

For Cold rolled stainless steel the old BS1449 standard has been replaced by two EN Standards:

EN10088-2 Replaces BS1449-Part 2: 1983

EN10059 - Covers Heat Resisting Grades

EN10259 & Now ISO 9445: Tolerances for COLD Rolled material

MATERIAL CERTIFICATION

Where multi-certification is required, a combination of EN10088-2, EN10029 or 10051 will appear together with the appropriate ASTM Standards.

THICKNESS TOLERANCES - EN10259

Thickness (mm)	Tols (+/- mm) for given width in mm		
	1000	1250	1500
Under 0.30	0.03	-	-
0.30 to 0.49	0.04	0.04	-
0.50 to 0.59	0.045	0.05	-
0.6 to 0.79	0.05	0.05	-
0.8 to 0.99	0.055	0.06	0.06
1.0 to 1.19	0.06	0.07	0.07
1.2 to 1.49	0.07	0.08	0.08
1.5 to 1.99	0.08	0.09	0.10
2.0 to 2.49	0.09	0.10	0.11
2.5 to 2.99	0.11	0.12	0.12
3.0 to 3.99	0.13	0.14	0.14

FLATNESS TOLERANCES

Nominal Length (L) (mm)	Normal Tolerance (mm)
Up to 3000	10
Over 3000	12

LENGTH TOLERANCES

Nominal Length (L) (mm)	Normal Tolerance (mm)
Up to 2000	+5 / -0
Over 2000	+0.0025 x L / -0

WIDTH TOLERANCES

Thickness (mm)	All Plus Tols (mm) for Given Width in (mm)	
	1000	1250 & 1500
Under 1.5	+1.5	+2.0
1.5 to 2.49	+2.0	+2.5
2.5 to 3.49	+3.0	+3.0
3.5 and Over	+4.0	+4.0

FINISHES ACCORDING TO BS EN 10088-2 / 10028-7

BS EN Finish	Old BS Finish	Description
Hot Rolled		
1C	0	Hot rolled, heat treated, not descaled
1E	1	Hot rolled, heat treated, mechanically descaled
1D	1	Hot Rolled, heat treated, pickled
1U	-	Hot rolled, not heat treated, not descaled
Cold Rolled		
2C	-	Cold rolled, heat treated, not descaled
2E	-	Cold rolled, heat treated, mechanically descaled
2D	2D	Cold Rolled, heat treated, pickled
2B	2B	Cold Rolled, heat treated, pickled, skin passed
2R	2A / (BA)	Cold Rolled bright annealed
2Q	-	Cold Rolled, hardened & tempered, scale free

FINISHES ACCORDING TO BS EN 10088-2 / 10028-7

*NOTE: Special finishes indicate hot rolled (1) and cold rolled (2) sheets, e.g.: Ground polished hot rolled sheets + 1G / Ground polished cold rolled sheets = 2G

For more information on stainless steel finishes please refer to the AALco technical datasheet on this subject.

BS EN Finish	Old BS Finish	Special Finishes - Description	Typical Grit	Typical Ra
1G or 2G	-	Ground Grit	120	2.5 to 2.0
1J or 2J	3B	Brushed - Unidirectional	180	1.2 to 1.0
1J or 2J	4	Dull Polished - Unidirectional	240	0.6
1K or 2K	5	Satin Polished - Unidirectional	320	0.5 Max
1P or 2P	7	Bright Polished - Non-Directional with a high degree of image clarity	600	0.1
1P or 2P	8	Mirror Finish - Non-Directional with a very high degree of image clarity	800	0.05
1M or 2M	-	Patterned		
2L	-	Coloured		
2W	-	Corrugated		
1S or 2S	-	Surface Coated (Metallic coatings such as tin, lead or aluminium)		

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REVISION HISTORY

Datasheet Updated 18 July 2019

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