

Cold-forming and drawing steels

Hot rolled and pickled

The first stage in the production of flat carbon steels in the form of coils is hot rolling. Albasider is able to supply its customers with hot-rolled coils in thicknesses between 1.50 and 20 mm.

Following hot rolling, the material can undergo a pickling process.

Pickling is a chemical dissolution operation that takes place mainly through the use of special acids, which allows rust, calamine

and other processing residues to be removed from the surfaces.

Albasider can supply its customers with pickled plates, tapes and straps in thicknesses between 1.50 and 12 mm.

Hot Rolled			Pickled		
	Thickness	Width		Thickness	Width
Plates	1.50 - 20	≤ 2000	Plates	1.50 - 12	≤ 2000
Tapes	1.50 - 6	≤ 2000	Tapes	1.50 - 6	≤ 2000
Straps	-	-	Straps	1.50 - 3	180 - 2000
				4 - 6	500 - 2000

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These steels are mainly characterised by a low carbon content and excellent weldability.

Their maximum ultimate tensile strength and minimum elongation parameters give them a good aptitude for bending and drawing.

The higher the grade chosen, DD11 → DD14, the greater the material's propensity for deep drawing.

Main fields of application:

GENERAL INDUSTRY

AUTOMOTIVE AND TRANSPORT

CARPENTRY

Mechanical properties

Thickness (mm)	EN 10111	DD11	DD12	DD13	DD14
1.35 - 1.49	Re (MPa)	170 - 360	170 - 340	170 - 330	170 - 310
	Rm (MPa)	≤ 440	≤ 420	≤ 400	≤ 380
	A 80 (%)	≥ 22	≥ 24	≥ 27	≥ 30
1.50 - 1.99	Re (MPa)	170 - 360	170 - 340	170 - 330	170 - 310
	Rm (MPa)	≤ 440	≤ 420	≤ 400	≤ 380
	A 80 (%)	≥ 23	≥ 25	≥ 28	≥ 31
2 - 2.99	Re (MPa)	170 - 340	170 - 320	170 - 310	170 - 290
	Rm (MPa)	≤ 440	≤ 420	≤ 400	≤ 380
	A 80 (%)	≥ 24	≥ 26	≥ 29	≥ 32
3 - 11	Re (MPa)	170 - 340	170 - 320	170 - 310	170 - 290
	Rm (MPa)	≤ 440	≤ 420	≤ 400	≤ 380
	A 5 (%)	≥ 28	≥ 30	≥ 33	≥ 36

Legend

Re (MPa) = Yield strength (inelastic index); Rm (MPa) = Tensile strength;
A 80 (%) = Elongation for thickness < 3mm; A 5 (%) = Elongation for thickness ≥ 3mm

Please note:

Tests carried out transversely to the rolling direction.