

Steels

Written by IT Department

Sunday, 01 December 2013 14:05 - Last Updated Sunday, 01 December 2013 14:19



All tinplate originates in the steel making furnace, where the proper chemistry for steel is obtained to meet the specific needs for the end user. All tin mill products start their production process in a basic oxygen furnace. This highly productive process uses a mixture of recycled steel scrap (25 to 30 percent) and liquid iron (70 to 75 percent) to make high quality, new steels, including tinplate.

Continuous Casting

Once steel is produced, the continuous process transforms molten steel into slabs in one continuous operation. Continuous casting is a highly energy- and cost-efficient process that produces a slab of excellent quality and consistency.

Blackplate

Blackplate is not actually black, but the surface qualities of blackplate steels are the same as cold-rolled steels that have not been coated. Blackplate is easily painted or plated for corrosion protection and appearance and can be easily bonded and welded. Blackplate is most commonly used for items such as toys, serving trays, building materials, household goods, closures and caps.

Electrolytic Tin Coating

The unique properties of tin provide a coating on the steel that protects the contents, while providing the steel with an attractive appearance, corrosion resistance and ease in bonding, welding and painting. Tin is applied to both sides of the blackplate coil through an electrolytic

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process at speeds up to 2,000 feet per minute. The thickness of the tin coating (called coating weight) is dependent upon the end use application. Typical applications for electrolytic tinplate include food and beverage containers, paint trays, battery tops and paint, varnish and aerosol cans.

APPLICATION :

Tinplate is used worldwide in the manufacture of cans for food, beverage and general line (chemical or technical) products.

- o Cans for human food, pet food, beverage
- o Specialty and promotional packaging
- o Paint cans
- o Aerosol cans

- o MORE

Standard

JP	US	TW	
JIS G3303	ASTM 624/626	CNS G3097	

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DIMENSION :

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ITEM	Thickne ss	Width	Length	Weight	Inside Dia.
	mm	mm	mm	MT	mm
SHEETS	0.15 ~ 0.60	700 ~ 970	508 ~ 1050		

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COILS	0.15 ~ 0.60	700 ~ 970		5 ~ 12	406 / 508
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STEEL TYPE :

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	Characteristics
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M R	it contains few residual minor constituents and has a good corrosion resistance so that it is widely used for each application as containers.
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L	it contains particularly few residual minor constituents such as Cu, Ni, Cr, Mo, so that it is suitable for the material of containers required improved corrosion resistance.
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R	it is aluminum killed steel, so that it is suitable for the applications which bear deep drawing or other working that is liable to produce Lude's lines.
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TEMPER DESIGNATION :

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The temper designation gives a guide to the hardness (and stiffness) of products.

For Single Reduced products, the softer tempers are normally produced from Batch Annealed

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(BA) feed, while the harder tempers are offered only from Continuous Annealed (CA) feed.

Continuous Annealed (CA) products normally have more consistent mechanical properties

throughout the length of coil than Batch Annealed (BA), due to the nature of the process

involved.

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Designation	HR-30T Aim	Example of Usage
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Single Reduced	T1BA	49 ± 3	soft for deep drawing
T2BA	53 ± 3	moderate drawing	

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T2.5B A	55 ± 3	pressings and general cans, available on enquiry
T3BA	57 ± 3	general purpose
T4CA	61 ± 3	moderate forming, fair degree of stiffness
T5CA	65 ± 3	increased stiffness to resist bucking

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Double Reduced	DR-8	73 ± 3	small diameter round can bodies and ends
DR-9	76 ± 3	large diameter round can bodies and ends	
DR-9M	77 ± 3	beer and carbonated beverage ends	
DR-10	80 ± 3	beer and carbonated beverage ends	

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Notice :

1. the suffix CA means Continuous Anneal. The CA tinplate has superior features due to the

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greater rigidity, high corrosion resistance and uniformity of mechanical properties and is idea for

speedy can making.

2. DR : base metal produced by the double cold reduction process -- the base metal has

received a second major cold reduction following annealing. Consequently, it offers greater

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rigidity and strength than conventional base metal.

3. Both CA and DR tinplate has the property of mechanical direction. It is necessary to have

the rolling direction of tinplate parallel with the can circle.

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