SLOVENSKI STANDARD
SIST EN 10169:2011+A1:2012

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Z organskimi materiali kontinuirno prevlečeni ploščati jekleni izdelki v svitkih - Tehnični dobavni pogoji

Continuously organic coated (coil coated) steel flat products - Technical delivery conditions

Kontinuierlich organisch beschichtete (bandbeschichtete) Flacherzeugnisse aus Stahl - Technische Lieferbedingungen

Produits plats en acier revêtus en continu de matières organiques (prélaqués) - Conditions techniques de livraison

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EUROPEAN STANDARD

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English Version

Continuously organic coated (coil coated) steel flat products - Technical delivery conditions

Produits plats en acier revêtus en continu de matières organiques (prélaqués) - Conditions techniques de livraison

Kontinuierlich organisch beschichtete (bandbeschichtete) Flacherzeugnisse aus Stahl - Technische Lieferbedingungen

This European Standard was approved by CEN on 7 August 2010 and includes Amendment 1 approved by CEN on 14 February 2012.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
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Foreword

This document (EN 10169:2010+A1:2012) has been prepared by Technical Committee ECISS/TC 109 [A1] "Coated and uncoated flat products to be used for cold forming" [A1], the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by September 2012, and conflicting national standards shall be withdrawn at the latest by September 2012.

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This document supersedes [A1] EN 10169:2010 [A1].

This document includes Amendment 1 approved by CEN on 2012-02-14.

The start and finish of text introduced or altered by amendment is indicated in the text by tags [A1] [A1].

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1 Scope

This European Standard specifies requirements for continuously organic coated (coil coated) steel flat products. It particularly specifies the performance requirements.

The products covered are wide strip, sheet cut from wide strip, slit wide strip, strip rolled in widths less than 600 mm and cut lengths (from sheet or strip).

NOTE This document is not applicable to continuously organic coated flat products made of:

— tinmill products,
— electrical steels.

2 Normative references

The following referenced documents are indispensable for the application 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.

EN 10020:2000, *Definition and classification of grades of steel*

EN 10021:2006, ▌A1⟩ *General technical delivery conditions for steel products* ⟨A1▐

EN 10025-1, *Hot-rolled products of structural steels — Part 1: General technical delivery conditions*

EN 10025-2, *Hot-rolled products of structural steels — Part 2: Technical delivery conditions for non-alloy structural steels*

EN 10048, *Hot rolled narrow steel strip — Tolerances on dimensions and shape*

EN 10051, *Continuously hot-rolled uncoated plate, sheet and strip of non-alloy and alloy steels — Tolerances on dimensions and shape*

EN 10079:2007, *Definition of steel products*

EN 10111, *Continuously hot rolled low carbon steel sheet and strip for cold forming — Technical delivery conditions*

EN 10130, *Cold rolled low carbon steel flat products for cold forming — Technical delivery conditions*

EN 10131, *Cold rolled uncoated and zinc or zinc-nickel electrolytically coated low carbon and high yield strength steel flat products for cold forming —Tolerances on dimensions and shape*

EN 10139, *Cold rolled uncoated mild steel narrow strip for cold forming — Technical delivery conditions*

EN 10140, *Cold rolled narrow steel strip — Tolerances on dimensions and shape*

EN 10143, *Continuously hot-dip coated steel sheet and strip — Tolerances on dimensions and shape*

EN 10152, *Electrolytically zinc coated cold rolled steel flat products for cold forming — Technical delivery conditions*

EN 10204:2004, *Metallic products — Types of inspection documents*

EN 10268, *Cold rolled steel flat products with high yield strength for cold forming — Technical delivery conditions*

prEN 10338:2007, *Hot rolled and cold rolled non-coated flat products of multiphase steels for cold forming — Technical delivery conditions*

EN 10346, *Continuously hot-dip coated steel flat products — Technical delivery conditions*

EN 13523-0, *Coil coated metals — Test methods — Part 0: General introduction and list of test methods*

EN 13523-1, *Coil coated metals — Test methods — Part 1: Film thickness*

EN 13523-2, *Coil coated metals — Test methods — Part 2: Specular gloss*

EN 13523-3, *Coil coated metals — Test methods — Part 3: Colour difference — Instrumental comparison*

EN 13523-4, *Coil coated metals — Test methods — Part 4: Pencil hardness*

EN 13523-5, *Coil coated metals — Test methods — Part 5: Resistance to rapid deformation (impact test)*

EN 13523-6, *Coil coated metals — Test methods — Part 6: Adhesion after indentation (cupping test)*

EN 13523-7, *Coil coated metals — Test methods — Part 7: Resistance to cracking on bending (T-bend test)*

EN 13523-8, *Coil coated metals — Test methods — Part 8: Resistance to salt spray (fog)*

EN 13523-9, *Coil coated metals — Test methods — Part 9: Resistance to water immersion*

EN 13523-10, *Coil coated metals — Test methods — Part 10: Resistance to fluorescent UV light and water condensation*

EN 13523-11, *Coil coated metals — Test methods — Part 11: Resistance to solvents (rubbing test)*

EN 13523-12, *Coil coated metals — Test methods — Part 12: Resistance to scratching*

EN 13523-14, *Coil coated metals — Test methods – Part 14: Chalking (Helmen method)*

EN 13523-15, *Coil coated metals — Test methods — Part 15: Metamerism*

EN 13523-18, *Coil coated metals — Test methods — Part 18: Resistance to staining*

EN 13523-19, *Coil coated metals — Test methods — Part 19: Panel design and method of atmospheric exposure testing*

EN 13523-21, *Coil coated metals — Test methods — Part 21: Evaluation of outdoor exposure panels*

EN 13523-22, *Coil coated metals — Test methods — Part 22: Colour difference — Visual comparison*

EN 13523-23, *Coil coated metals — Test methods — Part 23: Colour stability in humid atmospheres containing sulphur dioxide*

EN 13523-24, *Coil coated metals — Test methods—– Part 24: Resistance to blocking and pressure marking*

EN 13523-25, *Coil coated metals — Test methods — Part 25: Resistance to humidity*

EN 13523-26, *Coil coated metals — Test methods — Part 26: Resistance to condensation of water*

EN 13523-27, *Coil coated metals — Test methods — Part 27: Resistance to humid poultice (Cataplasm test)*

EN ISO 2815, *Paints and varnishes — Buchholz indentation test (ISO 2815:2003)*

EN ISO 4618:2006, *Paints and varnishes — Terms and definitions (ISO 4618:2006)*

EN ISO 4628-2, *Paints and varnishes — Evaluation of degradation of coatings — Designation of quantity and size of defects, and of intensity of uniform changes in appearance — Part 2: Assessment of degree of blistering (ISO 4628-2:2003)*

EN ISO 4628-4, *Paints and varnishes — Evaluation of degradation of coatings — Designation of quantity and size of defects, and of intensity of uniform changes in appearance — Part 4: Assessment of degree of cracking (ISO 4628-4:2003)*

EN ISO 4628-5, P*aints and varnishes — Evaluation of degradation of coatings — Designation of quantity and size of defects, and of intensity of uniform changes in appearance — Part 5: Assessment of the degree of flaking (ISO 4628-5:2003)*

EN ISO 8044:1999, *Corrosion of metals and alloys — Basic terms and definitions (ISO 8044:1999)*

EN ISO 9227*, Corrosion tests in artificial atmospheres — Salt spray tests (ISO 9227:2006)*

EN ISO 12944-2:1998, *Paints and varnishes — Corrosion protection of steel structures by protective paint systems — Part 2: Classification of environments (ISO 12944-2:1998)*

ISO 4997, *Cold-reduced carbon steel sheet of structural quality*

3 Terms and definitions

For the purpose of this document, the terms and definitions given in EN 10020:2000, EN 10021:2006, EN 10079:2007, EN 10204:2004, EN ISO 4618:2006, EN ISO 8044:1999, EN ISO 12944-2:1998 and the following apply.

3.1
accessibility
ease of access to the steel components for the purpose of inspection and maintenance without any work over and above that concerned with routine inspection

3.2
ambience
environmental conditions which prevail in the interior of the building

NOTE 1 These conditions determine the corrosivity category of the ambience and include different parameters such as the air temperature, the relative humidity, the operating conditions in the building (e.g. use of aggressive chemical products, refrigerated areas).

NOTE 2 It should be noted that the atmosphere surrounding the building can influence the ambience.

NOTE 3 Annex A gives an example of classification of types of ambience.

3.3
building interior application
application in buildings for which the concerned construction products (i.e. components of the building fabric) are submitted to the influence of interior ambiences without significant exposure of any side of the product to the influence of exterior atmospheres

NOTE 1 Building products include, for example: liner trays, ribbed profiles for roofing and walling, curved profiles, brake-pressed profiles, interior wall panels for partitions, ceiling panels, suspended frames (for suspended ceilings), factory foamed (or mineral wool) sandwich panels for cold rooms or rooms with controlled ambience, interior door frames, interior metal doors, interior metal windows.

NOTE 2 Some coil coated products can be used for interior applications having special performance requirements, e.g. lighting. In such cases, these particular requirements should also be considered in consultation with the manufacturer.

NOTE 3 For interior building elements, it is important that the risk of corrosive attack on the reverse side of the element should also be considered. This can be especially important in double-skin assemblies (e.g. built up insulated cladding) where the reverse side of the interior element is not easily accessible for maintenance and/or in situations where the interior element is expected to provide long-term durability.

NOTE 4 Besides the requirements written in this document, there can be other international or national requirements or regulations regarding fire, safety, food contact etc. that should be considered at the time of enquiry and order.

3.4
building exterior application
application in buildings for which the concerned products are submitted to the influence of exterior atmospheres

NOTE 1 Building products include, for example, ribbed profiles for roofing and walling, curved profiles, brake-pressed profiles, concealed fix roofing and walling, standing seam roofing, corrugated sheeting, cladding goods, sandwich panels for roofing and walling, roof tiles, accessories (flashings, trims), rainwater goods (gutters, down pipes), metal doors and garage doors.

NOTE 2 For exterior building elements, it is important that the risk of corrosive attack on internal, i.e. reverse side surfaces, should also be considered. In particular, buildings with wet or chemically polluted internal environments can require a reverse side organic coating selected to provide enhanced corrosion protection.

This can be especially important in double-skin assemblies (e.g. built-up insulated cladding) where the reverse side of the exterior element is not easily accessible for maintenance and/or in situations where the exterior element is expected to provide long-term durability.

NOTE 3 Besides the requirements written in this document, other international or national requirements regarding reaction to fire , safety etc. can be agreed on at the time of enquiry and order.

3.5
coating flexibility
ability of a coating to follow without [A1] damaging [/A1] the deformation [A1] *deleted text* [/A1] of the substrate [A1] to which it is applied [/A1]

[A1] NOTE 1 The flexibility is determined during cold forming of the coated product by the T-bend test. [/A1]

[A1] NOTE 2 [/A1]Cold forming is the process where the main forming is done without heating the working piece.

3.6
coating material
material comprising organic polymers, i.e. synthetic resin or plastics, to which pigments, additives and solvents (if required) have generally been added, suitable for coil coating

NOTE These may be paints (in liquid or powder form) that when applied form an opaque film or plastic film providing protective, decorative and/or specific properties.

3.7
coating systems

3.7.1
coating system, general
combination of the coatings applied on either the top side or the reverse side consisting of one or more coats of one or more coating materials, the designation of which is derived from the relevant coating material

3.7.2
multiple-coat system
system comprising a priming coat, possibly intermediate coat(s) and a top coat with particular requirements on appearance, corrosion protection, formability, etc.

3.7.3
one-coat system
single coating either with requirements on appearance (see 3.17), formability, corrosion protection, subsequent painting, foam adhesion, etc., or as a priming coat with special properties regarding adhesion and corrosion protection for post-finishing applications

3.8
〉A1〈 nominal organic coating thickness 〉A1〈
thickness of the organic coating system 〉A1〈 either 〉A1〈 on top side 〉A1〈 or 〉A1〈 on reverse side

〉A1〈 *deleted text* 〉A1〈

3.9
nominal thickness of a coil coated product
thickness of the metal substrate including metallic coating and excluding thickness of organic coating system

3.10
coating types

3.10.1
backing coat
coating of any type on reverse side with no particular requirements on appearance, corrosion protection, formability, etc.

NOTE In the case of particular requirements, see 3.7.2.

3.10.2
film coating, permanent

plastic film applied to the substrate to which generally an adhesive and, if appropriate, a priming coat has been applied beforehand

3.10.3
film coating, temporary
strippable plastic film applied to the coated surface in order to afford a temporary protection against mechanical damage (see also 6.1.2.3)

3.10.4
intermediate coat
coat between the priming coat and the top coat

3.10.5
priming coat
first coat of a multiple-coat system

〉A1〈 NOTE 〉A1〈 In the case of particular requirements, see 3.7.2 and 3.7.3.

〉A1〈 *deleted text* 〉A1〈

3.10.6
top coat (finishing coat)
final (uppermost) coat of a multiple-coat system

3.11
coil coating
process in which an (organic) coating material is applied on rolled metal strip in a continuous process which includes cleaning, if necessary, and chemical pre-treatment of the metal surface and either:

— one-side or two-side, single or multiple application of (liquid) paints or coating powders which are subsequently cured or/and

— laminating with permanent plastic films

NOTE 1 Curing processes include those by convective or inductive heating or by radiation.

NOTE 2 Laminating with metal strip resulting in a sandwich system is possible.

NOTE 3 A one-coat chemical pre-treatment and priming coat is possible.

3.12
colour
sensation resulting from the visual perception of radiation of a given composition (related to EN 13523-22)

NOTE A colour is uniquely characterized for a defined observer and a defined light source as well as illuminating and viewing geometry by the coordinates of a point in a space (colorimetric specification with tristimulous values).

3.13
colour difference
magnitude and character of the visually perceived, i.e. qualitative, difference between two colours under daylight and artificial light respectively, or the magnitude and direction of the (instrumentally) measured and calculated difference of two colours (related to EN 13523-3)

3.14
corrosion protection (interior) category
CPI
category of coating which presents a certain level of corrosion protection, the choice of which depends on the corrosivity category, the period of protection and the accessibility

3.15
corrosion resistance (outdoor) category
RC
category of product which presents a certain level of corrosion resistance, the choice of which depends on the corrosivity category, the period of resistance and the accessibility

NOTE 1 Different categories of organic coil coated products for outdoor application classified following their level of corrosion resistance are defined. Criteria of classification are related to their level of natural and artificial outdoor corrosion resistance.

NOTE 2 These conditions determine the corrosivity category and include both meteorological and pollution parameters [EN ISO 12944-2].

NOTE 3 It should be recognized that in some local areas within a region, environmental conditions can apply which are not typical of the region as a whole, e.g. in a rural atmosphere close to a fossil fuel burning power generation plant, areas immediately down wind of the prevailing wind direction can be subjected to an environment closer to urban or even industrial atmospheres. Such special cases should be considered when organic coatings are chosen.

3.16
corrosivity category
C
category which indicates the corrosivity of the environment taking into account both atmospheric conditions prevailing around a constituent element of a structure, and micro-environmental effects and shall be used for the selection of the appropriate product (related to EN ISO 12944-2)

NOTE The relationship between corrosivity categories and types of atmospheres is given in Table 6.

3.17
gloss
optical property of a surface, characterized by its ability to reflect light (related to EN 13523-2)

NOTE For qualitative purposes, gloss ranges are often described by the terms "matt", "low gloss" or "semi-matt", "satin", "semi-gloss", "gloss" and "high gloss".