

# **The Tolerances on Thickness of Rolled Steels and Thickness after Grinding**

## **Amended Rules and Guidance**

Rules for the Survey and Construction of Steel Ships Part K  
Guidance for the Survey and Construction of Steel Ships Part K

## **Reason for Amendment**

- (1) IACS amended Unified Requirement W13 stipulating the minus tolerances on thickness of hull structural steels and high strength quenched and tempered steels on October 2010. This requirement will be implemented in January 2011. The requirement stipulates that the average thickness of steels is to be not less than nominal thickness and the details of average thickness measurement methods. Accordingly, relevant provisions have been amended based on IACS Unified Requirement W13.
- (2) The requirement of thickness after grinding for hull structural steels is specified in 3.1.9, Part K of the Rules. However, the requirements for high strength quenched and tempered rolled steel plates for structures are not specified in the Rules. Therefore, relevant provisions have been amended based on the requirements for hull structural steels. In addition, regarding the rolled steel plates for boilers, rolled steel plates for pressure vessels, rolled steels for low temperature service and rolled stainless steels, relevant provisions have been amended based on JIS G3193 stipulating the thickness after grinding.

## **Outline of Amendment**

- (1) Requirements for the average thickness for hull structural steels and high strength quenched and tempered rolled steel plates for structures have been added.
- (2) Requirements for the thickness after grinding for rolled steel plates for boilers, rolled steel plates for pressure vessels, rolled steels for low temperature service, rolled stainless steels and high strength quenched and tempered rolled steel plates for structures have been specified.