

## Requirements for Returning Coils to ArcelorMittal Dofasco

Requirements for returning coils to ArcelorMittal Dofasco (AMD)

1. Coils must be properly identified.
  - a. Label coil with AMD claim number
  - b. Attach BOL
  - c. Attach a completed “*Authorization to Return*” form
  
2. Coils must be packaged for safe handling as outlined in the AMD packaging return policy. (see attachment)<sup>1</sup> This includes but is not limited to the following guidelines:
  - a. If product packaging has not been removed, the lift must be returned with original AMD packaging.
  - b. If product packaging has been removed, or has been compromised, the minimum steel strapping requirements must be implemented. Refer to pages 2 & 3 of this document.
  - c. Coil stability rules apply for individual or multi-slit coils (see attachment)<sup>2</sup>
  
3. While awaiting pickup for return to AMD, coils must be stored in a manner to prevent damage or deterioration and maintain general insurance.

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*1 -AMD Packaging Returns Policy*

<https://ec.dofasco.ca/ECommerce/Includes/AMD Packaging Returns Policy.pdf>

*2 - Authorization to return product & additional packaging rules*

<https://ec.dofasco.ca/ECommerce/Includes/Authorization to return product and additional packaging rules.docx>

Minimum strapping requirements for HSLA steel

ALL STRAPS - MINIMUM 1¼ in x .029 in				GAUGE (mm)																	
# OD STRAPS				GAUGE (inches)																	
				< .750	0.75-1.76	1.77-2.26	2.27-2.76	2.77-3.27	3.28-3.78	3.79-4.29	4.30-4.80	4.81-5.31	5.32-5.82	5.83-6.33	6.34-6.84	6.85-7.34	> 7.35				
Width (mm)				Width (in)				< .030	.030-.069	.070-.089	.090-.109	.110-.129	.130-.149	.150-.169	.170-.189	.190-.209	.210-.229	.230-.249	.250-.269	.270-.289	> .290
								<152	< 5.99												
152-254	6-9.99																				
254-381	10-14.99																				
381-508	15-19.99																				
508-635	20-24.99																				
635-762	25-29.99																				
762-889	30-34.99																				
889-1016	35-39.99																				
1016-1270	40-49.99																				
>1270	>50																				

  

ALL STRAPS - MINIMUM 1¼ in x .029 in				GAUGE (mm)																	
# ID STRAPS				GAUGE (inches)																	
				< .76	0.76-1.76	1.77-2.26	2.27-2.76	2.77-3.27	3.28-3.78	3.79-4.29	4.30-4.80	4.81-5.31	5.32-5.82	5.83-6.33	6.34-6.84	6.85-7.34	> 7.35				
Width (mm)				Width (in)				< .030	.030-.069	.070-.089	.090-.109	.110-.129	.130-.149	.150-.169	.170-.189	.190-.209	.210-.229	.230-.249	.250-.269	.270-.289	> .290
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635-762	25-29.99																				
762-889	30-34.99																				
889-1016	35-39.99																				
1016-1270	40-49.99																				
> 1270	> 50																				

\*The above banding requirements are based on ArcelorMittal Dofasco's capabilities as of 2016\*

\*Excludes Uncompressed Coils (Uncompressed coils have never been unwound/rewound after hot rolling)\*

Minimum strapping requirements for AHSS coils

ALL STRAPS - MINIMUM 1¼ in x .029 in																
# OD STRAPS		GAUGE (mm)														
		< .750	0.75-1.76	1.77-2.26	2.27-2.76	2.77-3.27	3.28-3.78	3.79-4.29	4.30-4.80	4.81-5.31	5.32-5.82	5.83-6.33	6.34-6.84	6.85-7.34	> 7.35	
		GAUGE (inches)														
		< .030	.030-.069	.070-.089	.090-.109	.110-.129	.130-.149	.150-.169	.170-.189	.190-.209	.210-.229	.230-.249	.250-.269	.270-.289	> .290	
Width (mm)	<152	Width (in)	< 5.99	1	1	1	1	1	1	1	1	1	1	1	1	
	152-254		6-9.99													
	254-381		10-14.99													
	381-508		15-19.99													
	508-635		20-24.99													
	635-762		25-29.99													
	762-889		30-34.99													
	889-1016		35-39.99													
	1016-1270		40-49.99													
	>1270		>50													

  

ALL STRAPS - MINIMUM 1¼ in x .029 in																
# ID STRAPS		GAUGE (mm)														
		< .76	0.76-1.76	1.77-2.26	2.27-2.76	2.77-3.27	3.28-3.78	3.79-4.29	4.30-4.80	4.81-5.31	5.32-5.82	5.83-6.33	6.34-6.84	6.85-7.34	> 7.35	
		GAUGE (inches)														
		< .030	.030-.069	.070-.089	.090-.109	.110-.129	.130-.149	.150-.169	.170-.189	.190-.209	.210-.229	.230-.249	.250-.269	.270-.289	> .290	
Width (mm)	<152	Width (in)	< 5.99													
	152-254		6-9.99													
	254-381		10-14.99													
	381-508		15-19.99													
	508-635		20-24.99													
	635-762		25-29.99													
	762-889		30-34.99													
	889-1016		35-39.99													
	1016-1270		40-49.99													
	>1270		>50													

Note: Any coil/cut > 20,000 LBS  
Minimum 3 eye straps

\*The above banding requirements are based on ArcelorMittal Dofasco's capabilities as of 2016\*  
\*Excludes Unprocessed Coils (Unprocessed" coils have never been unwound/ rewound after hot rolling)\*