## **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.

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 <u>HSLA</u> steel

ALL STRAPS - MINIMUM 1¼ in x .029 in																	
# OD STRAPS					GAUGE (mm)												
															6.34-		> 7.35
					1.76	2.26	2.76	3.27					5.82	6.33	6.84	7.34	
				GAUGE (inches)													
					.030 -				.130 -					.230-		.270-	>.290
	<152		< 5.99		.069	.089	.109	.129	.149	.169	.189	.209	.229	.249	.269	.289	
	152-254		6-9.99								<u> </u>						
	254-381		10-14.99			-											
(	381-508		15-19.99														
mm	508-635	(in)	20-24.99								-						
th	635-762	Width (in)	25-29.99														
Width (mm)	762-889		30-34.99							0							
	889-1016		35-39.99							Z						2	
	1016-1270		40-49.99													J	
	>1270		>50														
					STRAPS - MINIMUM 1¼ in x .029 in												
					GAUGE (mm)												
				<.76											6.34-		> 7.35
# ID STRAPS				1.76	2.26	2.76	3.27			4.80 (incl	-	5.82	6.33	6.84	7.34		
	# ID S	I KAP8															
	# ID S	TRAPS			.030	.070	.090 -	.110			-	_	.210-	.230-	250-	.270-	
	# ID S	TRAPS		< .030	.030 .069	.070 .089	.090 - .109	.110 .129		.150- .169	-	.190- .209	.210- .229	.230- .249	.250- .269	.270- .289	>.290
	<b># ID S</b>	TRAPS	< 5.99	< .030					.130 -	.150-	.170-	.190-					>.290
		TRAPS	< 5.99 6-9.99	< .030					.130 -	.150-	.170-	.190-					>.290
	< 152	TRAPS		< .030				.129	.130 -	.150-	.170-	.190-					>.290
m)	< 152 152-254		6-9.99	<.030				.129	.130 -	.150-	.170-	.190-					>.290
(mm)	< 152 152-254 254-381		6-9.99 10-14.99	< .030				.129	.130 -	.150-	.170-	.190-					>.290
idth (mm)	< 152 152-254 254-381 381-508		6-9.99 10-14.99 15-19.99	<.030				.129	.130 -	.150-	.170-	.190- .209	.229	.249	.269	.289	
Width (mm)	< 152 152-254 254-381 381-508 508-635	TRAPS Midth (in)	6-9.99 10-14.99 15-19.99 20-24.99	<.030	.069	.089	.109	.129	.130149	.150-	.170-	.190209	.229	.249	.269	.289	3
Width (mm)	< 152 152-254 254-381 381-508 508-635 635-762		6-9.99 10-14.99 15-19.99 20-24.99 25-29.99	<.030	.069	.089	.109	.129	.130149	.150-	.170-	.190- .209 3	.229	.249 3 coil/c	.269	.289 3	3
Width (mm)	< 152 152-254 254-381 381-508 508-635 635-762 762-889		6-9.99 10-14.99 15-19.99 20-24.99 25-29.99 30-34.99	< .030	.069	.089	.109	.129	.130149	.150-	.170-	.190- .209 3	.229	.249 3 coil/c	.269	.289 3	3
Width (mm)	<152 152-254 254-381 381-508 508-635 635-762 762-889 889-1016		6-9.99 10-14.99 15-19.99 20-24.99 25-29.99 30-34.99 35-39.99	< .030	.069	.089	.109	.129	.130149	.150-	.170-	.190- .209 3	.229	.249 3 coil/c	.269	.289 3	3
	<152 152-254 254-381 381-508 508-635 635-762 762-889 889-1016 1016-1270	Width (in)	6-9.99 10-14.99 15-19.99 20-24.99 25-29.99 30-34.99 35-39.99 40-49.99 > 50 g requirem	ents a	.069 3	.089	.109	.129 2 3	.130- .149	.150- .169	.170- .189	.190- .209 3 Note Mini	.229 3 e: Any imum	.249 3 coil/c 3 eye	.269 3 aut > 20 straps	.289 3 0,000	3 LBS

			ALL	STRA	<b>- S</b>	MIN	MU	M 11	í in x	0.02	9 in							
		STRAPS - MINIMUM 1¼ in x .029 in GAUGE (mm)																
# OD STRAPS					0.75-	1.77-	2.27-	2.77-					5.32-	5.83-	6.34-	6.85-		
						2.26											> 7.35	
					GAUGE (inches)													
									GA	UGE	(Incr	ies)						
					.030		.090 -				.170-					.270-	>.290	
				<.030	.069	.089	.109	.129	_	.169	.189	.209	.229	.249	.269	.289		
	<152		< 5.99	1	1	1	1	1	1	1	1	1	1	1	1	1	1	
	152-254		6-9.99							<u> </u>								
(L	254-381	Width (in)	10-14.99							<u> </u>								
L	381-508		15-19.99							<u> </u>								
Width (mm)	508-635		20-24.99						-									
idt	635-762		25-29.99		<u> </u>				┢	<u> </u>								
W	762-889 889-1016		30-34.99 35-39.99													0		
	1016-1270		40-49.99													Η.	_	
	>1270		>50		<u> </u>					<u> </u>						9	-	
	>12/0																	
		STRAPS - MINIMUM 1¼ in x .029 in																
				GAUGE (mm)														
				<.76		1.77-											> 7.35	
	# 1D S	TRAPS		<. <i>/</i> 0	1.76	2.26	2.76	3.27					5.82	6.33	6.84	7.34	- 1.55	
	# ID OTHAFO					GAUGE (inches)												
			<.030	.030	.070	.090	.110	.130	.150-	.170-	.190-	.210-	.230-	.250-	.270-	>.290		
				~.030	.069	.089	.109	.129	.149	.169	.189	.209	.229	.249	.269	.289	250	
	<152	Width (in)	< 5.99															
	152-254		6-9.99					_		L	<u> </u>							
(L	254-381		10-14.99					5	_									
Width (mm)	381-508		15-19.99									-	-			-		
	508-635		20-24.99		-	-	-	-	-			3	3	3	3	3	3	
	635-762		25-29.99		3	3	3	3	3									
M	762-889		30-34.99									Note: Any coil/cut > 20,000 LBS						
	889-1016		35-39.99									Minimum 3 eye straps						
	1016-1270		40-49.99						- 4									
	>1270		> 50															
	*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)*																	

## Minimum strapping requirements for <u>AHSS</u> coils