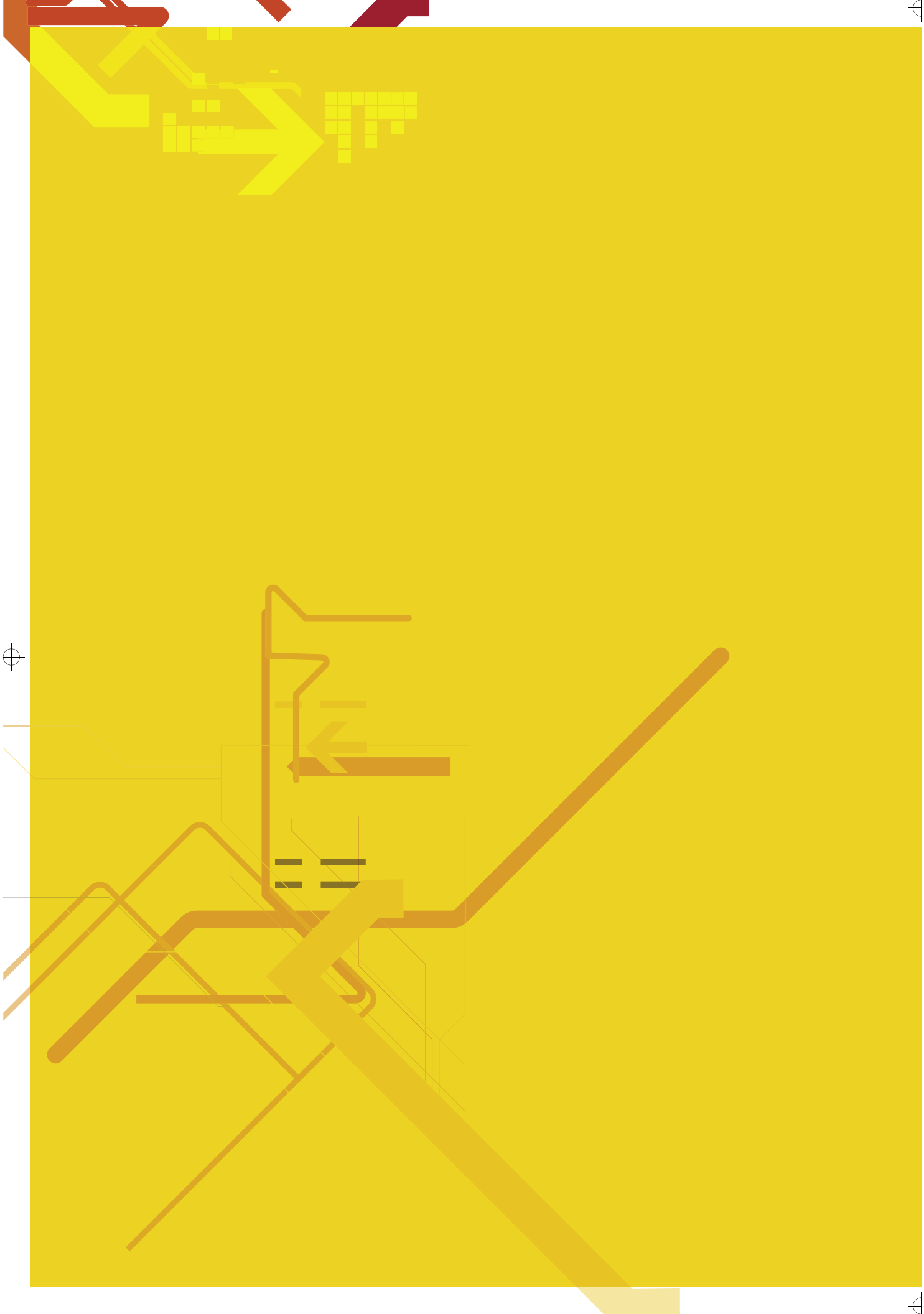




## Precision Strips

Innovation beyond imagination





### **Precision Strips – The cutting edge of technology**

Precision strips are cold rolled strips of stainless steel in width up to 450 mm and thicknesses between 0.05 - 0.60 mm. The specially produced precision strips from Jindal Stainless Limited (JSL) are in Bright Annealed (BA) or Temper Rolled and tension levelled form and are designed to meet the specific requirement for your application. These strips are often the starting material for industries like Automotive, Electronics and Telecommunication, Health & Hygiene, Consumer Durables and Petrochemical Industry.



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# JSL

Jindal Stainless Limited, JSL is India's largest integrated producer of stainless steel in 300, 200, 400 and Duplex grades.

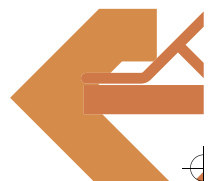


A leader and a name synonymous with enterprise, excellence and success, the company ethos mirrors characteristics of the metal it produces; JSL is innovative and versatile in its thought; strong and unrelenting in its operations; 'Think Green' in its manufacturing process; brilliant, appealing and beautiful in its community support activities.

Established in 1970, JSL is the largest Stainless Steel conglomerate in India and a part of the OP Jindal Group. An OHSAS 18001, ISO 9001, ISO 14001, ISO 18001, AD W0, PED certified company, JSL is the leading producer of Stainless Steel flat products in Austenitic, Ferritic, Martensitic and Duplex grades and global leader in Chrome Manganese (Cr-Mn) 200 Series Stainless Steel grades.

The company has strong export market and has presence in over 50 countries including US, Europe, China, Middle-East and South Asian countries.

JSL, while leading the Indian Stainless steel industry is also among the top 15 Stainless Steel producers worldwide.






# Harness the power of a leader

Jindal Stainless Limited are international in all respects. Behind our products and services lie the massive resources of one of the great metal producers. A clear focus on customer needs, coupled with cross market expertise, a wide product range and up-to-the-minute technology ensures that innovative solutions are provided.



# Precision Strips – An Innovation

Precision strips are cold rolled strip of stainless steel in width up to 450 mm and thicknesses between 0.05-0.60 mm.



Our specially produced precision strip is the starting material for Automotive, Electronics and Telecommunication, Consumer Durables and Petrochemical Industry.

The customised chemical composition, extra-ordinary mechanical properties and precise dimensional and shape tolerance makes JSL Precision Strips special. Apart from having world class equipment to produce such products, these high end products are backed up by strong R&D support coupled with a customer focussed approach.

If you need to know more, the JSL team is just one call away. Your company can benefit from our commitment to providing a level of support that helps you create a commercial advantage in your market place. If like most of our customers, you allow us to work closely with you, we can develop an understanding of your material requirements and, where appropriate, your business and markets you operate in. Every support and operational member involved in servicing your account, from the melting shops to the local sales company, will be aware of your specific product needs and operational parameters. The total involvement ensures that the product and support you receive not only meet your material requirements but also contributes fully to your business objectives.



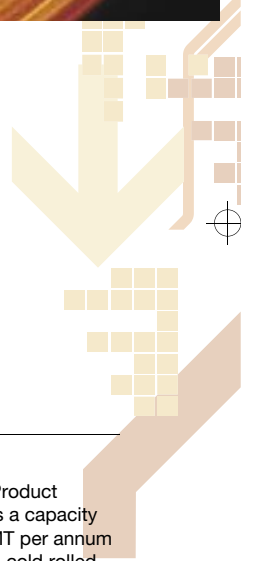
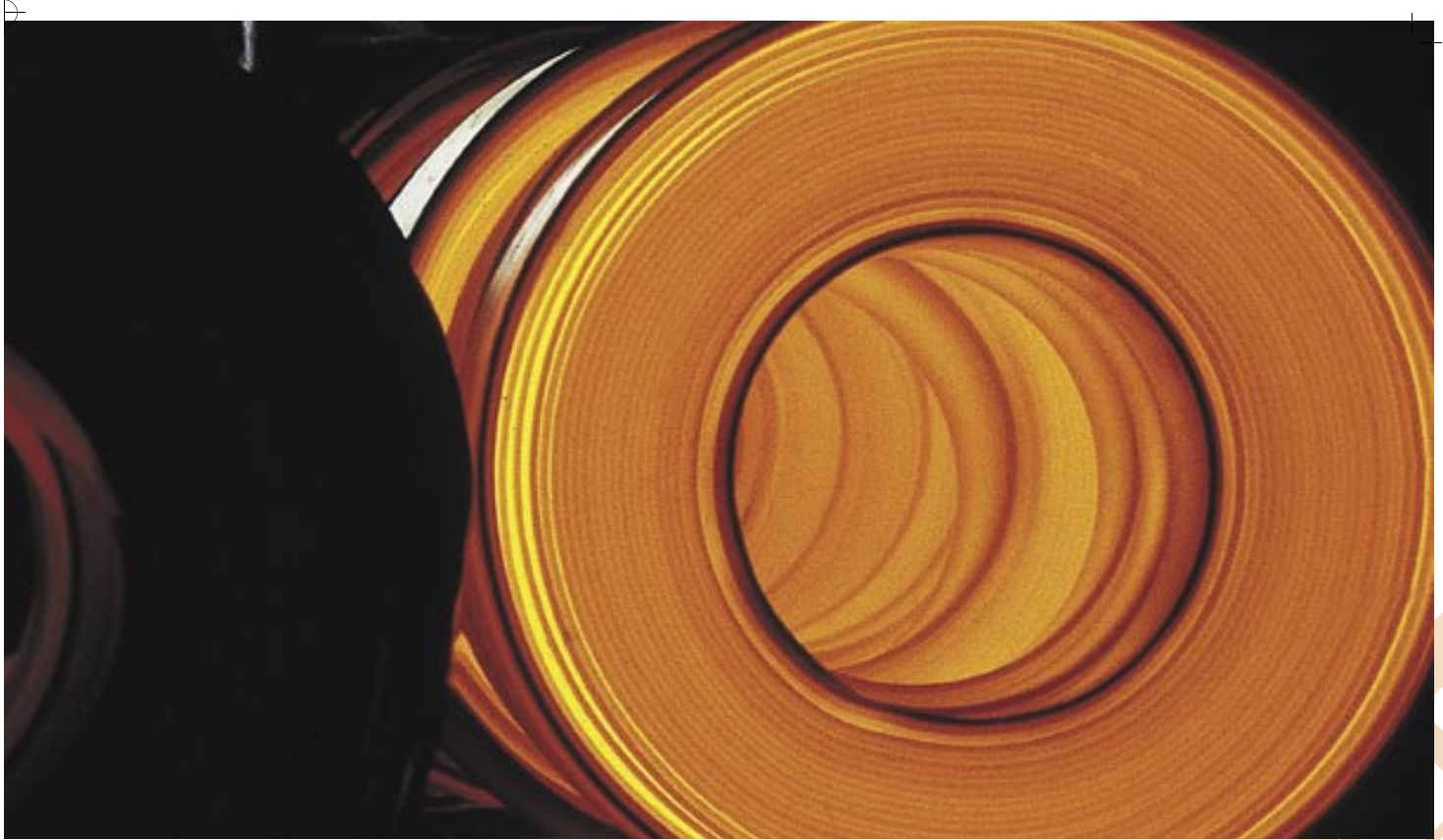
# The Production Process for Precision Strips

The strength of JSL lies in having a fully integrated operation at Hisar.

The production of precision strips begins with state-of-art Melt and Casting Shops where melting of ferrous scrap and ferro-alloys happens in the UHP Electric Arc Furnace, followed by secondary refining in AOD/VOD units. The liquid steel thus obtained is cast into slabs. The cast slab is subjected to stringent quality checks and then hot rolled in the Hot Steckel Mill comprising Walking Beam Furnace, Reverse Roughing and a twin Strand Steckel Mill.

The hot rolled coils are transferred to cold rolling complex where they are continuously annealed / bell annealed, shot blasted and pickled and cold rolled to desired thickness. The Speciality Product Division converts stainless steel to Precision Strips as a specialised product as per the customer's requirement. This division at Hisar has a capacity to produce 30,000 MT of highly specialised grades of cold rolled precision strips, which includes austenitic, ferritic and martensitic stainless steel along with razor blade steel.

The Speciality Product Division complex comprises processing equipment, primarily for annealing, rolling and finishing. There is an option of using either a Bell annealing or a Bright annealing or even Pull-through annealing depending on the grade and finish of stainless steel being produced. 4-Hi mills and 20-Hi mills are used for reduction rolling to thinner gauges with close thickness tolerances. To impart various finishes in the final product complex has Strip Grinding Line, Skin Pass Mill and Tension Leveller. Such product then passes through the Precision slitters which give it precise dimensions.



#### STEEL MAKING

The state of art Melt & Casting shops have an installed capacity of 720,000 metric tons per annum. These facilities comprise of:

- Ultra high power – Electric Arc Furnace – 2 nos. x 45 MT
- AOD (Argon Oxygen Decarburisation) Converters – 2 nos. x 50 MT
- VOD (Vacuum Oxygen Decarburisation) Converters – 1 no – 50 MT
- Continuous slab caster – 2 nos. – Size > 160/200 mm x 1270 mm (max.)
- Bloom caster – 1 no – Size > 200 x 200 mm



#### HOT ROLLING

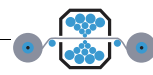
Hot rolling comprises of Hot Steckel Mill and Tandem Strip Mill with a total capacity of 720,000 MT per annum. Hot Steckel Mill consists of Walking beam slab reheating furnace. The Tandem Strip Mill comprises of reheating furnace, roughing stand five finishing strand and two down coilers.



#### COLD ROLLING

Cold rolling division having a capacity of 275,000 metric tons per annum of Stainless Steel flat products.

The complex is equipped with 20-Hi Sendzimer Mill, continuous annealing and pickling lines, two of them having electrolytic pickling facility. In addition it also has one bright annealing line and five slitters. This cold rolling division provides raw material for the production of precision strips in Speciality Product Division



#### COLD ROLLING - PRECISION STRIPS

Speciality Product Division has a capacity of 30,000 MT per annum of precision cold rolled strips. The facilities with modern equipment comprise:

- 20Hi/4Hi mills
- Bright Annealing lines from Ebner
- Skin Pass Mill
- Tension Leveller from Redex
- Precision Slitting lines from Nobag
- Strip Grinding
- Bell Annealing furnaces from Ebner



**ANDRITZ  
SUNDWIG**

**Z #4 ROLLING MILL**

**MILL HOUSING**



# Speciality Product Division

The Speciality Product Division has a capacity to roll precision strips to a thickness of 0.05mm in a maximum width of 450mm. In addition, the Razor Blade cold rolled blade strips of upto 0.07 mm thickness are also produced.



The Speciality Product Division at Hisar has a capacity to produce 30,000 MT of highly specialised grades of Cold Rolled Precision Strips which include Austenitic, Ferritic and Martensitic stainless steel along with Razor Blade steel that cater the special requirements for high-end applications.

This division focuses on the production of customised products through specialised equipment consisting of various highly automated rolling mills with electronic thickness and automatic gauge control to produce strips in close thickness tolerances both in 20-Hi and 4-Hi format.

The vertical Bright Annealing (BA) line features a muffle furnace. A specially developed seal system and variable flow in jet cooler helps achieve the desired mechanical properties along with a flat strip and bright surface. The unit also has an online degreasing unit to ensure good surface cleanliness.

On the tension levelling unit, variable load is applied along the width of the strip beyond the yield point to ensure even flatness. An online flatness measurement helps produce strips with a flatness of the level of low "I" units.

The final slitting comprises precision slitters which can slit strips in precise widths. To aid the entire production facility, the division also has bell annealing furnaces, Strip Grinding Line and a Skin Pass Mill.



# Chemical Composition

	Jindal Designation / Grade	UNS (Unified Numbering System)	USA - Canada / AISI - ASTM - ASME	%C (Max)	%Mn (Max)	%P (Max)	%S (Max)	%Si (Max)	%Cr	%Ni	%Mo	%N (Max.)	%Others
AUSTENITIC C-Mn*	J201#	S20100	201	0.15	5.5 - 7.5	0.06	0.03	1.00	16.0 - 18.0	3.5 - 5.5		0.25	
	J204 Cu†	S20430		0.10	6.5 - 9.0	0.06	0.01	0.75	16 - 17.5	1.5 - 3.5		0.10 - 0.20	Cu = 2.0 - 4.0
	JSLAUS (J1)			0.08	6.0 - 8.0	0.07	0.01	0.75	16.0 - 18.0	4.0 - 6.0		0.10	Cu = 1.50 - 2.0
	J4			0.10	8.50 - 10.0	0.08	0.01	0.75	15.0 - 16.0	1.0 - 2.0		0.20	Cu = 1.50 - 2.0
AUSTENITIC C-Mn	J-301	S30100	301	0.15	2.00	0.045	0.030	1.00	16.00 - 18.00	6.00 - 8.00		0.10	
	J-304	S30400	304	0.07	2.00	0.045	0.030	0.75	17.5 - 19.5	8.00 - 10.50		0.10	
	J-304L	S30403	304L	0.030	2.00	0.045	0.030	0.75	17.5 - 19.5	8.00 - 12.00		0.10	
	J-309S	S30908	309S	0.08	2.00	0.045	0.030	0.75	22.00 - 24.00	12.00 - 15.00			
	J-310S	S31008	310S	0.08	2.00	0.045	0.030	1.50	24.00 - 26.00	19.00 - 22.00			
	J-316L	S31603	316L	0.030	2.00	0.045	0.030	0.75	16.00 - 18.00	10.00 - 14.00	2.00 - 3.00	0.10	
	J-316Ti	S31635	316Ti	0.08	2.00	0.045	0.030	0.75	16.00 - 18.00	10.00 - 14.00	2.00 - 3.00	0.10	Ti=5X(C+N) Min., 0.70 Max.
	J-317L	S31703	317L	0.030	2.00	0.045	0.030	0.75	18.00 - 20.00	11.00 - 15.00	3.00 - 4.00	0.1 - 0.22	
	J-321	S32100	321	0.08	2.00	0.045	0.030	0.75	17.00 - 19.00	9.00 - 12.00		0.10	Ti=5X(C+N) Min., 0.70 Max.
	J-347	S34700	347	0.08	2.00	0.045	0.030	0.75	17.00 - 19.00	9.00 - 13.00			Cb=10xC Min., 1.00 Max.
	J-420	S42000	420	0.15 min	1.00	0.040	0.030	1.00	12.00 - 14.00	0.75 max			
	J-405	S40500	405	0.08	1.00	0.040	0.030	1.00	11.50 - 14.50	0.60 max			Al = 0.10 - 0.30
FERRITIC & MARTENSITIC	J-409	S40900	409	0.030	1.00	0.040	0.020	1.00	10.50 - 11.70	0.50 max		0.030	Ti = 6X (C+N) Min., 0.5 Max.
	J-410S	S41008	410S	0.08	1.00	0.040	0.030	1.00	11.50 - 13.50	0.60 max			
	J-430	S43000	430	0.12	1.00	0.040	0.030	1.00	16.00 - 18.00	0.75 max			
	J-430Ti		430	0.030	1.00	0.040	0.030	1.00	16.00 - 19.00				Ti = 0.10 - 1.00

\*These grades can be supplied with S 0.005% max also.

# This grade will be supplied with 0.08%C max for improved corrosion resistance.

† The grade can be supplied in two versions of 0.08%C max or 0.1%C max.

\* Other grades as per International Standard can also be supplied as per mutually terms.





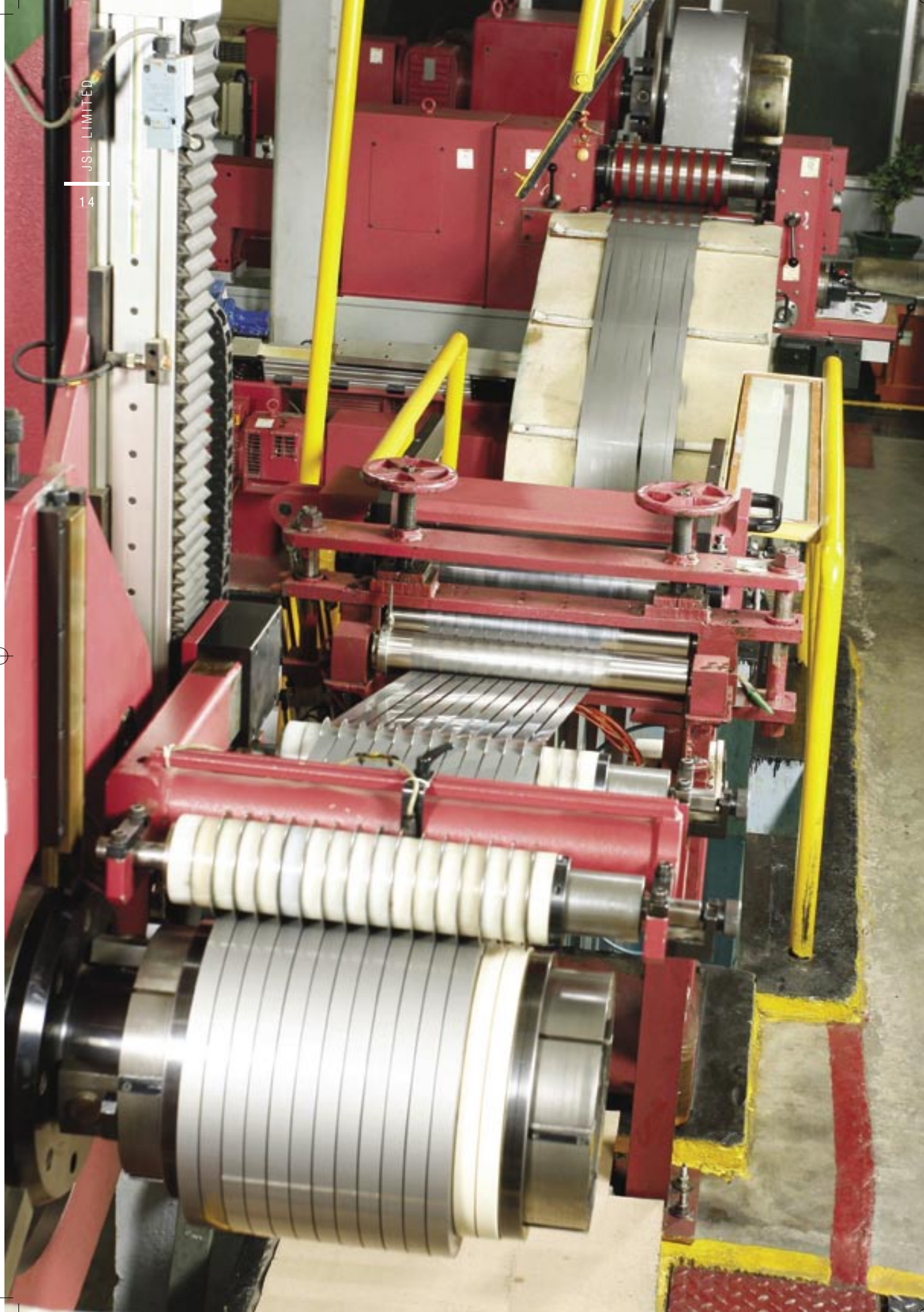
# Mechanical Properties

		MECHANICAL PROPERTIES				VARIOUS EQUIVALENT INTERNATIONAL STANDARDS					
Jindal Designation/Grade		Tensile Strength Mpa(min)	Yield strength Mpa(mm)	%Elongation (min)	Hardness Rockwell B (max)	INDIA/IS Letter Symbol	INDIA/IS Numerical Symbol (IS)	UNS Designation	GERMANY/DIN Designation	Japan/JIS	USSR/GOST
AUSTENITE C-Mn	J201	655	310	40	100	X10Cr17Mn6Ni4N20		S35350	X12Cr17MnNiN17-7-5	SUS201	
	J204Cu	620	310	40	98						
	JSLAUS(J1)	550	205	40	92						
	J4	650	325	40	98						
AUSTENITE C-Ni	J-301	515	205	40	95	X10Cr17Ni7	301		X12CrNi177	SUS301	
	J-304	515	205	40	92	X04Cr19Ni9	304Si		X5CrNi1810	SUS304	
	J-304L	485	170	40	92			S30403		SUS304L	03Ch18N11
	J-309S	515	205	40	95			S30908	X7CrNi23	SUS309S	
	J-310S	515	205	40	95			S31008	X12CrNi2621	SUS310S	20Ch23N18
	J-316L	485	170	40	95	X02Cr17Ni12Mo2	316L		X2CrNiMo17132	SUS316L	
	J-316LN	515	205	40	95				X2CrNiMoN17133	SUS316LN	
	J-316Ti	515	205	40	95	X04Cr17Ni12Mo2Ti	S31635		X0CrNiMoTi17122		10Ch17N13M2T
	J-317L	515	205	40	95		S31703		X20CrNiMo18154	SUS317L	
	J-321	515	205	40	95	X04Cr18Ni10Ti	321		X6CrNiTi1810	SUS321	08Ch18N10T
	J-347	515	205	40	92	X04Cr18Ni10Nb	347		X6CrNiNb1810	SUS347	08Ch18N12B
FERRITE & MARTENSITIC	J-420	690	15	96		X20Cr13	420 S1		X20Cr13	SUS420	
	J-405	415	170	20	88	X04Cr12	405		X6CrA13	SUS405	
	J-409	380	170	20	88				X2CrTi12		
	J-410S	415	205	22	89			S41008			
	J-430	450	205	22	89	X07Cr17	430		X6Cr17	SUS430	
	J-430Ti	360	175	22	90				X3CrTi17	SUS430L X	

## Mechanical properties in tempered condition

ASTM A666	Condition	Tensile Strength		Yield Strength		Elongation
		Ksi (min)	Mpa (min)	Ksi (min)	Mpa (min)	%
301	1/16 Hard	90	620	45	310	40
	1/8 Hard	100	690	55	380	40
	1/4 Hard	125	860	75	515	25
	1/2 Hard	150	1035	110	760	15
	3/4 Hard	175	1205	135	930	10
	Full Hard	185	1275	140	965	8
304	1/16 Hard	80	550	45	310	35
	1/8 Hard	100	690	55	380	35
	1/4 Hard	125	860	75	515	10
	1/2 Hard	150	1035	110	760	6

\* Other grades can also be supplied as per ASTM A666.



# Dimension & Tolerances



Dimension	
Width	435 mm (max)
Thickness	0.05mm to 1.0 mm

\* In BA finish the maximum thickness will be 1.0 mm

Delivery Forms	
Coils with inside diameter	16" (406 mm) 20" (508 mm)

Finishes	
2B	Cold Rolled, Annealed, Pickled and Skin-Passed
BA	Cold Rolled, Bright Annealed, Skin-Passed
2H	Cold Rolled, Tension Levelled

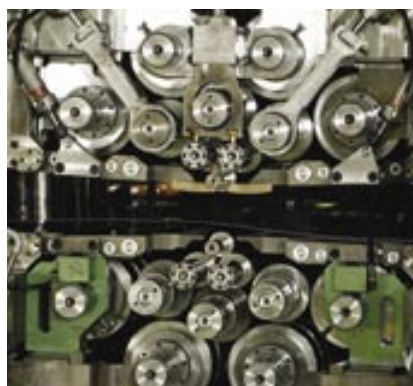
Edges	
Slit edges No.3	
Slitting leaves a straight edge without excessive burr	
ASTM	Edge no 3
Burr height	Normal = <10% of thickness
	Tight = <7% of thickness
	Precision = <5% of thickness

Thickness Tolerance		
Thickness		Thickness Tolerance
min(mm)	max (mm) incl.	(+/-mm)
0.05	0.15	0.008
0.15	0.20	0.012
0.20	0.25	0.014
0.25	0.30	0.015
0.30	0.40	0.018
0.40	0.50	0.020
0.50	0.60	0.023
0.60	0.70	0.025
0.70	0.80	0.027
0.80	1.00	0.030

Closer tolerances can be mutually agreed for specific applications

Width Tolerance		
Thickness		Width Tolerance
min(mm)	max (mm) incl.	(+/-mm)
0.05	0.50	0.127
0.50	0.60	0.152
0.60	0.80	0.175
0.80	1.00	0.254

Closer tolerances can be mutually agreed for specific applications





# Shape Tolerances

<b>Edge Camber</b> (in mm, on length of 1m)				
Condition	Width range (in mm)			
	$20 \leq w \leq 50$	$50 \leq w \leq 200$	$200 \leq w \leq 400$	$400 \leq w \leq 700$
Annealed (2B+BA)	2.5	2.0	1.5	1.3
Temper rolled (2H)	2.0	1.5	1.3	1.0

<b>Flatness</b> (in mm/%)		
	Coil set (on 300mm length) (in mm)	Wave in coil (H/L in %)
Annealed (2B+BA)	$\leq 20$	$\leq 4$
Temper rolled (2H)	$\leq 5$	$\leq 2$

<b>Cross bow (in mm)</b>					
	max. width 50mm	max. width 100mm	max. width 200mm	max. width 400mm	max. width 600mm
Annealed (2B+BA)	0.30	0.40	3.00	4.00	6.00
Temper rolled (2H)	0.10	0.20	0.50	1.00	2.00

Closer tolerances can be mutually agreed for specific applications

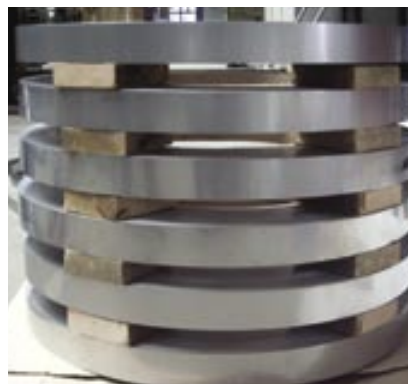


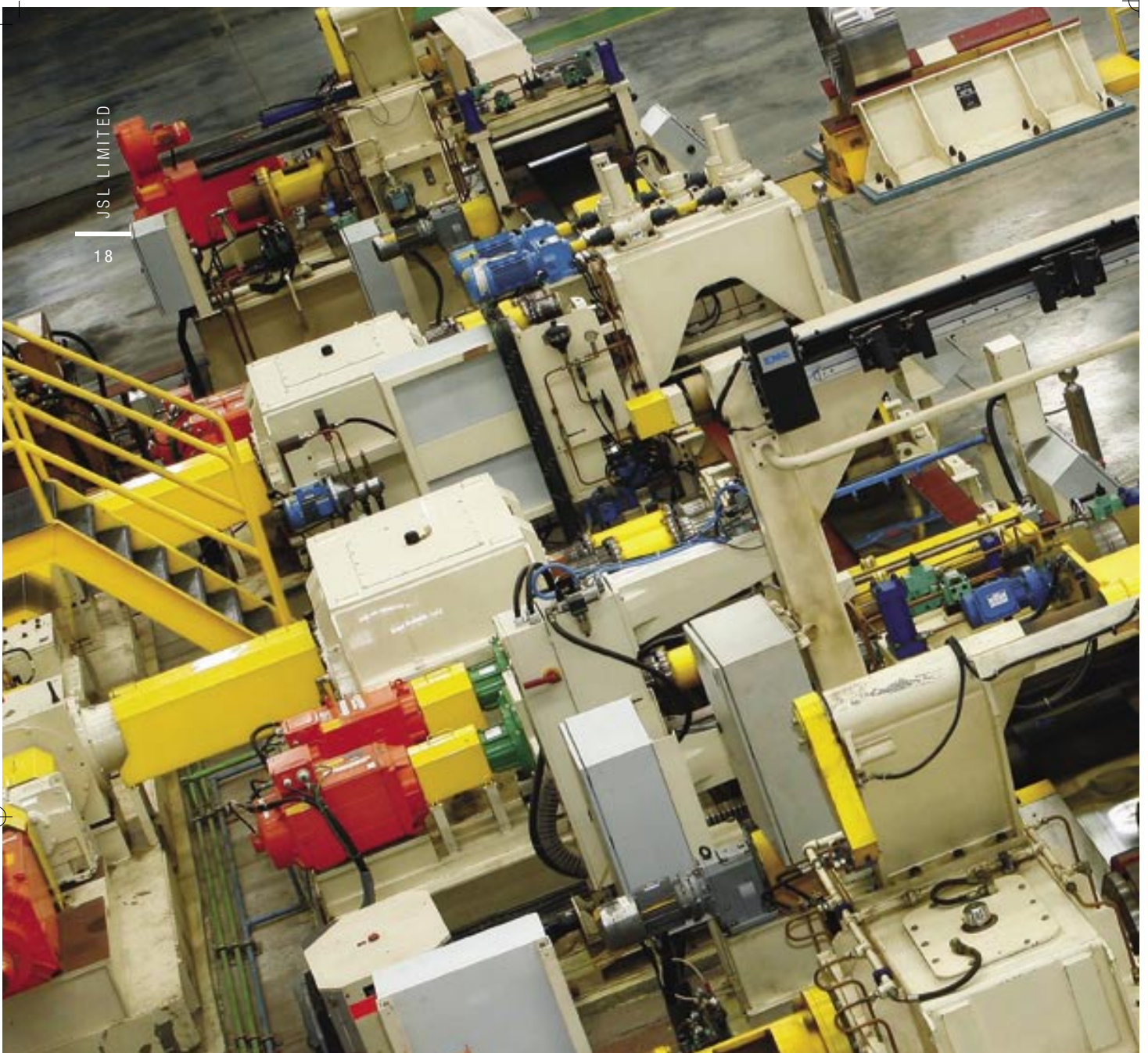
## Packaging

At JSL, we have adopted a packaging standard that ensures a 'safe & sound' arrival of our products at your workplace. The packaging standard has won approvals from many of our customers. However our flexible packaging process allows incorporation of customers' new and specific requirement, if any.

Packaging features, in brief:

- Cardboard core in the inside diameter.
- Stacked with vertical eye on wooden pallet.
- Use of wooden spacers to prevent coil edge from damage.
- Stretch film/HDPE used as seaworthy protection.





## JSL has the expertise

You get our expertise, capability and coverage to bring you the right solutions whenever and wherever you need them.

This is the strength needed for today's challenges: world class plants and skills backed by JSL's research and development which is dedicated to Stainless Steel.

It all adds up to a powerful partnership for total success.



# Quality Assurance

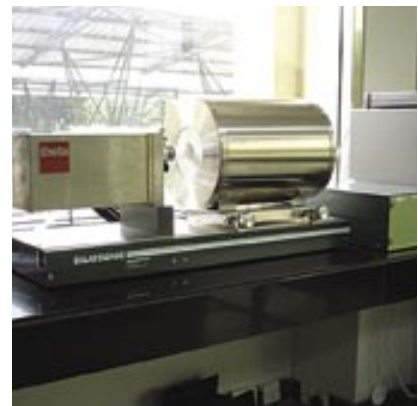
You get the backing of the JSL team. It is here that by sharing resources, expertise, skills, research findings and experience between our specialist divisions we can bring you the best possible solutions for your requirement.

The market approach adopted as a keystone in JSL culture ensures that innovation is customer focused.

Take advantage of all the benefits associated with large scale production yet flexible enough to meet the needs of all users of stainless steel.

Through our fast, flexible, reliable and responsive systems, our aim is to ensure your total satisfaction.

JSL are international in all respects. Behind our products and services lie the massive resources of one of the great metal producers. A clear focus on customer needs, coupled with cross market expertise, a wide product range and up to the minute technology ensures that innovative solutions are provided.







# Research and Development

Continuous up-gradation of quality, processes, services and through product innovation to develop new products at competitive costs has been a cornerstone of our philosophy.

The R&D division plays a pivotal role in retaining and consolidating company's leadership position in the Stainless Steel industry. This is achieved through Cross-fertilisation of knowledge between production, quality control and commercial units in order to maintain global standards has been the guiding principle of the R&D function.

- Development of high value products to serve niche markets
- Quality up-gradation of existing products to enable enhanced global acceptance
- Cost reduction by process development, optimization and refinement to provide a consistent competitive edge
- Technology enhancement to increase quality production
- Foster growth and develop new market segments through knowledge sharing with customers and to assist them in their operations and applications of our products

In addition to the above, the R&D division closely interacts with reputed national and international laboratories/scientific institutions/Universities to avail expert services and knowledge for critical investigations.



**Certifications** JSL is a BS OHSAS 18001:2007, DIN EN ISO 9001: 2008, ISO 14001:2004 and ADW (German Standards) and PED/97/23/ED certified company.



The plant has a well equipped laboratories with modern equipment such as Scanning Electron Microscope, Optical Emission Spectrometers, X-Ray Fluorescence Analyzer, Leco-Analyzers, Corrosion Testing facilities, UT testing facility, Image Analyzer, Surface energy measurement device and many more like hardness testers and Tensile testing machines.

The R&D division plays a pivotal role in retaining and consolidating Jindal's leadership position in the stainless steel.

# Applications



## AUTOMOBILE



*Engine Gasket*

### ENGINE GASKET

Gaskets under severe temperature, pressure and vibration conditions. The stainless steel displaying good flatness, closer thickness tolerance and high fatigue strength can be used.



*Welded Tube*

### WELDED TUBES

Corrugated hoses and seam-welded tubes of stainless steel. The steel used should have good corrosion resistance and for some application should have good high temperature corrosion resistance.



*Lamp Caps*

### DEEP DRAWN PARTS

Like Lamp cap, rings, caps and connectors. The starting materials need to be of close dimensional tolerance, special microstructures and yield strength to provide ideal material for such deep drawing application.



*Oxygen Sensors*

### SPRING STEEL PARTS

Stainless spring steel strip used are used in hose clamps. In addition to high strength, spring steels are also need to exhibit stiffness in some applications. Other components may require an optimum combination of high strength and good formability.

### INSULATING PANELS

Stainless steel with good corrosion resistance and formability is utilised to separate out the high temperature region from the low temperature region using such insulating panels.



## CONSTRUCTION



*Chimney Lining*

### CHIMNEY LINING

Fastened flexible tubes for the discharge of combustion gases from chimney. The stainless steel used should display very tight thickness tolerance and good corrosion resistance depending on the environment condition.



*Window spacers*

### WINDOW SPACERS

Due to stainless steel's low thermal conductivity compared with aluminium, stainless steel is also being used as spacers in double glazing.



Connecting Springs

**CONNECTING SPRINGS**

The stainless steel being used should have high level of homogeneity in mechanical properties, tight thickness tolerance and very good flatness for this application.



Keypad parts

**MOBILE PARTS**

Key pad, sealing, sim jacket and magnetic protection gasket of mobile phones. Stainless steel displaying homogeneity and isotropy in mechanical properties and fatigue strength and with good flatness can be used for such application.

**ELECTRONIC GUN PARTS**

Drawn and stamped components of stainless steel can be used for guiding devices of electron beam.



Electronic Gun parts

**SAFETY SHOES SOLES**

High stiffness and resistance to penetration e.g. by nails are key requirements for steel insoles in safety shoes. High dimensional stability, excellent flatness and high durability are also important. AISI 301 has been widely used in such application.



Safety Shoes Soles

**RAZOR PARTS**

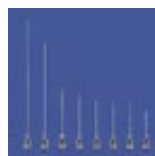
Head, sleeve of razor parts are being manufacture out of stainless steel displaying good flatness, suitable mechanical properties and special surface finishes.



Razor Parts

**HYPODERMIC NEEDLES**

Stainless steel having the characteristics of good hygiene is being used as syringe needles, lancets, suture needles, scalpels.



Hypodermic needles



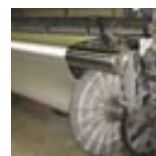
Watch and switch components

**SPIRALLY WOUND GASKET**

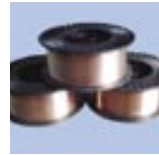
These gaskets are under radial pressure. They can be made from 0.10-0.3 mm thickness from various 304 with different nickel content depending on the toughness.

**WEAVING MACHINES**

As textile guiding elements stamped out of stainless steel displaying good flatness and having good wear resistance.



Weaving Machines



Welding strips electrodes

**WELDING STRIPS ELECTRODES**

Flux cored welding wire can be made from stainless steel with low residual analysis.



Distillation columns

**DISTILLATION COLUMNS**

The petrochemical industry requires a corrosion resistant and a formable packing material in the fractional distillation column to allow crude oil to flow through it and break into different forms of products. Here stainless steel finds its application.



# Jindal Stainless Limited

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