

Ex-mill Hot Rolled Finishes		
Abbreviation	Finishing Process Route	Notes
1C	Hot rolled, heat treated, not descaled	Surface covered with mill scale. Finished parts may be suitable for heat (oxidation) resisting applications as supplied, but should be descaled to optimise corrosion resistance
1E	Hot rolled, heat treated, mechanically descaled	Free of mill scale by shot blasting or grinding. This finish can also limit the crevice corrosion resistance
1D	Hot rolled, heat treated, pickled	Most common 'hot rolled' finish available. Most corrosion resistant hot rolled finish specified
1U	Hot rolled, not heat treated, not descaled	Surface is left covered with rolling (mill) scale. Surface suitable for products intended for further working eg strip for re-rolling.
Ex-mill Cold Rolled Finishes		
Abbreviation	Finishing Process Route	Notes
2B	Cold rolled, heat treated, pickled, skin passed	Most common 'cold rolled' finish available. Non-reflective, smooth finish, good flatness control. Thickness range limited by manufactures' skin passing rolling capacity.
2C	Cold rolled, heat treated, not descaled	Smooth with scale from heat treatment, suitable for parts to be machined or descaled in subsequent production or where the parts are for heat resisting applications.
2D	Cold rolled, heat treated, pickled	Thicker sheet size ranges. Smoothness not as good as 2B, but adequate for most purposes.
2E	Cold rolled, heat treated, mechanically descaled	Rough and dull. Usually applied to steels with a scale which is very resistant to pickling solutions
2H	Cold rolled, work hardened	"Temper" rolling on austenitic types improves mechanical strength. Smoothness similar to 2B
2R	Cold rolled, bright annealed	Highly reflective "mirror" finish, very smooth. Often supplied with plastic coatings for pressings. Manufactured items usually put into service without further finishing
2Q	Cold rolled, hardened and tempered, scale free	Only available on martensitic types (eg 420). Scaling avoided by protective atmosphere heat treatment or descaling after heat treatment
Special Finishes		
Abbreviation	Finishing Process Route	Notes
1G or 2G	Ground	Can be based on either '1' or '2' ex-mill finishes. A unidirectional texture, not very reflective
1J or 2J	Brushed or dull polished	Can be based on either '1' or '2' ex-mill finishes Smoother than "G" with a unidirectional texture, not very reflective
1K or 2K	Satin polished	Can be based on either '1' or '2' ex-mill finishes Smoothest of the special non-reflective finishes with corrosion resistance suitable for most external applications.
1P or 2P	Bright polished	Can be based on either '1' or '2' ex-mill finishes Mechanically polished reflective finish. Can be a mirror finish.
2F	Cold rolled, heat treated, skin passed on roughened rolls	Uniform non-reflective matt surface, can be based on either 2B or 2R mill finishes
1M or 2M	Patterned	Can be based on either '1' or '2' ex-mill finishes. One side patterned only. Includes "chequer" plates ("1" ex-mill finish) & fine textures finishes ("2" ex-mill finish)
2W	Corrugated	Profile rolled (eg trapezoidal or sinusoidal shapes)
2L	Coloured	Applied to flat (2R, 2P or 2K type fishes) or patterned (2M) sheet base finishes in a range of colours
1S or 2S	Surface coated	Can be based on either '1' or '2' ex-mill finishes . Normally coated on one side only with a metallic coating, such as tin, aluminium or titanium

Informations without engagement