

Technical Delivery Specification

Teknisk leveransspecifikation

SOURCE MATERIAL, TEST AND RELEASE REQUIREMENTS

Draft pre-commercial framework for finished GOREX 400, 450 and 500 wear parts tied to documented NM source steel.

NOT A SIGNED PURCHASE SPECIFICATION

Scope, status and precedence

Omfattning, status och företräde

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Detta dokument är förkommersiell kontrollerad information, inte kontrakt, ordererkännande, kontrollintyg, provresultat eller tekniskt godkännande. Slutliga krav uppstår endast genom signerad offert, order, tillämplig specifikation och leveransspecifika dokument.

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This document is pre-commercial controlled information, not a contract, order acknowledgement, inspection document, test result or engineering approval. Final requirements arise only through the signed quotation, order, applicable specification and shipment-specific documents.

Source basis / Källgrund: live controlled GOREX registries; GB/T 24186-2022 NM source-material framework; pre-commercial GOREX finished-part qualification and traceability requirements.

Contact / Kontakt: craig@craig gore.net

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Vid konflikt gäller signerad offert, ordererkännande och orderbilagd specifikation i den ordning som avtalats.

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Where requirements conflict, the signed quotation, order acknowledgement and order-attached specification apply in the agreed order of precedence.

Designation and delivery condition

Beteckning och leveranstillstånd

GRADES

NM400E / NM450E / NM500E

Source-material frameworks where the exact grade is contracted and documented.

CONDITION

Q or Q+T

Quenched or quenched-and-tempered only.

REPAIR

No weld repair

Weld repair of plate defects is not accepted.

ORDER

Dimensions are specific

Thickness, width, length, tolerances and UT are stated per order.

Source basis / Källgrund: grade registry and controlled overlay. **Contact:** craig@craiggores.net

Hardness framework

Hårdhetsramverk

FINISHED-PART SURFACE AND CENTRE HARDNESS REQUIREMENTS

GOREX CLASS	THICKNESS	SURFACE	CENTRE OVERLAY
GOREX 400	<= 80 mm	370-430 HBW	330-430 HBW
GOREX 400	> 80-120 mm	360-440 HBW	330-430 HBW
GOREX 450	<= 80 mm	420-480 HBW	375-480 HBW
GOREX 450	> 80-120 mm	410-480 HBW	375-480 HBW
GOREX 500	<= 70 mm	470-540 HBW	420-540 HBW
GOREX 500	> 70-100 mm	450-540 HBW	420-540 HBW

Centre hardness is optional in the source-material framework but mandatory in the GOREX finished-part qualification overlay.

Impact framework

Slagseghetsramverk

SEPARATE IMPACT RANGES FROM THE LIVE GRADE REGISTRY

GRADE / KLASS	THICKNESS / TJOCKLEK	KV2 MINIMUM	STATE / STATUS
GOREX 400	≤80 mm	24 J at -40 C	Specified / Specificerat
GOREX 400	>80–120 mm	21 J at -40 C	Specified / Specificerat
GOREX 450	≤80 mm	24 J at -40 C	Specified / Specificerat
GOREX 450	>80–120 mm	21 J at -40 C	Specified / Specificerat
GOREX 500	≤60 mm	21 J at -40 C	Specified / Specificerat
GOREX 500	>60–100 mm	18 J at -40 C	Specified / Specificerat

Impact requirements apply at -40 C within the stated thickness bands.

CEV framework

CEV-ramverk

SEPARATE CEV RANGES FROM THE LIVE GRADE REGISTRY

GRADE / KLASS	THICKNESS / TJOCKLEK	CEV MAXIMUM	STATE / STATUS
GOREX 400	≤50 mm	0.57% max	Specified / Specificerat
GOREX 400	>50–120 mm	0.67% max	Specified / Specificerat
GOREX 450	≤50 mm	0.59% max	Specified / Specificerat
GOREX 450	>50–120 mm	0.74% max	Specified / Specificerat
GOREX 500	≤50 mm	0.64% max	Specified / Specificerat
GOREX 500	>50–100 mm	0.77% max	Specified / Specificerat

Use actual inspection-document chemistry for shipment-specific CEV, CET and Pcm assessment.

Conditional tensile values

Villkorade dragprovsvärden

CONDITIONAL TENSILE VALUES

GRADE / KLASS	RM MINIMUM	A50 MINIMUM	STATE / QUALIFIER
GOREX 400	1200 MPa	10%	Indicative / Vägledande - only when agreed in the order
GOREX 450	1250 MPa	8%	Indicative / Vägledande - only when agreed in the order
GOREX 500	1350 MPa	7%	Indicative / Vägledande - only when agreed in the order

Indicative / Vägledande - only when agreed in the order. The base framework has no yield-strength minimum; no yield value may be inferred.

Chemistry, documents and test options

Kemi, dokument och provval

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- Stäm av heat-analys och produktanalys där beställd; beräkna och utvärdera CEV, CET och Pcm från verklig kemi.
- Originalverkets EN 10204 3.1-kontrollintyg krävs per frisläppt leverans.
- De första tre frisläppta leveranspartierna har verklig EN 10204 3.2 som mål endast när oberoende eller behörig validering arrangeras.
- Kvalificeringsprovning kräver laboratorium med relevant ackrediterad ISO/IEC 17025-provningsomfattning.
- Beställda tillägg kan omfatta UT, tolerans, provposition och dokumentomfattning.

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- Reconcile heat and product analysis where ordered; calculate and evaluate CEV, CET and Pcm from actual chemistry.
- Original mill EN 10204 3.1 inspection document is required per released shipment.
- The first three released shipment lots target true EN 10204 3.2 only when independent or authorised validation is arranged.
- Qualification testing requires a laboratory with relevant ISO/IEC 17025 accredited scope.
- Ordered additions may include UT, tolerance, specimen position and document scope.

Identity, qualification and release

Identitet, kvalificering och frisläppning

HEAT

PLATE

SAMPLE

DOCUMENT

DELIVERY

PRE-CHECK

Supplier and documents

Confirm required source records before material release.

TEST

Qualification scope

Surface/centre hardness, chemistry, impact and ordered tests.

RECONCILE

One identity chain

Values and objects must resolve to the same heat and plate.

DECISION

Release or quarantine

Incomplete or conflicting evidence enters nonconformance control.

Order-specific: dimensions, availability, processing suitability, mill, origin and lead time. **Contact:** craig@craiggore.net