



COLD ROLLED STEEL SHEET



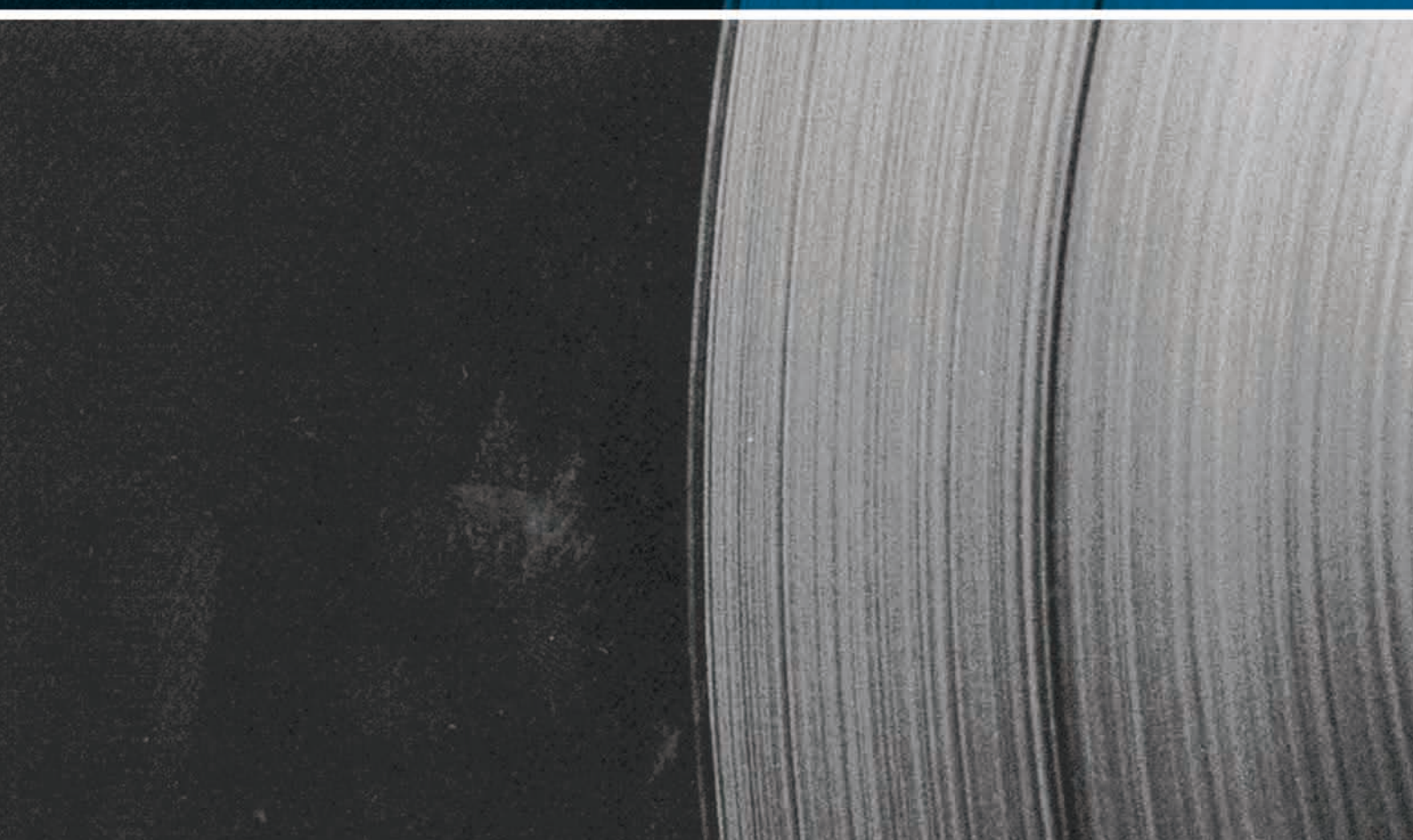
COLD ROLLED STEEL SHEET

JFE Steel Corporation

Cold rolled steel sheets offer a variety of outstanding properties, including easy formability and a smooth, clean surface, and are used in automobiles, appliances, furniture, and many other everyday items.

JFE Steel Corporation who holds ISO9001, QS-9000 and ISO14001 certifications, produces a full range of cold rolled products for these and other applications. Because strict quality requirements are now applied to meet the needs of improved product functions, JFE has adopted an integrated quality control system. Customer requirements are reflected in products from the quality design stage in order to supply customers with the optimum material for each application in a timely manner.

Based on a wealth of experience and an advanced production system, JFE is continuing to develop new technologies and products which meet the needs of the times.



Characteristics

Superior workability

JFE's cold rolled products have excellent formability and minimal deviation in mechanical properties thanks to the company's accumulated technical expertise, newly constructed and modernized facilities and innovative technologies, and integrated quality control system extending from raw materials to the final product.

Superior surface quality and dimensional accuracy

Modern facilities, advanced operational technologies, strict inspection, and integrated quality control ensure excellent surface quality. Dimensional accuracy is guaranteed by an automatic thickness control system using advanced numerical models.

Wide range of product standards

JFE produces cold rolled products to meet a wide range of product standards, including JIS and other public standards, as well as internal JFE standards. Products range from general use, including extra deep drawing quality and bake hardening sheets, to high strength sheets and sheets for enameling and other special applications.

Wide range of sizes

The available size range includes thickness from 0.14mm to 3.2 mm and width up to 1,850mm.

Superior shape

Applying tension leveler ensures superior strip flatness.

Outstanding technical service

To meet the requirements of diverse clients, JFE has established a complete technical servicing system with advises clients on questions ranging from material properties to processing technologies.

Cold rolled steel sheet

Contents

Characteristics	1
Manufacturing process	2
Correspondence with JFE standards to public standards	4
Product Standards, Characteristics and Application	5
JFE Standards	8
Dimensional and shape tolerances	18
Available product size range.....	20
Surface finish	24
Packaging and labeling	25
Remarks on product use and handling precautions / Instructions for ordering	26
(Appendix) Extracts from Japanese Industrial Standard (JIS) (1)	27
(Appendix) Extracts from Japanese Industrial Standard (JIS) (2)	28

Manufacturing process



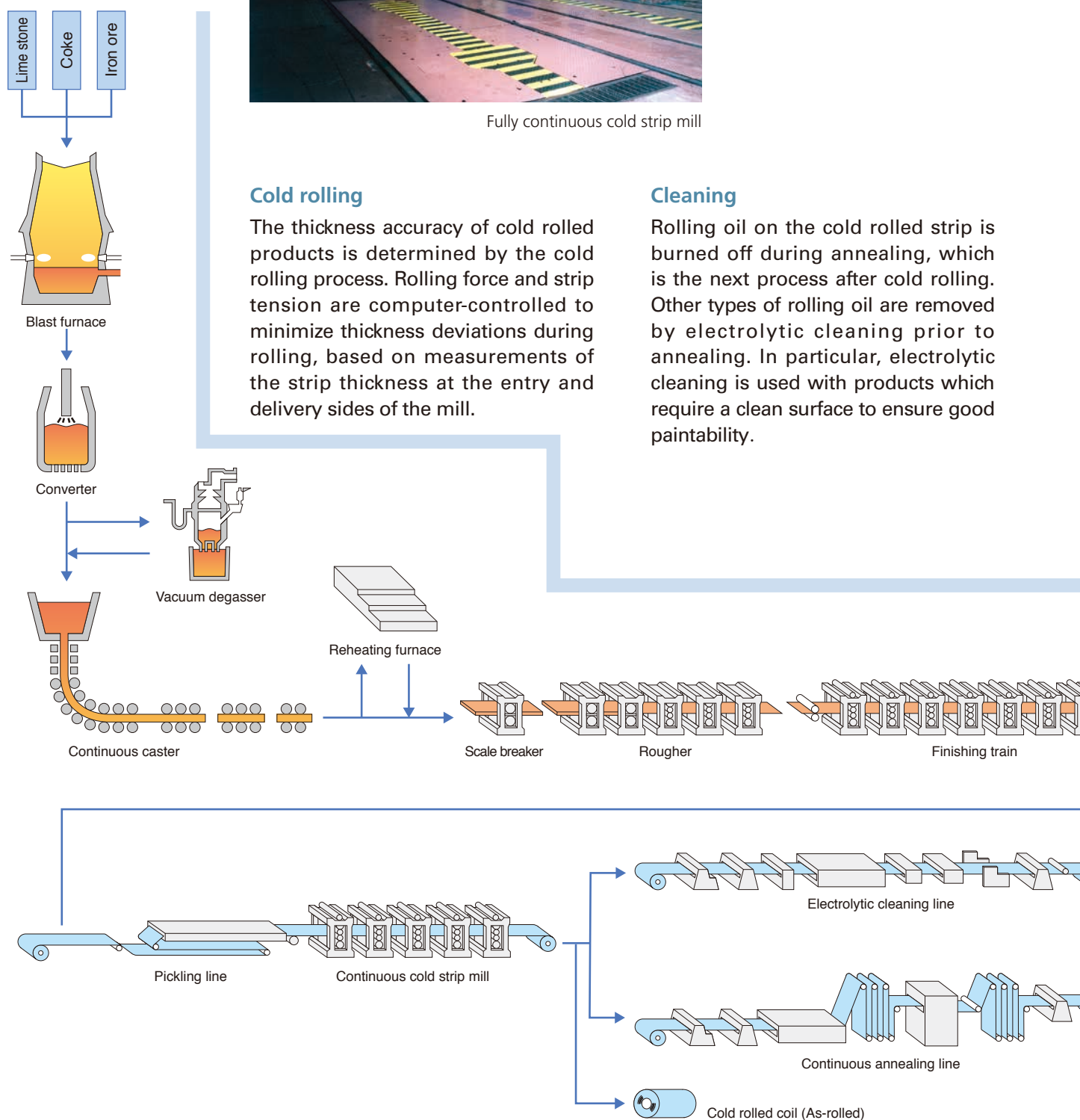
Fully continuous cold strip mill

Cold rolling

The thickness accuracy of cold rolled products is determined by the cold rolling process. Rolling force and strip tension are computer-controlled to minimize thickness deviations during rolling, based on measurements of the strip thickness at the entry and delivery sides of the mill.

Cleaning

Rolling oil on the cold rolled strip is burned off during annealing, which is the next process after cold rolling. Other types of rolling oil are removed by electrolytic cleaning prior to annealing. In particular, electrolytic cleaning is used with products which require a clean surface to ensure good paintability.



Annealing

The formability of products is determined by annealing. Because cold rolling significantly increases material hardness, making forming difficult, annealing is performed to improve ductility by inducing a recrystallized structure in the steel. As the annealing process, coils are piled and covered by the box and annealed and this is called the batch annealing. The other is the continuous annealing process, in which coils are continuously treated. JFE uses two annealing technologies, depending on product requirements.

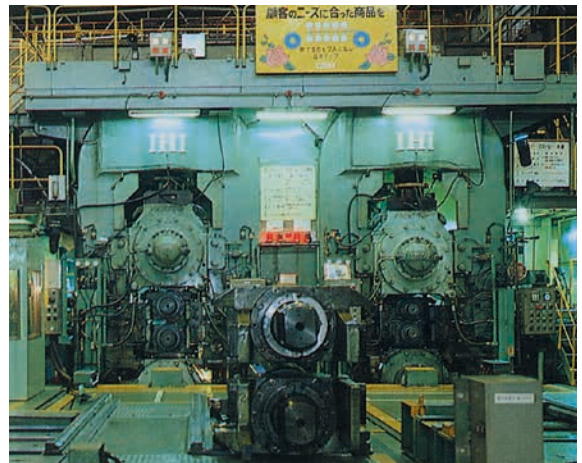
JFE is among the world's leaders in process technology for the continuous annealing line (CAL), and has also used the CAL to develop a wide range of new products, from 1500N/mm² high strength steel to non-aging extra deep drawing grade. JFE's advanced CALs are highly computerized and feature automatic quality assurance equipment, such as an automatic surface inspection device which was developed by JFE.



Continuous annealing line

Skinpass rolling

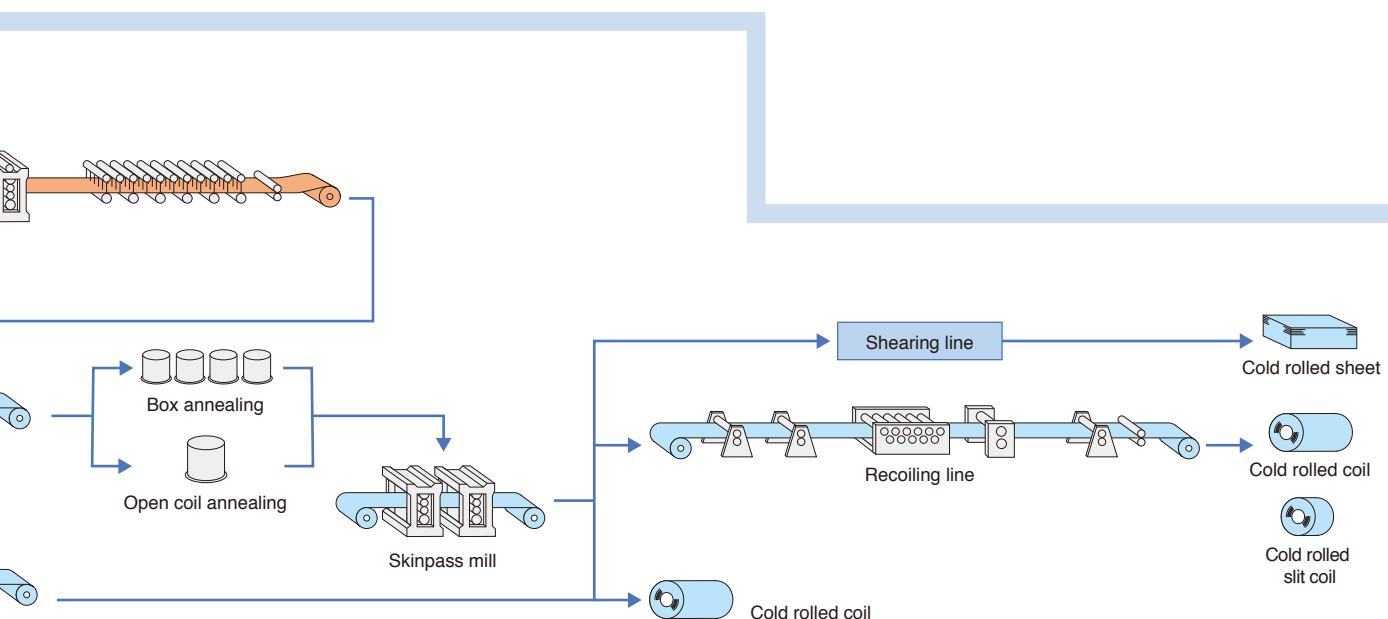
Annealed coils are lightly rolled by the skinpass mill to prevent a defect called stretcher strain, improve strip shape, and adjust mechanical properties. Skinpass rolling is also used to produce dull finish and bright finish products.



Skinpass mill

Finishing

After skinpass rolling, coils are processed at the recoiling line, where they are cut to produce product coils of the specified weight, or at the shearing line, where they are cut to sheets of the specified dimensions. Product thickness, width, shape, and surface quality are inspected, and mechanical properties are tested using specimens taken at the finishing line.



Correspondence with JFE standards to public standards

Classification	JFE standard	JIS	ASTM	Others
Steel sheets for general uses	JFE-CC JFE-CD JFE-CE	G 3141 SPCC SPCD SPCE	A109 A1008	BS1449 Part1 DIN1623-2 BS EN10130 DIN EN10130 BS EN10139 DIN EN10139
High strength steel sheets	JFE-CA	G 3135 SPFC	A980 A1008	
Atmospheric corrosion resistance steel sheets	JFE-CCUP	G 3125 SPA-C	A606	BS EN10155 DIN EN10155
Corrosion resistance steel sheets	JFE-ASA			
Steel sheets for porcelain enameling	JFE-CPE	G 3133 SPP	A424	BS EN10209 DIN EN10209
Steel sheets for electric wire sheath	JFE-CWD			
Steel sheets for galvanizing	JFE-CKT			
Steel sheets without annealing	JFE-CNA			
Steel sheets in high temperature atmosphere	JFE-CHCR			

Product Standards, Characteristics and Application

JFE Steel is producing wide range of products which have excellent characteristics based on the public standards like Japanese Industrial Standard(JIS) to original JFE standard, at the East Japan Works (Chiba and Keihin plants) and the West Japan Works (Fukuyama and Kurashiki plants).



Public Standard Products

JFE Steel is producing products based on following public standards.

● Japanese Industrial Standard (JIS)

	Classification	Designation	Characteristics and Application
G 3141	Cold-reduced carbon steel sheets and strip	SPCC, SPCC-T SPCD, SPCE, SPCF	Best suited for automobiles, electrical appliances, etc. due to wider workable ranges from commercial to deep drawing qualities.
G 3135	Cold rolled high strength steel sheets with improved formability for automobile structure use	SPFC SPFC***Y SPFC***H	Mainly used for automobiles due to high strength and improved formability.
G 3125	Superior atmospheric corrosion resisting rolled steels	SPA-C	Best suited for rolling stock bodies or constructions due to superior atmospheric corrosion resistance.

● The Japan Iron and Steel Federation Standard (JFS)

	Classification	Designation	Characteristics and Application
A 2001	Cold rolled steel sheets for automobile use	JSC	Specifying cold rolled steel products for automobile use (General use to high strength steel)

JFE Standard Products

JFE Steel is producing cold rolled steel sheets for general use, high strength steel sheets and cold rolled steel sheets for special use based on JFE standards.

● Cold rolled steel sheets for general use

Classification	Designation	Pages	Characteristics and Application
Commercial quality	JFE-CC	8~9	<p>JFE produces six grades of cold rolled soft steel products, ranging from commercial quality JFE-CC (equivalent to JIS-SPCC) to extra deep drawing quality JFE-CG, which is superior to JIS-SPCF, and ultra deep drawing quality JFE-CGX, which features an extremely high plastic strain ratio (mean r-value).</p> <p>JFE also produces two grades of bake hardenable (BH) cold rolled steel products which have a increased yield point during baking after painting.</p>
Drawing quality	JFE-CD		
Deep drawing quality 1	JFE-CE		
Deep drawing quality 2	JFE-CF		
Extra deep drawing quality	JFE-CG		
Ultra deep drawing quality	JFE-CGX		
Bake hardenability quality	JFE-CEH		
Deep drawing quality with bake hardenability	JFE-CGH		

● Cold rolled high strength steel sheets

Classification	Designation	Pages	Tensile Strength (N/mm ²)									
			340	370	390	440	490	540	590	780	980	
Commercial quality	JFE-CA...	10~13	○	○	○	○	○	—	○	○	○	
Deep drawing quality with bake hardenability	JFE-CA...H		○	—	—	—	—	—	—	—	—	
Drawing quality	JFE-CA...F		○	○	○	○	—	—	—	—	—	
Deep drawing quality	JFE-CA...P		○	○	○	○	—	—	—	—	—	
Extra deep drawing quality	JFE-CA...G		○	○	○	○	—	—	—	—	—	
High stretch flange formability quality	JFE-CA...SF		—	—	—	○	—	—	○	○	○	
Low yield ratio quality type 1	JFE-CA...Y1		—	—	—	○	—	—	○	○	○	
Low yield ratio quality type 2	JFE-CA...Y2		—	—	—	—	—	—	○	○	○	
High elongation quality	JFE-CA...A		—	—	—	—	—	—	○	○	—	

● Cold rolled steel sheets for special use

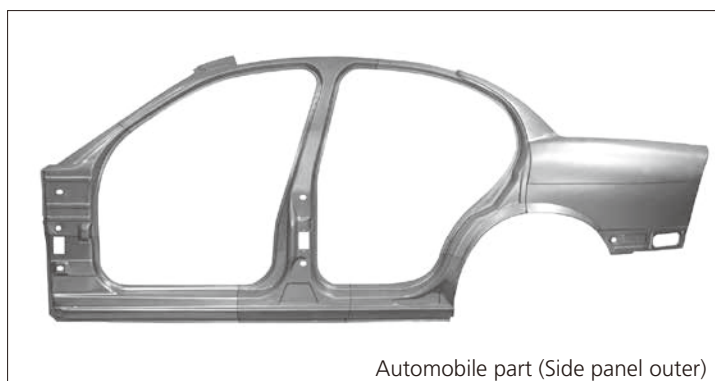
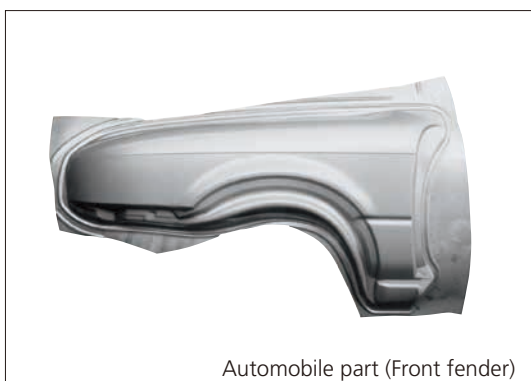
Classification	Designation	Pages	Characteristics and Application
Cold rolled steel sheets for porcelain enameling	JFE-CPE	14	Chemical compositions are adjusted for porcelain enameling use. General use or deep drawing, 1-coat or 2-coat usages are available.
Cold rolled steel sheets for electric wire sheath	JFE-CWD	15	Products especially developed for electric wire sheathing. Superior for welding and working.
Cold rolled steel sheets for galvanizing	JFE-CKT	15	Annealed cold-rolled sheet as the mother material for galvanizing is available.
Cold rolled steel sheets without annealing	JFE-CNA	16	Non-annealed cold-rolled sheet of thinner gages are available. Suitable for application needed strength without forming.
Cold rolled corrosion resistance steel sheets	JFE-ASA	16	Having superior resistance against sulfuric acid corrosion and atmospheric corrosion. Suitable to the air pre-heater of boilers, heat exchangers, chemical plants and exhaust chambers.
Cold rolled atmospheric corrosion resistance high strength steel sheets	JFE-CCUP	17	Having the superior corrosion resistance without painting due to the stable oxide film. Suitable to rolling stock bodies and structures.
Cold rolled steel sheets in high temperature atmosphere	JFE-CHCR	17	Having superior anti-oxidation properties and keeping strength under high temperature(450-600°C). Suitable to application like chimney ducts, needed heat resistance and workability.

			Characteristics	Application for automobile
1180	1370	1470		
○	○	○	Suitable for general processing like drawing or bending. Applying the water-quenching by a continuous annealing process, maximum 1,470N/mm ² tensile strength is available.	<ul style="list-style-type: none"> · Structure · Reinforce
—	—	—	Superior in deep drawability and bake-hardening. Suitable for outer parts of automobiles which require anti-dent properties.	<ul style="list-style-type: none"> · Outer panel
—	—	—	Superior ductility and suitable to drawing application.	<ul style="list-style-type: none"> · Outer panel · Inner part
—	—	—	Having excellent ductility and high r-value, suitable materials for deep drawing.	<ul style="list-style-type: none"> · Outer panel · Inner part
—	—	—	Adding excellent r-value and ductility with attaining super fine grain structure, suitable materials for extra deep drawing because of having good secondary-embrittlement resistance.	<ul style="list-style-type: none"> · Outer panel · Inner part
○	—	—	Having excellent ductility and high stretch flange formability, suitable for drawing with flange expansion forming.	<ul style="list-style-type: none"> · Structure · Reinforce
○	—	—	Having excellent ductility and high work hardening coefficient, suitable material for deep drawing processing.	<ul style="list-style-type: none"> · Structure · Reinforce
○	—	—		
—	—	—	Applying TRIP (Transformation Induced Plasticity) effects, excellent ductility and work hardening coefficient are achieved at the high strain range.	<ul style="list-style-type: none"> · Structure · Reinforce

JFE Standards

Cold rolled steel sheets for general use JFE-C

JFE produces six grades of cold rolled soft steel products, according to formability, ranging from commercial quality JFE-CC (equivalent to JIS-SPCC) to extra deep drawing quality JFE-CG, which is superior to JIS-SPCF, and ultra deep drawing quality JFE-CGX, which features an extremely high plastic strain ratio (mean r-value). JFE also produces two grades of bake-hardening (BH) cold rolled sheets, which display yield point increase when baked after painting.



● Mechanical Properties

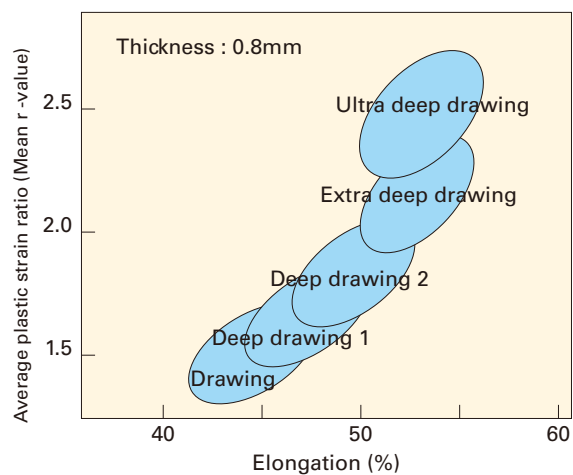
Classification	Designation	Tensile Test					
		Yield Point min. (N/mm ²)			Tensile Strength min. (N/mm ²)		
		Thickness mm					
		0.4 ≤ < 0.8	0.8 ≤ < 1.0	1.0 ≤ ≤ 3.2		0.4 ≤ < 0.6	0.6 ≤ < 0.8
Commercial quality	JFE-CC	(145)	(135)	(125)	(270)	(37)	(38)
Drawing quality	JFE-CD	135	125	115	270	40	41
Deep drawing quality 1	JFE-CE	130	120	110	270	42	43
Deep drawing quality 2	JFE-CF	120	110	100	270	44	45
Extra deep drawing quality	JFE-CG	100		90	260	46	47
Ultra deep drawing quality	JFE-CGX	100		90	260	46	47
Bake hardenability quality	JFE-CEH	135	125	115	270	40	41
Deep drawing quality with bake hardenability	JFE-CGH	135	125	115	260	—	44

- Reference
1. JIS No.5 test piece for tensile test taken in rolling direction.
 2. For thickness less than 0.6mm, the above tests are omitted if not specifically requested.
 3. Figures in parentheses are reference values.

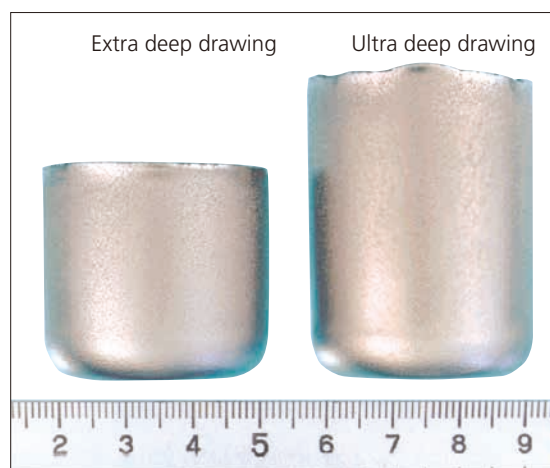
● Dimensional tolerance

Size tolerances conform JIS G 3141(Cold-reduced carbon steel sheets and strip). Refer to page 18.

Relation between elongation and average plastic strain ratio
(mean r-value) of cold rolled steel



Comparison of height of cups cylinder between extra
deep drawing and ultra deep drawing quality



						Mean r-value min.		BH Value min. (N/mm²)
Elongation min. (%)								
Thickness mm						Thickness mm		
0.8 ≤ < 1.0	1.0 ≤ < 1.2	1.2 ≤ < 1.6	1.6 ≤ < 2.0	2.0 ≤ < 2.5	2.5 ≤ ≤ 3.2	0.5 ≤ ≤ 1.0	1.0< ≤ 1.6	
(39)	(40)	(41)	(42)	(43)	(44)	—	—	—
42	43	44	45	46	47	(1.2)	(1.1)	—
44	45	46	47	48	49	(1.4)	(1.3)	—
46	47	48	49	50	51	(1.6)	(1.5)	—
48	49	50	51	52	—	1.8	1.7	—
48	49	50	—	—	—	2.1	2.0	—
42	43	44	45			(1.4)	(1.3)	30
45	46	—				(1.6)	(1.4)	30

● Available product size range

The available size range is shown on page 20.

Cold rolled high strength steel sheets (1) JFE-CA

Cold rolled high strength steel sheets produced by JFE have varieties from a commercial quality to an extra deep drawing quality. Applying the original JFE technology of the continuous annealing line, a wide range of tensile strength from 340N/mm² class to 1,470N/mm² class is available.

● Mechanical Properties

Classification	Designation							
		Yield Point min. (N/mm ²)			Tensile Strength min. (N/mm ²)			
		Thickness mm						
		0.4 ≤ < 0.8	0.8 ≤ < 1.0	1.0 ≤ ≤ 3.2		0.4 ≤ < 0.6	0.6 ≤ < 0.8	
Commercial quality	JFE-CA340	205	195	185	340	33	34	
Commercial quality	JFE-CA370	205	195	185	370	30	31	
Commercial quality	JFE-CA390	245	235	225	390	29	30	
Commercial quality	JFE-CA440	285	275	265	440	26	27	
Commercial quality	JFE-CA490	305	295	285	490	—	23	
Commercial quality	JFE-CA590	430	420	410	590	—	17	
Commercial quality	JFE-CA780	420	410	400	780	—	12	
Commercial quality	JFE-CA980	600	590	580	980	—	(8)	
Commercial quality	JFE-CA1180	—	—	825	1180	—		
Commercial quality	JFE-CA1370	—	—	950	1370	—		
Commercial quality	JFE-CA1470	—	—	1000	1470			
Deep drawing quality with bake hardenability	JFE-CA340H	185	175	165	340	34	35	
Drawing quality	JFE-CA340F	185	175	165	340	33	34	
Drawing quality	JFE-CA370F	195	185	175	370	31	32	
Drawing quality	JFE-CA390F	225	215	205	390	29	30	
Drawing quality	JFE-CA440F	265	255	245	440	26	27	
Deep drawing quality	JFE-CA340P	165	155	145	340	35	36	
Deep drawing quality	JFE-CA370P	175	165	155	370	33	34	
Deep drawing quality	JFE-CA390P	205	195	185	390	31	32	
Deep drawing quality	JFE-CA440P	245	235	225	440	28	29	
Extra deep drawing quality	JFE-CA340G	155	145	135	340	35	36	
Extra deep drawing quality	JFE-CA370G	165	155	145	370	33	34	
Extra deep drawing quality	JFE-CA390G	195	185	175	390	31	32	
Extra deep drawing quality	JFE-CA440G	235	225	215	440	—	29	

Reference 1. JIS No.5 test piece for tensile test taken transverse to rolling direction.
 2. For thickness less than 0.6mm, the above tests are omitted if not specifically requested.
 3. Figures in parentheses are reference values.



Tensile Test						Mean r-value min.		BH Value min. (N/mm²)	Hole Expanding Ratio min. λ (%)
Elongation min. (%)									
Thickness mm						Thickness mm			
0.8 ≤ < 1.0	1.0 ≤ < 1.2	1.2 ≤ < 1.6	1.6 ≤ < 2.0	2.0 ≤ < 2.5	2.5 ≤ ≤ 3.2	0.5 ≤ ≤ 1.0	1.0 < ≤ 1.6		
35	36	37	38			—	—	—	—
32	33	34	35			—	—	—	—
31	32	33	34			—	—	—	—
28	29	30	31			—	—	—	—
24	25	25	26		—	—	—	—	—
	18				—	—	—	—	—
13	14	15	16		—	—	—	—	—
(9)	(10)	(11)	(12)		—	—	—	—	—
	(6)	(7)	(8)		—	—	—	—	—
	(5)				—	—	—	—	—
—			(4)		—	—	—	—	—
36	37	38	39			(1.5)	(1.4)	30	—
35	36	37	38			(1.4)	(1.3)	—	—
33	34		35			(1.4)	(1.3)	—	—
31	32	33	34			(1.4)	(1.3)	—	—
28	29	30	31			(1.3)	(1.2)	—	—
37	38	39	40		—	(1.5)	(1.4)	—	—
35	36	37	38		—	(1.5)	(1.4)	—	—
33	34	35	36		—	(1.5)	(1.4)	—	—
30	31	32	33		—	(1.4)	(1.3)	—	—
37	38	39	40		—	1.7	1.6	—	—
35	36	37	38		—	1.7	1.6	—	—
33	34	35	36		—	1.7	1.6	—	—
30	31	32	33		—	1.6	1.5	—	—

Cold rolled high strength steel sheets (2) JFE-CA

●Mechanical Properties (Cont.)

Classification	Designation						
		Yield Point min. (N/mm ²)			Tensile Strength min. (N/mm ²)		
		Thickness mm					
		0.4 ≤ < 0.8	0.8 ≤ < 1.0	1.0 ≤ ≤ 3.2		0.4 ≤ < 0.6	0.6 ≤ < 0.8
High stretch flange formability quality	JFE-CA440SF	320	310	300	440	—	24
High stretch flange formability quality	JFE-CA590SF	430	420	410	590	—	
High stretch flange formability quality	JFE-CA780SF	—	—	500	780	—	—
High stretch flange formability quality	JFE-CA980SF	—	—	630	980	—	—
High stretch flange formability quality	JFE-CA1180SF	—	—	875	1180	—	—
Low yield ratio quality type 1	JFE-CA440Y1	235	225	215	440	—	29
Low yield ratio quality type 1	JFE-CA590Y1	—	315	305	590	—	—
Low yield ratio quality type 1	JFE-CA780Y1	—	—	400	780	—	—
Low yield ratio quality type 1	JFE-CA980Y1	—	—	530	980	—	—
Low yield ratio quality type 1	JFE-CA1180Y1	—	—	710	1180	—	—
Low yield ratio quality type 2	JFE-CA590Y2	325	315	305	590	—	22
Low yield ratio quality type 2	JFE-CA780Y2	—	—	360	780	—	—
Low yield ratio quality type 2	JFE-CA980Y2	—	—	530	980	—	—
Low yield ratio quality type 2	JFE-CA1180Y2	—	—	710	1180	—	—
High elongation quality type (Retained austenite)	JFE-CA590A	355			590	—	27
High elongation quality type (Retained austenite)	JFE-CA780A	—	—	400	780	—	—

Reference 1.JIS No.5 test piece for tensile test taken transverse to rolling direction.

2.For thickness less than 0.6mm, the above tests are omitted if not specifically requested.

3.Figures in parentheses are reference values.

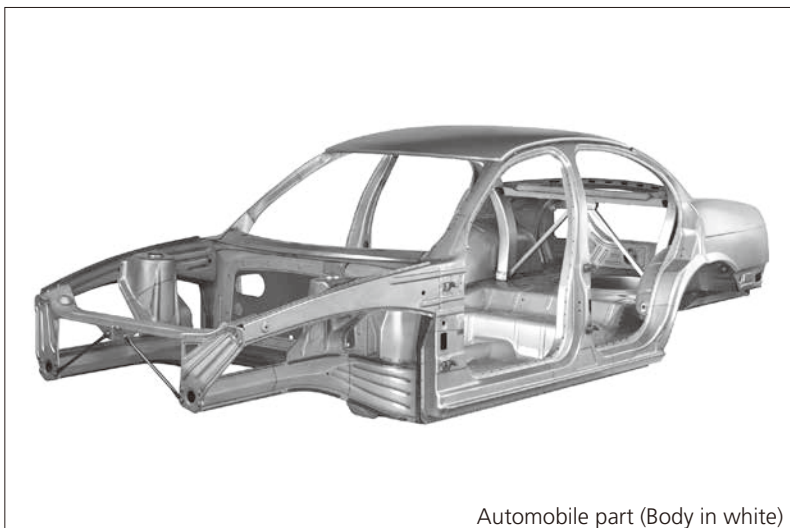
●Dimensional tolerance

Size tolerances conform JIS G 3141(Cold-reduced carbon steel sheets and strip). Refer to page 18.

●Available product size range

Available size range is shown on page 21.

Tensile Test							Mean r-value min.		BH Value min. (N/mm ²)	Hole Expanding Ratio min. λ (%)
Elongation min. (%)										
Thickness mm							Thickness mm			
	0.8 ≤ < 1.0	1.0 ≤ < 1.2	1.2 ≤ < 1.6	1.6 ≤ < 2.0	2.0 ≤ < 2.5	2.5 ≤ ≤ 3.2	0.5 ≤ ≤ 1.0	1.0 < ≤ 1.6		
	25	26	27	28			—	—	—	80
17			18			—	—	—	—	60
	—	(14)				—	—	—	—	50
	—	(10)				—	—	—	—	40
	—	(7)				—	—	—	—	40
	30	31	32	33			—	—	—	—
	21	23	23	24			—	—	—	—
	—	14	15	16		—	—	—	—	—
	—	10	11	—	—	—	—	—	—	—
	—	—	7	—	—	—	—	—	—	—
	23	24	25	26			—	—	—	—
	—	19	20	21		—	—	—	—	—
	—	12	13	14		—	—	—	—	—
	—	8	9	10		—	—	—	—	—
	28	29	30	31			—	—	—	—
	—	23	24	25			—	—	—	—



Automobile part (Body in white)



Automobile part (Center pillar inner)

Cold rolled steel sheets for porcelain enameling JFE-CPE

JFE's cold rolled steel sheets for porcelain enameling are for general use, deep drawing quality and for 1-coat, 2-coat depending on application. Chemical compositions of the steel are severely controlled.

●Manufacturing Standard

Classification		Designation
1-Coat	Drawing 1	JFE-CPE1D1
	Drawing 2	JFE-CPE1D2
2-Coat, 2-Bake	Flat sheet use	JFE-CPE2P
	Commercial use	JFE-CPE2C
	Drawing	JFE-CPE2D
	Deep drawing	JFE-CPE2E



As wall material

●Typical Chemical Composition (wt.%)

Designation	C	Si	Mn	P	S	Al	N	O	Cu	Others
JFE-CPE1D1	0.0012	0.01	0.29	0.008	0.018	—	0.0018	0.055	0.030	—
JFE-CPE1D2	0.0015	0.01	0.25	0.008	0.018	—	0.0080	0.020	0.030	added
JFE-CPE2P	0.0030	0.01	0.25	0.012	0.015	—	0.0080	0.014	0.030	added
JFE-CPE2C	0.0230	0.01	0.18	0.013	0.013	0.050	0.0060	—	0.030	added
JFE-CPE2D	0.0504	0.02	0.15	0.011	0.007	0.055	0.0077	—	0.030	added
JFE-CPE2E	0.0020	0.01	0.25	0.008	0.030	0.040	0.0080	—	0.035	added

●Mechanical Properties

Designation	Yield point min. (N/mm ²)			Tensile Strength min. (N/mm ²)	Elongation min. (%)										Mean r-value min.	
	Thickness mm				Thickness mm										Thickness mm	
	0.4 ≤ <0.8	0.8 ≤ < 1.0	1.0 ≤ ≤ 3.2		0.2 ≤ <0.5	0.5 ≤ <0.6	0.6 ≤ <0.8	0.8 ≤ <1.0	1.0 ≤ < 1.2	1.2 ≤ < 1.6	1.6 ≤ < 2.0	2.0 ≤ <2.3	2.3< < 2.5	2.5 ≤ ≤ 3.2	0.5 ≤ < 1.2	1.2 ≤ ≤ 1.6
JFE-CPE1D1	135	125	115	270	39	40	41	42	43	44	45	46	46	47	(1.2)	(1.1)
JFE-CPE1D2	135	125	115	270	39	40	41	42	43	44	45	46	—	—	(1.2)	(1.1)
JFE-CPE2P	—	—	—	275	30	35	36	36	38	38	39	39	40	40	—	—
JFE-CPE2C	145	135	125	270	30	37	38	39	40	41	42	43	43	44	—	—
JFE-CPE2D	135	125	115	270	39	40	41	42	43	44	45	46	—	—	(1.2)	(1.1)
JFE-CPE2E	120	110	100	275	43	44	45	46	47	48	49	50	50	51	1.6	1.5

- Reference 1. JIS No.5 test piece for the tensile test taken to the rolling direction.
 2. In case of thickness less than 0.6mm, above tests are skipped if not requested.
 3. Figures in the parentheses are the reference values.

●Example of Mechanical Properties

Designation	Thickness mm	Yield point (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Mean r-value	n-Value
JFE-CPE1D1	0.80	165	282	51.4	1.50	0.22
JFE-CPE1D2	1.00	165	313	46.0	1.77	0.26
JFE-CPE2P	0.30	252	351	39.0	—	—
JFE-CPE2C	0.50	201	325	41.8	1.42	0.21
JFE-CPE2D	1.20	161	286	51.7	1.64	0.25
JFE-CPE2E	0.80	148	307	49.0	2.16	0.27

●Dimensional tolerance

Size tolerances conform JIS G 3141(Cold-reduced steel sheets and strip). Refer to page 18.

●Available product size range

Available size range is the same as for JFE-CF. Refer to page 20.

Cold rolled steel sheets for electric wire sheath JFE-CWD

Developed by JFE for electric wire sheathing and has good weldability and workability.

● Mechanical Properties

Designation	Tensile Test				
	Yield Point min. (N/mm ²)	Tensile Strength min. (N/mm ²)	Elongation min. (%)		
			Thickness mm		
			0.4 ≤ , < 0.6	0.6 ≤ , < 0.8	0.8 ≤ , ≤ 1.0
JFE-CWD	—	270	35	37	

Reference : 1. JIS No.5 test for the tensile test piece taken to the rolling direction.

● Dimensional tolerance

Size tolerances conform JIS G 3141(Cold-reduced steel sheets and strip). Refer to page 18.

● Available product size range

Strip thickness from 0.30mm to 1.00mm and strip widths from 610mm to 1,600mm are available.
Strip products are available in widths of 50mm to 200mm.

Cold rolled steel sheets for galvanizing JFE-CKT

Annealed cold rolled steel sheets are available for galvanizing.

● Mechanical Properties

Designation	Tensile Test									
	Yield Point min. (N/mm ²)	Tensile Strength min. (N/mm ²)	Elongation min. (%)							
			Thickness mm							
			0.4 ≤ < 0.6	0.6 ≤ < 0.8	0.8 ≤ < 1.0	1.0 ≤ < 1.2	1.2 ≤ < 1.6	1.6 ≤ < 2.0	2.0 ≤ < 2.5	2.5 ≤ ≤ 3.2
JFE-CKT	—	—	(30)	(32)	(32)	(33)	(33)	(34)	(34)	(35)

Reference : 1. JIS No.5 test piece for the tensile test taken to the rolling direction.

2. Figures in the parentheses are the reference values.

● Dimensional tolerance

Size tolerances conform JIS G 3141(Cold-reduced steel sheets and strip). Refer to page 18.

● Available product size range

Available size range is the same as for commercial quality JFE-CC. Refer to page 20.

Cold rolled steel sheets without annealing JFE-CNA

It is suitable for application which needs only toughness and no working.

●Dimensional tolerance

Size tolerances conform JIS G 3141(Cold-reduced steel sheets and strip). Refer to page 18.

●Available product size range

Available size range is shown on page 22.

Cold rolled corrosion resistance steel sheets JFE-ASA

It has superior corrosion resistance against sulfuric acid and superior atmospheric corrosion resistance. It is suitable to the air pre-heater of boilers, heat exchangers and chimney ducts, etc.

●Chemical Composition (wt.%)

Designation	C	Si	Mn	P	S	Cu	Ni	Cr	Sb	Sn	Mo
JFE-ASA400W	0.14max.	0.55max.	0.30-0.70	0.030max.	0.020max.	0.25-0.50	0.50max.	0.50-1.00	0.05-0.20	0.10max.	0.10max.
JFE-ASA440W	0.17max.	0.55max.	0.30-0.70	0.030max.	0.020max.	0.25-0.50	0.50max.	0.50-1.00	0.05-0.20	0.10max.	0.10max.

●Mechanical Properties

Designation	Tensile Test		
	Yield Point min. (N/mm ²)	Tensile Strength min. (N/mm ²)	Elongation min. (%)
JFE-ASA400W	245	400	22
JFE-ASA440W	265	440	22

Reference : 1. JIS No.5 test piece for the tensile test taken transverse to the rolling direction.

2. The bend test is available depending on a demand. JIS No.3 test piece for the bend test taken transverse to the rolling direction.

●Dimensional tolerance

Size tolerances conform JIS G 3141(Cold-reduced steel sheets and strip). Refer to page 18.

●Available product size range

Available size range is shown on page 22.

Cold rolled atmospheric corrosion resistance high strength steel sheets JFE-CCUP

Have unpainted corrosion resistance due to formation of a stable oxidation film on the strip surface.
Suitable for rolling stock bodies and exposed structures.

●Chemical Composition (wt.%)

Designation	C	Si	Mn	P	S	Cu	Ni	Cr
JFE-CCUP	0.12max.	0.25-0.75	0.20-0.50	0.07-0.15	0.040max.	0.25-0.60	0.65max.	0.30-1.25

●Mechanical Properties

Designation	Tensile Test		
	Yield Point min. (N/mm ²)	Tensile Strength min. (N/mm ²)	Elongation min. (%)
JFE-CCUP	315	450	26

Reference : 1.JIS No.5 test piece for the tensile test taken transverse to the rolling direction.

●Dimensional tolerance

Size tolerances conform JIS G 3141(Cold-reduced steel sheets and strip). Refer to page 18.

●Available product size range

Available size range is shown on page 23.

Cold rolled steel sheets in high temperature atmosphere JFE-CHCR

Have cold formability and anti-oxidation properties combined with adequate high temperature strength (450-600°C). Suitable for applications which require heat resistance and cold formability, such as chimney ducts.

●Chemical Composition (wt.%)

Designation	C	Si	Mn	P	S	Cu	Ni	Cr	Sb	Sn
JFE-CHCR	0.10max.	—	0.40max.	0.035max.	0.035max.	(Including other chemicals)				

●Mechanical Properties

Designation	Tensile Test		
	Yield Point min. (N/mm ²)	Tensile Strength (N/mm ²)	Elongation min. (%)
JFE-CHCR	—	(310-410)	(36)

Reference 1. JIS No.5 test piece for tensile test taken in rolling direction.
2. Figures in parentheses are reference values.

●Dimensional tolerance

Size tolerances conform JIS G 3141(Cold-reduced steel sheets and strip). Refer to page 18.

●Available product size range

Available size range is shown on page 23.

Dimensional and shape tolerances

Dimensional and shape tolerances as specified in JIS G 3141 (Cold-reduced carbon steel sheets and strip) are shown below. Normally, Table A is applied to thickness, width, and length tolerances. When stricter tolerances are required, Table B is applied.

● Thickness tolerance

Thickness is measured at the normal point in case of strips or coils, and at any point 15mm from the strip edge in case of sheets.

Table A

Unit mm

Thickness \ Width	< 630	630 ≤ < 1000	1000 ≤ < 1250	1250 ≤ < 1600	1600 ≤
0.25 >	±0.03	±0.03	±0.03	—	—
0.25 ≤, < 0.40	±0.04	±0.04	±0.04	—	—
0.40 ≤, < 0.60	±0.05	±0.05	±0.05	±0.06	—
0.60 ≤, < 0.80	±0.06	±0.06	±0.06	±0.06	±0.07
0.80 ≤, < 1.00	±0.06	±0.06	±0.07	±0.08	±0.09
1.00 ≤, < 1.25	±0.07	±0.07	±0.08	±0.09	±0.11
1.25 ≤, < 1.60	±0.08	±0.09	±0.10	±0.11	±0.13
1.60 ≤, < 2.00	±0.10	±0.11	±0.12	±0.13	±0.15
2.00 ≤, < 2.50	±0.12	±0.13	±0.14	±0.15	±0.17
2.50 ≤, < 3.15	±0.14	±0.15	±0.16	±0.17	±0.20
3.15 ≤	±0.16	±0.17	±0.19	±0.20	—

Table B

Unit mm

Thickness \ Width	< 160	160 ≤ < 250	250 ≤ < 400	400 ≤ < 630
< 0.10	±0.010	±0.020	—	—
0.10 ≤, < 0.16	±0.015	±0.020	—	—
0.16 ≤, < 0.25	±0.020	±0.025	±0.030	±0.030
0.25 ≤, < 0.40	±0.025	±0.030	±0.035	±0.035
0.40 ≤, < 0.60	±0.035	±0.040	±0.040	±0.040
0.60 ≤, < 0.80	±0.040	±0.045	±0.045	±0.045
0.80 ≤, < 1.00	±0.04	±0.05	±0.05	±0.05
1.00 ≤, < 1.25	±0.05	±0.05	±0.05	±0.06
1.25 ≤, < 1.60	±0.05	±0.06	±0.06	±0.06
1.60 ≤, < 2.00	±0.06	±0.07	±0.08	±0.08
2.00 ≤, < 2.50	±0.07	±0.08	±0.08	±0.09
2.50 ≤, < 3.15	±0.08	±0.09	±0.09	±0.10
3.15 ≤	±0.09	±0.10	±0.10	±0.11

●Width tolerance

Width is measured at the normal point in case strips and coils, and at any point in case of sheets.

Table A Unit mm

< 1250	1250 ≤
+7 0	+10 0

Table B Unit mm

< 1250	1250 ≤
+3 0	+4 0

●Length tolerance

Length is measured at any point in case of sheets

Table A Unit mm

Length	Tolerance
< 2000	+10, 0
2000 ≤, < 4000	+15, 0
4000 ≤, < 6000	+20, 0

Table B Unit mm

Length	Tolerance
< 1000	+3, 0
1000 ≤, < 2000	+4, 0
2000 ≤, < 3000	+6, 0
3000 ≤, < 4000	+8, 0

●Flatness

The maximum value of flatness is shown below. The flatness tolerance shall be classified into class A and class B as given Table A and Table B, respectively. These tables shall be applied to the steel sheet of standard temper grade which is 500mm or over in width during cold rolling.

Flatness shall be measured by lying a steel sheet under its own mass on flat surface plate, and the value of flatness shall be determined as the difference between the maximum deviation of convex from the flat surface and the nominal thickness of the steel sheet when its convex side is upper-most.

Table A Unit mm

Width \ Strain	Warp	EdgeWave	Buckle
< 1000	12	8	6
1000 ≤, < 1250	15	9	8
1250 ≤, < 1600	15	11	8
1600 ≤	20	13	9

Table B Unit mm

Width \ Strain	Warp	EdgeWave	Buckle
< 1000	2	2	2
1000 ≤, < 1250	3	2	2
1250 ≤, < 1600	4	3	2
1600 ≤	5	4	2

Reference : Table is not applied to the strip processed by a stretch leveler.

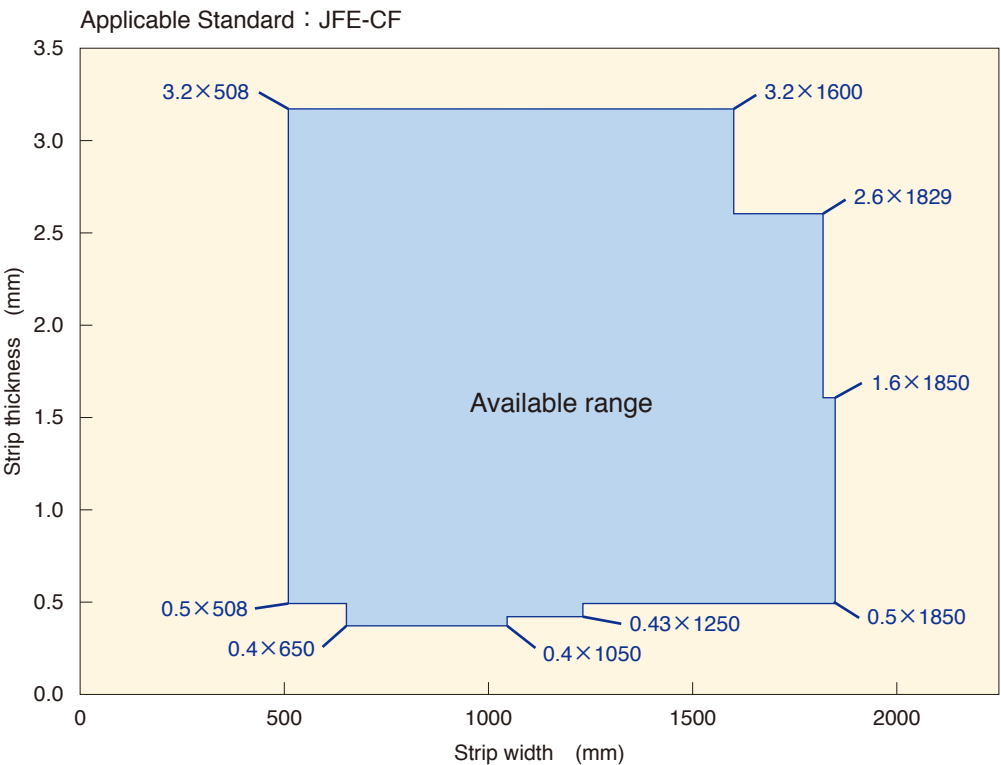
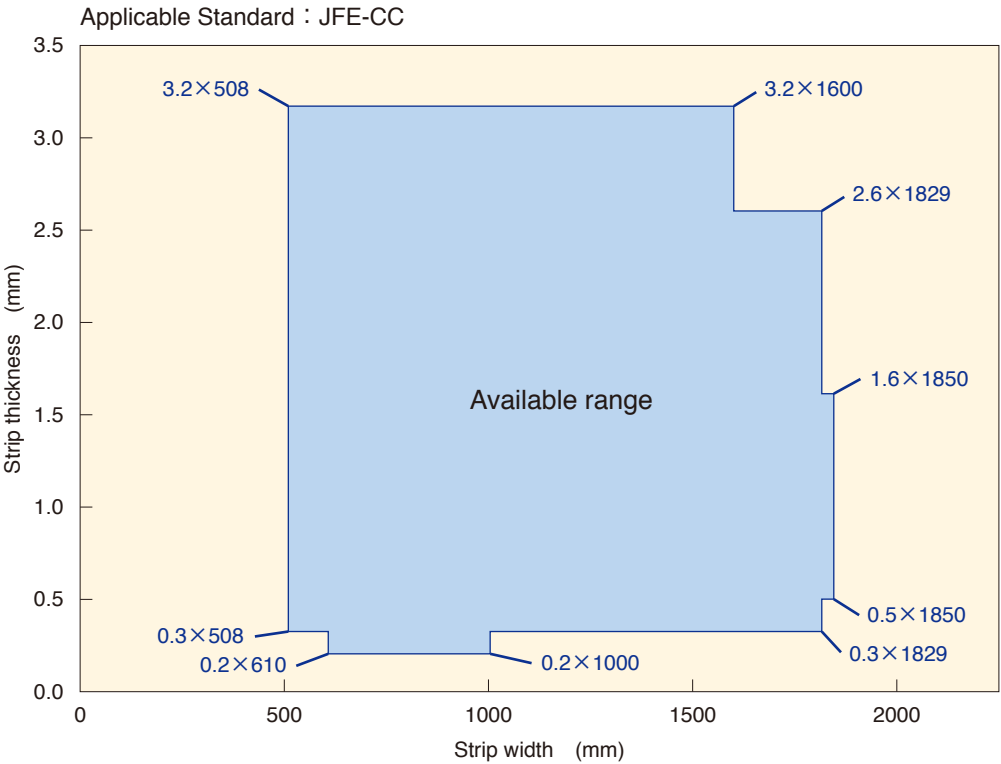
Camber Unit mm

Width \ Strip,Band	Strip		Band
	Length < 2000	Length 2000 ≤	
30 ≤, < 60	8	At any length of 2000	8
60 ≤, < 630	4	//	4
630 ≤	2	//	2

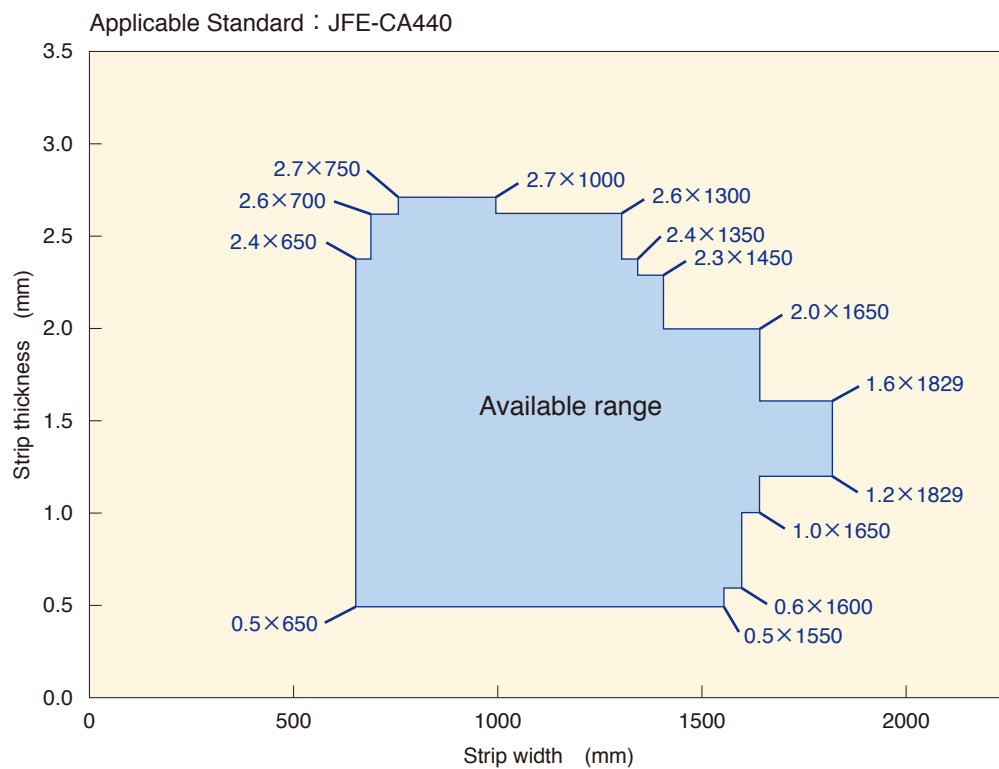
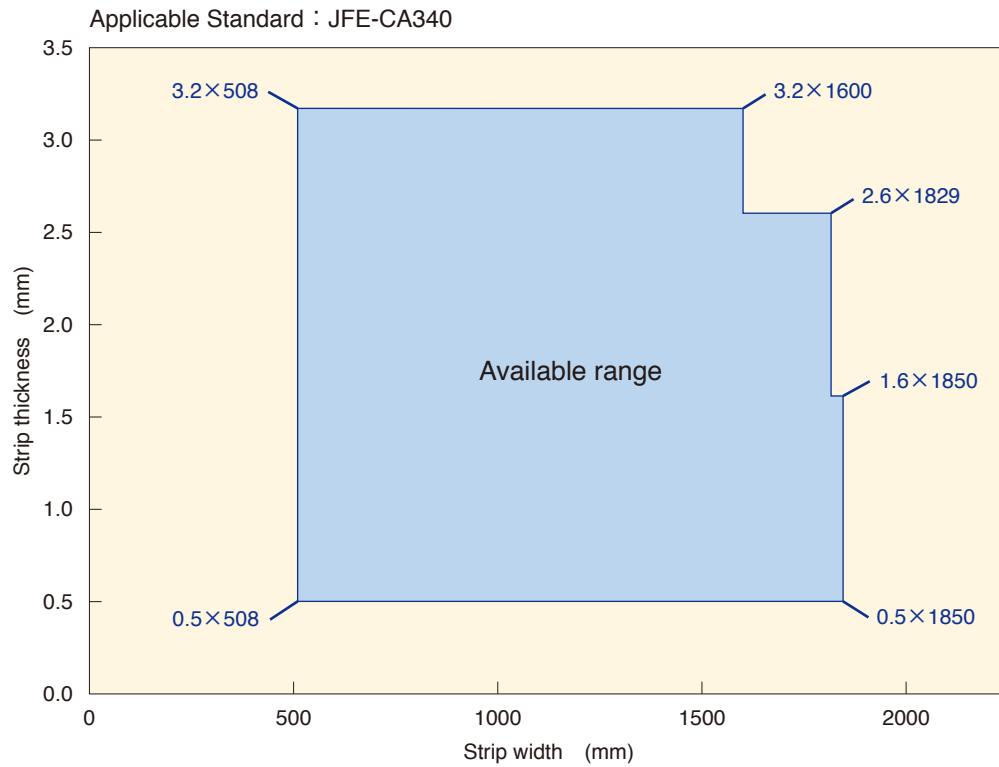
Reference : Table is not applied to the abnormal portion.

Available product size range

Examples of the available products size range are shown below.
Other size outside the available range and products not shown here are subject to negotiation.

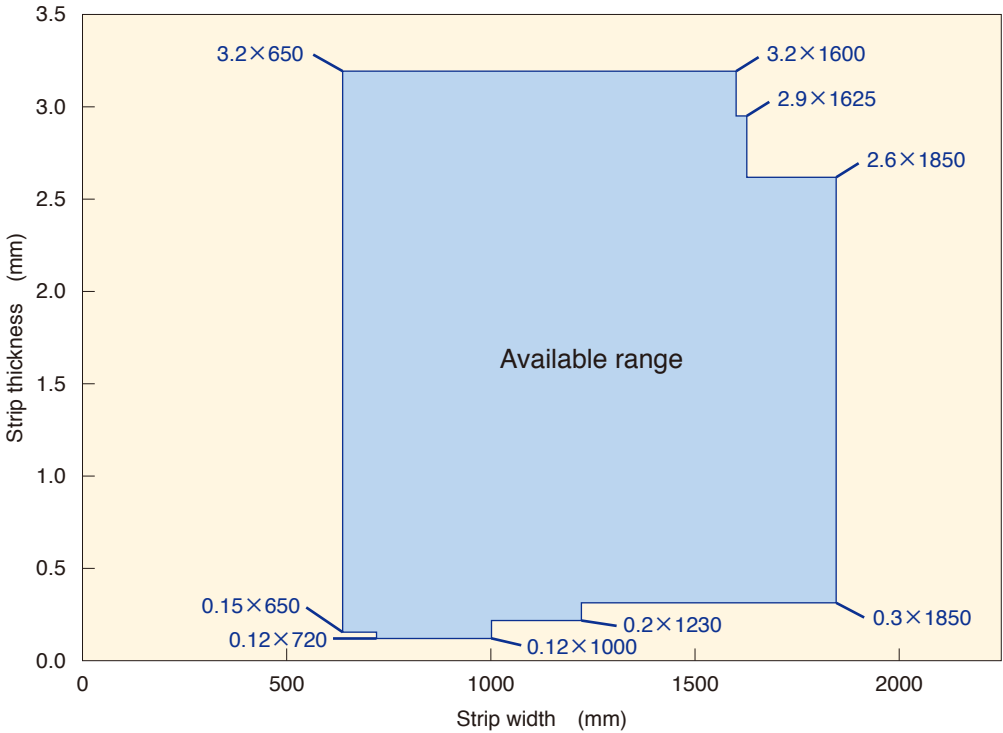


Other size outside the available range and products not shown here are subject to negotiation.

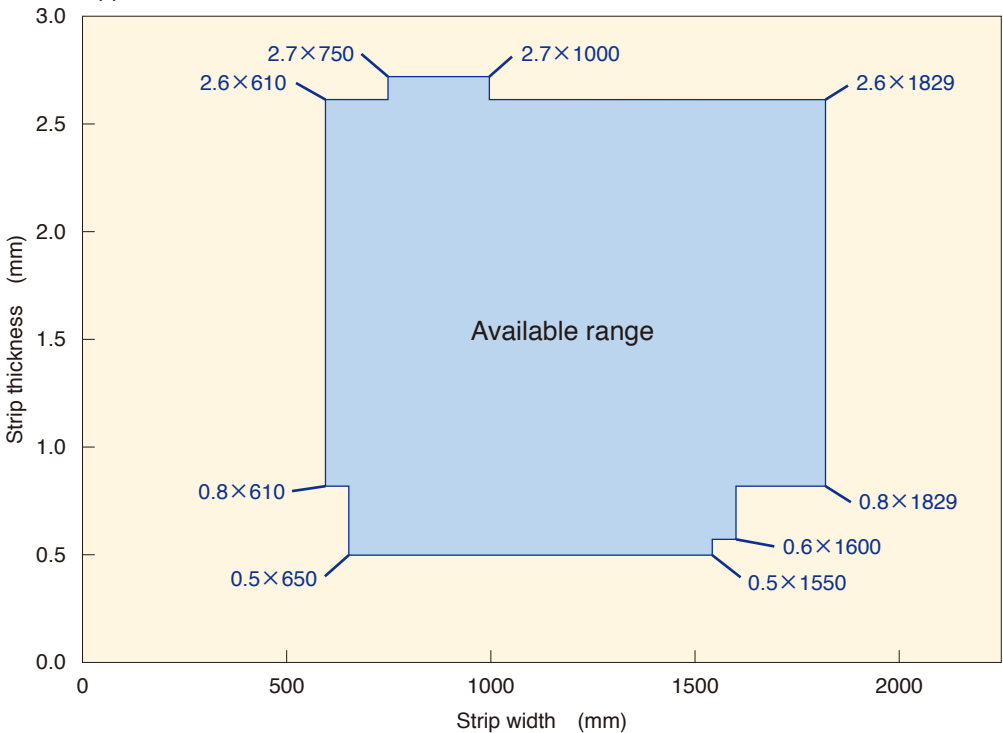


Examples of the available products size range are shown below.
Other size outside the available range and products not shown here are subject to negotiation.

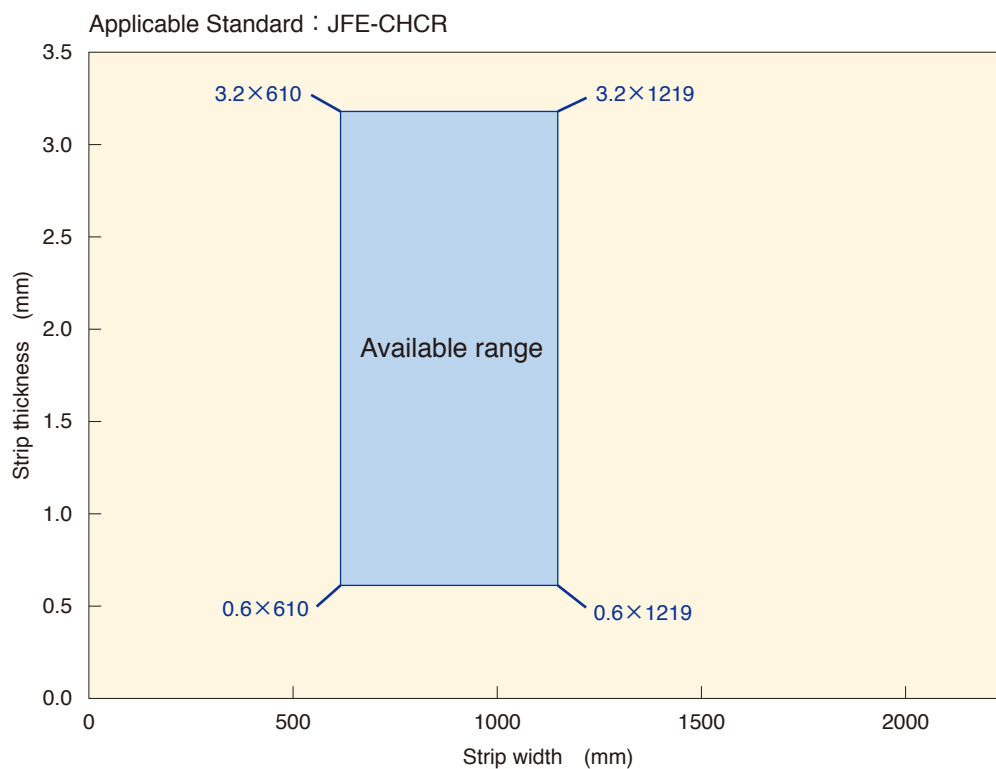
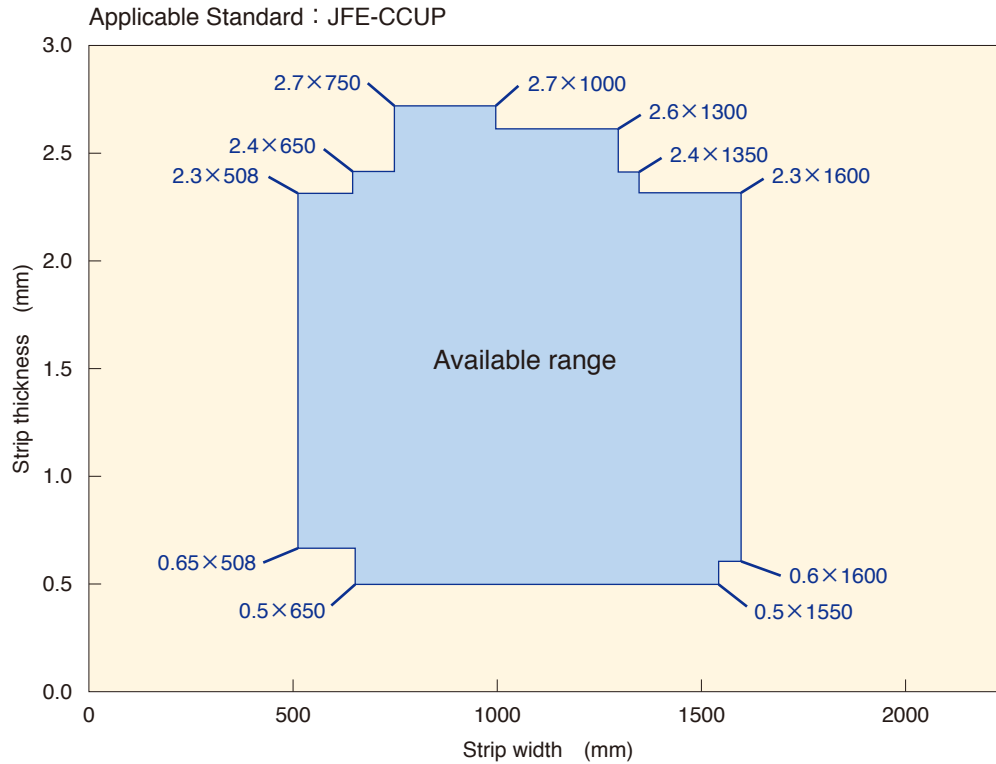
Applicable Standard : JFE-CNA



Applicable Standard : JFE-ASA



Other size outside the available range and products not shown here are subject to negotiation.



Surface finish

● Surface finish

Classification	Designation	Characteristics
Dull finish	SD	Finished with rough (dull) surface rolls which are processed mechanically or chemically. Dull surface products are widely used to improve pressing performance by ensuring even distribution of press oil and to improve paint adhesion. It is equivalent to D finish in JIS.
Bright finish	SB	Finished with smoothly polished rolls. Bright products are suitable for application which require attractive luster, such as metallic coated surfaces and for lightly painted surfaces. It is equivalent to B finish in JIS. Products brighter than JIS bright finish are also available and are subject to negotiation.

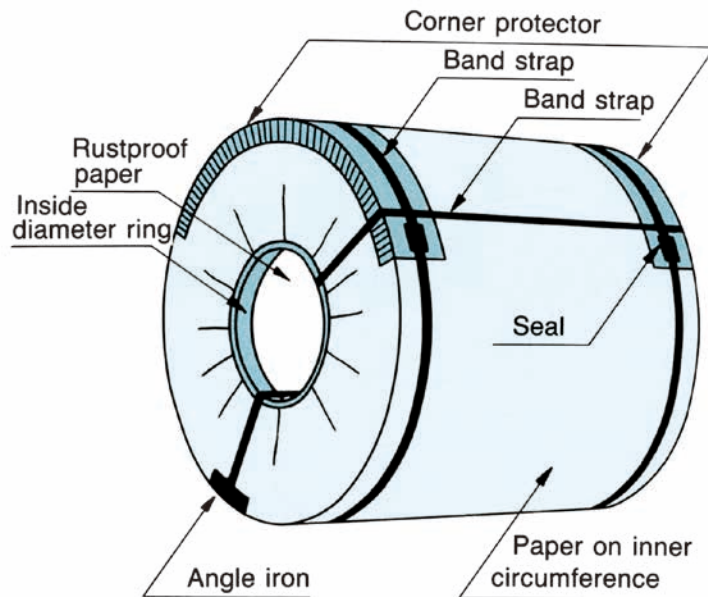
Reference : 1. Normally dull finish is applied. Detailed discussion is requested for bright finish.
2. Not available in as-annealed products.
3. Other surface classifications are subject to negotiation.

Packaging and labeling

● Packaging

Cold rolled products are packaged according to applicable standards and preserved in a properly controlled environment until shipment.

Example of coil package



● Labeling

Labels showing the product standard, dimensions, mass and product serial no. are attached to the product.

Sample is shown below.

COMMODITY		PACKAGE NO.		CUSTOMER'S NAME DESTINATION
COLD ROLLED STEEL		00001		
SPECIFICATION				
JFE-CC-SD OILED				
SIZE				
0.80MMx914MM				
N/W KGS		G/W KGS		
5000		5050		
COIL NO.		HEAT NO.		
C-1111-1		E5555		
O/#				
C041111001				
JFE Steel Corporation West Japan Works (Fukuyama)				

JFE MADE IN JAPAN

Remarks on product use and handling precautions / Instructions for ordering

Remarks on product use and handling precautions

●Product use

Cold rolled steel sheets include a wide range of products with diverse properties. More economical manufacturing can be expected if the user fully understands these differences. JFE will propose the optimum product for the customer's intended application. JFE can also provide advice on operational problems.

●Handling precautions

In using cold rolled steel sheets, the following precautions should be taken in order to ensure optimum use:

JFE products are normally coated with rust preventive oil with a degreasing property. However, products should be used promptly, as rust can occur if products are held for long periods after unpacking.

Avoid exposure to water, including condensation, as this can cause rust even in case of oil-coated sheets.

The strip edge is sharp and must be handled carefully using gloves to avoid injury.

Instructions for ordering

When ordering, please include following information:

1	Classification of standard / Dimension / Quantity / Delivery date
2	Application or part name
3	Type of processing (In case of press forming, please show the part shape in detail)
4	Unit mass and packaging ● Coils : Maximum and minimum coil mass / Maximum coil outer diameter / Inner diameter / Acceptability of welded portion in coil ● Sheets : Maximum lot mass
5	Other requirements : Surface finish, edge form, strip shape, oiling, etc.

(Appendix) Extracts from Japanese Industrial Standard (JIS) (1)

●JIS G 3141 (2002)

Table 1. Symbol of quality

Symbol of quality	Remarks
SPCC	Commercial quality
SPCD	Drawing quality
SPCE	Deep Drawing quality

Remark 1. When the steel sheet and coil of standard temper grade and as-annealed one in quality SPCC are requested by the purchaser to guarantee tensile test values, letter symbol T shall be suffixed to the symbol of quality, thus appears SP CCT.

●JIS G 3141 (2002)

Table 2. Temper grade

Temper grade	Symbol of temper grade
As-annealed	A
Standard temper grade	S
1/8 hard	8
1/4 hard	4
1/2 hard	2
Full hard	1

(Appendix) Extracts from Japanese Industrial Standard (JIS) (2)

● JIS G 3141 (2002)

Table 3. Surface finish

Surface finish	Symbol of surface finish	Remarks
Dull finish	D	A matt finish produced with a roll roughened its surface mechanically or chemically
Bright finish	B	A smooth finish produced with a roll finished its surface smoothly

Remarks : This table is not applicable to the steel sheet and coil as-annealed.

● JIS G 3141 (2002)

Table 4. Tensile strength, elongation and non-aging property

Symbol of quality	Tensile strength N/mm ²	Elongation %						Tensile test piece
	Discrimination according to nominal thickness mm							
	0.25 or over	0.25 or over to and excl. 0.40	0.40 or over to and excl. 0.60	0.60 or over to and excl. 1.0	1.0 or over to and excl. 1.6	1.6 or over to and excl. 2.5	2.5 or over	
SPCC	(270 min.)	(32 min.)	(34 min.)	(36 min.)	(37 min.)	(38 min.)	(39 min.)	No. 5, in rolling direction
SPCD	270 min.	34 min.	36 min.	38 min.	39 min.	40 min.	41 min.	
SPCE	270 min.	36 min.	38 min.	40 min.	41 min.	42 min.	43 min.	

Remarks 1. The tensile test value, as a rule, is not applicable to SPCC. When specified (SPCCT) by purchaser, however, the values in parentheses shall be applied.
 2. For those less than 0.60mm in thickness, as a rule, the tensile test shall be omitted.
 3. This table is applicable to those of 30 mm or over in width.

● JIS G 3141 (2002)

Table 5. Hardness

Temper grade	Symbol of temper grade	Hardness	
		HRB	HV
1/8 hard	8	50 to 71	95 to 130
1/4 hard	4	65 to 80	115 to 150
1/2 hard	2	74 to 89	135 to 185
Full hard	1	85 min.	170 min.

Remarks : As to hardness, either HRB or HV shall be applied.

● JIS G 3141 (2002)

Table 6. Bendability

Temper grade	Symbol of temper grade	Bend test		
		Bend angle	Inside Radius	Bend test piece
As-annealed	A	180°	Flat on itself	No. 3 test piece, in the rolling direction
Standard temper grade	S	180°	Flat on itself	
1/8 hard	8	180°	Flat on itself	
1/4 hard	4	180°	Thickness × 0.5	
1/2 hard	2	180°	Thickness × 1.0	
Full hard	1	—	—	

Remarks : The bend test may be omitted for the steel sheet and coil of as-annealed and of standard temper grade.

JFE Steel Corporation<http://www.jfe-steel.co.jp/en/>**HEAD OFFICE**

Hibiya Kokusai Building, 2-3 Uchisaiwaicho 2-chome, Chiyodaku, Tokyo 100-0011, Japan Phone: (81)3-3597-3111 Fax: (81)3-3597-4860

■ ASIA PACIFIC**SEOUL**JFE Steel Korea Corporation
16th Floor, 41, Chunggyecheon-ro, Jongno-gu, Seoul,
03188, Korea
(Youngpung Building, Seorin-dong)
Phone: (82)2-399-6337 Fax: (82)2-399-6347**BEIJING**JFE Steel Corporation Beijing
1009 Beijing Fortune Building No.5, Dongsanhuan
North Road, Chaoyang District, Beijing, 100004,
P.R.China
Phone: (86)10-6590-9051 Fax: (86)10-6590-9056**SHANGHAI**JFE Consulting (Shanghai) Co., Ltd.
Room 801, Building A, Far East International Plaza,
319 Xianxia Road, Shanghai 200051, P.R.China
Phone: (86)21-6235-1345 Fax: (86)21-6235-1346**GUANGZHOU**JFE Consulting (Guangzhou) Co., Ltd.
Room 3901 Citic Plaza, 233 Tian He North Road,
Guangzhou, 510613, P.R.China
Phone: (86)20-3891-2467 Fax: (86)20-3891-2469**MANILA**JFE Steel Corporation, Manila Office
23rd Floor 6788 Ayala Avenue, Oledan Square,
Makati City, Metro Manila, Philippines
Phone: (63)2-886-7432 Fax: (63)2-886-7315**HO CHI MINH CITY**JFE Steel Vietnam Co., Ltd.
Unit 1704, 17th Floor, MPlaza, 39 Le Duan Street,
Dist 1, HCMC, Vietnam
Phone: (84)28-3825-8576 Fax: (84)28-3825-8562**HANOI**JFE Steel Vietnam Co., Ltd., Hanoi Branch
Unit 1501, 15th Floor, Cornerstone Building, 16 Phan
Chu Trinh Street, Hoan Kiem Dist., Hanoi, Vietnam
Phone: (84)24-3855-2266 Fax: (84)24-3533-1166**BANGKOK**JFE Steel (Thailand) Ltd.
22nd Floor, Abdulrahim Place 990, Rama IV Road,
Silom, Bangrak, Bangkok 10500, Thailand
Phone: (66)2-636-1886 Fax: (66)2-636-1891**YANGON**JFE Steel (Thailand) Ltd., Yangon Office
Unit 05-01, Union Business Center, Nat Mauk Road,
Bocho Quarter, Bahan Tsp, Yangon, 11201, Myanmar
Phone: (95)1-860-3352**SINGAPORE**JFE Steel Asia Pte. Ltd.
16 Raffles Quay, No.15-03, Hong Leong Building,
048581, Singapore
Phone: (65)6220-1174 Fax: (65)6224-8357**JAKARTA**PT. JFE STEEL INDONESIA
6th Floor Summitmas II, JL Jendral Sudirman Kav.
61-62, Jakarta 12190, Indonesia
Phone: (62)21-522-6405 Fax: (62)21-522-6408**NEW DELHI**JFE Steel India Private Limited
806, 8th Floor, Tower-B, Unitech Signature Towers,
South City-I, NH-8, Gurgaon-122001, Haryana, India
Phone: (91)124-426-4981 Fax: (91)124-426-4982**MUMBAI**JFE Steel India Private Limited, Mumbai Office
603-604, A Wing, 215 Atrium Building, Andheri-Kurla
Road, Andheri (East), Mumbai-400093, Maharashtra,
India
Phone: (91)22-3076-2760 Fax: (91)22-3076-2764**CHENNAI**JFE Steel India Private Limited, Chennai Office
No.86, Ground Floor, Polyhose Towers(SPIC Annexe),
Mount Road, Guindy, Chennai-600032, Tamil Nadu,
India
Phone: (91)44-2230-0285 Fax: (91)44-2230-0287**BRISBANE**JFE Steel Australia Resources Pty Ltd.
Level28, 12 Creek Street, Brisbane QLD 4000
Australia
Phone: (61)7-3229-3855 Fax: (61)7-3229-4377**■ EUROPE and MIDDLE EAST****LONDON**JFE Steel Europe Limited
15th Floor, The Broadgate Tower, 20 Primrose Street,
London EC2A 2EW, U.K.
Phone: (44)20-7426-0166 Fax: (44)20-7247-0168**DUBAI**JFE Steel Corporation, Dubai Office
P.O.Box 261791 LOB19-1208, Jebel Ali Free Zone
Dubai, U.A.E.
Phone: (971)4-884-1833 Fax: (971)4-884-1472**■ NORTH, CENTRAL and SOUTH AMERICA****NEW YORK**JFE Steel America, Inc.
600 Third Avenue, 12th Floor, New York, NY 10016,
U.S.A.
Phone: (1)212-310-9320 Fax: (1)212-308-9292**HOUSTON**JFE Steel America, Inc., Houston Office
750 Town & Country Blvd., Suite 705 Houston,
Texas 77024, U.S.A.
Phone: (1)713-532-0052 Fax: (1)713-532-0062**MEXICO CITY**JFE Steel America, Inc., Mexico Office
Ruben Dario #281-1002, Col. Bosque de
Chapultepec, C.P. 11580, CDMX. D.F. Mexico
Phone: (52)55-5985-0097 Fax: (52)55-5985-0099**RIO DE JANEIRO**JFE Steel do Brasil LTDA
Praia de Botafogo, 228 Setor B, Salas 508 & 509,
Botafogo, CEP 22250-040, Rio de Janeiro-RJ, Brazil
Phone: (55)21-2553-1132 Fax: (55)21-2553-3430**Notice**

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