

MERCIN

Steelmaking and Bridge Plate Capabilities MN DOT - ACEC | NSBA Steel Bridge Forum Oct. 26, 2021 – David Stoddard, SSAB Americas

Outline

- Introduction to Steel Production
 - Comparison between Integrated and Electric Arc Furnace Mills
- American Plate and Structural Steel Mills
- Determination of Bridge Plate Capabilities
 - SSAB Americas Bridge Plate Capabilities
- From Inquiry to Shipment How a Bridge Plate Order Happens

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Blast Furnace Process – Convert iron ore into pig iron





Pig Iron 5% C Most Steel < 0.4% C)

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Basic Oxygen Furnace (BOF) – Convert pig iron into steel





Refine liquid pig iron (5% C) into steel (0.02 – 0.40% C) using O₂ to remove carbon: • C + O₂ \rightarrow CO₂

 $C + \frac{1}{2}O_2 \rightarrow CO$

Also add steel scrap (25%), Flux (Lime) and Alloys

- BF-BOF steelmaking accounts for 5.5% of world CO₂ emissions
- Cement production accounts for 5 – 7%
- SSAB HYBRIT (2026) use C free electricity and H to reduce iron ore to steel

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Electric Arc Furnace (EAF) – Melt steel scrap to liquid



EAF Charge Based on Density and Residual Element Content

Cu	Cr	Ni	Мо
0.01	0.04	0.05	0.01
0.25	0.09	0.09	0.02
0.40	0.13	0.13	0.03
0.30	0.33	0.33	0.11
	Cu 0.01 0.25 0.40 0.30	CuCr0.010.040.250.090.400.130.300.33	CuCrNi0.010.040.050.250.090.090.400.130.130.300.330.33

Other Inputs: Carbon (recycled tires), Lime, Electricity (focus on C free)

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Electric Arc Furnace

Scrap Bucket Charging



In Operation (Melting)



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Steel refining to obtain final composition



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Comparison of Steelmaking Routes



Continuous Casting - Molten Heats are cast into solid steel slabs



B. G. Thomas, Encyclopedia of Advanced Materials, Vol. 2, 2001, p. 8

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Other Steel Casting - Near Net Shape Casting of Beam Blanks



Primetals Technologies (primetals.com)

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Other Steel Casting – Blooms and Billets



vizagsteel.com



sms-group.com)

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Reheating and Rolling





Reheat Furnace: heat slab to proper rolling temperature 2100 – 2350°F

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Rolling Mill: reduce the slab to the ordered thickness and develop the specified properties during rolling and cooling



Rolling slabs into plates

Schematic of **single stand reversing rolling mill** reduction of 6" slab to asrolled 3" plate

In this example a 36 ft. slab would be rolled into a 72 ft. plate. At the thinner gauges much longer plates would be rolled from the same slab, which would take additional rolling passes: 2" - 108 ft. 1" - 216 ft. $1'_2" - 432$ ft. $1'_4" - 864$ ft. **7**

1 2 3 4 5 6 15

Note: an individual slab can be rolled to any thickness within the mills capability and is the smallest quantity that can be rolled to a given gauge

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³/₁₆" - 1152 ft.

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Plate Hot Rolling Mill

Reduce the 6 - 10 in. slab to the ordered thickness, develop required properties



Finishing and Shipping

Level, cool, inspect, shear/burn, stencil discrete plate to ordered size, and test mechanical properties and CVN



Plate Bundle

Conveyer

Stack

Cooling

Structural Plate Availability



Structural Shape Availability



SSAB – Americas Plate Production Mills

- Scrap-based Electric Arc Furnace (EAF)
- Capacity of 1.25 million tons
- Capable of casting slabs from 60-120/123" wide for immediate in-line rolling into discrete plate
- Steel scrap can be converted to finished plate in a matter of hours



Montpelier, IA (1997)



Mobile, AL (2001)

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Determination of Plate Dimensional Capabilities

Physical mill limitations

- Width range set by caster and rolling mill
- Length set by shipping bay length
- Weight set by shipping crane capacity
- Thickness set by slab thickness and reduction ratio
 - Minimum of 2:1
- Heat treated plate may have additional dimensional / weight restrictions

Sampling and end cut loss

- If plate can be sheared inline no sample loss
- Thicker plate must be torch cut off-line, lose 24" for 1 sample, 36" for 2 samples

Metallurgical limits to meet properties

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https://media.istockphoto.com



SSAB ASTM A709 Bridge Plate Capabilities

A709-36, 50, 50W, HPS-50W

- ► 3/16 3" non-fracture critical
- ▶ 3/16 2" fracture critical (anticipate increasing thickness to 3")
- Lengths up to 102 ft.
- ▶ Width: Montpelier 72" to 120", Mobile 72" 123"
- Max weight 73,000 lbs.

A709 HPS-70W

- 11/16 2" non-fracture critical & fracture critical
- ▶ Lengths up to 100 ft. (11/16 1.25")
- ► Lengths up to 92 ft. (1.25" 2.0")

SSAB Americas

ASTM A709/A709M Structural Steel Plate for Bridges A709-50 & 50W Non Fract Critic

Product Capability Brochure 2018 02 05 Page |5 of 9

| N | laximum | <u> </u> | | | | | | | | | |

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 | Orde | red Pla | te Width | (in.)
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 | OF | 96 | 07 | 00 | - | 00 | 01 | 03 | 02
 | 04 | | vc 07 | ,
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 | 107 | 100 | 100 | 110 | | 113 | 112 | 114 | 115 | 110 | 117 | | 10 120 |
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 | 1200 1 | 200 1 | 200 120 | 0 1200
 | 0 1200 | 1187 | 1175 | 1164 | 1152 | 1141 | 1130 | 1119
 | 1108 | 1098 | 1087 | 1077 | 1067 | 1058 | 1048 | 1039 | 1029 | 1020 | 1011 1 | 1003 | 994 985 |
| | 2-1/4" | 1200 | 1200 | 1200 | 1200 | 1200 | 1200 | 1200 | 1200 | 1200 | 1200 | 1200

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 | 7 1016 | 1000 | 995 | 985 | 976 | 966 | 957 | 947
 | 938 | 929 | 921 | 912 | 904 | 895 | 887 | 879 | 871 | 864 | 856 | 849 | 841 834 |
| | 2-5/8" | 1200 | 1200 | 1200 | 1200 | 1200 | 1200 | 1200 | 1200 | 1200 | 1187 | 7 1172

 | 1157 | 1143
 | 1130 | 1116 | 1103 | 1090 | 1078 | 1066 | 1054 | 1042 | 1030
 | 1019 1 | 008 | 997 98 | 7 97
 | 7 966 | 957 | 947 | 937 | 928 | 919 | 910 | 901
 | 892 | 884 | 876 | 867 | 859 | 852 | 844 | 836 | 829 | 821 | 814 | 807 | 800 793 |
| | 2-3/4" | 1200 | 1200 | 1200 | 1200 | 1200 | 1192 | 1176 | 1161 | 1146 | 1132 | 2 1117

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 | 972 | 961 | 951 94 | 1 93:
 | 1 921 | 912 | 903 | 894 | 885 | 876 | 867 | 859
 | 851 | 843 | 835 | 827 | 819 | 812 | 804 | 797 | 790 | 783 | 776 | 769 | 763 756 |
| | 2-7/8" | 1200 | 1200 | 1186 | 1170 | 1154 | 1139 | 1124 | 1109 | 1095 | 1081 | 1 1068

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 | 1029 | 1017 | 1005 | 993 | 982 | 971 | 960 | 949 | 939
 | 928 | 918 | 909 89 | 9 890
 | 0 880 | 871 | 862 | 854 | 845 | 837 | 829 | 821
 | 813 | 805 | 797 | 790 | 783 | 775 | 768 | 761 | 755 | 748 | 741 | 735 | 728 722 |
| | 3" | 1168 | 3 1151 | 1135 | 1120 | 1105 | 1090 | 1076 | 1062 | 1049 | 1035 | 5 1022

 | 1010 | 997
 | 985 | 974 | 962 | 951 | 940 | 929 | 919 | 909 | 899
 | 889 | 879 | 870 86 | 1 852
 | 2 843 | 834 | 826 | 817 | 809 | 801 | 793 | 785
 | 778 | 770 | 763 | 756 | 749 | 742 | 735 | 729 | 722 | 716 | 709 | 703 | 697 691 |
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| Ac | tual Plate
Weight
(tons) | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 | 81 | 82

 | 83 | 84
 | 85 | 86 | 87 | 88 | 89 | 90 | 91 | 92 | 93
 | Orde | red Pla
95 9 | te Width
96 97 | (in.)
98
 | 99 | 100 | 101 | 102 | 103 | 104 | 105 | 106
 | 107 | 108 | 109 | 110 | 111 | 112 | 113 | 114 | 115 | 116 | 117 : | 118 1 | 19 120 |
| Ac | tual Plate
Weight
(tons)
3/8" | 72 | 73
7 4.8 | 74
4.8 | 75 | 76 | 77
5.0 | 78 | 79
5.1 | 80
5.2 | 81 | 82
3 5.3

 | 83 | 84
5.5
 | 85
5.5 | 86 | 87 | 88
5.7 | 89
5.8 | 90
5.9 | 91
5.9 | 92
6.0 | 93
6.1
 | Orde
94 94 94 | red Pla | te Width
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98
3 6.4
 | 99
4 6.4 | 100
6.5 | 101
6.6 | 102
6.6 | 103
6.7 | 104
6.8 | 105
6.8 | 106
6.9
 | 107 | 108 | 109
7.1 | 110
7.2 | 111
7.2 | 112
7.3 | 113
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7.6 | 118 1
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| Ac | tual Plate
Weight
(tons)
3/8"
7/16"
1/2" | 72
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| Ac | tual Plate
Weight
(tons)
3/8"
7/16"
1/2"
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10.5 | 109
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8.9
10.2
11.4 | 118 1
7.7
9.0
10.2 1
11.5 1 | 19 120 7.7 7.8 9.0 9.1 10.3 10.4 1.6 11.7 |
| Ac | tual Plate
Weight
(tons)
3/8"
7/16"
1/2"
9/16"
5/8" | 72
4.7
5.5
6.2
7.0
7.8 | 73
7 4.8
5 5.5
2 6.3
0 7.1
3 7.9 | 74
4.8
5.6
6.4
7.2
8.0 | 75
4.9
5.7
6.5
7.3
8.1 | 76
4.9
5.8
6.6
7.4
8.2 | 77
5.0
5.8
6.7
7.5
8.4 | 78
5.1
5.9
6.8
7.6
8.5 | 79
5.1
6.0
6.9
7.7
8.6 | 80
5.2
6.1
6.9
7.8
8.7 | 81
5.3
6.2
7.0
7.9
8.8 | 82
3 5.3
2 6.2
0 7.1
9 8.0
8 8.9

 | 83
5.4
6.3
7.2
8.1
9.0 | 84
5.5
6.4
7.3
8.2
9.1
 | 85
5.5
6.5
7.4
8.3
9.2 | 86
5.6
6.5
7.5
8.4
9.3 | 87
5.7
6.6
7.5
8.5
9.4 | 88
5.7
6.7
7.6
8.6
9.5 | 89
5.8
6.8
7.7
8.7
9.7 | 90
5.9
6.8
7.8
8.8
9.8 | 91
5.9
6.9
7.9
8.9
9.9 | 92
6.0
7.0
8.0
9.0
10.0 | 93
6.1
7.1
8.1
9.1
10.1
 | Orde
94 9
6.1
7.1
8.2
9.2
10.2 | red Pla
95 9
6.2
7.2
8.2
9.3
10.3 1 | te Width
6.2 6.
7.3 7.
8.3 8.
9.4 9.
0.4 10. | (in.)
98
3 6.4
4 7.4
4 8.5
5 9.6
5 10.6
 | 99
4 6.4
4 7.5
5 8.6
6 9.7
6 10.7 | 100
6.5
7.6
8.7
9.8
10.8 | 101
6.6
7.7
8.8
9.9
11.0 | 102
6.6
7.7
8.9
10.0
11.1 | 103
6.7
7.8
8.9
10.1
11.2 | 104
6.8
7.9
9.0
10.2
11.3 | 105
6.8
8.0
9.1
10.3
11.4 | 106
6.9
8.0
9.2
10.3
11.5
 | 107
7.0
8.1
9.3
10.4
11.6 | 108
7.0
8.2
9.4
10.5
11.7 | 109
7.1
8.3
9.5
10.6
11.8 | 110
7.2
8.4
9.5
10.7
11.9 | 111
7.2
8.4
9.6
10.8
12.0 | 112
7.3
8.5
9.7
10.9
12.1 | 113
7.4
8.6
9.8
11.0
12.3 | 114
7.4
8.7
9.9
11.1
12.4 | 115
7.5
8.7
10.0
11.2
12.5 | 116
7.5
8.8
10.1
11.3
12.6 | 117 1
7.6
8.9
10.2
11.4
12.7 | 118 1 7.7 9.0 10.2 1 11.5 1 12.8 1 | 19 120 7.7 7.8 9.0 9.1 10.3 10.4 11.6 11.7 12.9 13.0 |
| Ac | tual Plate
Weight
(tons)
3/8"
7/16"
1/2"
9/16"
5/8"
11/16" | 72
4.7
5.5
6.2
7.0
7.8
8.6 | 73
7 4.8
5 5.5
2 6.3
0 7.1
8 7.9
5 8.7 | 74
4.8
5.6
6.4
7.2
8.0
8.8 | 75
4.9
5.7
6.5
7.3
8.1
8.9 | 76
4.9
5.8
6.6
7.4
8.2
9.1 | 77
5.0
5.8
6.7
7.5
8.4
9.2 | 78
5.1
5.9
6.8
7.6
8.5
9.3 | 79
5.1
6.0
6.9
7.7
8.6
9.4 | 80
5.2
6.1
6.9
7.8
8.7
9.5 | 81
5.3
6.2
7.0
7.9
8.8
9.7 | 82
3 5.3
2 6.2
0 7.1
9 8.0
8 8.9
7 9.8

 | 83
5.4
6.3
7.2
8.1
9.0
9.9 | 84
5.5
6.4
7.3
8.2
9.1
10.0
 | 85
5.5
6.5
7.4
8.3
9.2
10.1 | 86
5.6
6.5
7.5
8.4
9.3
10.3 | 87
5.7
6.6
7.5
8.5
9.4
10.4 | 88
5.7
6.7
7.6
8.6
9.5
10.5 | 89
5.8
6.8
7.7
8.7
9.7
10.6 | 90
5.9
6.8
7.8
8.8
9.8
10.7 | 91
5.9
6.9
7.9
8.9
9.9
10.9 | 92
6.0
7.0
8.0
9.0
10.0
11.0 | 93
6.1
7.1
8.1
9.1
10.1
11.1
 | Orde
94 9
6.1
7.1
8.2
9.2
10.2
11.2 | red Pla
95 9
6.2
7.2
8.2
9.3
10.3 1
11.3 1 | te Width
96 97
6.2 6.
7.3 7.
8.3 8.
9.4 9.
0.4 10.
1.5 11. | (in.)
98
3 6.4
4 7.4
4 8.9
5 9.6
5 10.6
5 11.7
 | 99
4 6.4
4 7.5
5 8.6
6 9.7
6 10.7
7 11.8 | 100
6.5
7.6
8.7
9.8
10.8
11.9 | 101
6.6
7.7
8.8
9.9
11.0
12.1 | 102
6.6
7.7
8.9
10.0
11.1
12.2 | 103
6.7
7.8
8.9
10.1
11.2
12.3 | 104
6.8
7.9
9.0
10.2
11.3
12.4 | 105
6.8
8.0
9.1
10.3
11.4
12.5 | 106
6.9
8.0
9.2
10.3
11.5
12.6
 | 107
7.0
8.1
9.3
10.4
11.6
12.8 | 108
7.0
8.2
9.4
10.5
11.7
12.9 | 109
7.1
8.3
9.5
10.6
11.8
13.0 | 110
7.2
8.4
9.5
10.7
11.9
13.1 | 111
7.2
8.4
9.6
10.8
12.0
13.2 | 112
7.3
8.5
9.7
10.9
12.1
13.4 | 113
7.4
8.6
9.8
11.0
12.3
13.5 | 114
7.4
8.7
9.9
11.1
12.4
13.6 | 115
7.5
8.7
10.0
11.2
12.5
13.7 | 116
7.5
8.8
10.1
11.3
12.6
13.8 | 117 1
7.6
8.9
10.2
11.4
12.7
14.0 | 118 1 7.7 9.0 10.2 1 11.5 1 12.8 1 14.1 1 | 19 120 7.7 7.8 9.0 9.1 10.3 10.4 11.6 11.7 12.9 13.0 14.2 14.3 |
| Ac | tual Plate
Weight
(tons)
3/8"
7/16"
1/2"
9/16"
5/8"
11/16"
3/4" | 72
4.7
5.5
6.2
7.0
7.8
8.6
9.4 | 73
7 4.8
5 5.5
2 6.3
0 7.1
3 7.9
5 8.7
4 9.5 | 74
4.8
5.6
6.4
7.2
8.0
8.8
9.6 | 75
4.9
5.7
6.5
7.3
8.1
8.9
9.8 | 76
4.9
5.8
6.6
7.4
8.2
9.1
9.9 | 77
5.0
5.8
6.7
7.5
8.4
9.2
10.0 | 78
5.1
5.9
6.8
7.6
8.5
9.3
10.2 | 79
5.1
6.0
6.9
7.7
8.6
9.4
10.3 | 80
5.2
6.1
6.9
7.8
8.7
9.5
10.4 | 81
5.3
6.2
7.0
7.9
8.8
9.7
10.5 | 82
3 5.3
2 6.2
0 7.1
9 8.0
3 8.9
7 9.8
5 10.7

 | 83
5.4
6.3
7.2
8.1
9.0
9.9
10.8 | 84
5.5
6.4
7.3
8.2
9.1
10.0
10.9
 | 85
5.5
6.5
7.4
8.3
9.2
10.1
11.1 | 86
5.6
6.5
7.5
8.4
9.3
10.3
11.2 | 87
5.7
6.6
7.5
8.5
9.4
10.4
11.3 | 88
5.7
7.6
8.6
9.5
10.5
11.5 | 89
5.8
6.8
7.7
8.7
9.7
10.6
11.6 | 90
5.9
6.8
7.8
8.8
9.8
10.7
11.7 | 91
5.9
6.9
7.9
8.9
9.9
10.9
11.8 | 92
6.0
7.0
8.0
9.0
10.0
11.0
12.0 | 93
6.1
7.1
8.1
9.1
10.1
11.1
12.1
 | Orde
94 9
6.1
7.1
8.2
9.2
10.2
11.2
12.2 | red Pla
95 9
6.2
7.2
8.2
9.3
10.3 1
11.3 1
12.4 1 | te Width
6.2 6.
7.3 7.
8.3 8.
9.4 9.
0.4 10.
1.5 11.
2.5 12. | (in.)
98
3 6.4
4 7.4
4 8.5
5 9.6
5 10.6
5 11.7
5 12.8
 | 99
4 6.4
4 7.5
5 8.6
6 9.7
6 10.7
7 11.8
8 12.9 | 100
6.5
7.6
8.7
9.8
10.8
11.9
13.0 | 101
6.6
7.7
8.8
9.9
11.0
12.1
13.1 | 102
6.6
7.7
8.9
10.0
11.1
12.2
13.3 | 103
6.7
7.8
8.9
10.1
11.2
12.3
13.4 | 104
6.8
7.9
9.0
10.2
11.3
12.4
13.5 | 105
6.8
8.0
9.1
10.3
11.4
12.5
13.7 | 106
6.9
8.0
9.2
10.3
11.5
12.6
13.8
 | 107
7.0
8.1
9.3
10.4
11.6
12.8
13.9 | 108
7.0
8.2
9.4
10.5
11.7
12.9
14.1 | 109
7.1
8.3
9.5
10.6
11.8
13.0
14.2 | 110
7.2
8.4
9.5
10.7
11.9
13.1
14.3 | 111
7.2
8.4
9.6
10.8
12.0
13.2
14.4 | 112
7.3
8.5
9.7
10.9
12.1
13.4
14.6 | 113
7.4
8.6
9.8
11.0
12.3
13.5
14.7 | 114
7.4
8.7
9.9
11.1
12.4
13.6
14.8 | 115
7.5
8.7
10.0
11.2
12.5
13.7
15.0 | 116
7.5
8.8
10.1
11.3
12.6
13.8
15.1 | 117 7.6
8.9
10.2
11.4
12.7
14.0
15.2 | 118 1 7.7 9.0 10.2 1 11.5 1 12.8 1 14.1 1 15.4 1 | 19 120 7.7 7.8 9.0 9.1 10.3 10.4 1.6 11.7 2.9 13.0 4.2 14.3 5.5 15.6 |
| Ac | tual Plate
Weight
(tons)
3/8"
7/16"
1/2"
9/16"
5/8"
11/16"
3/4"
13/16"
7/8" | 72
4.7
5.9
6.2
7.0
7.8
8.6
9.4
10.2 | 73
7 4.8
5 5.5
2 6.3
0 7.1
3 7.9
5 8.7
4 9.5
2 10.3
0 111 | 74
4.8
5.6
6.4
7.2
8.0
8.8
9.6
10.4 | 75
4.9
5.7
6.5
7.3
8.1
8.9
9.8
10.6 | 76
4.9
5.8
6.6
7.4
8.2
9.1
9.9
10.7
115 | 77
5.0
5.8
6.7
7.5
8.4
9.2
10.0
10.9 | 78
5.1
5.9
6.8
7.6
8.5
9.3
10.2
11.0 | 79
5.1
6.0
6.9
7.7
8.6
9.4
10.3
11.1 | 80
5.2
6.1
6.9
7.8
8.7
9.5
10.4
11.3
12.1 | 81
5.3
6.2
7.0
7.9
8.8
9.7
10.5
11.4 | 82
3 5.3
2 6.2
0 7.1
9 8.0
8 8.9
7 9.8
5 10.7
4 11.6
8 125

 | 83
5.4
6.3
7.2
8.1
9.0
9.9
10.8
11.7 | 84
5.5
6.4
7.3
8.2
9.1
10.0
10.9
11.8
12.8
 | 85
5.5
6.5
7.4
8.3
9.2
10.1
11.1
12.0
12.9 | 86
5.6
6.5
7.5
8.4
9.3
10.3
11.2
12.1
13.1 | 87
5.7
6.6
7.5
8.5
9.4
10.4
11.3
12.3
13.2 | 88
5.7
6.7
7.6
8.6
9.5
10.5
11.5
12.4 | 89
5.8
6.8
7.7
8.7
9.7
10.6
11.6
12.6
13.5 | 90
5.9
6.8
7.8
8.8
9.8
10.7
11.7
12.7
13.7 | 91
5.9
6.9
7.9
8.9
9.9
10.9
11.8
12.8
13.8 | 92
6.0
7.0
8.0
9.0
10.0
11.0
12.0
13.0 | 93
6.1
7.1
8.1
9.1
10.1
11.1
12.1
13.1
14.1
 | Orde
94 9
6.1
7.1
8.2
9.2
10.2
11.2
12.2
13.3 | red Pla
95 9
6.2
7.2
8.2
9.3
10.3 1
11.3 1
12.4 1
13.4 1 | te Width
6.2 6.
7.3 7.
8.3 8.
9.4 9.
0.4 10.
1.5 11.
2.5 12.
3.5 13.
4.5 14. | (in.)
98
3 6.4
4 7.4
4 8.5
5 9.6
5 10.6
5 11.5
5 12.8
7 13.8
7 13.8
 | 99
4 6.4
4 7.5
5 8.6
6 9.7
6 10.7
7 11.8
8 12.9
8 14.0
9 15 0 | 100
6.5
7.6
8.7
9.8
10.8
11.9
13.0
14.1 | 101
6.6
7.7
8.8
9.9
11.0
12.1
13.1
14.2 | 102
6.6
7.7
8.9
10.0
11.1
12.2
13.3
14.4 | 103
6.7
7.8
8.9
10.1
11.2
12.3
13.4
14.5 | 104
6.8
7.9
9.0
10.2
11.3
12.4
13.5
14.7 | 105
6.8
8.0
9.1
10.3
11.4
12.5
13.7
14.8 | 106
6.9
8.0
9.2
10.3
11.5
12.6
13.8
14.9
16.1
 | 107
7.0
8.1
9.3
10.4
11.6
12.8
13.9
15.1
16.2 | 108
7.0
8.2
9.4
10.5
11.7
12.9
14.1
15.2
16.4 | 109
7.1
8.3
9.5
10.6
11.8
13.0
14.2
15.4
15.6 | 110
7.2
8.4
9.5
10.7
11.9
13.1
14.3
15.5
16.7 | 111
7.2
8.4
9.6
10.8
12.0
13.2
14.4
15.7 | 112
7.3
8.5
9.7
10.9
12.1
13.4
14.6
15.8
17.0 | 113
7.4
8.6
9.8
11.0
12.3
13.5
14.7
15.9 | 114
7.4
8.7
9.9
11.1
12.4
13.6
14.8
16.1 | 115
7.5
8.7
10.0
11.2
12.5
13.7
15.0
16.2
17.5 | 116
7.5
8.8
10.1
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15.1
16.4
17.6 | 117 1
7.6
8.9
10.2
11.4
12.7
14.0
15.2
16.5 | 118 1 7.7 9.0 10.2 1 11.5 1 12.8 1 14.1 1 15.4 1 16.6 1 17.9 1 | 19 120 7.7 7.8 9.0 9.1 10.3 10.4 11.6 11.7 12.9 13.0 14.2 14.3 15.5 15.6 16.8 16.9 16.8 16.9 |
| Ac | tual Plate
Weight
(tons)
3/8"
7/16"
1/2"
9/16"
5/8"
11/16"
3/4"
13/16"
7/8" | 72
4.7
5.5
6.2
7.0
7.8
8.6
9.4
10.2
10.9 | 73
7 4.8
5 5.5
2 6.3
0 7.1
8 7.9
5 8.7
4 9.5
2 10.3
9 11.1
5 12.7 | 74
4.8
5.6
6.4
7.2
8.0
8.8
9.6
10.4
11.2
12.8 | 75
4.9
5.7
6.5
7.3
8.1
8.9
9.8
10.6
11.4
13.0 | 76
4.9
5.8
6.6
7.4
8.2
9.1
9.9
10.7
11.5
13.2 | 77
5.0
5.8
6.7
7.5
8.4
9.2
10.0
10.9
11.7
13.4 | 78
5.1
5.9
6.8
7.6
8.5
9.3
10.2
11.0
11.8
13.5 | 79
5.1
6.0
6.9
7.7
8.6
9.4
10.3
11.1
12.0
13.7 | 80
5.2
6.1
6.9
7.8
8.7
9.5
10.4
11.3
12.1
13.9 | 81
5.3
6.2
7.0
7.9
8.8
9.7
10.5
11.4
12.3
14 1 | 82
3 5.3
2 6.2
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9 8.0
3 8.9
7 9.8
5 10.7
4 11.6
3 12.5
1 14 2

 | 83
5.4
6.3
7.2
8.1
9.0
9.9
10.8
11.7
12.6
14 4 | 84
5.5
6.4
7.3
8.2
9.1
10.0
10.9
11.8
12.8
14.6
 | 85
5.5
6.5
7.4
8.3
9.2
10.1
11.1
12.0
12.9
14.8 | 86
5.6
6.5
7.5
8.4
9.3
10.3
11.2
12.1
13.1
14.9 | 87
5.7
6.6
7.5
8.5
9.4
10.4
11.3
12.3
13.2
15.1 | 88
5.7
6.7
7.6
8.6
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10.5
11.5
12.4
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15.3 | 89
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10.6
11.6
12.6
13.5
15.4 | 90
5.9
6.8
7.8
8.8
9.8
10.7
11.7
12.7
13.7
15.6 | 91
5.9
6.9
7.9
8.9
9.9
10.9
11.8
12.8
13.8
15.8 | 92
6.0
7.0
8.0
9.0
10.0
11.0
12.0
13.0
14.0
16.0 | 93
6.1
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 | Orde
94 9
6.1
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14.3
16.3 | red Pla
95 9
6.2
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10.3 1
11.3 1
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14.4 1
14.4 1 | te Width
96 97
6.2 6.
7.3 7.
8.3 8.
9.4 9.
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1.5 11.
2.5 12.
3.5 13.
4.6 14.
67 16.
67 16. | (in.)
98
3 6.4
4 7.4
4 8.5
5 9.6
5 10.6
5 11.5
5 12.8
7 13.8
7 14.9
3 17 (
 | 99
4 6.4
4 7.5
5 8.6
6 9.7
6 10.7
7 11.8
8 12.9
8 14.0
9 15.0
0 17 2 | 100
6.5
7.6
8.7
9.8
10.8
11.9
13.0
14.1
15.2
17.4 | 101
6.6
7.7
8.8
9.9
11.0
12.1
13.1
14.2
15.3
17.5 | 102
6.6
7.7
8.9
10.0
11.1
12.2
13.3
14.4
15.5
17.7 | 103
6.7
7.8
8.9
10.1
11.2
12.3
13.4
14.5
15.6
17.9 | 104
6.8
7.9
9.0
10.2
11.3
12.4
13.5
14.7
15.8
18.1 | 105
6.8
8.0
9.1
10.3
11.4
12.5
13.7
14.8
15.9
18.2 | 106
6.9
8.0
9.2
10.3
11.5
12.6
13.8
14.9
16.1
18.4
 | 107
7.0
8.1
9.3
10.4
11.6
12.8
13.9
15.1
16.2
18.6 | 108
7.0
8.2
9.4
10.5
11.7
12.9
14.1
15.2
16.4
18.7 | 109
7.1
8.3
9.5
10.6
11.8
13.0
14.2
15.4
16.6
18.9 | 110
7.2
8.4
9.5
10.7
11.9
13.1
14.3
15.5
16.7
19.1 | 111
7.2
8.4
9.6
10.8
12.0
13.2
14.4
15.7
16.9
19.3 | 112
7.3
8.5
9.7
10.9
12.1
13.4
14.6
15.8
17.0
19.4 | 113
7.4
8.6
9.8
11.0
12.3
13.5
14.7
15.9
17.2
19.6 | 114
7.4
8.7
9.9
11.1
12.4
13.6
14.8
16.1
17.3
19.8 | 115
7.5
8.7
10.0
11.2
12.5
13.7
15.0
16.2
17.5
20.0 | 116
7.5
8.8
10.1
11.3
12.6
13.8
15.1
16.4
17.6
20.1 | 117 1 7.6 8.9 10.2 11.4 12.7 14.0 15.2 16.5 17.8 20.3 | 118 1 7.7 9.0 10.2 1 11.5 1 12.8 1 14.1 1 15.4 1 16.6 1 17.9 1 20.5 2 | 19 120 7.7 7.8 9.0 9.1 10.3 10.4 11.6 11.7 2.9 13.0 44.2 14.3 5.5 15.6 6.8 16.9 18.1 18.2 0.7 2.0 |
| | tual Plate
Weight
(tons)
3/8"
7/16"
1/2"
9/16"
5/8"
11/16"
3/4"
13/16"
7/8"
1"
1-1/8" | 72
4.7
5.5
6.2
7.0
7.8
8.6
9.4
10.2
10.9
12.5
14.1 | 73
7 4.8
5 5.5
2 6.3
0 7.1
8 7.9
5 8.7
4 9.5
2 10.3
9 11.1
5 12.7
1 14.3 | 74
4.8
5.6
6.4
7.2
8.0
8.8
9.6
10.4
11.2
12.8
14.4 | 75
4.9
5.7
6.5
7.3
8.1
8.9
9.8
10.6
11.4
13.0
14.6 | 76
4.9
5.8
6.6
7.4
8.2
9.1
9.9
10.7
11.5
13.2
14.8 | 77
5.0
5.8
6.7
7.5
8.4
9.2
10.0
10.9
11.7
13.4
15.0 | 78
5.1
5.9
6.8
7.6
8.5
9.3
10.2
11.0
11.8
13.5
15.2 | 79
5.1
6.0
6.9
7.7
8.6
9.4
10.3
11.1
12.0
13.7
15.4 | 80
5.2
6.1
6.9
7.8
8.7
9.5
10.4
11.3
12.1
13.9
15.6 | 81
5.3
6.2
7.0
7.9
8.8
9.7
10.5
11.4
12.3
14.1
15.8 | 82
3 5.3
2 6.2
0 7.1
9 8.0
3 8.9
7 9.8
5 10.7
4 11.6
3 12.5
1 14.2
3 16.0

 | 83
5.4
6.3
7.2
8.1
9.0
9.9
10.8
11.7
12.6
14.4
16.2 | 84
5.5
6.4
7.3
8.2
9.1
10.0
10.9
11.8
12.8
14.6
16.4
 | 85
5.5
6.5
7.4
8.3
9.2
10.1
11.1
12.0
12.9
14.8
16.6 | 86
5.6
6.5
7.5
8.4
9.3
10.3
11.2
12.1
13.1
14.9
16.8 | 87
5.7
6.6
7.5
8.5
9.4
10.4
11.3
12.3
13.2
15.1
17.0 | 88
5.7
7.6
8.6
9.5
10.5
11.5
12.4
13.4
15.3
17.2 | 89
5.8
6.8
7.7
9.7
10.6
11.6
12.6
13.5
15.4
17.4 | 90
5.9
6.8
7.8
8.8
9.8
10.7
11.7
12.7
13.7
15.6
17.6 | 91
5.9
6.9
7.9
9.9
10.9
11.8
12.8
13.8
15.8
17.8 | 92
6.0
7.0
8.0
9.0
10.0
11.0
12.0
13.0
14.0
16.0
18.0 | 93
6.1
7.1
8.1
9.1
10.1
11.1
12.1
13.1
14.1
16.1
18.2
 | Orde
94
6.1
7.1
8.2
9.2
10.2
11.2
12.2
13.3
14.3
16.3
18.4 | red Pla
95 9
6.2
7.2
8.2
9.3
10.3 1
11.3 1
12.4 1
13.4 1
14.4 1
16.5 1
18.5 1 | te Width
62 6.
7.3 7.
8.3 8.
9.4 9.
0.4 10.
1.5 11.
2.5 12.
3.5 13.
4.6 14.
6.7 16.
8.7 18. | (in.)
98
3 6.4
4 7.4
4 8.5
5 9.6
5 10.6
5 11.7
5 12.8
7 13.8
7 14.9
8 17.0
9 19.7
 | 99
4 6.4
4 7.5
5 8.6
6 9.7
6 10.7
7 11.8
8 12.9
8 14.0
9 15.0
0 17.2
1 19.3 | 100
6.5
7.6
8.7
9.8
10.8
11.9
13.0
14.1
15.2
17.4
19.5 | 101
6.6
7.7
8.8
9.9
11.0
12.1
13.1
14.2
15.3
17.5
19.7 | 102
6.6
7.7
8.9
10.0
11.1
12.2
13.3
14.4
15.5
17.7
19.9 | 103
6.7
7.8
8.9
10.1
11.2
12.3
13.4
14.5
15.6
17.9
20.1 | 104
6.8
7.9
9.0
10.2
11.3
12.4
13.5
14.7
15.8
18.1
20.3 | 105
6.8
8.0
9.1
10.3
11.4
12.5
13.7
14.8
15.9
18.2
20.5 | 106
6.9
8.0
9.2
10.3
11.5
12.6
13.8
14.9
16.1
18.4
20.7
 | 107
7.0
8.1
9.3
10.4
11.6
12.8
13.9
15.1
16.2
18.6
20.9 | 108
7.0
8.2
9.4
10.5
11.7
12.9
14.1
15.2
16.4
18.7
21.1 | 109
7.1
8.3
9.5
10.6
11.8
13.0
14.2
15.4
16.6
18.9
21.3 | 110
7.2
8.4
9.5
10.7
11.9
13.1
14.3
15.5
16.7
19.1
21.5 | 111
7.2
8.4
9.6
10.8
12.0
13.2
14.4
15.7
16.9
19.3
21.7 | 112
7.3
8.5
9.7
10.9
12.1
13.4
14.6
15.8
17.0
19.4
21.9 | 113
7.4
8.6
9.8
11.0
12.3
13.5
14.7
15.9
17.2
19.6
22.1 | 114
7.4
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9.9
11.1
12.4
13.6
14.8
16.1
17.3
19.8
22.3 | 115
7.5
8.7
10.0
11.2
12.5
13.7
15.0
16.2
17.5
20.0
22.5 | 116
7.5
8.8
10.1
11.3
12.6
13.8
15.1
16.4
17.6
20.1
22.6 | 117 : 7.6 8.9 10.2 11.4 12.7 14.0 15.2 16.5 17.8 20.3 22.8 22.8 | 118 1 7.7 9.0 10.2 1 11.5 1 12.8 1 14.1 1 15.4 1 16.6 1 17.9 1 20.5 2 23.0 2 | 19 120 7.7 7.8 9.0 9.1 10.3 10.4 11.6 11.7 12.9 13.0 44.2 14.3 5.5 15.6 16.8 16.9 18.1 182 12.7 20.8 12.2 23.4 |
| Actives (in) | tual Plate
tual Plate
(tons)
3/8"
7/16"
1/2"
9/16"
5/8"
11/16"
3/4"
13/16"
13/16"
13/16"
13/16"
13/16"
1-1/8" | 72
4.7
5.5
6.2
7.0
7.8
8.6
9.4
10.2
10.9
12.5
14.1
15.6 | 73
7 4.8
5 5.5
2 6.3
0 7.1
8 7.9
5 8.7
4 9.5
2 10.3
9 11.1
5 12.7
1 14.3
5 15.8 | 74
4.8
5.6
6.4
7.2
8.0
8.8
9.6
10.4
11.2
12.8
14.4
16.1 | 75
4.9
5.7
6.5
7.3
8.1
8.9
9.8
10.6
11.4
13.0
14.6
16.3 | 76
4.9
5.8
6.6
7.4
8.2
9.1
9.9
10.7
11.5
13.2
14.8
16.5 | 77
5.0
5.8
6.7
7.5
8.4
9.2
10.0
10.9
11.7
13.4
15.0
16.7 | 78
5.1
5.9
6.8
7.6
8.5
9.3
10.2
11.0
11.8
13.5
15.2
16.9 | 79
5.1
6.0
6.9
7.7
8.6
9.4
10.3
11.1
12.0
13.7
15.4
17.1 | 80
5.2
6.1
6.9
7.8
8.7
9.5
10.4
11.3
12.1
13.9
15.6
17.4 | 81
5.3
6.2
7.0
7.9
8.8
9.7
10.5
11.4
12.3
14.1
15.8
17.6 | 82
3 5.3
2 6.2
0 7.1
9 8.0
3 8.9
7 9.8
5 10.7
4 11.6
3 12.5
1 14.2
8 16.0
5 17.8

 | 83
5.4
6.3
7.2
8.1
9.0
9.9
10.8
11.7
12.6
14.4
16.2
18.0 | 84
5.5
6.4
7.3
8.2
9.1
10.0
10.9
11.8
12.8
14.6
16.4
18.2
 | 85
5.5
6.5
7.4
8.3
9.2
10.1
11.1
12.0
12.9
14.8
16.6
18.4 | 86
5.6
6.5
7.5
8.4
9.3
10.3
11.2
12.1
13.1
14.9
16.8
18.7 | 87
5.7
6.6
7.5
9.4
10.4
11.3
12.3
13.2
15.1
17.0
18.9 | 88
5.7
6.7
7.6
8.6
9.5
10.5
11.5
12.4
13.4
15.3
17.2
19.1 | 89
5.8
6.8
7.7
8.7
9.7
10.6
11.6
12.6
13.5
15.4
17.4
19.3 | 90
5.9
6.8
7.8
8.8
9.8
10.7
11.7
12.7
13.7
15.6
17.6
19.5 | 91
5.9
6.9
7.9
8.9
9.9
10.9
11.8
12.8
13.8
15.8
17.8
19.7 | 92
6.0
7.0
8.0
9.0
10.0
11.0
12.0
13.0
14.0
16.0
18.0
20.0 | 93
6.1
7.1
8.1
9.1
10.1
11.1
12.1
13.1
14.1
16.1
18.2
20.2
 | Orde
94 6.1 7.1 8.2 9.2 10.2 11.2 13.3 14.3 16.3 18.4 20.4 5 | red Pla
95 9
6.2
7.2
8.2
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10.3 1
11.3 1
12.4 1
13.4 1
14.4 1
16.5 1
18.5 1
20.6 2 | te Width
6.2 6.
7.3 7.
8.3 8.
9.4 9.
0.4 10.
1.5 11.
2.5 12.
3.5 13.
4.6 14.
6.7 16.
8.7 18.
0.8 21. | (in.)
98
3 6.4
4 7.4
4 8.5
5 9.6
5 10.6
5 11.5
5 12.8
7 13.8
7 14.9
8 17.0
9 19.1
0 21.3
 | 99
4 6.4
4 7.5
5 8.6
6 9.7
6 10.7
7 11.8
8 12.9
8 14.0
9 15.0
0 17.2
1 19.3
3 21.5 | 100
6.5
7.6
8.7
9.8
10.8
11.9
13.0
14.1
15.2
17.4
19.5
21.7 | 101
6.6
7.7
8.8
9.9
11.0
12.1
13.1
14.2
15.3
17.5
19.7
21.9 | 102
6.6
7.7
8.9
10.0
11.1
12.2
13.3
14.4
15.5
17.7
19.9
22.1 | 103
6.7
7.8
8.9
10.1
11.2
12.3
13.4
14.5
15.6
17.9
20.1
22.3 | 104
6.8
7.9
9.0
10.2
11.3
12.4
13.5
14.7
15.8
18.1
20.3
22.6 | 105
6.8
8.0
9.1
10.3
11.4
12.5
13.7
14.8
15.9
18.2
20.5
22.8 | 106
6.9
8.0
9.2
10.3
11.5
12.6
13.8
14.9
16.1
18.4
20.7
23.0
 | 107
7.0
8.1
9.3
10.4
11.6
12.8
13.9
15.1
16.2
18.6
20.9
23.2 | 108
7.0
8.2
9.4
10.5
11.7
12.9
14.1
15.2
16.4
18.7
21.1
23.4 | 109
7.1
8.3
9.5
10.6
11.8
13.0
14.2
15.4
16.6
18.9
21.3
23.6 | 110
7.2
8.4
9.5
10.7
11.9
13.1
14.3
15.5
16.7
19.1
21.5
23.9 | 111
7.2
8.4
9.6
10.8
12.0
13.2
14.4
15.7
16.9
19.3
21.7
24.1 | 112
7.3
8.5
9.7
10.9
12.1
13.4
14.6
15.8
17.0
19.4
21.9
24.3 | 113
7.4
8.6
9.8
11.0
12.3
13.5
14.7
15.9
17.2
19.6
22.1
24.5 | 114
7.4
8.7
9.9
11.1
12.4
13.6
14.8
16.1
17.3
19.8
22.3
24.7 | 115
7.5
8.7
10.0
11.2
12.5
13.7
15.0
16.2
17.5
20.0
22.5
24.9 | 116
7.5
8.8
10.1
11.3
12.6
13.8
15.1
16.4
17.6
20.1
22.6
25.2 | 117 2 7.6 8.9 10.2 11.4 12.7 14.0 15.2 16.5 17.8 20.3 22.8 25.4 | 118 1 7.7 9.0 10.2 1 11.5 1 12.8 1 14.1 1 15.4 1 16.6 1 17.9 1 20.5 2 23.0 2 25.6 2 | 19 120 7.7 7.8 9.0 9.1 10.3 10.4 11.6 11.7 12.9 13.0 14.2 14.3 15.5 15.6 16.8 16.9 18.1 18.2 10.7 20.8 12.2 23.4 15.8 26.0 |
| Thickness (in) | tual Plate
Weight
(tons)
3/8"
7/16"
1/2"
9/16"
5/8"
11/16"
3/4"
13/16"
13/16"
13/16"
13/16"
1-1/8"
1-1/8"
1-3/8" | 72
4.7
5.5
6.2
7.0
7.8
8.6
9.4
10.2
10.9
12.5
14.1
15.6
17.2 | 73 7 4.8 5 5.5 2 6.3 0 7.1 3 7.9 5 8.7 4 9.5 2 10.3 9 11.1 5 12.7 1 14.3 5 15.8 2 17.4 | 74
4.8
5.6
6.4
7.2
8.0
8.8
9.6
10.4
11.2
12.8
14.4
16.1
17.7 | 75
4.9
5.7
6.5
7.3
8.1
8.9
9.8
10.6
11.4
13.0
14.6
16.3
17.9 | 76
4.9
5.8
6.6
7.4
8.2
9.1
9.9
10.7
11.5
13.2
14.8
16.5
18.1 | 77
5.0
5.8
6.7
7.5
8.4
9.2
10.0
10.9
11.7
13.4
15.0
16.7
18.4 | 78
5.1
5.9
6.8
7.6
8.5
9.3
10.2
11.0
11.8
13.5
15.2
16.9
18.6 | 79
5.1
6.0
6.9
7.7
8.6
9.4
10.3
11.1
12.0
13.7
15.4
17.1
18.9 | 80
5.2
6.1
6.9
7.8
8.7
9.5
10.4
11.3
12.1
13.9
15.6
17.4
19.1 | 81
5.3
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10.5
11.7
12.9
14.1
15.2
16.4
18.7
21.1
23.4
25.8
28.1
30.5
22.8 | 109
7.1
8.3
9.5
10.6
11.8
13.0
14.2
15.4
16.6
18.9
21.3
23.6
26.0
28.4
30.7
33.1 | 110
7.2
8.4
9.5
10.7
11.9
13.1
14.3
15.5
16.7
19.1
21.5
23.9
26.3
28.6
31.0 | 111
7.2
8.4
9.6
10.8
12.0
13.2
14.4
15.7
16.9
19.3
21.7
24.1
26.5
28.9
31.3
33.7
 | 112
7.3
8.5
9.7
10.9
12.1
13.4
14.6
15.8
17.0
19.4
21.9
24.3
26.7
29.2
31.6
34.0 | 113
7.4
8.6
9.8
11.0
12.3
13.5
14.7
15.9
17.2
19.6
22.1
24.5
27.0
29.4
31.9
34.3 | 114
7.4
8.7
9.9
11.1
12.4
13.6
14.8
16.1
17.3
19.8
22.3
24.7
27.2
29.7
32.2
34.6 | 115
7.5
8.7
10.0
11.2
12.5
13.7
15.0
16.2
17.5
20.0
22.5
24.9
27.4
29.9
32.4
29.9
32.4
9 | 116
7.5
8.8
10.1
11.3
12.6
13.8
15.1
16.4
17.6
20.1
22.6
25.2
27.7
30.2
27.7
30.2
32.7
35.2 | 117 2 7.6 8.9 10.2 11.4 12.7 14.0 15.2 16.5 17.8 20.3 22.8 25.4 27.9 30.5 33.0 35.5 | 118 1 7.7 9.0 10.2 1 11.5 1 12.8 1 15.4 1 15.4 1 16.6 1 20.5 2 23.0 2 25.6 2 30.7 3 33.3 3 35.8 3 | 19 120 7.7 7.8 9.0 9.1 10.3 10.4 1.6 1.7 1.2.9 13.0 4.4.2 14.3 5.5 15.6 6.6.8 16.9 8.3.2 23.4 5.5.8 26.0 8.4.4 28.6 8.1.0 31.2 13.6 33.8 61.0 31.2 |
| dered Blate Thickness (in) | tual Plate
Weight
(tons)
3/8"
7/16"
5/8"
11/16"
3/4"
13/16"
13/16"
13/16"
13/16"
1-1/8"
1-1/8"
1-3/8"
1-1/2"
1-5/8"
1-3/4" | 72
4.7
5.5
6.2
7.0
7.8
8.6
9.4
10.2
10.9
12.5
14.1
15.6
17.2
18.7
20.3
21.9
23.4 | 73 7 4.8 5 5.5 2 7.1 3 7.9 5 8.7 4 9.5 2 10.3 9 11.1 5 15.8 2 17.4 7 1.400 6 15.8 2 17.4 7 19.0 3 20.6 9 22.2 4 23.8 | 74
4.8
5.6
6.4
7.2
8.0
8.8
9.6
10.4
11.2
12.8
14.4
16.1
17.7
19.3
20.9
22.5
22.5
24.1 | 75
4.9
5.7
6.5
7.3
8.1
8.9
9.8
10.6
11.4
13.0
14.6
16.3
17.9
19.5
21.2
22.28
24.4 | 76
4.9
5.8
6.6
7.4
8.2
9.1
9.9
10.7
11.5
13.2
14.8
16.5
18.1
19.8
21.4
23.1
24.7 | 77
5.0
5.8
6.7
7.5
8.4
9.2
10.0
10.9
11.7
13.4
15.0
16.7
18.4
20.0
21.7
23.4
25.1 | 78
5.1
5.9
6.8
7.6
8.5
9.3
10.2
11.0
11.8
13.5
15.2
16.9
18.6
20.3
22.0
23.7
25.4 | 79
5.1
6.0
6.9
7.7
8.6
9.4
10.3
11.1
12.0
13.7
15.4
17.1
18.9
20.6
22.3
24.0
25.7 | 80
5.2
6.1
6.9
7.8
8.7
9.5
10.4
11.3
12.1
13.9
15.6
17.4
19.1
20.8
22.6
24.3
26.0 | 81
5.3
6.2
7.0
7.9
8.8
9.7
10.5
11.4
12.3
14.1
15.8
17.6
19.3
21.1
22.8
24.6
26 4 | 82
3 5.3
2 6.2
0 7.1
9 8.0
3 8.9
7 9.8
5 10.7
4 11.6
3 12.5
1 142.5
1 142.5
1 142.5
3 19.6
1 21.3
3 2.3.1
5 24.9
4 26.7
1 4 26.7
1 5 24.9
4 26.7
1 5 24.9
1
 | 83
5.4
6.3
7.2
8.1
9.0
9.9
10.8
11.7
12.6
14.4
16.2
18.0
19.8
21.6
23.4
23.4
23.4
27.0 | 84
5.5
6.4
7.3
8.2
9.1
10.0
10.9
11.8
12.8
12.8
12.8
12.8
12.8
12.8
12.8

 | 85
5.5
6.5
7.4
8.3
9.2
10.1
11.1
12.0
12.9
14.8
16.6
18.4
20.3
22.1
24.0
25.8
27.7 | 86
5.6
6.5
7.5
8.4
9.3
10.3
11.2
12.1
13.1
14.9
16.8
18.7
20.5
22.4
24.3
26.1
28.0 | 87
5.7
6.6
7.5
8.5
9.4
10.4
11.3
12.3
13.2
15.1
17.0
18.9
20.8
22.6
24.5
26.4
24.5
26.4
28.3 | 88
5.7
6.7
7.6
9.5
10.5
11.5
12.4
15.3
17.2
19.1
21.0
22.9
24.8
26.7
28.6 | 89
5.8
6.8
7.7
9.7
10.6
11.6
12.6
13.5
15.4
17.4
19.3
21.2
23.2
25.1
27.0
29.0 | 90
5.9
6.8
7.8
9.8
10.7
11.7
12.7
13.7
15.6
17.6
19.5
21.5
23.4
25.4
27.3
29.3 | 91
5.9
6.9
7.9
9.9
10.9
11.8
12.8
13.8
15.8
17.8
19.7
21.7
23.7
23.7
27.6
29.6 | 92
6.0
7.0
9.0
10.0
11.0
12.0
13.0
14.0
16.0
18.0
20.0
22.0
24.0
25.9
27.9
29.9 | 93
6.1
7.1
8.1
9.1
10.1
11.1
12.1
13.1
14.1
16.1
18.2
20.2
22.2
24.2
26.2
28.2
30.3 | Orde
94
6.1
7.1
8.2
9.2
10.2
11.2
12.2
13.3
14.3
16.3
18.4
20.4
22.4
24.5
26.5
28.6
30.6
 | red Pla
95 9
6.2
7.2
9.3
10.3 1
1.3 1
1.3 1
1.3 1
1.4.4 1
1.6.5 1
1.6.5 1
1.8.5 1
1.6.5 2
2.7 2
2.4.7 2
2.4.9 2
2.4.7 2
2.4.9 2 | te Width
6.2 6.
7.3 7.
8.3 8.
9.4 9.
0.4 10.
1.5 11.
2.5 12.
5.1 12.
5.1 12.
1.5 13.
4.6 14.
6.7 16.
8.7 18.
0.8 21.
12.9 23.
5.0 25.
7.1 27.
9.2 29.
12. 21.
12. 21.
13. 21.
14. 21.
15. 2 | 98 98 3 6.4 4 7.4 4 8.5 5 9.6 5 10.0 5 11.1 5 12.8 6 11.3 7 14.9 9 19.2 1 23.4 3 27.5 4 29.8 5 29.6 5 31.9 | 99
4 6.4
4 7.5
5 8.6
6 9.7
6 10.7
7 11.8
8 12.9
8 14.0
9 15.0
0 15.0
0 15.0
0 15.0
1 19.3
3 21.5
4 23.6
5 25.8
6 27.9
8 3.0.1
9 32.2
9 32.2
9
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9
9 | 100
6.5
7.6
8.7
9.8
10.8
11.9
13.0
14.1
15.2
17.4
19.5
21.7
23.9
26.0
28.2
23.0,4
30.4
32,5 | 101
6.6
7.7
8.8
9.9
11.0
12.1
13.1
14.2
15.3
17.5
19.7
21.9
24.1
26.3
28.5
30.7
32.9 |
102
6.6
7.7
8.9
10.0
11.1
12.2
13.3
14.4
15.5
5.7
7.7
19.9
22.1
24.3
26.6
8
8.3
1.0
33.2 | 103
6.7
7.8
8.9
10.1
11.2
12.3
13.4
14.5
15.6
17.9
20.1
22.3
24.6
26.8
29.1
313
335 | 104
6.8
7.9
9.0
10.2
11.3
12.4
13.5
14.7
15.8
18.1
20.3
22.6
24.8
27.1
29.3
31.6
33.8 | 105
6.8
8.0
9.1
10.3
11.4
12.5
13.7
14.8
15.9
18.2
20.5
22.8
25.1
27.3
29.6
31.9
34.2 | 106
6.9
8.0
9.2
10.3
11.5
12.6
13.8
14.9
16.1
18.4
20.7
23.0
25.3
27.6
29.9
32.2
34.5 | 107
7.0
8.1
9.3
10.4
11.6
12.8
13.9
15.1
16.2
18.6
20.9
23.2
25.5
27.9
30.2
32.5
34.8 | 108
7.0
8.2
9.4
10.5
11.7
12.9
14.1
15.2
16.4
18.7
21.1
23.4
25.8
28.1
30.5
32.8
35.1 | 109
7.1
8.3
9.5
10.6
11.8
13.0
14.2
15.4
16.6
18.9
21.3
23.6
26.0
28.4
30.7
33.1
34.8 | 110
7.2
8.4
9.5
10.7
11.9
13.1
14.3
15.5
16.7
19.1
21.5
23.9
26.3
28.6
31.0
33.4 | 111
7.2
8.4
9.6
10.8
12.0
13.2
14.4
15.7
16.9
19.3
21.7
24.1
26.5
28.9
31.3,7
35.4 | 112
7.3
8.5
9.7
10.9
12.1
13.4
14.6
15.8
17.0
19.4
21.9
24.3
26.7
29.2
31.6
34.0
35.7 | 113
7.4
8.6
9.8
11.0
12.3
13.5
14.7
15.9
17.2
19.6
22.1
24.5
27.0
29.4
31.9
35.8 | 114
7.4
8.7
9.9
11.1
12.4
13.6
14.8
16.1
17.3
19.8
22.3
24.7
27.2
29.7
32.2
34.6
35.8 | 115
7.5
8.7
10.0
11.2
12.5
13.7
15.0
16.2
17.5
20.0
22.5
24.9
27.4
29.9
27.4
29.9
32.4
9
35.8 | 116
7.5
8.8
10.1
11.3
12.6
13.8
15.1
16.4
17.6
20.1
22.6
25.2
27.7
30.2
32.7
30.2
35.2
35.8 | 117 2 7.6 8.9 10.2 11.4 12.7 14.0 15.2 16.5 17.8 20.3 22.8 25.4 27.9 30.5 33.0 35.5 | 118 1 7.7 9.0 10.2 1 11.5 1 12.8 1 14.1 1 15.4 1 16.6 1 20.5 2 23.0 2 28.2 2 30.7 3 35.8 3 35.7 3 | 19 120 7.7 7.8 9.0 9.1 10.3 10.4 11.6 11.7 12.9 13.0 14.2 14.3 15.5 15.6 16.8 16.9 18.1 18.2 20.7 20.8 13.2 23.4 15.8 26.0 14.2 18.4 28.6 33.8 31.0 31.2 13.6 33.8 16.1 36.4 55.7 35.7 |
| Ordered Plate Thickness (in) | tual Plate
Weight
(tons)
7/16"
1/2"
9/16"
3/4"
13/16"
1/16"
13/16"
1.1/4"
1-1/8"
1-1/4"
1-3/8"
1-1/2"
1-5/8"
1-3/4"
2" | 72
4.7
5.5
6.2
7.0
7.8
8.6
9.4
10.2
10.9
12.5
14.1
15.6
17.2
18.7
20.3
21.9
23.4
25.0 | 73 7 4.8 5 5.5 2 6.3 0 7.1 3 7.9 5 8.7 4 9.5 2 10.3 9 11.1 5 12.7 1 14.3 5 15.8 2 17.4 7 19.0 3 20.6 9 22.2 4 23.8 2 25.3 | 74
4.8
5.6
6.4
7.2
8.0
8.8
9.6
10.4
11.2
12.8
14.4
16.1
17.7
19.3
20.9
22.5
24.1
25.7 | 75
4.9
5.7
6.5
7.3
8.1
8.9
9.8
10.6
11.4
13.0
14.6
16.3
17.9
19.5
21.2
22.8
24.4
26.0 | 76
4.9
5.8
6.6
7.4
8.2
9.1
9.9
9.10.7
11.5
13.2
14.8
16.5
18.1
19.8
21.4
23.1
24.7
26.4 | 77
5.0
5.8
6.7
7.5
8.4
9.2
10.0
10.9
11.7
13.4
15.0
16.7
18.4
20.0
21.7
23.4
25.1
26.7 | 78
5.1
5.9
6.8
7.6
8.5
9.3
10.2
11.0
11.8
13.5
15.2
16.9
18.6
20.3
22.0
23.7
25.4
27.1 | 79
5.1
6.0
6.9
7.7
8.6
9.4
10.3
11.1
12.0
13.7
15.4
17.1
18.9
20.6
22.3
24.0
25.7
27.4 | 80
5.2
6.1
6.9
7.8
8.7
9.5
10.4
11.3
12.1
13.9
15.6
17.4
19.1
20.8
22.6
24.3
26.0
27.8 | 81
5.3
6.2
7.0
7.9
8.8
9.7
10.5
11.4
12.3
14.1
15.8
17.6
19.3
21.1
22.8
24.6
26.4
28.1 | 82
3 5.3
2 6.2
0 7.1
9 8.0
3 8.9
7 9.8
5 10.7
4 11.6
3 12.5
1 142.5
1 142.5
3 19.6
1 21.3
3 23.1
5 24.9
4 26.7
1 28.5

 | 83
5.4
6.3
7.2
8.1
9.0
9.9
9.9
10.8
11.7
12.6
14.4
16.2
18.0
19.8
21.6
23.4
25.2
27.0
28.8 | 84
5.5
6.4
7.3
8.2
9.1
10.0
10.9
11.8
12.8
12.8
12.8
12.8
12.8
12.8
12.8
 | 85
5.5
6.5
7.4
8.3
9.2
10.1
11.1
12.0
12.9
14.8
16.6
18.4
20.3
22.1
24.0
25.8
27.7
29.5 | 86
5.6
6.5
7.5
8.4
9.3
10.3
11.2
12.1
13.1
14.9
16.8
18.7
20.5
22.4
24.3
26.1
28.0
28.9 | 87
5.7
6.6
7.5
8.5
9.4
10.4
11.3
13.2
15.1
17.0
18.9
20.8
22.6
26.4
28.3
30.2 | 88
5.7
6.7
9.5
9.5
10.5
11.5
12.4
13.4
15.3
17.2
19.1
21.0
22.9
24.8
26.7
28.6
30.5 | 89
5.8
6.8
7.7
9.7
10.6
11.6
12.6
13.5
15.4
17.4
19.3
21.2
23.2
25.1
27.0
29.0
30.9 | 90
5.9
6.8
7.8
8.8
9.8
10.7
11.7
12.7
13.7
15.6
17.6
17.6
19.5
23.4
25.4
27.3
29.3
31.2 | 91
5.9
6.9
9.9
9.9
10.9
11.8
12.8
13.8
15.8
17.8
19.7
21.7
23.7
25.7
25.7
22.6
29.6
31.6 | 92
6.0
7.0
8.0
9.0
10.0
11.0
12.0
13.0
14.0
16.0
18.0
20.0
22.0
24.0
25.9
27.9
29.9
31.9 | 93
6.1
7.1
8.1
10.1
11.1
12.1
13.1
14.1
16.1
18.2
20.2
24.2
26.2
28.2
28.2
30.3
32.3
 | Orde
94
6.1
7.1
8.2
9.2
10.2
11.2
12.2
13.3
14.3
16.3
18.4
20.4
22.4
24.5
26.5
28.6
30.6
30.6
32.6 | red Pla
95 9
6.2
7.2
8.2
9.3
1.1.3
1.1.3
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| Ordered Blate Thickness (in) | tual Plate
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| Ordered Plate Thirkness (in) | tual Plate
Weight
(tons)
3/8"
7/16"
1/2"
5/8"
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The Bill of Materials (BOM), Inquiry, and Quote

- Bridge Fabricators rationalize the flanges, webs, splice plates, stiffeners, cross frames and other bridge components into B.O.M. to send to mills.
 - a. Fabricator adds width allowances for kerf and mill camber (3 4")
 - b. B.O.M. can vary by fabricator
- 2. Mill determines capability to produce (grade, thickness, length, etc.)
- 3. Mill rationalizes B.O.M into heats, slabs, and plates to be produced. This may be different than the original B.O.M. (Ex: offering 96" wide for 93" wide)



Example: Mill technical review of bridge inquiry

- ▶ Inquiry for A709-50T2 585 tons
- Rationalize inquired widths to "more producible" widths
- Determine percentage over inquired weight

								Steel Mill's offered width	Steel Mill's offered width
item	pcs	width	gauge	ft	in	length	tons		tons
1	12	74	0.625	90	8	1088	85.6	74	85.6
2	12	74	0.625	94	0	1128	88.7	74	88.7
3	24	74	0.625	64	4	772	121.5	74	121.5
4	2	98	0.75	90	8	1088	22.7	108	25.0
6	2	98	1	90	8	1088	30.2	108	33.3
7	6	90	1.75	94	0	1128	151.1	90	151.1
8	3	74	0.75	85	6	1026	24.2	74	24.2
9	3	74	0.75	43	0	516	12.2	74	12.2
10	3	74	1	85	6	1026	32.3	74	32.3
11	3	74	1	43	0	516	16.2	74	16.2



From Inquiry to Shipment – How a Bridge Order Happens

4. Sales develops pricing based on current market, consist of base price (A36) plus adders for grades, testing, dimensions, etc.

5. Offer for B.O.M. (rationalized) with pricing and current lead time summited to customer.

a. Lead time a function of market, current mill capacity, etc.

6. Customer accepts offer, becomes an order.

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Inquiry to Shipment – How a Bridge Order Happens (cont'd)

7. Mill puts order into melting/casting schedule to maximize efficiency

a. Based on chemistry. A709-50/50W have multiple chemistries depending on product thickness.

b. Based on width. Caster has limited or no ability to change width on the fly. 120", 96", and 72" will all be cast at different times (sequences).



8. Mill puts order into rolling schedule to maximize efficiency.

a. Based on thickness, grade and width.

b. After rolling plates are cut to order, sampled and tested.

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https://www.bloombergquint.com/business

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Inquiry to Shipment – How a Bridge Order Happens (cont'd)

9. Plates are shipped to customer via rail or truck.

- a. Rail more efficient, larger, longer loads.
- b. Truck faster.



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10. Aim: on time delivery (88%).

a. All orders delivered with in 4 weeks of aim.

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Want to learn More?

- ▶ Mill Tours (post COVID)
- Steelmaking Seminars/Webinars
- Provide PDHs
- Contact:
 - David Stoddard David.Stoddard@ssab.com
 - Tony Peterson Peterson@aisc.org

