

STANDARD FINISHES OF STAINLESS STEEL FLAT-ROLLED PRODUCTS

Surface finishes on stainless steel sheets, strip and plates are generally selected for appearance, although degree and extent of forming and welding should be taken into consideration. Where forming is severe, or much welding is done, it is often more economical to use a cold-rolled finish, and then polish.

UNPOLISHED FINISHES

No. 1 Finish. Hot rolled, annealed and descaled. Produced by hot rolling, followed by annealing and descaling.

Generally used in industrial applications, such as for heat or corrosion resistance, where smoothness of finish is not of particular importance.

No. 2D Finish. A dull, cold-rolled finish produced by cold-rolling, annealing and descaling. The dull finish may result from the descaling or pickling operation, or may be developed by a final light cold roll pass on dull rolls. The dull finish is favorable for the retention of lubricants on the surface in deep-drawing operations.

The finish is generally used in forming deep-drawn articles, which may be polished after fabrication.

No. 2B Finish. A bright, cold-rolled finish commonly produced in the same manner as No. 2D, except that the annealed and descaled sheet receives a final light cold-rolled pass on polished rolls.

This is a general purpose cold-rolled finish. It is commonly used for all but exceptionally difficult deep-drawing applications.

This finish is more readily polished than No. 1 or No. 2D Finish.

Bright Annealed. Sometimes referred to as BA or 2BA, this finish has a mirror-like appearance produced by cold rolling and then annealing in an atmospherically controlled furnace.