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JAPANESE INDUSTRIAL STANDARD

Rolled steels for welded structure

Ⓔ JIS G 3106—1995

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JAPANESE INDUSTRIAL STANDARD
Rolled steels for welded structure

J I S
G 3106-1995

1. Scope This Japanese Industrial Standard specifies the hot rolled steels (hereafter referred to as "steel products") to be used for bridges, ships, rolling stocks, petroleum storage tanks, containers and other constructions that are required superiority in weldability.

Remarks: The standards cited in this Standard are given in Attached Table 1.

2. Grade and symbol The steel products shall be classified into 11 categories and their symbols shall be as given in Table 1.

Table 1. Symbol of grade

Symbol of grade	Applicable thickness	mm
SM400A	Steel plate, coil, section and flat	200 or under
SM400B		
SM400C	Steel plate, coil and section	100 or under
SM490A	Steel plate, coil, section and flat	200 or under
SM490B		
SM490C	Steel plate, coil and section	100 or under
SM490YA	Steel plate, coil, section and flat	100 or under
SM490YB		
SM520B	Steel plate, coil, section and flat	100 or under
SM520C	Steel plate, coil and section	100 or under
SM570	Steel plate, coil and section	100 or under

Remarks: The steel plate of 150 mm and under in thickness of SM520B, SM520C and SM570 may be produced as agreed upon between the purchaser and supplier.

3. Chemical composition The steel products shall be tested in accordance with 9.1 and the cast analysis value thereof shall be as given in Table 2.

Table 2. Chemical composition

Unit: %

Symbol of grade	C	Si	Mn	P	S
SM400A	50 mm or under in thickness 0.23 max. Over 50 mm, up to and incl. 200 mm in thickness 0.25 max.	-	2.5 × C min. ⁽¹⁾	0.035 max.	0.035 max.
SM400B	50 mm or under in thickness 0.20 max. Over 50 mm, up to and incl. 200 mm in thickness 0.22 max.	0.35 max.	0.60 to 1.40	0.035 max.	0.035 max.
SM400C	100 mm or under in thickness 0.18 max.	0.35 max.	1.40 max.	0.035 max.	0.035 max.
SM490A	50 mm or under in thickness 0.20 max. Over 50 mm, up to and incl. 200 mm in thickness 0.22 max.	0.55 max.	1.60 max.	0.035 max.	0.035 max.
SM490B	50 mm or under in thickness 0.18 max. Over 50 mm, up to and incl. 200 mm in thickness 0.20 max.	0.55 max.	1.60 max.	0.035 max.	0.035 max.
SM490C	100 mm or under in thickness 0.18 max.	0.55 max.	1.60 max.	0.035 max.	0.035 max.
SM490YA	100 mm or under in thickness 0.20 max.	0.55 max.	1.60 max.	0.035 max.	0.035 max.
SM490YB					
SM520B	100 mm or under in thickness 0.20 max.	0.55 max.	1.60 max.	0.035 max.	0.035 max.
SM520C					
SM570	100 mm or under in thickness 0.18 max.	0.55 max.	1.60 max.	0.035 max.	0.035 max.

Note ⁽¹⁾ The value of carbon herein is the actual cast analysis value.

Remarks 1. Alloying elements other than those given in Table 2 may be added as necessary.

2. The chemical composition of the steel plate of SM520B, SM520C and SM570 of over 100 mm up to and including 150 mm in thickness shall be as agreed upon between the purchaser and supplier.

4. Carbon equivalent or chemical composition on sensitivity of welding crack

4.1 Carbon equivalent or chemical composition on sensitivity of welding crack for SM570 The carbon equivalent or chemical composition on sensitivity of welding crack for SM570 shall be as follows:

Further, the carbon equivalent shall apply to quench-hardened and tempered steel products.

- (1) The carbon equivalent shall be as given in Table 3. The carbon equivalent shall be calculated from the following formula by using the cast analysis value of 9.1.

Table 3. Carbon equivalent

Thickness of steel product mm	50 or under	Over 50, up to and incl. 100	Over 100
Carbon equivalent %	0.44 max.	0.47 max.	As agreed upon between the purchaser and supplier

$$\text{Carbon equivalent (\%)} = C + \frac{\text{Mn}}{6} + \frac{\text{Si}}{24} + \frac{\text{Ni}}{40} + \frac{\text{Cr}}{5} + \frac{\text{Mo}}{4} + \frac{\text{V}}{14}$$

- (2) Chemical composition on sensitivity of welding crack may be applied instead of carbon equivalent subject to the agreement between the purchaser and supplier. In this case, the chemical composition on sensitivity of welding crack shall be as given in Table 4. The chemical composition on sensitivity of welding crack shall be calculated from the following formula by using the cast analysis value of 9.1.

Table 4. Chemical composition on sensitivity of welding crack

Thickness of steel product mm	50 or under	Over 50, up to and incl. 100	Over 100
Chemical composition on sensitivity of welding crack %	0.28 max.	0.30 max.	As agreed upon between the purchaser and supplier

Chemical composition on sensitivity of welding crack (%)

$$= C + \frac{\text{Si}}{30} + \frac{\text{Mn}}{20} + \frac{\text{Cu}}{20} + \frac{\text{Ni}}{60} + \frac{\text{Cr}}{20} + \frac{\text{Mo}}{15} + \frac{\text{V}}{10} + 5B$$

4.2 Carbon equivalent or chemical composition on sensitivity of welding crack for thermomechanical controlled steel plate The carbon equivalent of the steel plate which is thermomechanically controlled is subject to the agreement between the purchaser and supplier and its calculation formula shall be as given in Annex 1.

Further, the chemical composition on sensitivity of welding crack may be applied instead of the carbon equivalent subject to the agreement between the purchaser and supplier. The chemical composition on sensitivity of welding crack in this case and its calculation formula shall be as given in Annex 2.

5. Mechanical property

5.1 Yield point or proof stress, tensile strength, and elongation The steel products shall be tested in accordance with 9.2 and the yield point or proof stress, tensile strength and elongation thereof shall be as given in Table 5.

Table 5. Yield point or proof stress, tensile strength and elongation

Symbol of grade	Yield point or proof stress N/mm ²					Tensile strength N/mm ²		Elongation		
	Thickness of steel product ⁽²⁾ mm					Thickness of steel product ⁽²⁾ mm		Thickness of steel product ⁽²⁾ mm	Test piece	%
	Over 16, up to and incl. 40	Over 40, up to and incl. 75	Over 75, up to and incl. 100	Over 100, up to and incl. 160	Over 160, up to and incl. 200	100 or under	Over 100, up to and incl. 200			
SM400A SM400B	245 min.	235 min.	215 min.	215 min.	195 min.	400 to 510	400 to 510	5 or under Over 5, up to and incl. 16 Over 16, up to and incl. 50 Over 40	No. 5 No. 1A No. 1A No. 4	23 min. 18 min. 22 min. 24 min.
SM490A SM490B	325 min.	315 min.	295 min.	295 min.	275 min.	490 to 610	490 to 610	5 or under Over 5, up to and incl. 16 Over 16, up to and incl. 50 Over 40	No. 5 No. 1A No. 1A No. 4	22 min. 17 min. 21 min. 23 min.
SM490C										
SM490YA SM490YB	365 min.	355 min.	335 min.	325 min.	-	490 to 610	-	5 or under Over 5, up to and incl. 16 Over 16, up to and incl. 50 Over 40	No. 5 No. 1A No. 1A No. 4	19 min. 15 min. 19 min. 21 min.

Table 5. (continued)

Symbol of grade	Yield point or proof stress N/mm^2					Tensile strength N/mm^2		Elongation		
	Thickness of steel product ⁽²⁾ mm					Thickness of steel product ⁽²⁾ mm		Thickness of steel product ⁽²⁾ mm	Test piece	%
	16 or under	Over 16, up to and incl. 40	Over 40, up to and incl. 75	Over 75, up to and incl. 100	Over 100, up to and incl. 160	Over 160, up to and incl. 200	Over 200, up to and incl. 520			
SM520B SM520C	365 min.	355 min.	335 min.	325 min.	-	-	520 to 640	5 or under Over 5, up to and incl. 16 Over 16, up to and incl. 50 Over 40	No. 5 No. 1A No. 1A No. 4	19 min. 15 min. 19 min. 21 min.
SM570	460 min.	450 min.	430 min.	420 min.	-	-	570 to 720	16 or under Over 16 Over 20	No. 5 No. 5 No. 4	19 min. 26 min. 20 min.

Note ⁽²⁾ As to the term "thickness of steel product" for sections, it means the thickness at the position where the test piece(s) is taken as shown in Fig. 1.

Remarks 1. Table 5 does not apply to both ends of steel coils.

2. For the elongation of No. 4 test piece of the steel products over 100 mm in thickness, 1 % is subtracted from the value of elongation given in Table 5 per each increase of 25 mm in thickness or its fraction. However, the limit to be subtracted shall be 3 %.

3. The yield point or proof stress, tensile strength and elongation of the steel plate of over 100 mm up to and including 150 mm in thickness of SM520B, SM520C and SM570 shall be as agreed upon between the purchaser and supplier.

5.2 Charpy absorption energy The steel products over 12 mm in thickness shall be tested in accordance with 9.2 and the Charpy absorption energy thereof shall be as given in Table 6. The Charpy absorption energy in this case shall be expressed by the mean of measured values of three test pieces.

Table 6. Charpy absorption energy

Symbol of grade	Test temperature °C	Charpy absorption energy J	Test piece
SM400B	0	27 min.	No. 4 in rolling direction
SM400C	0	47 min.	
SM490B	0	27 min.	
SM490C	0	47 min.	
SM490YB	0	27 min.	
SM520B	0	27 min.	
SM520C	0	47 min.	
SM570	-5	47 min.	

6. Shape, dimension, mass and the tolerance thereon The shape, dimension, and mass of the steel products and the tolerance thereon shall be in accordance with the following standards:

JIS G 3192, JIS G 3193, JIS G 3194

In this case, the width tolerances for the steel plate and cut-edged coil as well as the length tolerances for the steel plate shall be in accordance with the tolerance A in JIS G 3193 unless particularly specified.

7. Appearance The appearance of the steel products shall be in accordance with 9. in JIS G 3192, 6. in JIS G 3193 or 8. in JIS G 3194.

Further, the repair by welding of the steel plate of SM570 shall be previously agreed between the purchaser and supplier.

8. Heat treatment and symbol

8.1 Heat treatment The steel products may be subjected to normalizing, quench-hardening and tempering, or tempering, as necessary.

Further, thermomechanical control, or appropriate heat treatment may be applied as agreed upon between the purchaser and supplier.

8.2 Symbol of heat treatment When the steel products have been subjected to heat treatment, the symbol of heat treatment shall be as follows:

Further, in appending the symbol of heat treatment according to the following manner, the symbol shall additionally be written to the end of the symbol of grade given in Table 1.

- (1) In the case where normalizing is applied for the steel products by agreement between the purchaser and manufacturer: N
- (2) In the case where tempering is applied for the steel products by agreement between the purchaser and manufacturer: T
- (3) In the case where quench-hardening and tempering is applied for the steel products: Q
- (4) In the case where thermomechanical control is applied for the steel products: TMC
- (5) In the case where appropriate heat treatment is applied for the steel products: By agreement

9. Tests

9.1 Chemical analysis

9.1.1 General requirements for chemical analysis and sampling method of specimen The chemical composition of the steel products shall be determined by cast analysis, and the general requirements for chemical analysis and the sampling method of specimen for analysis shall be as specified in 3. of JIS G 0303.

9.1.2 Analytical method The method for chemical analysis shall be in accordance with any one of the following standards:

JIS G 1211, JIS G 1212, JIS G 1213, JIS G 1214, JIS G 1215, JIS G 1216, JIS G 1217, JIS G 1218, JIS G 1219, JIS G 1221, JIS G 1227, JIS G 1253, JIS G 1256, JIS G 1257, JIS G 1258

9.2 Mechanical test

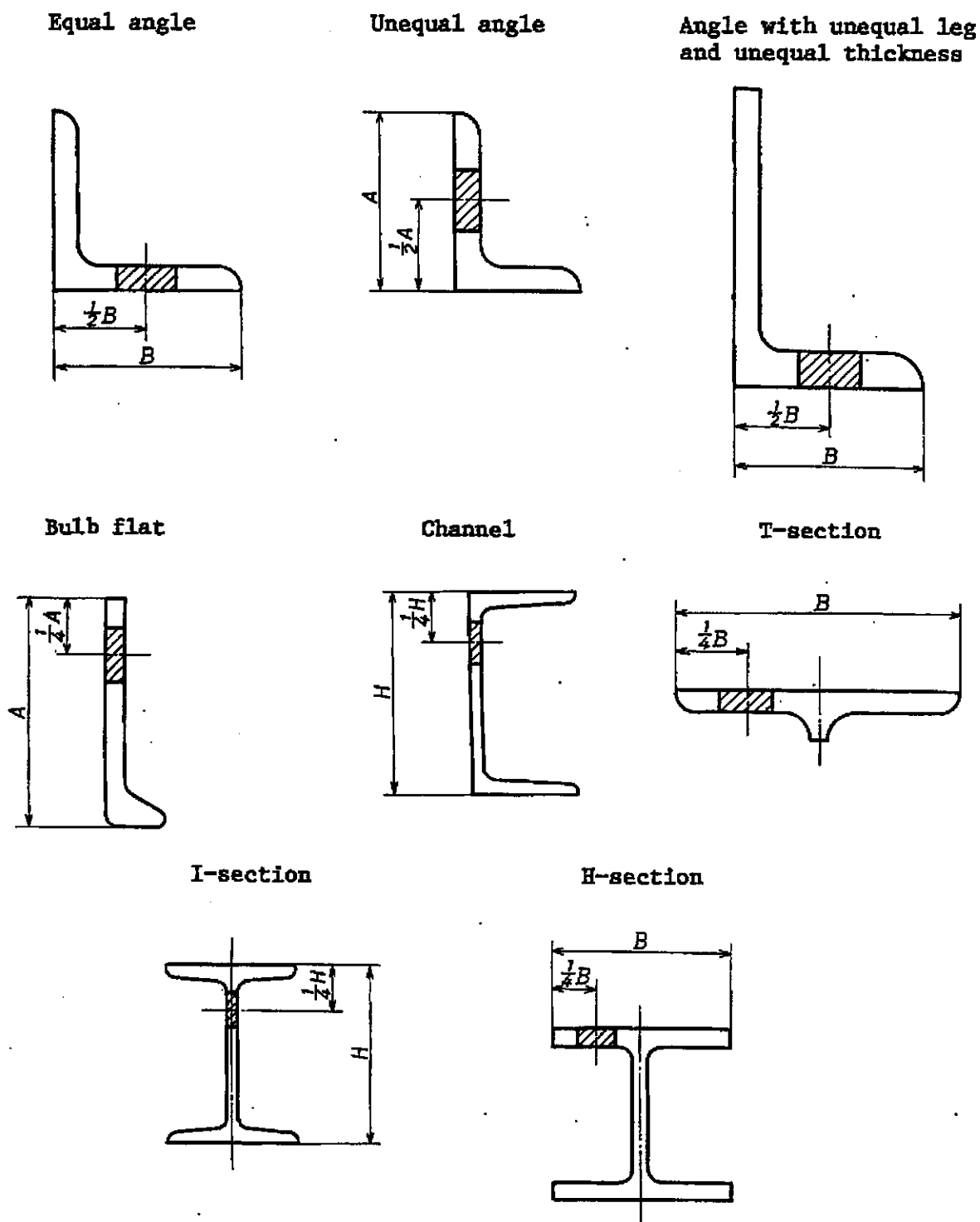
9.2.1 Test in general General requirements for mechanical testing shall be as specified in 4. of JIS G 0303. In this respect, the sampling method of specimen shall conform to Class A, and number of test pieces and sampling positions shall be as follows:

- (1) Number of tensile test pieces The number of tensile test pieces shall be as follows:
 - (a) Steel plate and flat A test lot shall consist of the steel products, from one heat where the maximum thickness is within twice the minimum thickness, and one tensile test piece shall be taken therefrom. When the mass of one test lot, however, exceeds 50 t, two tensile test pieces shall be taken. With this respect, if a single steel plate exceeds 50 t, one test piece shall be taken from the said plate.
 - (b) Steel coil and cut-to-lengths A test lot shall consist of the steel products, from one heat, rolled to the same thickness, and one tensile test piece shall be taken therefrom. When the mass of one test lot, however, exceeds 50 t, two tensile test pieces shall be taken.

- (c) Steel section A test lot shall consist of the steel products, from one heat, rolled to the same sectional profile group where the maximum thickness is within twice the minimum thickness, and one tensile test piece shall be taken therefrom. When the mass of one test lot, however, exceeds 50 t, two tensile test pieces shall be taken.
 - (d) Number of test pieces for heat treated steel products The number of test pieces for the heat treated steel products, from the same heat, rolled to the same sectional profile group, subjected to heat treatment under the same treatment conditions, shall be determined in accordance with (a), (b), or (c) in this item.
- (2) Number of impact test pieces For the steel products that have not been heat treated, one specimen shall be taken from the maximum thickness product of a test lot, from one heat, rolled to the same sectional profile group. For the heat treated steel products, one specimen shall be taken from the maximum thickness product of a test lot, from one heat, rolled to the same sectional profile group, subjected to heat treatment under the same treatment conditions. Three test pieces shall be taken from each specimen parallel to the rolling direction.
- (3) Sampling position of tensile test piece The sampling position of the tensile test piece shall be as follows:
- (a) Steel plate, coil and flat The centre of the test piece shall be at a quarter-width from a side edge, and further in the case of No. 4 test piece, it shall be at a quarter-thickness from a surface as well as at a quarter-width from a side edge. When it is infeasible to allow the centre of the test piece to be at a quarter-width from a side edge or a quarter-thickness from a surface, sampling should be made as close to the aforementioned position as possible.
 - (b) Steel section Sampling shall be made as shown in Fig. 1. When this is infeasible, sampling should be made as close to the specified position as possible. For the H-section, when it is infeasible to take a test piece as shown in Fig. 1, the sampling position for the I-section should apply *mutatis mutandis* thereto. For other sections, sampling position shall be agreed between the purchaser and supplier.
- (4) Sampling position of impact test piece The sampling position of the impact test piece shall be as follows:
- (a) Steel plate, coil and flat The centre of the test piece shall be at a quarter-thickness from a surface as well as a quarter-width from a side edge. When it is infeasible to allow the centre of the test piece to be at a quarter-thickness from a surface as well as a quarter-width from a side edge, sampling should be made as close to the aforementioned position as possible.

- (b) Steel section The centre of the test piece shall be at a quarter-thickness from a surface (see Fig. 1). When it is infeasible to allow the centre of the test piece at a quarter-thickness from a surface, sampling should be made as close to the aforementioned position as possible. For the H-section, when it is infeasible to take a test piece as shown in Fig. 1, the sampling position for the I-section shall apply mutatis mutandis thereto. For other sections, sampling position shall be agreed between the purchaser and supplier.

Fig. 1. Sampling position of test pieces for sections



9.2.2 Test piece The tensile test piece and impact test piece shall be as follows:

- (1) No. 1A, No. 4 or No. 5 test piece specified in JIS Z 2201.
- (2) No. 4 test piece specified in JIS Z 2202. In this case, the notch shall be made in the direction of thickness.

9.2.3 Test method The methods for tensile test and impact test shall be as follows:

- (1) JIS Z 2241.
- (2) Charpy impact test specified in JIS Z 2242.

9.2.4 Tensile test in the case where tensile test piece having specified dimensions can not be taken In the case where it is infeasible to secure the test piece having specified dimensions, matters on execution of tensile testing, test result values or the like shall be agreed upon between the purchaser and supplier.

9.2.5 Omission of tensile test and impact test of steel coil The tensile test and impact test of the steel coil may be omitted when approved by the purchaser.

10. Inspection

10.1 Inspection The inspection shall be carried out as follows:

- (1) General requirements for inspection shall be as specified in JIS G 0303.
- (2) The chemical composition shall conform to the requirements specified in 3.
- (3) The carbon equivalent or chemical composition on sensitivity of welding crack shall conform to the requirements specified in 4.
- (4) The mechanical properties shall conform to the requirements specified in 5.
- (5) The shape, dimensions and mass shall conform to the requirements specified in 6.
- (6) The appearance shall conform to the requirements specified in 7.
- (7) The purchaser may specify the ultrasonic testing specified in JIS G 0801 or JIS G 0901 or the like in addition to the inspection items given in (1) to (6). In this case, the test method, acceptance criteria, etc. shall be agreed previously between the purchaser and manufacturer.

10.2 Reinspection The reinspection shall be as follows:

- (1) The steel products which have not passed the tensile test may be retested in accordance with 4.4 in JIS G 0303, and then whether it is accepted or not may be determined.
- (2) The reinspection on impact test shall be as follows:
 - (a) When although the mean value of three test pieces in the impact test does not satisfy the specified value of Table 6, the mean is 85 % and over of the specified value, three additional test pieces shall be taken from the vicinity where the original test pieces have been taken, and a retest shall be carried out. When the mean of the tested values of the six test pieces is not less than the specified value of Table 6, all the steel products of the same heat, sectional profile group and heat treatment conditions shall be accepted. However, when the mean value of the tested values of new three test pieces is under 85 % of the specified value, or when in the retest, the mean value of the tested values of the six test pieces fails to meet the specified value, the steel products shall be considered unacceptable, and the test shall be made on each piece of the steel products of the same thickness not used for the test specimen. The determination of acceptance may be made for each steel product.

When even one piece of the steel products of the largest thickness fails to be accepted, the retest shall be performed further as follows:

- (b) A retest shall be made for the steel product of the largest thickness of the remainders of the same heat, sectional profile group and heat treatment conditions in the same way as the first test. In this case, when its value is not less than the specified value of Table 6, all the remaining steel products of the same heat, sectional profile group and heat treatment conditions shall be accepted.
- (3) The steel products which have not passed the mechanical test, may be again subjected to the mechanical test after heat treatment or reheat treatment. Then, whether it is accepted or not may be determined.

11. Marking The steel products which have passed the inspection shall be marked on each piece or each bundle with the following items by a suitable method. However, a part of the items may be omitted subject to the agreement between the purchaser and supplier.

- (1) Symbol of grade (including the symbol which stands for symbol of heat treatment specified in 8.2.)
- (2) Heat number or inspection number
- (3) Dimension
- (4) Quantity or mass of each bundle (for steel plate and coil)
- (5) Manufacturer's name or identifying brand

12. Report The report shall comply with 8. in JIS G 0303.

Further, when Remarks 1. of Table 2 is applied, the content of added element shall be supplementary noted to the test report.

Attached Table 1. Cited standards

JIS G 0303	General rules for inspection of steel
JIS G 0801	Ultrasonic examination of steel plates for pressure vessels
JIS G 0901	Classification of structural rolled steel plate and wide flat for building by ultrasonic test
JIS G 1211	Iron and steel - Methods for determination of carbon content
JIS G 1212	Methods for determination of silicon in iron and steel
JIS G 1213	Methods for determination of manganese in iron and steel
JIS G 1214	Methods for determination of phosphorus in iron and steel
JIS G 1215	Iron and steel-Methods for determination of sulfur content
JIS G 1216	Methods for determination of nickel in iron and steel
JIS G 1217	Methods for determination of chromium in iron and steel
JIS G 1218	Iron and steel-Methods for determination of molybdenum content
JIS G 1219	Methods for determination of copper in iron and steel
JIS G 1221	Methods for determination of vanadium in iron and steel
JIS G 1227	Methods for determination of boron in iron and steel
JIS G 1253	Iron and steel - Method for spark discharge atomic emission spectrometric analysis
JIS G 1256	Method for X-ray fluorescence spectrometric analysis of iron and steel
JIS G 1257	Iron and steel-Methods for atomic absorption spectrometric analysis
JIS G 1258	Methods for inductively coupled plasma emission spectrochemical analysis of steel
JIS G 3192	Dimensions, mass and permissible variations of hot rolled steel sections
JIS G 3193	Dimensions, mass and permissible variations of hot rolled steel plates, sheets and strip
JIS G 3194	Shape, dimensions, weight and tolerance for hot rolled flat steel

Attached Table 1. (continued)

JIS Z 2201 Test pieces for tensile test for metallic materials
JIS Z 2202 Test pieces for impact test for metallic materials
JIS Z 2241 Method of tensile test for metallic materials
JIS Z 2242 Method of impact test for metallic materials

Related standards:

ISO 630	Structural steels
ISO 4950-2	High yield strength flat steel products - Part 2: Products supplied in the normalized or controlled rolled condition
ISO 4950-3	High yield strength flat steel products - Part 3: Products supplied in the heat-treated (quenched+tempered) condition
ISO 4951	High yield strength steel bars and sections
ISO 4996	Hot-rolled steel sheet of high yield stress structural quality

Annex 1 Carbon equivalent of steel plate which is subjected to thermomechanical control.

1. Scope This Annex 1 specifies the carbon equivalent of the steel plate which is subjected to thermomechanical control.

2. Carbon equivalent of steel plate which is subjected to thermomechanical control

2.1 Calculation formula of carbon equivalent The carbon equivalent shall be calculated from the following formula by using the cast analysis value in the body 9.1.

$$\text{Carbon equivalent (\%)} = C + \frac{Mn}{6} + \frac{Si}{24} + \frac{Ni}{40} + \frac{Cr}{5} + \frac{Mo}{4} + \frac{V}{14}$$

2.2 Carbon equivalent The carbon equivalent shall be as given in Annex 1 Table 1.

Annex 1 Table 1. Carbon equivalent

Unit: %

Symbol of grade		SM490A SM490B SM490C	SM490YA SM490YB	SM520B SM520C
Applicable thickness	50 mm or under	0.38 max.		0.40 max.
	Over 50 mm, up to and incl. 100 mm	0.40 max.		0.42 max.

Remarks: The carbon equivalent of the steel plate of over 100 mm in applied thickness shall be as agreed upon between the purchaser and supplier.

Annex 2 Chemical composition on sensitivity of welding crack for steel plate which is subjected to thermomechanical control

1. Scope This Annex 2 specifies the chemical composition on sensitivity of welding crack for the steel plate which is subjected to thermomechanical control.

2. Chemical composition on sensitivity of welding crack for steel plate which is subjected to thermomechanical control

2.1 Calculation formula of chemical composition on sensitivity of welding crack The chemical composition on sensitivity of welding crack shall be calculated from the following formula by using the cast analysis value in the body 9.1.

Chemical composition on sensitivity of welding crack (%)

$$= C + \frac{Si}{30} + \frac{Mn}{20} + \frac{Cu}{20} + \frac{Ni}{60} + \frac{Cr}{20} + \frac{Mo}{15} + \frac{V}{10} + 5B$$

2.2 Chemical composition on sensitivity of welding crack The chemical composition on sensitivity of welding crack shall be as given in Annex 2 Table 1.

Annex 2 Table 1. Chemical composition on sensitivity of welding crack
Unit: %

Symbol of grade		SM490A SM490YA SM490B SM490YB SM490C	SM520B SM520C
Applicable thickness	50 mm or under	0.24 max.	0.26 max.
	Over 50 mm, up to and incl. 100 mm	0.26 max.	0.27 max.

Remarks: The chemical composition on sensitivity of welding crack for the steel plate of over 100 mm in applied thickness shall be as agreed upon between the purchaser and supplier.

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Rolled steels for welded structure

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ERRATA

Page 12

(2)(a) of subclause 10.2

In line 10, replace "of new three test pieces..." by "of three test pieces...", so that reads as follows :

of three test pieces is under 85% of the specified value, or

Remarks: This errata is for correcting the 1st and 2nd editions of this Standard.
Japanese Standards Association