

Appendix 6

Rules For The Use of Non ACRS Certified Feed Materials In The Supply Of Reinforcing Steel.

This Appendix covers the requirements for sampling, testing and data management for the supply of reinforcing steel in the form of billets for conversion to finished product, rods for conversion to cold worked reinforcing steel or mesh, and finished products in the form of reinforcing bars, coils and mesh that has been sourced from non ACRS certified suppliers.

7.1: General

All non ACRS certified steel sourced shall be assessed for conformance to specification by the purchaser. ACRS Assessors shall review the procedures for purchasing, specification control and specification checking for all non ACRS certified steel sourced by the purchaser.

There shall be documented procedures for ensuring the surface quality, dimensions and shape of the product are suitable for the application and meet the requirements of AS/NZS 4671 and the user's specifications.

ACRS shall perform at least one full batch test (see below) from each size range as part of the normal ACRS assessment program (if such product is available). Additional ACRS sampling and testing may be performed outside the normal assessment schedule at ACRS discretion. Generally, at least one additional test sampling program, at the Surveillance Assessment level will be conducted in each 12 month interval, for each non ACRS certified supplier.

In cases where batch identity has generally not been maintained, all material shall be sampled and tested in accordance with the requirements of AS/NZS 4671, Clause B7. However, in cases where the identity of the majority of the supplied steel has been maintained, and only a small number or proportion of bundles have lost identity (eg, through loss of tag) ACRS may agree in writing after receipt of such a request that a review of order and delivery documentation, as well as supplier mill certificates may be performed to determine to a reasonable level of certainty the likely batch(s) the bundle(s) belongs to. If the identity of these bundle(s) cannot be determined to a reasonable level of certainty, they shall be sampled and tested in accordance with the requirements of AS/NZS 4671, Clause B7.

When sampling product for testing, each individual test sample shall be obtained from an individual bundle, coil or billet.

Verification of non ACRS certified steel may be on the basis of full AS/NZS 4671 batch testing for all batches received as detailed in clause 7.2 below, or on the basis of a sampling plan and generation of LTQ data as detailed in clause 7.3.

All testing shall be performed by a registered Testing House that is approved by ACRS. This may include a Testing House operated by the applicant.

The sampling, testing and data management regimes as described below shall be performed for each individual non ACRS certified supplier.

APPENDIX 6	Approved By:	Position:	Date of Issue:	Page:
	Philip Sanders	Executive Director	16/10/07	1 of 3

7.2 Billets, and Rods for Conversion to Cold Worked Wire or Mesh

At least one third of batches, in each size and product form received from each non ACRS certified supplier and released for processing each quarter shall be sampled and their chemical analysis and CEQ determined. Chemical analysis certificates showing all elements necessary for the determination of CEQ must be obtained from the steel supplier for each cast received, and be available for examination by ACRS Assessors during assessments or at any other times required by ACRS, together with the user's analysis results as determined above.

7.3: Finished Product (reinforcing bars, coils and mesh)

7.3.1 Full Batch Testing.

The purchaser/user shall conduct full batch testing for all properties and characteristics as required by AS/NZS 4671 clause B3. The results of these tests shall be forwarded to ACRS each quarter, together with copies of all of the supplier's batch test certificates.

7.3.2 Sampling and LTQ Data Management.

Test certificates showing all data necessary to show conformance to AS/NZS 4671 shall be supplied with each batch. All batches and bundles shall be identifiable and able to be matched to the test certificates; the bar design and markings shall comply with the requirements of AS/NZS 4671; bundle tags shall contain the information required by AS/NZS 4671 Clause 9.3

At least one third of the batches, up to a maximum of 3 batches, in each size and product form received from each non ACRS certified supplier and released for processing each quarter shall be sampled and tested in accordance with the requirements of AS/NZS 4671 clause B3.

The results of all such testing shall be entered into ACRS LTQ spreadsheets, and forwarded to ACRS each quarter, along with the suppliers' certificated results for those batches.

The minimum number of batches to be sampled and tested as above is shown in Table 1.

In addition, for weekly LTQ testing for off-coil processing, sampling and testing shall be on the basis of one test per size per machine per week for each supplier. All ACRS certified suppliers shall be grouped as one supplier for the purpose of this sampling and testing.

Satisfactory evidence of the above sampling and testing, and all test results shall be reviewed during ACRS assessments, and at any other times as required by ACRS.

The supplier's certificated test data for all non ACRS certified product shall be entered into ACRS spreadsheets and forwarded to ACRS each quarter to develop LTQ data over time.

7.4: Failures in Testing

If a test fails to meet the requirements of AS4671, further samples shall be taken and tested from that batch in accordance with AS/NZS 4671 clause B5. If this retesting confirms failure to conform to specification, the batch shall be rejected, and the purchaser shall test all batches in that product form and size in current possession, and the next 3 batches received in that product form and size. If this subsequent testing confirms specification compliance in all cases, the normal sampling and testing program may

APPENDIX 6	Approved By:	Position:	Date of Issue:	Page:
	Philip Sanders	Executive Director	16/10/07	2 of 3

resume. Should additional test failures occur, these must be reported immediately to ACRS. ACRS will then review the suitability of ongoing supply from that particular steelmaker.

The discovery of steel not meeting the requirements of AS/NZS 4671, either by way of test certificate data, user initiated testing or testing by ACRS shall be reported by the user to the steel supplier and ACRS. The documentation of this user generated NCR and the CAR response provided by the supplier shall also be forwarded to ACRS and further reviewed in ACRS programmed assessments.

Any batch not meeting the requirements of AS/NZS 4671, either by certificated test data, the applicant's testing or testing by ACRS, shall be quarantined and rejected. If detected by test certificate data or by the applicant's testing, ACRS must be immediately informed in writing of this non conformance. ACRS reserves the right to inspect such material, and ensure it is not supplied as conforming product unless the applicant's customer has provided written acceptance for such supply. Evidence of the quarantining and rejection process shall be submitted to ACRS in writing.

7.5: Variation Between Mill Certificates and Verification Testing

Where the verification test results do not appear to come from the same population as the mill certificate results ACRS may, at its complete discretion, require further sampling and testing of the batch(es) in question and/or further sampling and testing of additional batches. Such additional sampling and testing shall be at the purchaser's expense.

Table 1

No. of Batches Per Supplier Mill Released for Processing per Product Form and Size per Quarter	No. of Batches Per Supplier Mill to be Sampled and Tested per Product Form and Size per Quarter
1	1
2	1
3	1
4	2
5	2
6	2
>6	3