

	<b>Free-cutting steels</b> Technical delivery conditions for semi-finished products, hot-rolled bars and rods English version of DIN EN 10087	<b>DIN</b> <b>EN 10087</b>
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ICS 77.140.50; 77.140.60; 77.140.65

Supersedes parts of  
DIN 1651, April 1988 edition.Descriptors: Steel, free-cutting steel, semi-finished products, bars,  
rod.Automatenstähle – Technische Lieferbedingungen für Halbzeug,  
warmgewalzte Stäbe und Walzdraht**European Standard EN 10087 : 1998 has the status of a DIN Standard.***A comma is used as the decimal marker.***National foreword**

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DIN V 17006-100 and DIN 50601 are the standards corresponding to the European Standard CR 10260 and EURONORM 103, respectively, referred to in clause 2 of the EN.

**Amendments**

Parts of DIN 1651, April 1988 edition, have been superseded by the specifications of DIN EN 10087.

**Previous editions**

DIN 1651: 1944-08, 1954-08, 1960-11, 1970-04, 1988-04.

**National Annex NA****Standards referred to**(and not included in **Normative references**)

DIN V 17006-100 Designation system for steel – Additional symbols for steel names

DIN 50601 Metallographic examination – Determination of the ferritic or austenitic grain size of steel and ferrous materials

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ICS 77.140.50; 77.140.60; 77.140.65

Descriptors: Steel, free-cutting steel, semi-finished products, bars, rod.

**English version**

**Free-cutting steels**

Technical delivery conditions for semi-finished products,  
hot-rolled bars and rods

Aciers de décolletage – Conditions  
techniques de livraison pour les  
demi-produits, barres et fils-machine  
laminés à chaud

Automatenstähle – Technische  
Lieferbedingungen für Halbzeug,  
warmgewalzte Stäbe und Walzdraht

This European Standard was approved by CEN on 1998-09-04.

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Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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**CEN**

European Committee for Standardization  
Comité Européen de Normalisation  
Europäisches Komitee für Normung

**Central Secretariat: rue de Stassart 36, B-1050 Brussels**

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## Foreword

This European Standard has been prepared by Technical Committee ECISS/TC 23 "Steels for heat treatment, alloy steels and free-cutting steels - Qualities and dimensions", the secretariat of which is held by DIN.

ECISS/TC 23 met on 1st/2nd July 1997 in Düsseldorf and agreed on the text for submission of this draft European Standard to COCOR-Vote. The following countries were represented in the meeting:  
Finland, France, Germany, Italy and United Kingdom.

The United Kingdom issues a non-conflicting national addition which describes a steel used in the United Kingdom but not included in this European Standard.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by March 1999, and conflicting national standards shall be withdrawn at the latest by March 1999.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

## 1 Scope

1.1 This European Standard gives the technical delivery conditions for

- semi-finished products,
- hot-rolled bars (including peeled bars),
- rods

manufactured from the free-cutting steels listed in table 1.

This European Standard covers those groups of free-cutting steels classified as listed in table 1.

NOTE: European Standards for similar steels are listed for information in annex C.

1.2 In special cases, variations in these technical delivery conditions or additions to them may form the subject of an agreement at the time of enquiry and order (see annex B).

1.3 In addition to the specifications of this European Standard, the general technical delivery conditions specified in EN 10021 are applicable unless otherwise specified below.

## 2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 10002-1	Metallic materials - Tensile testing - Part 1: Method of test (at ambient temperature)
EN 10003-1	Metallic materials - Brinell hardness test - Part 1: Test method
EN 10020	Definition and classification of grades of steel
EN 10021	General technical delivery requirements for steel and iron products
EN 10027-1	Designation systems for steel - Part 1: Steel names, principal symbols
EN 10027-2	Designation systems for steel - Part 2: Numerical system
EN 10052	Vocabulary of heat treatment terms for ferrous products
EN 10079	Definition of steel products

EN 10204	Metallic products - Types of inspection documents (includes amendment A1:1995)
EN 10221	Surface quality classes for hot-rolled bars and rods - Technical delivery conditions
CR 10260	ECISS IC 10 - Designation systems for steel - Additional symbols
EN ISO 377	Steel and steel products - Location and preparation of test pieces for mechanical testing
EURONORM 103 <sup>1)</sup>	Microscopic determination of the ferritic or austenitic grain size of steels
ISO 14284	Steel and iron - Sampling and preparation of samples for the determination of chemical composition

### 3 Definitions

For the purpose of this European Standard the following definition applies in addition to the definitions in EN 10020, EN 10021, EN 10052, EN 10079, EN ISO 377 and ISO 14284:

**3.1 Free-cutting steels:** Steels with a minimum sulfur content of at least, in general, 0,1% are regarded as free-cutting steels.

### 4 Classification and Designation

#### 4.1 Classification

All steels covered by this European Standard are classified as non-alloy quality steels according to EN 10020.

#### 4.2 Designation

##### 4.2.1 Steel names

For the steel grades covered by this European Standard, the steel names as given in table 1 are allocated in accordance with EN 10027-1 and CR 10260.

<sup>1)</sup> It may be agreed at the time of ordering, until this EURONORM has been adopted as an European Standard, that either this EURONORM or a corresponding national standard may be applied.

## 4.2.2 Steel numbers

For the steel grades covered by this European Standard, the steel numbers as given in table 1 are allocated in accordance with EN 10027-2.

## 5 Information to be supplied by the purchaser

### 5.1 Mandatory information

The following information shall be supplied by the purchaser at the time of enquiry and order:

- a) the quantity to be delivered;
- b) the designation of the product form (e.g. round or square);
- c) the number of the dimensional standard (see Annex D);
- d) the dimensions and tolerances on dimensions and shape and, if applicable, letters denoting relevant special tolerances;
- e) the number of this European Standard (EN 10087);
- f) steel name or steel number (see 4.2);
- g) the standard designation for a test report (2.2) or, if required, any other type of inspection document in accordance with EN 10204 (see 8.1).

#### EXAMPLE:

20 rounds EURONORM 60 - 40x8000  
EN 10087 - 35S20  
EN 10204 - 2.2

or

20 rounds EURONORM 60 - 40x8000  
EN 10087 - 1.0726  
EN 10204 - 2.2

### 5.2 Options

A number of options are specified in this European Standard and listed below. If the purchaser does not indicate his wish to implement one of these options, the supplier shall supply in accordance with the basis specification of this European Standard (see 5.1).

- a) any special requirement on treatment condition at delivery (see 6.2);
- b) any special requirement on grain size (see 7.3 and B.2);
- c) any requirement for internal soundness (see 7.4 and B.3);
- d) any requirement relating to surface quality (see 7.5.3);
- e) any requirement concerning suitability of bars and for bright drawing (see 7.5.4);
- f) any requirement relating to removal of surface defects (see 7.5.5);
- g) any requirement concerning special marking of the products (see clause 9 and B.5);
- h) any special requirement concerning verification of the mechanical properties in the quenched and tempered condition on a reference test piece (see 8.2.1.1 e) and B.1);
- i) any verification of the product analysis (see 8.2.1.1 f), table 8 and B.4).

## **6 Manufacturing process**

### **6.1 General**

The manufacturing process of the steel and of the products is left to the discretion of the manufacturer with the restrictions given by the requirements in 6.2 (see also 7.3).

### **6.2 Treatment condition at delivery**

Unless otherwise agreed, products shall be delivered in the untreated condition.

### **6.3 Cast separation**

The products shall be delivered separated by cast.

## **7 Requirements**

### **7.1 Chemical composition and mechanical properties**

The product shall have a chemical composition and mechanical properties, i.e. tensile strength and hardness, appropriate to the product form and treatment condition as set out in tables 1 to 5.

### **7.2 Weldability**

Because of their high sulfur and phosphorus contents, free-cutting steels are not normally recommended for welding.

### **7.3 Structure**

Unless otherwise agreed at the time of enquiry and order, the grain size shall be left to the discretion of the manufacturer. If, for case-hardening or direct-hardening steels, a fine grain structure is required in accordance with a reference treatment, this must be agreed at the time of enquiry and order (see B.2).

### **7.4 Internal soundness**

Requirements for internal soundness may be agreed upon at the time of enquiry and order, e.g. on the basis on non-destructive tests (see B.3).

### **7.5 Surface quality**

**7.5.1** All products shall have a surface finish appropriate to the forming processes applied.

**7.5.2** Minor surface imperfections which may occur also under normal manufacturing conditions, such as scores originating from rolled-in scale in the case of hot-rolled products, shall not be regarded as defects.

**7.5.3** Where appropriate, requirements relating to the surface quality of the products shall be agreed on at the time of enquiry and order with reference to EN 10221.

NOTE: It is more difficult to detect and eliminate surface discontinuities from coiled products than from cut lengths. This should be taken into account when agreements are made on surface quality.

**7.5.4** If suitability of bars and rod for bright drawing is required, this shall be agreed at the time of enquiry and order.

**7.5.5** The repair of surface defects by welding is not permitted.

The method and permissible depth of defect removal, where appropriate, shall be agreed at the time of enquiry and order.

## **7.6 Dimensions, tolerances on dimensions and shape**

The nominal dimensions, tolerances on dimensions and shape tolerances for the product shall be agreed at the time of enquiry and order, if possible, with reference to the dimensional standards applicable (see annex D).

## **8 Inspection and testing**

### **8.1 Types and contents of inspection documents**

**8.1.1** Products complying with this European Standard shall be ordered and delivered with one of the inspection documents as specified in EN 10204. The type of document shall be agreed upon at the time of enquiry and order. If the order does not contain any specification of this type, a test report shall be issued.

**8.1.2** If, in accordance with 8.1.1, a test report is to be issued, it shall contain the following information:

- a) the confirmation that the material complies with the requirements of the order;
- b) the results of the cast analysis for all the elements specified in table 1 for the steel grade concerned.

**8.1.3** If, in accordance with the agreements at the time of enquiry and order, an inspection certificate or inspection report is to be issued, the specific inspection described in 8.2 shall be carried out and the results shall be confirmed in the inspection document.

In addition, the inspection document shall contain the following information:

- a) the manufacturer's results for the cast analysis of all elements specified in table 1 for the steel grade concerned;

b) the results of inspections and tests ordered as a result of supplementary or special requirements (see annex B);

c) the symbol letters or numbers relating the inspection documents, test pieces and products to each other.

## **8.2 Specific inspection and testing**

### **8.2.1 Chemical composition and mechanical properties**

**8.2.1.1** Where specific inspection and testing is specified (see clause 8.1.3) the properties of the product in the untreated or quenched and tempered condition shall be verified as follows:

a) for steels not intended for heat treatment, tensile strength in accordance with table 3;

b) for steels intended for case hardening, tensile strength in accordance with table 4;

c) for steels intended for quenching and tempering, tensile strength in the untreated condition in accordance with table 5;

d) for steels according to table 5 delivered in the quenched and tempered condition, the mechanical properties in accordance with table 5;

e) where specified at the time of enquiry and order, the mechanical properties of steels intended for quenching and tempering shall be verified by the testing of a reference test piece in accordance with B.1;

f) where specified at the time of enquiry and order, the product analysis shall be verified in accordance with B.4.

**8.2.1.2** The frequency of testing, sampling conditions and the test methods to be applied for verification of the requirements shall be as given in table 8.

### **8.2.2 Visual and dimensional inspection**

A sufficient number of products shall be inspected to ensure compliance with the specification.

### **8.2.3 Retests**

See EN 10021.

## **9 Marking**

The manufacturer shall mark the products or the bundles or boxes in a suitable way so that it is possible to determine the cast, the steel grade and the origin of the delivery (see B.5).

**Table 1: Types of steel, chemical composition  
(applicable to cast analysis)<sup>1)</sup>**

Steel designation		Chemical composition (% by mass)					
Name	Number	C	Si max.	Mn	P max.	S	Pb
<b>Steels not intended for heat treatment</b>							
11SMn30	1.0715	≤ 0,14	0,05 <sup>2)</sup>	0,90 to 1,30	0,11	0,27 to 0,33	-
11SMnPb30	1.0718	≤ 0,14	0,05	0,90 to 1,30	0,11	0,27 to 0,33	0,20 to 0,35
11SMn37	1.0736	≤ 0,14	0,05 <sup>2)</sup>	1,00 to 1,50	0,11	0,34 to 0,40	-
11SMnPb37	1.0737	≤ 0,14	0,05	1,00 to 1,50	0,11	0,34 to 0,40	0,20 to 0,35
<b>Case-hardening steels</b>							
10S20	1.0721	0,07 to 0,13	0,40	0,70 to 1,10	0,06	0,15 to 0,25	-
10SPb20	1.0722	0,07 to 0,13	0,40	0,70 to 1,10	0,06	0,15 to 0,25	0,20 to 0,35
15SMn13	1.0725	0,12 to 0,18	0,40	0,90 to 1,30	0,06	0,08 to 0,18	-
<b>Direct-hardening steels</b>							
35S20	1.0726	0,32 to 0,39	0,40	0,70 to 1,10	0,06	0,15 to 0,25	-
35SPb20	1.0756	0,32 to 0,39	0,40	0,70 to 1,10	0,06	0,15 to 0,25	0,15 to 0,35
36SMn14	1.0764	0,32 to 0,39	0,40	1,30 to 1,70	0,06	0,10 to 0,18	-
36SMnPb14	1.0765	0,32 to 0,39	0,40	1,30 to 1,70	0,06	0,10 to 0,18	0,15 to 0,35
38SMn28	1.0760	0,35 to 0,40	0,40	1,20 to 1,50	0,06	0,24 to 0,33	-
38SMnPb28	1.0761	0,35 to 0,40	0,40	1,20 to 1,50	0,06	0,24 to 0,33	0,15 to 0,35
44SMn28	1.0762	0,40 to 0,48	0,40	1,30 to 1,70	0,06	0,24 to 0,33	-
44SMnPb28	1.0763	0,40 to 0,48	0,40	1,30 to 1,70	0,06	0,24 to 0,33	0,15 to 0,35
46S20	1.0727	0,42 to 0,50	0,40	0,70 to 1,10	0,06	0,15 to 0,25	-
46SPb20	1.0757	0,42 to 0,50	0,40	0,70 to 1,10	0,06	0,15 to 0,25	0,15 to 0,35
<p><sup>1)</sup> Elements not quoted in this table shall not be intentionally added to the steel without the agreement of the purchaser, other than for the purpose of finishing the heat. However, elements such as Te, Bi etc. may only be added by the manufacturer for improving the machinability, if this has been agreed at the time of enquiry and order.</p> <p><sup>2)</sup> If, by metallurgical techniques, the formation of special oxides is guaranteed, a Si-content of 0,10% to 0,40% can be agreed.</p>							

**Table 2: Permissible deviations between specified analysis and product analysis**

Element	Permissible maximum content according to cast analysis % by mass	Permissible deviations <sup>1)</sup> % by mass
C	>0,30    ≤0,30 ≤0,50	± 0,02 ± 0,03
Si	>0,05    ≤0,05 ≤0,40	+ 0,01 + 0,03
Mn	>1,00    ≤1,00 ≤1,70	± 0,04 ± 0,06
P	>0,06    ≤0,06 ≤0,11	+ 0,008 + 0,02
S	>0,33    ≤0,33 ≤0,40	± 0,03 ± 0,04
Pb	≤0,35	+ 0,03 - 0,02

<sup>1)</sup> ± means that in one cast the deviation may occur over the upper value or under the lower value of the specified range in table 1, but not both at the same time.

**Table 3: Hardness and tensile strength in the untreated condition of free-cutting steels not intended for heat-treatment**

Steel designation		Diameter	Hardness <sup>1)2)</sup> HB	Tensile strength <sup>1)3)</sup>
Name	Number	d mm		N/mm <sup>2</sup>
11SMn30	1.0715	5 ≤ d ≤ 10	-	380 to 570
		10 < d ≤ 16	-	380 to 570
11SMnPb30	1.0718	16 < d ≤ 40	112 to 169	380 to 570
11SMn37	1.0736	40 < d ≤ 63	109 to 169	370 to 570
11SMnPb37	1.0737	63 < d ≤100	107 to 154	360 to 520

<sup>1)</sup> In cases of dispute, the tensile strength values are deciding.  
<sup>2)</sup> The hardness values are given for information only.  
<sup>3)</sup> For flats, a minimum tensile strength of 340 N/mm<sup>2</sup> applies.

**Table 4: Hardness and tensile strength of case hardening free-cutting steels in the untreated condition**

Steel designation		Diameter $d$ mm	Hardness <sup>1)</sup> <sup>2)</sup> HB	Tensile strength <sup>1)</sup> N/mm <sup>2</sup>
Name	Number			
10S20 10SPb20	1.0721 1.0722	$5 \leq d \leq 10$	–	360 to 530
		$10 < d \leq 16$	–	360 to 530
		$16 < d \leq 40$	107 to 156	360 to 530
		$40 < d \leq 63$	107 to 156	360 to 530
		$63 < d \leq 100$	105 to 146	350 to 490
15SMn13	1.0725	$5 \leq d \leq 10$	–	430 to 610
		$10 < d \leq 16$	–	430 to 600
		$16 < d \leq 40$	128 to 178	430 to 600
		$40 < d \leq 63$	128 to 172	430 to 580
		$63 < d \leq 100$	125 to 160	420 to 540
<sup>1)</sup> In cases of dispute, the tensile strength values are deciding. <sup>2)</sup> The hardness values are given for information only.				

**Table 5: Mechanical properties of direct-hardening free-cutting steels<sup>1)</sup>**

Steel designation		Diameter $d$ mm	Untreated		Quenched and tempered		
Name	Number		Hardness <sup>2)3)</sup> HB	Tensile strength <sup>2)</sup> N/mm <sup>2</sup>	$R_c$ N/mm <sup>2</sup> min.	$R_m$ N/mm <sup>2</sup>	$A$ % min.
35S20 35SPb20	1.0726 1.0756	$5 \leq d \leq 10$	–	550 to 720	430	630 to 780	15
		$10 < d \leq 16$	–	550 to 700	430	630 to 780	15
		$16 < d \leq 40$	154 to 201	520 to 680	380	600 to 750	16
		$40 < d \leq 63$	154 to 198	520 to 670	320	550 to 700	17
		$63 < d \leq 100$	149 to 193	500 to 650	320	550 to 700	17
36SMn14 36SMnPb14	1.0764 1.0765	$5 \leq d \leq 10$	–	580 to 770	480	700 to 850	14
		$10 < d \leq 16$	–	580 to 770	460	700 to 850	14
		$16 < d \leq 40$	166 to 222	560 to 750	420	670 to 820	15
		$40 < d \leq 63$	166 to 219	560 to 740	400	640 to 790	16
		$63 < d \leq 100$	163 to 219	550 to 740	360	570 to 720	17
38SMn28 38SMnPb28	1.0760 1.0761	$5 \leq d \leq 10$	–	580 to 780	480	700 to 850	15
		$10 < d \leq 16$	–	580 to 750	460	700 to 850	15
		$16 < d \leq 40$	166 to 216	560 to 730	420	700 to 850	15
		$40 < d \leq 63$	166 to 216	560 to 730	400	700 to 850	16
		$63 < d \leq 100$	163 to 207	550 to 700	380	630 to 800	16
44SMn28 44SMnPb28	1.0762 1.0763	$5 \leq d \leq 10$	–	630 to 900	520	700 to 850	16
		$10 < d \leq 16$	–	630 to 850	480	700 to 850	16
		$16 < d \leq 40$	187 to 242	630 to 820	420	700 to 850	16
		$40 < d \leq 63$	184 to 235	620 to 790	410	700 to 850	16
		$63 < d \leq 100$	181 to 231	610 to 780	400	700 to 850	16
46S20 46SPb20	1.0727 1.0757	$5 \leq d \leq 10$	–	590 to 800	490	700 to 850	12
		$10 < d \leq 16$	–	590 to 780	490	700 to 850	12
		$16 < d \leq 40$	175 to 225	590 to 760	430	650 to 800	13
		$40 < d \leq 63$	172 to 216	580 to 730	370	630 to 780	14
		$63 < d \leq 100$	166 to 211	560 to 710	370	630 to 780	14

<sup>1)</sup>  $R_c$  = yield strength (0,2% proof stress);

$R_m$  = tensile strength;

$A$  = percentage elongation after fracture ( $L_0 = 5 d_0$ ).

<sup>2)</sup> In cases of dispute, the tensile strength values are deciding.

<sup>3)</sup> The hardness values are given for information only.

**Table 6: Conditions für heat treatment of case-hardening free-cutting steels<sup>1)</sup>**

Steel designation		Carburizing temperature <sup>2)</sup> °C	Core-hardening temperature <sup>3)</sup> °C	Case-hardening temperature <sup>3)</sup> °C	Quenching agent	Tempering <sup>5)</sup> at °C
Name	Number					
10S20	1.0721	880 to 980	880 to 920	780 to 820	water, oil, emulsion <sup>4)</sup>	150 to 200
10SPb20	1.0722					
15SMn13	1.0725					

- 1) The temperatures given for carburizing, core-hardening, case hardening and tempering are for guidance; the actual temperatures chosen should be those that will give the properties required.
- 2) The carburizing temperature will depend on the chemical composition of the steel, the mass of the product, and the carburizing medium. If the steels are direct hardened, in general, a temperature of 950 °C is not exceeded. For special procedures, for example under vacuum, higher temperatures (for example 1020 to 1050 °C) are not unusual.
- 3) When applying the single quench method, the steel is to be quenched from the carburizing temperature or a lower temperature. The lower hardening temperatures are in each case to be preferred, in particular when there is risk of distortion.
- 4) The kind of quenching agent depends on, for example, the shape of the products, the cooling conditions and the amount of furnace filling.
- 5) Time for tempering as a guide: 1 h minimum.

**Table 7: Conditions for heat treating of direct-hardening free-cutting steels<sup>1)</sup>**

Steel designation		Quenching <sup>2)</sup>		Tempering <sup>3)</sup> at °C
Name	Number	temperature °C	agent	
35S20 35SPb20	1.0726 1.0756	860 to 890	Water or oil	540 to 680
36SMn14 36SMnPb14	1.0764 1.0765	850 to 880	Water or oil	540 to 680
38SMn28 38SMnPb28	1.0760 1.0761	850 to 880	Water or oil	540 to 680
44SMn28 44SMnPb28	1.0762 1.0763	840 to 870	Oil or water	540 to 680
46S20 46SPb20	1.0727 1.0757	840 to 870	Oil or water	540 to 680

- 1) The temperatures are for guidance, but the actual temperatures chosen shall be those that will give the properties required.
- 2) Time for austenitizing as a guide: 0,5 h minimum.
- 3) Time for tempering as a guide: 1 h minimum.

**Table 8: Test conditions for verification of compliance with the various requirements**

NOTE: Verification of the requirements is only necessary if an inspection certificate or an inspection report is ordered and if the requirement is applicable according to 8.2.1.1.

1	2		3	4	5	6	7
No.	Requirements		Amount of testing			Sampling <sup>2)</sup>	Test method
	see table	Test unit <sup>1)</sup>	sample products per test unit	Number of tests per sample product			
1	Chemical composition	1 + 2	C	(The cast analysis is given by the manufacturer; for product analysis, see B.4)			
2	Hardness in the untreated condition (as rolled or as peeled)	3 + 4 + 5	C + D	1	1	The hardness shall, where possible, be determined at the following point on the surface: – at a distance of 1 × diameter from the end of the bar in the case of round bars, – at a distance of 1 × thickness from one end and 0,25 × thickness from one longitudinal edge of the product in the case of bars with square or rectangular cross section.	According to EN 10003-1
3	Mechanical properties of products in the untreated or quenched and tempered delivery condition	3 + 4 + 5	C + D + T	1 <sup>3)</sup>	1	The test pieces for the tensile test shall be taken in accordance with EN ISO 377	The tensile test shall be carried out in accordance with EN 10002-1 on proportional test pieces having a gauge length of $L_0 = 5,65 \sqrt{S_0}$ ( $S_0$ = area of the cross section of the test piece.)

- 1) The tests shall be carried out separately for each cast as indicated by “C”, each dimension as indicated by “D” and each heat treatment batch as indicated by “T”.  
 Products with different thicknesses may be grouped if the thicknesses lie in the same dimensional range for mechanical properties and if the differences in thickness do not affect the properties. In cases of doubt, the thinnest and the thickest product shall be tested.
- 2) The general conditions for selection and preparation of test samples and test pieces shall be in accordance with EN ISO 377 and ISO 14284.
- 3) If the products are continuously heat treated, one test piece shall be taken for each 25 t or part thereof, but at least one test piece shall be taken per cast.

## **Annex A (normative)**

### **Ruling section for the mechanical properties**

#### **A.1 Definition**

The ruling section of a product is the section for which the mechanical properties have been specified.

Whatever the actual shape and dimensions of the cross section of the product, the size of its ruling section is always expressed as a diameter. This corresponds to the diameter of an equivalent round bar. That is a round bar which, at the position of its cross section specified for taking test pieces for mechanical tests, will, when being cooled from the austenitizing temperature, show the same cooling rate as the actual ruling section of the product concerned at its position for taking test pieces.

#### **A.2 Determination of the diameter of the ruling section**

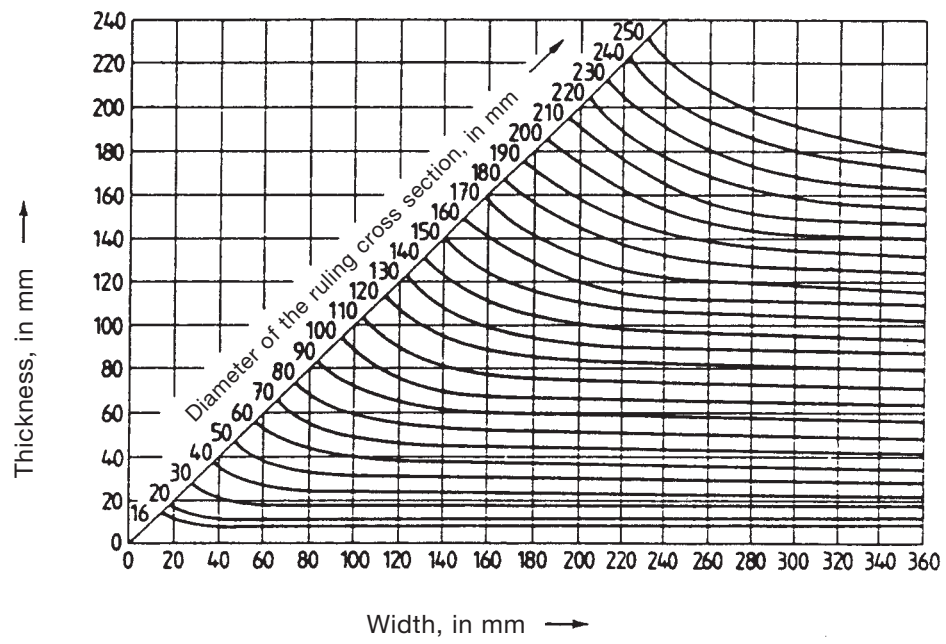
**A.2.1** If the test pieces are taken from products with simple cross sections and from positions with quasi two-dimensional heat flow, A.2.1.1 to A.2.1.3 shall apply.

**A.2.1.1** For rounds the nominal diameter of the product (not comprising the machining allowance) shall be taken as the diameter of the ruling section.

**A.2.1.2** For hexagons and octagons the nominal distance between two opposite sides of the cross section shall be taken as the diameter of the ruling section.

**A.2.1.3** For square and rectangular bars the diameter of the ruling section shall be determined in accordance with the example shown in figure A.1.

**A.2.2** For other product forms the ruling section shall be agreed at the time of enquiry and order.



Example: For a rectangular bar with a section of 40 mm × 60 mm, the diameter of the ruling section is 50 mm.

**Figure A.1: Diameter of the ruling section for square and rectangular sections for quenching in oil or water**

## **Annex B (normative)**

### **Supplementary or special requirements**

NOTE: One or more of the following supplementary or special requirements may be agreed upon at the time of enquiry and order. The details of these requirements may be agreed upon between the manufacturer and the purchaser at the time of enquiry and order if necessary.

#### **B.1 Mechanical properties of reference test piece in the quenched and tempered condition (direct-hardening steels only)**

For deliveries in a condition other than quenched and tempered the requirements for the mechanical properties in the quenched and tempered condition shall be verified on a reference test piece.

In the case of bars and rods, the quenched and tempered sample bar shall, unless otherwise agreed, have the cross section of the product. In all other cases the dimensions and the preparation of the sample bar shall be agreed at the time of enquiry and order, where appropriate, taking into consideration the method for determining the ruling section given in annex A. The sample bars shall be quenched and tempered in accordance with the conditions given in table 7 or as agreed at the time of enquiry and order. The details of the heat treatment shall be given in the document. The test pieces shall, unless otherwise agreed, be taken in accordance with EN ISO 377.

#### **B.2 Fine grain steels**

Unless otherwise agreed, the steel when tested in accordance with one of the methods described in EURONORM 103 shall show an austenitic grain size of 5 to 8. The grain structure shall be considered satisfactory if 70% of the area is within the specified size limits.

#### **B.3 Non-destructive testing**

The products shall be non-destructively tested in accordance with a method to be agreed upon at the time of enquiry and order and to acceptance criteria also to be agreed upon at the time of enquiry and order.

#### **B.4 Product analysis**

One product analysis shall be carried out per cast for the determination of elements for which values are specified for the cast analysis (see table 1) of the steel grade concerned.

Sampling shall be carried out as specified in ISO 14284. In cases of dispute, the method used shall be agreed if possible with reference to the corresponding European Standards or EURONORMS.

#### **B.5 Special marking**

The product shall be marked in a way specially agreed at the time of enquiry and order.

## **Annex C (informative)**

### **Bibliography**

European Standards for similar steel grades as in table 1 which are intended for other product forms, treatment conditions or special applications are:

EN 10083-1	Quenched and tempered steels - Part 1: Technical delivery conditions for special steels
EN 10083-2	Quenched and tempered steels - Part 2: Technical delivery conditions for unalloyed quality steels
EN 10083-3	Quenched and tempered steels - Part 3: Technical delivery conditions for boron steels
EN 10084	Case-hardening steels - Technical delivery conditions
prEN 10277-1	Bright steel products - Technical delivery conditions - Part 1: General
prEN 10277-3	Bright steel products - Technical delivery conditions - Part 3: Free-cutting steels

## **Annex D (informative)**

### **Dimensional standards applicable to products complying with this European Standard**

#### **For hot rolled rod:**

- EURONORM 17 Rod in general purpose non-alloy steel for cold drawing; dimensions and tolerances
- EURONORM 108 Round steel rod for cold-stamped bolts and nuts; dimensions and tolerances

#### **For hot rolled bars:**

- EURONORM 58 Hot rolled flats for general purposes
- EURONORM 59 Hot rolled square bars for general purposes
- EURONORM 60 Hot rolled round bars for general purposes
- EURONORM 61 Hot rolled steel hexagons
- EURONORM 65 Hot rolled round steel bars for screws and rivets