Title: Controlled-Rolled

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Revision: 0

Purpose: 1. Clarify Section 2.2.7.4 and 2.2.9.2 requirements regarding to Controlled Rolled (CR) plate.

Business Impact: Save user time by clarifying some of the confusion in current CR requirements.

Rationale: 1. Section 2.2.7.4 states that purchaser’s approval is requires when CR plate is use where normalized plates are required. Section 2.2.7.4 does not specifically state the meaning of “where normalized plates are required”. It can be interpreted as follows:
   a) The specific requirement in 2.2.9.1 where normalized, N&T or Q&T plates are required when thickness is over 1.5".
   b) Where low design metal temperature makes as-rolled plate not exempt from impact testing, so controlled-rolled, impact tested plate is used in lieu of normalized plate w/o impact testing.

Modify Section 2.2.7.4 to specifically state “where normalized plates are required per Section 2.2.9.1” should clarify intent of the code.

Proposal:

- 2.2.7.4 Subject to the Purchaser’s approval, controlled-rolled or thermo-mechanical-control-process (TMCP) plates (plates produced by a mechanical-thermal rolling process designed to enhance notch toughness) may be used where normalized plates are required per 2.2.9.1. Each plate-as-rolled shall receive Charpy V-notch impact energy testing in accordance with 2.2.8, 2.2.9, and 2.2.10. When controlled-rolled or TMCP steels are used, consideration should be given to the service conditions outlined in 3.3.3.

  2.2.7.6 When TMCP steel is used, the plate purchaser shall specify to the plate producer when the plates are to be subjected to warm forming or thermal stress relief. (See 3.7.4.6)