

## 1. NAMEN SPECIFIKACIJE

## PURPOSE OF SPECIFICATION

<p>Tehnično prevzemni pogoji specificirajo zahteve in smernice za posamezne vrste scrapa, ki so specificirane v standardih EN 1780-1 do 1780-3 in EN 13920-1 do 13920-16 izdani leta 2002/2004.</p> <p>Sekundarni aluminij (scrap), uporablja se kot surovina za proizvodnjo gnetnih aluminijevih zlitin, je nastal kot posledica zbiranja in/ali obnavljanja:</p> <ul style="list-style-type: none"> <li>– <b>Industrijski odpadni aluminij</b>, ki nastaja pri različnih stopnjah predelave v Al polizdelke ali končne izdelke (KR6 in KR7)</li> <li>– <b>Sekundarni odpadni aluminij</b>, ki nastane iz izdelkov po uporabi (KR8 in KR9)</li> <li>– <b>Sekundarni pretaljeni ingoti/klobuki</b>, ki nastanejo pri pretaljevanju odpadkov z znano kemijsko sestavo. (KR6)</li> </ul>	<p>Technical acceptance criteria specify the requirements and guidelines for type of scrap, which are specified in the standards EN 1780-1 to 1780-3 and EN 13920-1 to 13920-16 published 2002.</p> <p>Secondary aluminium (scrap), used for production of aluminium wrought alloys of major pretentiousness, become as result of collection or/and reconstruction:</p> <ul style="list-style-type: none"> <li>– <b>Industrial new scrap</b>, arising from the production and fabrication of aluminium product, (post consumer KR6, KR7)</li> <li>– <b>Secondary old scrap</b>, arising from products after use (post consumer KR8, KR9)</li> <li>– <b>Reclaimed Al Scrap Ingot/Sows</b>, arising with remelted of scrap with known chemical composition. (post consumer KR6)</li> </ul>
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## 2. SPLOŠNE KAKOVOSTNE ZAHTEVE

## GENERAL QUALITY REQUIREMENTS

## 2.1 SPLOŠNO

## GENERAL

Če odpad v celoti ne izpolnjuje teh zahtev, mora dobavitelj obvestiti kupca o zahtevah, ki odstopajo in pridobiti njegovo soglasje pred odpremo.	If the scrap does not meet the entire requirements, the supplier shall notify the deviating characteristics to the customer and shall obtain his agreement before shipment.
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## 2.2 NEVARNE SNOVI

## HAZARDOUS CONTAMINANTS

Odpad ne sme vsebovati snovi, kot so azbest, kadmij, živo srebro, litij, PCB impregniranih materialov, eksplozivnih ali radioaktivnih snovi in drugih tujih snovi.	The scrap shall not contain materials like asbestos, cadmium, mercury lithium, PCB impregnated materials, explosive or radioactive materials and other foreign material.
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## 2.3 KEMIJSKA SESTAVA

## CHEMICAL COMPOSITION

Kemična sestava po vzorčenju ali taljenju, kot je določeno s standardom EN 13920-1, mora biti v skladu z zahtevami iz tabele 1.	The chemical composition after sampling or melting as determined according to EN 13920-1 shall conform to the requirements given in table 1.
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## Tabela1: SKUPINE ODPADA

## Table 1: GROUP OF SCRAP

Skrbnik dokumenta: Marina Jelen	Solastniki dokumenta: /	Lastnik dokumenta: Jure Čretnik
Datum: 20. 03. 2018	Veljavnost od: 19. 03. 2018	Veljavnost do: /

Stopnja zaupnosti dokumenta: zaupno

Status dokumenta: objavljen

Dokumenti so obvladovani v informacijskem sistemu DNA. V primeru razlik med dokumenti, velja izvorni dokument v sistemu DNA.

Dokument je internega značaja. Prenos tretjim osebam brez predhodne odobritve ni dovoljen. Vse pravice pridržane.

SKUPINA / GROUP	VRSTA ODPADA / TYPE OF SCRAP	IZKORISTE K / YIELD	KARATEKTERISTIKE / CHARACTERISTIC
<b>1. Nelegiran Al odpad / UNALLOYED ALUMINIUM SCRAP ACCORDING TO STANDARD EN 13920-2</b>			
AA 1xxx (Al99,0 - Al99,5)	novi čisti industrijski odpad pločevin, trakov, cevi, odrezkov itd	min. 95 KR6 KR7	Mora biti brez olj, maščob, umazanije, plastike in drugih tujih materialov.
	new clean industrial production scrap from sheet, strip, tube etc.		It shall be free from oil, grease, dust, plastics and any other foreign material.
	star čisti odpad kot so odrezki, ostanki pločevin, trakov, ostanki mehanskih obdelav itd.	min. 95 KR8 KR9	Mora biti brez olj, maščob, umazanije, plastike in drugih tujih materialov.
	old clean production scrap from sheet, strip, tube, residues of mechanical treatment etc.etc.		It shall be free from oil, grease, dust, plastics, and any other foreign material.
<b>2. Nelegirana Al žica in kabli / WIRE AND CABLE AL SCRAP ACCORDING TO STANDARD EN 13920-3</b>			
AA 1xxx (Al99,0-99,5)	nova ali stara čista žica in kabli z min premerom 0,8mm posamezne žice (TALON ali TASTE)	min. 95 KR6 KR7	Mora biti brez Fe-jedra, površinskih premazov, olja, maščob, izolacije, plastike in drugih tujih materialov.
	new or old scrap from wire or cabel with min diamater 0,8mm for any individual wire (TALON or TASTE)		It shall be free from steel core wire, oil, grease, insulation, dust, plastics and any other foreign material.
	stara, namaščena žica in kabli	min. 90 KR8 KR9	Vsebuje lahko max. 1 % olja, maščob, toda brez Fe-jedra, površinskih premazov, izolacije, plastike in drugih tujih materialov.
	old greasy wire and cable		It could contain max. 1% of oil, grease, but free from steel core wire, coatings, insulation, plastics and any other foreign material.
<b>3. Legirana Al žica in kabli / WIRE AND CABLE AL SCRAP ACCORDING TO STANDARD EN 13920-3</b>			
1xxx/6xxx (Al99,5 / AlMgSi0,7)	nova ali stara čista žica in kabli zlitine serije 1xxx in 6xxx (TANN or TASSEL)	min. 95 KR6 KR7	Mora biti brez Fe-jedra, površinskih premazov, olja, maščob, izolacije, plastike in drugih tujih materialov.
	new or old clean scrap from wire or cabel alloys of the series 1xxx and 6xxx (TANN or TASSEL)		It shall be free from steel core wire, oil, grease, dust, insulation, plastics and any other foreign material.
<b>4. Odpadni Al ene gnetne zlitine / SCRAP CONSISTING ONE SINGLE WROUGHT ALLOY ACCORDING TO STANDARD EN 13920-4</b>			
3xxx (3003, 3004, 3103, 3005)  5xxx (5754, 5052, 5049, 5083)	nov ali star čisti industrijski odpad kot so odrezki, ostanki pločevin, trakov (TAINT, TABOR) ali stiskani in vlečeni profili, ostanki palic, cevi itd.	min. 95 KR6 KR7	Mora biti brez olj, maščob, umazanije, plastike in drugih tujih materialov.
	new or old clean industrial production scrap from sheet, strip (TAINT, TABOR) or extruded and drawn profiles, ends of extrusion bars, tubes etc.		It shall be free from oil, grease, dust, plastics and any other foreign material.

2xxx (2011, 2014, 2017, 2024, 2030) 4xxx (4032) 6xxx (6060, 6061, 6063, 6082, 6182) 7xxx (7020, 7022, 7075)	nov ali star čisti industrijski odpad kot so stiskani in vlečeni profili, ostanki palic, cevi, odkovkov, ostanki mehanskih obdelav itd.	min. 95 KR6 KR7	Mora biti brez olj, maščob, umazanije, plastike in drugih tujih materialov.
	new or old clean industrial production scrap from extruded and drawn profiles, ends of extrusion bars, tubes, residues of mechanical treatment etc.		It shall be free from oil, grease, dust, plastics and any other foreign material.
6xxx (6060, 6063, 6082)	nov ali star odpad v obliki profilov kot čisti, barvan ali anodiziran	min. 90 KR8 KR9	Vsebuje lahko površinski premaz, vendar brez olja, maščob, plastike in drugih tujih materialov.
	new or old scrap from profiles which could be clean, coated or anodised		It could contain s coatings, but free from oil, grease, plastics and any other foreign material.
<b>5. Odpadni Al iz dveh ali več gnetnih zlitin iste skupine/SCRAP CONSISTING OF TWO OR MORE WROUGHT ALLOYS OF SAME SERIES ACCORDING TO STANDARD EN 13920-5</b>			
AlMn, Al Mn(Mg) AlMg1-3, AlMg4Mn	star čisti odpad kot so odrezki, ostanki pločevin, trakov, ostanki mehanskih obdelav itd.	min. 95 KR8	Mora biti brez olj, maščob, umazanije, plastike in drugih tujih materialov.
	old clean production scrap from sheet, strip, tube, residues of mechanical treatment etc.etc.		It shall be free from oil, grease, dust, plastics, and any other foreign material.
AlMn, Al Mn(Mg) AlMg1-3, AlMg4Mn	star, masten ali barvan odpad pločevin, trakov, itd	min. 90 KR9	Vsebuje lahko max. 1% olja, površinskih premazov, barve, lakov, PVC, toda brez drugih tujih materialov.
	old contaminated production scrap from sheet, strip, tube etc.		It could contain max. 1% of oil, grease, coatings, plastics, but free from any other foreign material.
AlMgSi 0,5-1	star čisti odpad kot so stiskani in vlečeni profili, ostanki palic, cevi, odkovkov, ostanki mehanskih obdelav itd.	min. 95 KR8 KR9	Mora biti brez olj, maščob, umazanije, plastike in drugih tujih materialov.
	old clean production scrap from extruded and drawn profiles, ends of extrusion bars, tubes, residues of mechanical treatment etc.		It shall be free from oil, grease, dust, plastics and any other foreign material.
<b>7. Odpadni Al ulitki / SCRAP CONSISTING OF CASTINGS ACCORDING TO STANDARD EN 13920-7</b>			
AlSi7Mg (EN AC-42100, AC-42200)	čista nova ali stara platišča	min. 95 KR8	Vsebuje lahko max. 5% površine z anodno oksidacijo, vendar brez čistega svinca, cinka, kromiranja in drugih tujih materialov.
	new clean or old wheels		It could contain max. 5% of anodized surface, but free of pure lead, zinc, chromium-plated and any other foreign material.
<b>6. Odpadni Al v obliki ostružkov ene zlitine / TURNINGS CONSISTING OF ONE SINGLE ALLOY ACCORDING TO STANDARD EN 13920-12</b>			
6xxx (6082)	ločeni briketirani ostružki nastali pri struženju, rezkanju, vrtanju itd. (TEENS)	min. 90 KR9	Vsebuje lahko max. 3% olja, maščob, toda brez površinskih premazov, izolacije, plastike in drugih tujih materialov.

	selected turnings made from scalping, milling, boring etc. (TEENS)		It could contain max. 3% of oil, grease, but free from coatings, plastics and any other foreign material.
<b>8. Sekundarni ingoti (klobuki) / RECLAIMED AL SCRAP INGOT /SOWS</b>			
<b>Kemijska sestava po EN 573-3</b>	sekundarni ingoti, klobuki iz pretaljenih odpadkov znane kemijske sestave	min. 95 <b>KR6</b>	Material mora biti čist, brez ostankov žlindre, soli, korozije in odprtih por, lunckerjev na površini.
	secondary ingots, sows made from remelted scrap with known chemical composition		Ingots, sows should be free of skim/dross residue, salt cake, oxidation corrosion and open shrinkage cavities/internal voids, which connect to the surface.

**2.4 OZNAČEVANJE****MARKING**

Vsaka posamezna embalažna enota ali dobava mora biti sortirana in označena z zlitino ali skupino ter mora imeti na vidnem mestu oznako: <ul style="list-style-type: none"> <li>– proizvajalec/dobavitelj</li> <li>– oznaka zlitine (skupine zlitin) opisane v tč. 2.3.</li> </ul>	Each packed unit (case, palette, bond) or shipment should be sorted by alloy or groups and be marked with the following data: <ul style="list-style-type: none"> <li>– Identification of supplier</li> <li>– Type of alloy (group of alloys) specified in item 2.3.</li> </ul>
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**3. SPECIFIKACIJA ODPREME****SHIPPING SPECIFICATION****3.1 OBLIKA IN VELIKOST ODPADA****SCRAP FORM AND SIZE**

<p>Pakiranje in dobava sekundarnega aluminija je lahko v naslednjih oblikah in dimenzijah:</p> <p><b>Razsuti odpad:</b></p> <ul style="list-style-type: none"> <li>- Velikost posameznega kosa (pločevine, profilov, palic, odrezkov, odkovkov itd.) širine x dolžine ali dolžine posameznega kosa je lahko maksimalno 50cm.</li> </ul> <p><b>Balirani odpad na paletah ali v razsutih oblikah:</b></p> <ul style="list-style-type: none"> <li>- <b>Odpad</b> je lahko dobavljen v velikih balah z maksimalno velikostjo bale 80x60x120cm ali v malih balah z velikostjo bale 40x40x60cm.</li> </ul> <p><b>Pakiran odpad na paletah:</b></p> <ul style="list-style-type: none"> <li>- Odpad dobavljen kot paketi na paletah z maksimalno velikostjo 80x60x120cm.</li> </ul> <p><b>Razsekan in/ali stisnjen odpad:</b></p> <ul style="list-style-type: none"> <li>- V obliki granul, briketov, ostružkov se dobavlja v vrečah na paletah ali zabojih. V razsutih oblikah se dobavlja samo po dogovoru z odjemalcem (npr. briketi zlitine 6082).</li> </ul>	<p>Packaging and supply of secondary aluminum should be in the following formats and sizes:</p> <p><b>Bulk scrap:</b></p> <ul style="list-style-type: none"> <li>- Size of each piece (sheet, plate, profiles, bars, forgings etc.) width x length or the length of each piece should be a maximum of 50 cm.</li> </ul> <p><b>Scrap baled on pallets or in bulk form:</b></p> <ul style="list-style-type: none"> <li>- Scrap could be supplied in large bales with a maximum size of bales 80x60x120cm or in small bales dimension 40x40x60cm.</li> </ul> <p><b>The packaged waste on pallets:</b></p> <ul style="list-style-type: none"> <li>- Scrap supplied as packages on pallets with a maximum size 80x60x120cm.</li> </ul> <p><b>Cut and/or compressed waste:</b></p> <ul style="list-style-type: none"> <li>- In the form of granules, briquettes, chips are supplied in big bags on pallets or boxes. The bulk is supplied only by agreement with the customer (example briquettes alloy 6082).</li> </ul>
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**3.2 SPECIFIKACIJA PAKIRANJA****PACKAGING SPECIFICATION**

<p>Ves nabavljen odpad mora biti natovorjen tako, da je mogoče raztovoriti z viličarji v razumnem času.</p> <p>Opad mora biti natovorjen, da se zagotovi varno raztovarjanje, ki ne bo povzročilo nobene škode ali poškodbe na opremi ali osebju dobavitelja ali kupca.</p> <p>Nabavljen odpad mora biti pakiran v bale, ki so varno in čvrsto povezane na paletu, do višine 100 cm.</p>	<p>All purchased scrap must be loaded in a manner that allows unloading with forklift equipment in a reasonable amount of time.</p> <p>Scrap must be loaded so as to ensure safe unloading which will cause no damage or injury to shipper's or receiver's equipment or personnel.</p> <p>Purchased scrap must be packaged in such bales securely strapped or banded on pallets no higher than 100cm.</p>
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#### 4. KRITERIJI KAKOVOSTI

#### QUALITY CRITERIA

##### 4.1 KEMIJSKA SESTAVA

##### CHEMICAL COMPOSITIONS

<p>Kemijska sestava mora biti v skladu s specifikacijo naročila, ki odgovarja mednarodnim standardom DIN EN 1712-1, EN 573-3 za Al in Al gnetne zlitine.</p>	<p>Chemical compositions should be according with the order's specification, which corresponded to international standards DIN 1712/1, DIN EN 573-3 for aluminum in aluminum wrought alloys.</p>
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##### 4.2 NEČISTOČE IN OSTALE SUBSTANCE

##### IMPURITIES AND OTHER FOREIGN MATERIAL

<p><b>Ni dovoljeno:</b></p> <p>Opad ne sme vsebovati radioaktivnih ali drugih nevarnih onesnaženj, ki so škodljive za zdravje in okolje.</p> <p>Opad ne sme vsebovati razen aluminijeve zlitine, naveden na naročilnici, kot so jeklo, svinec, baker, cink, itd.</p> <p>Aluminijevi kompoziti, aluminij litijeve zlitine ali drugi kovinskih kompozitne zlitine niso sprejemljive.</p> <p>Ostružki, žagovina ali ostali tanki materiali niso dovoljeni razen po dogovoru z odjemalcem.</p> <p><b>Dovoljeno:</b></p> <p>Dovoljeni so jekleni trakovi za povezovanje v bale ali pakete.</p> <p>Maksimalna vsebnost vlage ne sme presegati 0,2%, ki je prisotna zaradi uporabe, skladiščenja, transporta itd.</p> <p>Prisotnosti organskih in anorganske snovi (kot so mast, olje, prah, papir, PVC, itd.):</p> <ul style="list-style-type: none"> <li>- Pri čistem odpadu (KR6, KR7) mora biti vsebnost manjša od 0,5%.</li> <li>- Pri kontaminiranem odpadu (KR8, KR9) mora biti vsebnost manjša od 3%.</li> </ul>	<p><b>It is not allowed:</b></p> <p>Scrap must not contain any radioactive or other hazardous contaminant, which is danger for health and environment.</p> <p>Scrap must be free of metals other than the aluminium alloy specified on the purchase order such as steel, lead, copper, zinc, etc.</p> <p>Aluminium composites such as aluminium lithium alloys or other metal composite alloys are not acceptable.</p> <p>Chips, borings, turnings or light gauge scrap will not be accepted unless is approved by customer.</p> <p><b>It is allowed:</b></p> <p>Steel banding around bales or packets will be accepted.</p> <p>Maximum of moisture should be less than 0,2%, which is present because of usage, storage or transportation.</p> <p>The presents of organic and inorganic substances (such as grease, oil, dust, paper, PVC):</p> <ul style="list-style-type: none"> <li>- In a clean scrap (KR6, KR7) contend should be less than 0.5%.</li> <li>- In a contaminated scrap (KR8, KR9) contend should be less than 3%.</li> </ul>
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#### 4.3 KAKOVOSTNI PREVZEM

#### QUALITY CONTROL

<p>Dobavljen material po specifikaciji naročila se preveri po internem kakovostnem postopku, preden se prevzame, pri katerem se upoštevajo zahteve, ki so v skladu z EN 13920-1:2003:</p> <ul style="list-style-type: none"> <li>✓ Preveriti ustreznost priložene dokumentacije, če je v skladu s specifikacijo naročila in oznakami na embalažnih enotah, ali celotno pošiljko.</li> <li>✓ S postopkom vzorčevanja se izbere reprezentančni vzorec, s katerim se določi: <ul style="list-style-type: none"> <li>• povprečna kemijska sestava z analizo vzorcev ali določena s pretaljevanjem,</li> <li>• vizualni nadzor nad celotno pošiljko glede vsebnosti vlage, hlapljivih in drugih neznanih substance,</li> <li>• izkoristek kovine.</li> </ul> </li> <li>✓ Odpad za pretaljevanja v vzorčnih pečeh je teže od 50 do 1000 kg in maksimalne velikosti, če je v balirani obliki 40x40x20-80cm ali maksimalne dolžine 50cm posameznega kosa.</li> <li>✓ Če so potrebne dodatne kemijske analize, se stroški za nastale analize bremenijo dobavitelja.</li> </ul>	<p>All scrap delivered against a specific order, must be verified by internal quality process, before it is accepted to consider the demand according to EN 13920-1:2003:</p> <ul style="list-style-type: none"> <li>✓ Check of adequacy of supporting documentation with purchasing order and marking on each packed unit or complete load.</li> <li>✓ The sampling procedure is selected the representative sample to be determined: <ul style="list-style-type: none"> <li>• average chemical composition with samples or determine by remelting,</li> <li>• visual control of the entire shipment for moisture content, volatile and other unknown substances,</li> <li>• efficiency of metal.</li> </ul> </li> <li>✓ Scrap intended for remelting furnaces should be weight from 50 to 1000 kg and maximum size when are in the bales 40x40x20-80 cm or maximum length 50cm each piece.</li> <li>✓ If it is necessary to take additionally chemical analysis these costs are to be charged to the supplier.</li> </ul>
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## 5. DOKUMENTI KAKOVOSTI

## QUALITY DOCUMENTS

<p>Dobavitelj mora zagotavljati kakovost v skladu s sistemom zagotavljanja kakovosti ISO 9001. Spremljajoča dokumentacija mora vsebovati podatke o dobavitelju, številko naročila in vrsti prejetega materiala v skladu s specifikacijo naročila.</p> <p>Vsaka osnovna sprememba o označevanju in osnovnem materialu, ki ima za posledico kakovost materiala ne sme biti narejena brez dogovora z odjemalcem.</p>	<p>The supplier must provide quality in accordance with quality assurance system ISO 9001. Supporting documentation should include information of the supplier, order number and type of material received in accordance with the specification in the contract.</p> <p>Any basic change in the labeling and the base material, which results in the quality of the material must not be made without the agreement of the customer.</p>
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## 6. REKLAMACIJE

## REJECTION

<p>Če material ne ustreza vsem kriterijem naročila, kupec lahko pošiljko zavrne na stroške dobavitelja.</p> <p>Pogojno se sprejme v primeru, ko se dobavitelj in odjemalec sporazumeta, da dobavitelj pokrije nastale izgube in dodatne stroške tudi v primeru pretaljene surovine.</p>	<p>If delivered scrap does not conform to the contract, the customer may reject the scrap on supplier costs.</p> <p>Alternatively, supplier and customer may agree upon compensation that covers the losses and extra costs as well as remelted costs.</p>
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