



# MINERVA WELDING AND FABRICATING, INC.

22133 US 30 • P.O. BOX 369 • MINERVA, OHIO 44657 • PHONE [330] 868-7731 • FAX [330] 868-3377  
AN ISO 9001/2008 CERTIFIED COMPANY

## SQA-6 GRADE A SHEET & STEEL PLATE SUPPLIER QUALITY REQUIREMENTS Rev. B 10/05/2010

### 1.0 APPLICABILITY:

Applies to all suppliers providing sheet & plate steel.

### 2.0 PURPOSE:

To clarify to raw material suppliers the Minerva Welding & Fabricating (MWF) quality and specification requirements.

### 3.0 REQUIREMENTS:

The following requirements must be complied with in order for the material to be considered acceptable for Minerva Welding & Fabricating (MWF) production use.

### 3.2 FLATNESS REQUIREMENTS:

All Grade A Sheet Steel plate material will be subjected to multiple testing upon receipt and must pass the following requirements.

- a) The flatness of the material should not exceed .250" in a 10' length.
- b) When a sample is taken on any five foot section going in any direction on the sheet the material should not exceed .125" from the horizontal plane.
- c) Should a sheet contain low spots or "waves", the sum of the differences from the bottom of the low spots must not exceed .250". For example: 1) If there were two (2) low spots running along the long axis of the 10' sheet, then each spot could not exceed .125". 2) If there were four (4) low spot running along the long axis of the 10' sheet, then each low spot could not exceed .062".

### 4.0 SURFACE FINISH REQUIREMENTS:

- a) All gouges, divots, nicks, marks or any surface defect of any kind must not exceed .020" depth on the flat horizontal surface.
- b) All surfaces of the material must be rust free.
- c) All surfaces of the material must be free of any loose or heavy scale.
- d) All surfaces of the Pickled material must be scale free.

### 5.0 DIMENSIONAL TOLERANCE:

- a) The overall dimensions in the flat horizontal plane (X-Axis and Y-Axis) must be in the range of (+.500 - .000).
- b) The thickness of the material should be within the range of (+ - .010).

### 6.0 MATERIAL TEST REPORTS:

- a) Material test reports must be included with the shipment of material upon delivery to MWF, the test reports shall be actual chemical and physical data in accordance with the applicable material specifications from the heat of material provided. Ranges, minimums or maximums are not acceptable and shall be cause for reject material.

### 7.0 SHIPPING & RECEIVING REQUIREMENTS:

- a) Each bundle of material shall be stacked straight and even. Each bundle shall be banded with heavy banding, on each end, parallel with the short axis of the material.
- b) Weight limitations shall not exceed 7,500 lbs. per bundle.
- c) Each bundle of material shall be stacked on the shipping truck using wood blocks that carry an approximate dimension of 4" X 4" square. The block must run parallel to the short axis of the sheet. There should be one block in the center of the bundle and one block on each end. The blocks on each end should be placed approximately 16" from each end. When stacking bundles on the truck, each bundle must be directly over the top of the block below it.
- d) Bundles that contain fewer sheets than the other bundles, is a light bundle, and as such shall be stacked on the top of the other bundles of steel.



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### 8.0 ON TIME DELIVERY:

- a) Material is required to be delivered as required by MWF and agreed to by the supplier.
- b) Material delivery must be within the MWF receiving hours of 7:00 AM to 2:30 PM daily except weekend and holidays.

### 9.0 OVERALL REQUIREMENTS:

In order for MWF to have a long term financial relationship with it's steel plate suppliers it is important that the criteria as noted below be practiced continually.

- a) Material meets or exceeds all quality requirements.
- b) Pricing of the material must be competitive and complete which includes all add on such as delivery and surcharges etc.
- c) The delivery of material is always maintained as required.

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	APPROVALS		TECHNICAL MANAGER		QUALITY MANAGER		PRODUCTION MANAGER		REVISED BY						
	SIGNATURE:														