



Dokumentnamn/Dokument name
Purchase specification: Tightening bolts
(Double classified)

Reg. Nr./Reg. No.
PS- 0132

Utfärdare/Issued by
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TIGHTENING BOLTS IN FERRITIC ALLOY (DOUBLE CLASSIFIED)

1. SCOPE

This specification provides the requirements for ferritic alloy-steel to be used as tightening bolts for plate heat exchangers in accordance with the current pressure vessel rules.

2. CONDITION

Hardened and tempered bolt.

3. REQUIREMENTS

3.1 General

1. The material shall meet the requirements for composition, mechanical properties and testing for all:
 - 42CrMo4 acc. to EN 10269:1999 & EN 10269-A1:2006
 - Grade B7 acc. to ASME SA-193
 - EN 20898-1/ISO 898-1 class 8.8.
 - AD-2000-W7.
2. The manufacturer must be approved by Notified Body (AD W0) and in connection with dividing of the material have the permission from Notified Body for transferring the original marking and shall issue a remarking certificate.
3. Surface treatment (FZB = standard):
 - FZB = Electroplated coating acc. to ISO 4042 grade A
 - FZV = Hot dip galvanized alt. DIN 267-10
4. All bars and bolts shall be marked by die stamping on one of the sides stating:
 - Property class (8.8 & B7)
 - Identification marking of the manufacturer
 - Marking for traceability to Heat No. and its certificate

3.2 Certification

The material certificates shall refer to both EN 20898-1/ISO 898-1 class 8.8 and ASME SA-193 B7 material specifications.



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If the manufacturer has an appropriate quality-assurance system, certified by a competent Notified body established as a legal entity within the Community and having undergone a specific assessment for materials, inspection certificate according to EN 10204:2004 type 3.1 is acceptable.

If the requirements above are not fulfilled, an inspection certificate according to EN 10204:2004 type 3.2 needs to be issued by a competent Notified Body.

The inspection certificate shall include the year-date of the ASME SA-193 specification to which the material is furnished.

3.3 Additional mechanical requirements

Impact strength: Min 40J at -40°C ISO-V test. Min. 14% elongation.

Min value from 3 samples