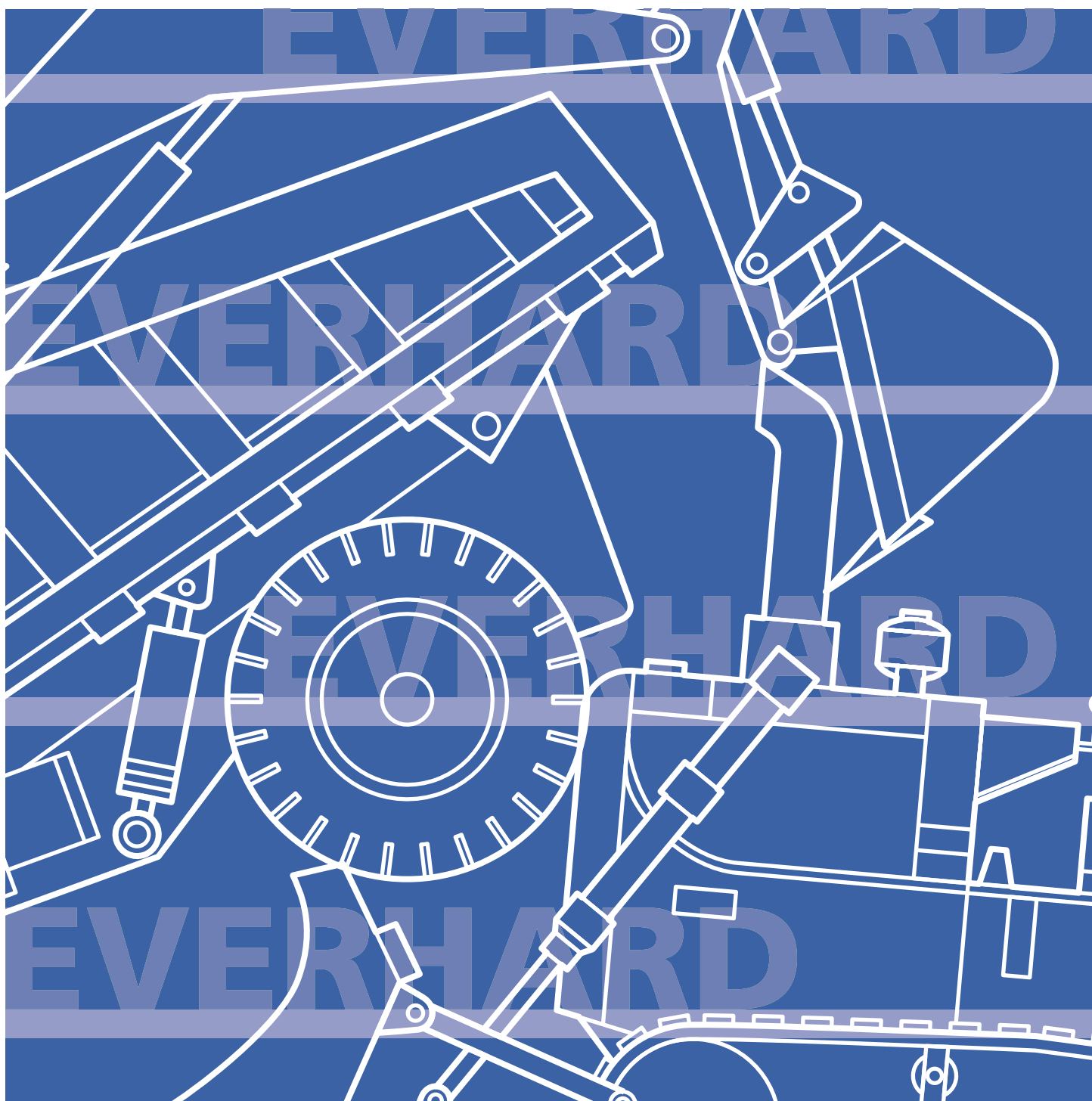


Recommended Practice

in Flame Gas Cutting and Storage for High Grade JFE-EVERHARD Steel Plates



Recommended Practice in Flame Gas Cutting and Storage for High Grade JFE-EVERHARD Steel Plates

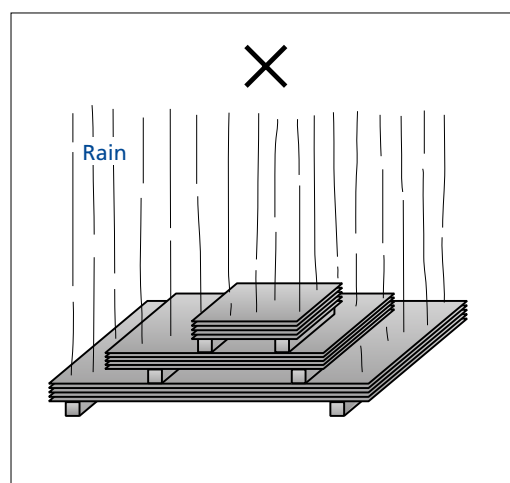
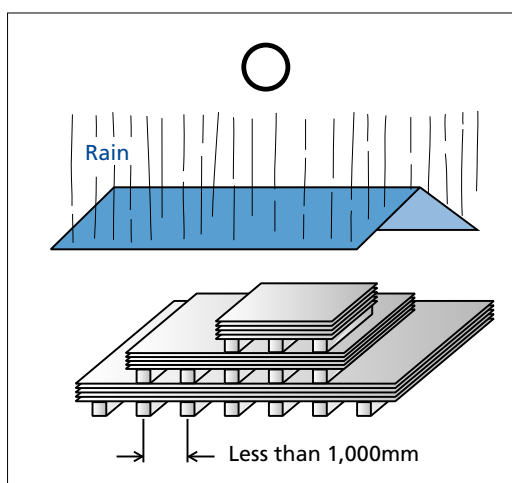
JFE-EH450, JFE-EH500, JFE-EH500A

To prevent cracking problems of High Grade JFE-EVERHARD Steel Plates, JFE would like to request the following customer's attention.

1. Storage

In storing, deflection and distortion of the plates should be minimized, and the plates have to be waterproofed to prevent rusting and pitting by corrosion from which cracks would be originated.

When a waterproof sheet is used, it should be removed away occasionally to reduce the humidity inside.



2. Flame Gas Cutting

- The notches formed on cut surface, which are causes of cracks, should be prevented.
And the gas and oxygen pressures are raised to a level and a low cutting speed is also recommended.

The table shows a recommendation of flame gas cutting speed.

Plate Thickness mm	Flame Gas Cutting Speed mm/min.
~ 29.9	250
30.0 ~ 49.9	200
50.0 ~ 69.9	200
70.0 ~100.0	150

- Post heating at around 200°C or heating by a dummy burner behind the cutting burner is recommended for the plates in thickness more than 20mm.
- When notches are produced while cutting, the notches might be the cause of cracking.
Therefore it is recommended that the notches are removed with grinder or suitable tools.
- It is noted that cracking has incubation time of several hours after gas cutting, then inspection of gas cut surface after several hours is recommended.



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