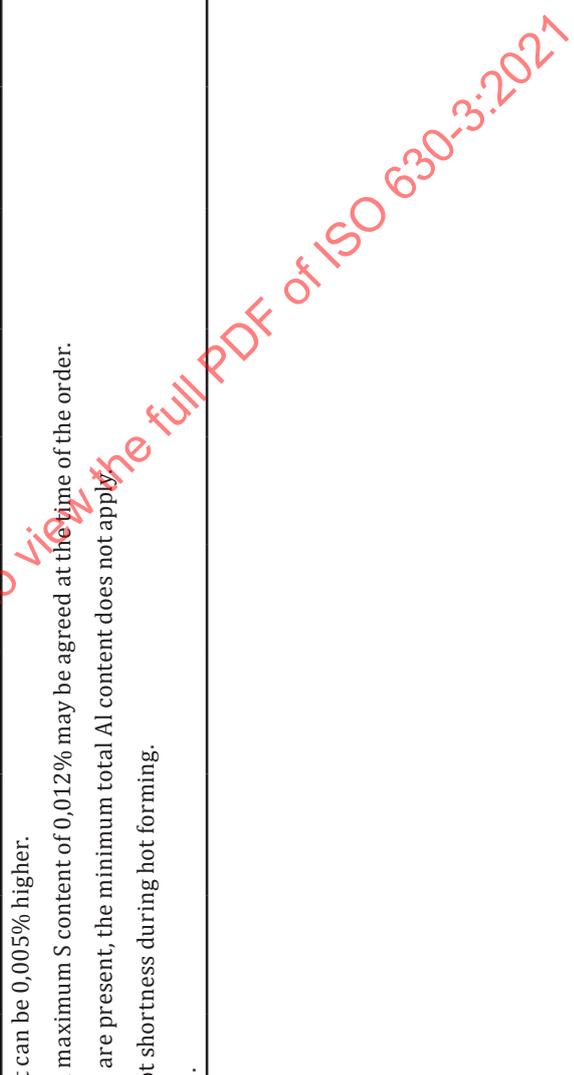


Table A.4 — Chemical composition % by mass (product analysis) based on Table A.2

Grade	Designation	C	Si	Mn	P	S	Cr	Ni	Mo	N	Al ^{total}	B	Cu	Nb	Ti	V	
		% max.	% max.	% max.	% max. ^a	% max. ^{ab}	% max.	% min. ^c	% max. ^d								
S275M	D	0,15 ^e	0,55	1,60	0,030	0,030	0,35	0,35	0,13	0,017	0,015	—	0,60	0,06	0,06	0,10	
	E, L																0,025
S355M	D	0,16 ^e	0,55	1,70	0,030	0,030	0,35	0,55	0,13	0,017	0,015	—	0,60	0,06	0,06	0,12	
	E, L																0,025
	F																0,015
S390M	D	0,17 ^e	0,55	1,80	0,035	0,030	0,35	0,55	0,13	0,017	0,015	—	0,60	0,06	0,06	0,14	
	E, L																0,025
S420M	D	0,18 ^f	0,55	1,80	0,035	0,030	0,35	0,85	0,23	0,027	0,015	—	0,60	0,06	0,06	0,14	
	E, L																0,025
S460M	D	0,18 ^f	0,65	1,80	0,035	0,030	0,35	0,85	0,23	0,027	0,015	—	0,60	0,06	0,06	0,14	
	E, L																0,025
S500M	D	0,18	0,65	1,80	0,035	0,030	0,35	0,85	0,23	0,027	0,015	0,0045	0,60	0,06	0,06	0,14	
	E, L																0,025

^a For long products, the P and S content can be 0,005% higher

^b For some applications, e.g. railways, a maximum S content of 0,012% may be agreed at the time of the order.

^c If sufficient other N-binding elements are present, the minimum total Al content does not apply

^d Cu content above 0,45% may cause hot shortness during hot forming

^e For long products, a maximum C content of 0,17% for grade S275, a maximum C content of 0,18% for grade S355 and a maximum C content of 0,19% for grade S390 applies

^f For long products of the grades S420 and S460, a maximum C content of 0,20% applies

Table A.5 — Maximum CEV based on the heat analysis for normalized or normalized rolled steel

Designation		Maximum CEV in % for nominal product thickness in mm		
Grade	Quality	≤63	>63 ≤100	>100 ≤250
S275N	D, E, L	0,40	0,40	0,42
S355N	D, E, L, F	0,43	0,45	0,45
S390N	D, E, L	0,46	0,48	0,49
S420N	D, E, L	0,48	0,50	0,52
S460N	D, E, L	0,53	0,54	0,55

Table A.6 — Maximum CEV based on the heat analysis for thermomechanical processed steel

Designation		Maximum CEV in % for nominal product thickness in mm			
Grade	Quality	≤16	>16 ≤40	>40 ≤63	>63 ≤150
S275M	D, E, L	0,34	0,34	0,35	0,38
S355M	D, E, L, F	0,39	0,39	0,40	0,45
S390M	D, E, L	0,41	0,43	0,44	0,46
S420M	D, E, L	0,43	0,45	0,46	0,47
S460M	D, E, L	0,45	0,46	0,47	0,48
S500M	D, E, L	0,47	0,47	0,47	0,48

Table A.7 — Tensile properties at room temperature for normalized or normalized rolled steel

Designation	Nominal thickness mm																			
	≤16		>16 ≤40		>40 ≤63		>63 ≤80		>80 ≤100		>100 ≤200		>200 ≤250							
	Minimum yield strength R_{eH}^a							Tensile strength R_m^a							Minimum elongation after fracture $L_0 = 5,65\sqrt{S_0}$					
Grade	Quality																			
	MPa ^b																			
S275N	275	265	255	245	235	225	215	205	370 to 510	350 to 480	350 to 480	24	24	24	23	23	23			
S355N	355	345	335	325	315	295	285	275	470 to 630	450 to 600	450 to 600	22	22	22	21	21	21			
S390N	390	380	360	340	340	320	310	300	490 to 650	470 to 620	470 to 620	20	20	20	19	19	19			
S420N	420	400	390	370	360	340	330	320	520 to 680	500 to 650	500 to 650	19	19	19	18	18	18			
S460N	460	440	430	410	400	380	370	370	540 to 720	530 to 710	530 to 710	17	17	17	17	17	16			

^a For plates and wide flats with widths ≥ 600 mm; the direction transverse to the rolling direction applies. For all other products, the values apply for the direction parallel to the rolling direction.

^b 1 MPa = 1 N/mm².

Table A.8 — Tensile properties at room temperature for thermomechanical processed steel

Designation	Nominal thickness												Minimum elongation after fracture % $L_0 = 5,65\sqrt{S_0}$
	Minimum yield strength $R_{eH a}$ MPa ^b						Tensile strength $R_m a$ MPa ^b						
	≤16	>16 ≤40	>40 ≤63	>63 ≤80	>80 ≤100	>100 ≤150	≤40	>40 ≤63	>63 ≤80	>80 ≤100	>100 ≤150		
Grade	Quality												
S275M	275	265	255	245	245	240	370 to 530	360 to 520	350 to 510	350 to 510	350 to 510	24	
S355M	355	345	335	325	325	320	470 to 630	450 to 610	440 to 600	440 to 600	430 to 590	22	
S390M	390	380	360	340	340	335	490 to 650	480 to 640	470 to 630	460 to 620	450 to 610	20	
S420M	420	400	390	380	370	365	520 to 680	500 to 660	480 to 640	470 to 630	460 to 620	19	
S460M	460	440	430	410	400	385	540 to 720	530 to 710	510 to 690	500 to 680	490 to 660	17	
S500M	500	490	480	460	450	450	610 to 770	600 to 760	590 to 750	560 to 750	560 to 750	15	

^a For plate and wide flats with widths ≥ 600 mm, the direction transverse to the rolling direction applies. For all other products, the values apply for the direction parallel to the rolling direction.

^b 1 MPa = 1 N/mm².

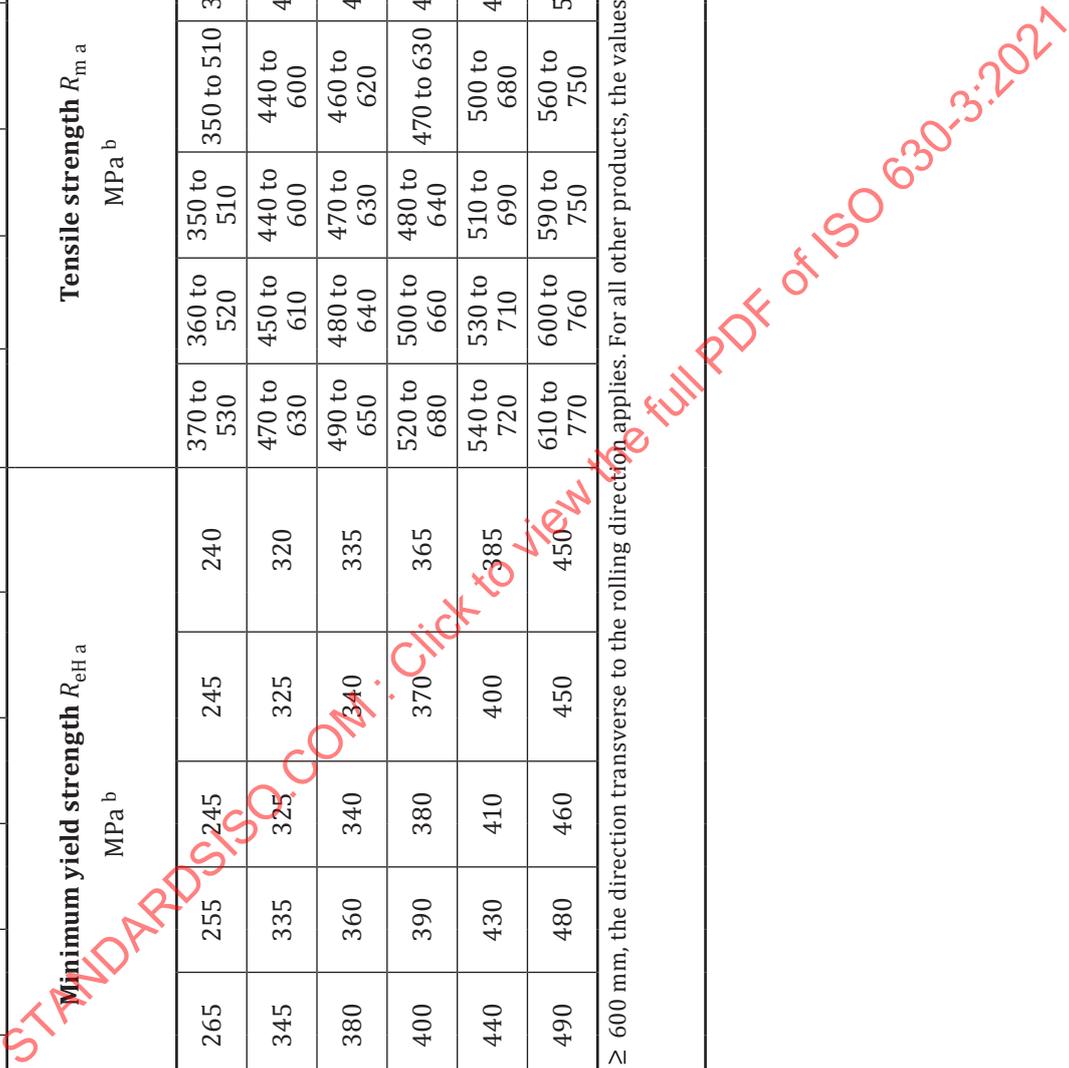


Table A.9 — Longitudinal Charpy V-notch properties for normalized or normalized rolled steel

Designation		Minimum energy, J at test temperature ^b , °C							
Grade	Quality	+20	0	-10	-20	-30	-40	-50	-60
S275N	D	55	47	43	40 ^a	—	—	—	—
S355N	E	55	51	47	40	31	27	—	—
S390N	L	63	55	51	47	40	31	27	—
S420N									
S460N									
S355N	F	68	63	55	51	47	40	31	27

^a This value corresponds with 27 J at -30 °C.

^b Unless otherwise specified, the testing temperature for each quality is the lowest available with a specified energy value.

Table A.10 — Transverse Charpy V-notch properties for normalized or normalized rolled steel ^a

Designation		Minimum energy, J at test temperature ^b , °C							
Grade	Quality	+20	0	-10	-20	-30	-40	-50	-60
S275N	D	31	27	24	20	—	—	—	—
S355N	E	34	30	27	23	20	16	—	—
S390N	L	40	34	30	27	23	20	16	—
S420N									
S460N									
S355N	F	47	40	34	30	27	23	20	16

^a See 5.2.

^b Unless otherwise specified, the testing temperature for each quality is the lowest available with a specified energy value.

Table A.11 — Longitudinal Charpy V-notch properties for thermomechanical processed steel

Designation		Minimum energy, J at test temperature ^b , °C							
Grade	Quality	+20	0	-10	-20	-30	-40	-50	-60
S275M	D	55	47	43	40 ^a	—	—	—	—
S355M	E	55	51	47	40	31	27	—	—
S390M	L	63	55	51	47	40	31	27	—
S420M									
S460M									
S500M	F	68	63	55	51	47	40	31	27
S355M									

^a This value corresponds with 27J at -30 °C.

^b Unless otherwise specified, the testing temperature for each quality is the lowest available with a specified energy value.