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Steels for cold heading and cold extruding

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National foreword

This British Standard is the UK implementation of ISO 4954:2021.

The UK participation in its preparation was entrusted to Technical Committee ISE/105, Steels for Heat Treatment, Alloy Steels, Free-Cutting Steels and Stainless Steels.

A list of organizations represented on this committee can be obtained on request to its secretary.

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Aciers pour transformation à froid et extrusion à froid

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Contents

Page

Foreword ... **v**

1 Scope ... **1**

2 Normative references ... **1**

3 Terms and definitions ... **2**

4 Classification and designation ... **3**
4.1 Classification ... 3
4.2 Designation ... 3

5 Information to be supplied by the purchaser ... **3**
5.1 Mandatory information ... 3
5.2 Options and/or supplementary or special requirements ... 4
5.3 Ordering example ... 5

6 Manufacturing process ... **5**
6.1 General ... 5
6.2 Deoxidation ... 5
6.3 Heat-treatment condition and surface condition at delivery ... 5
6.3.1 Heat-treatment condition ... 5
6.3.2 Particular surface conditions ... 5
6.4 Traceability of the cast ... 6
6.5 Statistical evaluation ... 6

7 Requirements ... **6**
7.1 Chemical composition, mechanical properties and hardenability ... 6
7.1.1 General ... 6
7.1.2 Chemical composition ... 6
7.1.3 Mechanical properties ... 8
7.1.4 Hardenability (only applicable to steel grades of Annexes B and C) ... 8
7.2 Grain size ... 9
7.3 Carbide spheroidization (only applicable for steels of Annexes A, B and C) ... 9
7.4 Non-metallic inclusions ... 9
7.4.1 Microscopic inclusions (only applicable for steels of Annexes B and C) ... 9
7.4.2 Macroscopic inclusions ... 9
7.5 Internal soundness ... 9
7.6 Aptitude to cold forming ... 9
7.7 Surface quality ... 10
7.7.1 General ... 10
7.7.2 Wire rod (only applicable for steels of Annexes A, B and C) ... 10
7.7.3 Bars (only applicable for steels of Annexes A, B and C) ... 10
7.7.4 Wire rod and bars for stainless steels (only applicable for steels of Annex D) ... 10
7.7.5 Bright products ... 10
7.7.6 Removal of surface defects ... 10
7.7.7 Non-destructive testing of the surface ... 10
7.8 Decarburization (only applicable for steels of Annexes B and C) ... 10
7.9 Corrosion resistance of stainless steels ... 11
7.10 Shape, dimensions and tolerances ... 11

8 Inspection ... **11**
8.1 Testing procedures and types of documents ... 11
8.2 Summary of specific inspection and frequency of testing ... 12

9 Preparation of samples and test pieces ... **13**
9.1 Selection and preparation of samples for product analysis ... 13
9.2 Selection and preparation of samples and test pieces for the mechanical test ... 13

10 Test methods ... **14**
10.1 Chemical analysis ... 14

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AVA Documents
Document Sharing Hub

Full document details: BS ISO 4954:2021

10.2 Mechanical tests ... 14
10.3 Hardenability and core hardness tests ... 14
10.3.1 Verification of hardenability ... 14
10.3.2 Verification of core hardness ... 14
10.4 Aptitude to cold forming ... 14
10.4.1 Upsetting test for non-alloy and alloy steels of Annexes A, B and C ... 14
10.4.2 Upsetting test for stainless steels of Annex D ... 15
10.5 Non-destructive testing ... 15
10.6 Visual and dimensional test ... 15
10.7 Retests ... 15

11 Surface treatment, marking and packaging ... 15
11.1 Surface treatment and temporary corrosion protection ... 15
11.2 Marking ... 15
11.3 Packaging ... 16

Annex A (normative) **Specific requirements for cold heading and cold extruding steels not intended for heat treatment after cold working ... 17**

Annex B (normative) **Specific requirements for cold heading and cold extruding case-hardening steels ... 21**

Annex C (normative) **Specific requirements for cold heading and cold extruding steels for quenching and tempering ... 33**

Annex D (normative) **Specific requirements for cold heading and cold extruding stainless steels 51**

Annex E (normative) **Supplementary or special requirements ... 59**

Annex F (informative) **Designation of steels given in Annexes A, B, C and D and the comparable grades covered in various designation systems ... 63**

Bibliography ... 67

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Documents
Document Sharing Hub
Full document details: BS ISO 4954:2021

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 4, *Heat treatable and alloy steels*.

This fourth edition cancels and replaces the third edition (ISO 4954:2018), of which it constitutes a minor revision. The changes compared to the previous edition are as follows:

— the wording in 7.8, first paragraph was corrected to "free from complete decarburization";

— in Clause E.3, end of last paragraph, a reference was added as an example: "e. g. ISO 23825";

— editorial corrections.

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Steels for cold heading and cold extruding

1 Scope

This document specifies requirements for non-alloy and alloy steels that are intended for cold heading or cold extruding and are delivered as wire rods, wire or bars. It also contains specific requirements for:

— steels not intended for heat treatment, with diameters from 2 mm to 100 mm (see Annex A);

— case-hardening steels with diameters from 2 mm to 100 mm (see Annex B);

— steels for quenching and tempering, including boron alloyed steels (see Table C.3), with diameters from 2 mm to 100 mm (see Annex C);

— stainless steels with diameters of 0,8 mm up to 50 mm for austenitic steels, up to 25 mm for ferritic steels and up to 100 mm for martensitic steels (see Annex D).

This document (except Annex A) is applicable to the properties of cold-headed or cold-extruded parts which have been subjected to a subsequent heat treatment. As the properties of the parts in the cold-headed or cold-extruded, and subsequently not-heat-treated condition, are largely dependent on the applied cold-heading or cold-extruding conditions, these are, if necessary, subject to agreement between the purchaser and the manufacturer of the parts.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 377, *Steel and steel products — Location and preparation of samples and test pieces for mechanical testing*

ISO 404, *Steel and steel products — General technical delivery requirements*

ISO 642, *Steel — Hardenability test by end quenching (Jominy test)*

ISO 643, *Steels — Micrographic determination of the apparent grain size*

ISO 683-1, *Heat-treatable steels, alloy steels and free-cutting steels — Part 1: Non-alloy steels for quenching and tempering*·

ISO 683-2, *Heat-treatable steels, alloy steels and free-cutting steels — Part 2: Alloy steels for quenching and tempering*

ISO 683-3, *Heat-treatable steels, alloy steels and free-cutting steels — Part 3: Case-hardening steels*

ISO 683-18:2014, *Heat-treatable steels, alloy steels and free-cutting steels — Part 18: Bright steel products*

ISO 1035-1, *Hot-rolled steel bars — Part 1: Dimensions of round bars*

ISO 1035-2, *Hot-rolled steel bars — Part 2: Dimensions of square bars*

ISO 1035-3, *Hot-rolled steel bars — Part 3: Dimensions of flat bars*

ISO 1035-4, *Hot-rolled steel bars — Part 4: Tolerances*

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ISO 3651-2, *Determination of resistance to intergranular corrosion of stainless steels — Part 2: Ferritic,austenitic and ferritic-austenitic (duplex) stainless steels — Corrosion test in media containing sulfuric acid*

ISO 3887, *Steels — Determination of the depth of decarburization*

ISO 4885, *Ferrous materials — Heat treatments — Vocabulary*

ISO 4948-1, *Steels — Classification — Part 1: Classification of steels into unalloyed and alloy steels based on chemical composition*

ISO 4948-2, *Steels — Classification — Part 2: Classification of unalloyed and alloy steels according to main quality classes and main property or application characteristics*

ISO/TS 4949, *Steel names based on letter symbols*

ISO 4967:2013, *Steel — Determination of content of non-metallic inclusions — Micrographic method using standard diagrams*

ISO 6508-1, *Metallic materials — Rockwell hardness test — Part 1: Test method*

ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature*

ISO 6929, *Steel products — Vocabulary*

ISO 9443, *Surface quality classes for hot-rolled bars and wire rod*

ISO 9934-1, *Non-destructive testing — Magnetic particle testing — Part 1: General principles*

ISO 10474, *Steel and steel products — Inspection documents*

ISO 14284, *Steel and iron — Sampling and preparation of samples for the determination of chemical composition*

ISO 15549, *Non-destructive testing — Eddy current testing — General principles*

ISO 16124, *Steel wire rod — Dimensions and tolerances*

ISO 16143-2, *Stainless steels for general purposes — Part 2: Corrosion-resistant semi-finished products, bars, rods and sections*

ISO 22034-2, *Steel wire and wire products — Part 2: Tolerances on wire dimensions*

EN 10204, *Metallic products — Types of inspection documents*

JIS G 0415, *Steel and steel products —Inspection documents*

JIS G 0555:2015, *Microscopic testing method for the non-metallic inclusions in steel*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 377, ISO 683-1, ISO 683-2, ISO 683-3, ISO 683-18, ISO 4885, ISO 4948-1, ISO 4948-2, ISO 6929, ISO 14284, ISO 16143-2 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at http://www.electropedia.org/

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3.1
bright steel product
drawn or peeled/turned bar with smoother surface quality and better dimensional accuracy in comparison with a hot-rolled bar

3.2
drawn product
product of various cross-sectional shapes obtained, after descaling, by cold drawing of hot-rolled bars or wire rod, on a drawing bench (cold deformation without removing material)

Note 1 to entry: This operation gives the product special features with respect to shape, dimensional accuracy and surface finish. Products in lengths are delivered straightened, products of small cross-section may also be supplied in coils.

3.3
peeled/turned product
steel bar of circular cross-section having the same features of *drawn products* (3.2) concerning shape, dimensional accuracy and bright surface finish but without work hardening

Note 1 to entry: They are produced by peeling on a peeling machine usually followed by straightening and by polishing. The removal of metal by peeling is carried out in such a way that the bright product is generally free from surface defects and decarburization coming from the hot-rolling process.

4 Classification and designation

4.1 Classification

The classification of the relevant steel grades shall be in accordance with ISO 4948-1 and ISO 4948-2.

All steel grades mentioned in this document are special steels in accordance with ISO 4948-2.

The steels not intended for heat treatment after cold forming (see Annex A) are non-alloy steels.

The case hardening steel grades (see Annex B) are alloy steels, except steel grades C10E2C to C20E2C.

The steel grades for quenching and tempering (see Annex C) are alloy steel grades, except steel grades C35EC to C45RC.

The steel stainless steel grades (see Annex D) are classified according to their microstructures.

4.2 Designation

For the steel grades covered by this document, the steel names as given in the relevant tables shall be allocated in accordance with ISO/TS 4949.

Annex F provides a list of steels given in Annexes A, B, C and D and the comparable grades covered in various designation systems.

5 Information to be supplied by the purchaser

5.1 Mandatory information

The manufacturer shall obtain the following information from the purchaser at the time of enquiry and order:

a) the quantity to be delivered (mass, length);

b) the product form (round bar, wire rod, wire);

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c) the nominal diameter and the tolerances on dimensions and shape of the product with reference to the relevant International Standard;

d) for bars the length and for wire rod and wire the dimensions, i.e. inner diameter and mass of the coils;

e) reference to this document, i.e. ISO 4954;

f) the designation of the steel grade given in Tables A.2, B.2, C.2, C.3 and D.2;

g) if applicable, the symbol for the required heat-treatment condition, see Tables A.3, B.3 to B.7, C.4 to C.10 and D.3 to D.6;

h) standard designation for a test report 2.2 or, if required, any other type of inspection document in accordance with ISO 10474.

5.2 Options and/or supplementary or special requirements

A number of options are specified in this document and listed below. If the purchaser does not indicate a wish to implement any of these options, the products will be supplied in accordance with the basic specifications of this document (see 5.1).

a) Any requirement for the hardenability (+H, +HH, +HL) of case hardening steels of Annex B and of steels for quenching and tempering of Annex C and for the core hardening (+CH) of steels for quenching and tempering of Annex C, see 7.1.4.

b) Verification of hardenability and, if agreed, information about the calculation of the hardenability for the case hardening steels of Annex B and for the steels for quenching and tempering of Annex C, see 10.3.1.

c) If another surface condition than hot-rolled or a special surface quality is required, for the surface condition, see Table 1, and for the surface quality of E for bars and D for wire rod, see 7.7.2 and 7.7.3.

d) Any requirement relating to the removal of surface defects, see 7.7.6.

e) Any requirement for the verification of the surface quality, see 7.7.5.

f) Any requirement for a product analysis, see 7.1.2.2.

g) Any requirement for the verification of the fine grain structure, see E.2, of case hardening steels of Annex B and of steels for quenching and tempering of Annex C.

h) Carbide spheroidization, see 7.3, and any requirement for the verification of the carbide spheroidization, see E.3.

i) Any requirement for the verification of the non-metallic inclusions of case hardening steels of Annex B and of steels for quenching and tempering of Annex C, see 7.4 and E.4.

j) Internal soundness and any requirements for non-destructive testing, see 7.5 and 10.5.

k) Verification of aptitude to cold forming, see 7.6 and 10.4.

l) Maximum depth of surface discontinuities for stainless steels, see 7.7.4 and E.5.

m) Any requirement concerning non-destructive testing of the surface, see 7.7.7 and 10.5.

n) Depth of decarburization, see 7.8, and any requirements for testing the depth of decarburization, see E.6.

o) Corrosion resistance of stainless steel products and any requirements for resistance to intergranular corrosion, see E.7.

p) Any requirement concerning surface treatment and temporary corrosion protection, see 11.1.

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q) Any special requirements concerning special or additional marking, see 11.2.

r) Any special requirements concerning packaging, see 11.3.

s) Statistical evaluation, see 6.5.

5.3 Ordering example

EXAMPLE 50 t round bars with a nominal diameter of 40 mm and a nominal length of 6 000 mm with diameter tolerance according to class S and with length tolerance according to class L2 of ISO 1035-4 made of steel grade ISO 4954, 42CrMo4 in the heat-treatment condition +AC+PE (see Table C.5), with hardenability requirement +H (see Table C.7) and product analysis with an inspection certificate 3.1 in accordance with ISO 10474.

50 t round bars ISO 1035-4 – 40,0S × 6 000L2

ISO 4954, 42CrMo4+AC+PE+H – product analysis

ISO 10474 – 3.1

6 Manufacturing process

6.1 General

The manufacturing process of the steel and of the products is, with the restrictions given by the requirements in 6.2 to 6.4, left to the discretion of the manufacturer.

6.2 Deoxidation

All steels shall be deoxidized. The steels not intended for heat treatment (see Annex A) are aluminium or silicon killed. By agreement, aluminium may be replaced by another suitable element having a similar effect.

6.3 Heat-treatment condition and surface condition at delivery

6.3.1 Heat-treatment condition

Treatment and heat-treatment condition shall conform to one of the conditions indicated in Tables A.1, B.1, C.1 and D.1.

Bright steel products in cold drawn or peeled/turned condition are coated with a light film of grease from processing. For bright steel products in a finally heat treated condition, the manufacturer chooses the rust protection after heat treatment.

The usual light application of ordinary grease or oil does not afford positive protection against rusting, particularly in the presence of condensation water. Any surface treatment that can facilitate subsequent cold heading and cold extrusion or partially delay any formation of rust shall, if required, be agreed at the time of enquiry and order, see 11.1.

6.3.2 Particular surface conditions

If so agreed at the time of enquiry and order, the products shall be delivered in one of the particular surface conditions given in Table 1.

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Table 1 — Surface condition at delivery

Surface condition at delivery		Symbol	Bar	Wire rod	Wire
Unless otherwise agreed	as-rolled	none or +AR	x	x	—
Particular surface conditions supplied by agreement	cold drawn	+C	x	—	x
	skin passed	+LC	x	—	x
	peeled	+PE	x	x	x

6.4 Traceability of the cast

Each product shall be traceable to the cast, see 11.2.

6.5 Statistical evaluation

Suppliers are responsible, using the means they think fit, for inspecting their product in accordance with various quality criteria specified. In view of the practical difficulties in inspecting a coil of wire rod along its entire length, it cannot be proved that no value greater than the specified limits is to be found in the coil as a whole. Statistical evaluation of performances applicable to all coils may be agreed between the purchaser and the manufacturer at the time of ordering.

7 Requirements

7.1 Chemical composition, mechanical properties and hardenability

7.1.1 General

Wire rod, bars and wire shall be supplied in one of the delivery conditions as indicated in Tables A.1, B.1, C.1 and D.1 as agreed at the time of enquiry and order. These tables show the combinations of usual heat-treatment conditions at delivery, product forms and applicable requirements.

In addition to this document, the general technical delivery requirements of ISO 404 are applicable.

7.1.2 Chemical composition

7.1.2.1 The chemical composition determined by cast analysis shall conform to the values in Tables A.2, B.2, C.2, C.3 and D.2.

In cases where steels for case hardening or for quenching and tempering are ordered with hardenability requirements in accordance with Tables B.6, B.7, C.7, C.8 and C.9, a deviation of the cast analysis with respect to the values indicated in Tables B.2, C.2 and C.3 is admissible, taking into account the prescriptions given in footnote b) of those tables. In any case, however, the deviations in the product analysis in relation to the specified limits of cast analysis shall not exceed the values indicated in Table 2.

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7.1.2.2 Permissible deviations between the limiting values for cast analysis and the values for product analysis are given in Tables 2 and 3. The product analysis shall be carried out when specified at the time of the enquiry and order.

Table 2 — Permissible deviations between product analysis and the limiting values of the cast analysis specified in Tables A.2, B.2, C.2 and C.3

Elements	Limiting values of the cast (heat) analysis % mass fraction	Permissible deviation for the product analysis % mass fraction[a]
For non-alloy and alloy steel grades of Annexes A, B and C		
C	≤0,50	±0,02
Si	≤1,00	±0,03
Mn	≤1,00	±0,04
	> 1,00 ≤ 1,45	±0,06
P	≤0,025	+0,005
S	≤0,040	+0,005[b]
Cr	≤1,70	±0,05
Ni	≤1,00	±0,03
	> 1,00 ≤ 2,00	±0,05
Mo	≤0,30	±0,03
	> 0,30 ≤ 0,50	±0,04
Al	≤0,060	±0,005
B	≤0,005 0	±0,000 3
Cu	≤0,25	+0,03

[a] ± means that in one heat the deviation of the product analysis for a given element may occur over the upper value or under the lower value of the specified range of the cast analysis, but not both at the same time.

[b] For steels with a specified sulfur range (0,020 % to 0,035 or 0,040 %) according to cast analysis, the permissible deviation is ±0,005 %.

Table 3 — Permissible deviations between product analysis and the limiting values of the cast analysis specified in Table D.2

Elements	Limiting values of the cast (heat) analysis % mass fraction	Permissible deviation for the product analysis % mass fraction[a]
For stainless steel grades of Annex D		
C	≤0,030	+0,005
	> 0,030 ≤ 0,15	±0,01
Si	≤1,00	+0,05
	> 1,00 ≤ 2,00	±0,10
Mn	≤1,00	+0,03
	> 1,00 ≤ 2,00	±0,04
P	≤0,045	+0,005
S	≤0,015	+0,003
	> 0,015 ≤ 0,030	±0,005

[a] ± means that in one heat the deviation of the product analysis for a given element may occur over the upper value or under the lower value of the specified range of the cast analysis, but not both at the same time.

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Table 3 *(continued)*

Elements	Limiting values of the cast (heat) analysis % mass fraction	Permissible deviation for the product analysis % mass fraction[a]
Cr	≥ 11,5 < 15,0	±0,15
	≥ 15,0 ≤ 20,0	±0,20
	> 20,0 ≤ 23,0	±0,25
Ni	≤1,00	+0,03
	> 1,00 ≤ 5,0	±0,07
	> 5,0 ≤ 10,0	±0,10
	> 10,0 ≤ 20,0	±0,15
	> 20,0 ≤ 27,0	±0,20
Mo	<1,75	±0,05
	≥ 1,75 ≤ 3,5	±0,10
N	≤0,22	±0,02
Al	≤0,35	+0,10
B	> 0,001 ≤ 0,010	±0,000 5
Cu	≤1,00	+0,04
	> 1,00 ≤ 4,0	±0,10
Ti	≤1,00	±0,05
	> 1,00 ≤ 2,35	±0,07
V	≤0,50	±0,03

[a] ± means that in one heat the deviation of the product analysis for a given element may occur over the upper value or under the lower value of the specified range of the cast analysis, but not both at the same time.

7.1.3 Mechanical properties

The mechanical properties of the products, to be determined by the tensile test (and, as an option, either by end quench test hardenability requirements or by core hardening requirements for steels of Annexes B and C) and by consideration of the delivery conditions of Tables A.1, B.1, C.1 and D.1 and of the surface condition of Table 1, shall conform to Tables A.3, B.3, B.4, B.5, C.4, C.5, C.6, D.3, D.4, D.5 and D.6.

7.1.4 Hardenability (only applicable to steel grades of Annexes B and C)

7.1.4.1 Where the steel is not ordered with hardenability or core hardening requirements, the requirements for mechanical properties apply as given in Tables B.3, B.4, B.5, C.4, C.5 and C.6. In this case, the hardenability values given in Tables B.6, B.7, C.7, C.8 and C.9 and the core hardness values in Table C.10 are for guidance purposes only.

7.1.4.2 In the case of products ordered with standard requirements regarding hardenability, that is, when the steel names or numbers are supplemented by the symbol "+H", the hardness values obtained in the end quench test (Jominy test) shall conform to the values given in Tables B.6, C.7 and C.8.

In the case of products ordered with restricted requirements regarding the scatter bands of the hardness values obtained by the Jominy test, that is, when the steel name or number is supplemented by

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the symbols "+HH" or "+HL", the above hardness values shall conform to the values given in Tables B.7 and C.9.

NOTE 1 The symbol "+HH" denotes that the upper limit of the scatter band coincides with the upper limit for the corresponding steel "+H".

NOTE 2 The symbol "+HL" denotes that the lower limit of the scatter band coincides with the lower limit for the corresponding steel "+H".

NOTE 3 For hardenability by calculation and for verification of hardenability, see 10.3.

The austenizing temperatures for the Jominy test are given in Tables B.6, B.7, C.7, C.8 and C.9.

7.1.4.3 In the case of steels for quenching and tempering (see Annex C) ordered with core hardening requirements, that is, when the steel names or number are supplemented by the symbol "+CH", the minimum core hardness shall conform to the values given in Table C.10.

At least 90 % of the structure shall be martensite.

7.2 Grain size

Steels of Annexes B and C (except the non-alloy grades C35EC to C45RC) shall have a fine grain structure with an austenite grain size number of 5 or finer. For verification, see E.2.

For steels of Annex A, the non-alloy grades C35EC to C45RC of Annex C and the steels of Annex D, unless otherwise agreed, the austenitic grain size is left to the manufacturer's discretion.

7.3 Carbide spheroidization (only applicable for steels of Annexes A, B and C)

If carbide spheroidization is requested, reference shall be made to E.3.

7.4 Non-metallic inclusions

7.4.1 Microscopic inclusions (only applicable for steels of Annexes B and C)

The special steels shall have a certain degree of cleanness. However, verification of the non-metallic inclusion content requires a special agreement. For such an agreement, see E.4.

7.4.2 Macroscopic inclusions

This requirement is applicable to the verification of the macroscopic inclusions in special steels. If verification is agreed, the method and acceptance limits shall be agreed at the time of enquiry and order.

7.5 Internal soundness

Wire rod, bars and wire shall be free from internal defects, which can cause an adverse effect on products during cold heading or cold extrusion or during heat treatment.

Where appropriate, non-destructive-testing relating to the internal soundness of the products shall be agreed at the time of enquiry and order, see 10.5.

7.6 Aptitude to cold forming

A test for verification of the aptitude of products to cold forming may be carried out if agreed at the time of enquiry and order with reference to 10.4

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7.7 Surface quality

7.7.1 General

All products shall have a smooth surface finish appropriate to the manufacturing process applied. For hot-rolled products, minor surface imperfections, which can occur also under normal manufacturing conditions, such as prints originating from rolled-in scale, shall not be regarded as defects. 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 on surface quality are made.

7.7.2 Wire rod (only applicable for steels of Annexes A, B and C)

Wire rod shall meet surface quality requirements in accordance with ISO 9443 quality class D. For certain higher applications, quality class E in accordance with ISO 9443 is appropriate and may be agreed at the time of enquiry and order.

7.7.3 Bars (only applicable for steels of Annexes A, B and C)

Bars shall meet surface quality requirements in accordance with ISO 9443 quality class D. Conformity to surface quality in accordance with ISO 9443 quality class E may be agreed at the time of enquiry and order. When the diameter of the product is greater than the maximum diameter specified in ISO 9443 for the surface quality class concerned, the maximum permissible depth of surface defects on the product shall not be greater than that specified for this maximum diameter.

7.7.4 Wire rod and bars for stainless steels (only applicable for steels of Annex D)

Wire rod is normally supplied in the pickled condition. Mechanical descaling (sandblasting) can also be used, in which case a subsequent treatment in a pickling solution shall be carried out unless otherwise agreed. Particular processes such as peeling or shaving may also be applied, subject to specific agreement at the time of enquiry and order. For an agreement concerning the maximum depth of surface discontinuities, see E.5.

7.7.5 Bright products

For wire, the permissible depth of surface discontinuities shall be in proportion to the reduction of the diameter during cold drawing. Depending on the starting material for cold drawn products, the same requirements apply as specified in 7.7.2 and 7.7.4.

Cold drawn bars shall be delivered with the surface quality class 1 and peeled/turned bars shall be delivered with surface quality class 3 in accordance with ISO 683-18:2014, Table 4.

7.7.6 Removal of surface defects

Removal of surface defects and imperfections is only permitted after approval from the purchaser.

7.7.7 Non-destructive testing of the surface

A non-destructive testing of the surface with magnetic particle inspection can be agreed at the time of enquiry and order, see 10.5.

7.8 Decarburization (only applicable for steels of Annexes B and C)

Bars and wire rod with as-rolled surface of steels specified in Tables B.2, C.2 and C.3 and wire, independent of the heat treatment condition, shall be free from complete decarburization.

For bars and wire rod with as-rolled surface and wire partial decarburization (ferrite-pearlite), E is admissible provided that it does not exceed the following limits. For diameters $d \leq 10$ mm, the maximum

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permissible depth of decarburization is E = 0,07 mm. For diameters greater than 10 mm, the maximum permissible depth of decarburization is E = 0,007 d.

For cold drawn products with diameters greater than 5 mm, the limits of partial decarburization shall be the same as those for hot-rolled products. For cold drawn products with diameter less than 5 mm, the permissible depth of partial decarburization shall be reduced in function of the reduction of the diameter during the cold drawing.

Peeled/turned bars, wire rod and wire shall be free of decarburization.

If, in special cases, the purchaser requests other values (e.g. bars annealed in an atmosphere that is not controlled the depth of decarburization) for partial decarburization, those values shall be agreed at the time of enquiry and order with reference to E.6. Testing for decarburization should also be done according to E.6.

7.9 Corrosion resistance of stainless steels

Tests for the determination of corrosion resistance of stainless steels of Annex D may be agreed at the time of enquiry and order with reference to E.7.

7.10 Shape, dimensions and tolerances

The shape, dimensions and tolerances of the products shall conform to the requirements agreed at the time of enquiry and order. The agreements shall be based on corresponding International Standards: ISO 683-18, ISO 1035-1, ISO 1035-2, ISO 1035-3, ISO 1035-4, ISO 16124 and ISO 22034-2, or on other suitable regional standards.

8 Inspection

8.1 Testing procedures and types of documents

8.1.1 Products conforming to this document shall be ordered and delivered with one of the inspection documents as specified in ISO 10474 or another comparable national standard, such as EN 10204 or JIS G 0415. 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 2.2 shall be issued.

8.1.2 If, in accordance with the agreements made at the time of enquiry and order, a test report 2.2 is to be provided, this shall cover the following information:

a) confirmation that the material conforms to the requirements of the order;

b) results of the cast analysis for all elements specified in Tables A.2, B.2, C.2, C.3 and D.2 for the steel grade concerned.

8.1.3 If, in accordance with the agreements in the order, an inspection certificate 3.1 or 3.2, is to be provided, the specific inspections and tests described in 8.2 and Clause 10 shall be carried out and the results shall be confirmed in the inspection certificate.

In addition, the inspection certificate shall cover:

a) confirmation that the material conforms to the requirements of the order;

b) results of the cast analysis for all elements specified in in Tables A.2, B.2, C.2, C.3 and D.2 for the steel grade concerned;

c) results of all mandatory and optional inspections and tests (see Table 4);

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

8.2 Summary of specific inspection and frequency of testing

The requirements for specific inspection for steels for cold heading and cold extrusion are given in Table 4.

Table 4 — Specific inspection and frequency of inspection of steels for cold heading and cold extrusion

Inspection requirements				Frequency of testing			Applicable for steels according to Annex[d]			
Type of test			Subclause reference	Test unit[a]	Number of samples per test unit	Number of test pieces per sample	A	B	C	D
Mandatory tests	1	Cast analysis	7.1.2 and 10.1	C	the cast analysis is given by the manufacturer		m	m	m	m
	2	Tensile test	7.1.3 and 10.2	C + D + T	1 for each 15 tons with a maximum of 3	1	m	m	m	m
	3	Surface condition and dimensions	Clause 7 and 10.4	C + D + T	at the manufacturer's discretion	—	m	m	m	m
Optional tests	4	Verification of hardenability or of core hardness	7.1.4 and 10.3	C	1 per cast	1	—	o	o	—
	5	Product analysis	7.1.2, 9.1, 10.1	C	1 per cast	1	o	o	o	o
	6	Fine grain structure	7.2 and E.3	C	1 per cast	1	—	o	o	—
	7	Carbide spheroidization	7.3 and E.4	C + D + T	1 for each 15 tons with a maximum of 3	1	o	o	o	—
	8	Non-metallic inclusions	7.4 and E.5	C[c]	[b]	[b]	—	o	o	—
	9	NDT-testing	7.5, 7.7.7 and 10.5	C[c]	[b]	[b]	o	o	o	o
	10	Aptitude of cold forming	7.6 and 10.4	C[c]	[b]	[b]	—	—	—	o
	11	Decarburization	7.8 and E.6	C + D + T	1 for each 15 tons with a maximum of 3	1	—	o	o	—
	12	Resistance to intergranular corrosion	7.9 and E.7	C[c]	[b]	[b]	—	—	—	o

[a] The tests shall be carried out separately for each cast as indicated by "C", — for each dimension as indicated by "D" — and for each treatment batch as indicated by "T". Wire rod, bars and wire for which the ratio of nominal section does not exceed 3:1 may be grouped in a single test unit. In cases where heat treatment is performed as a continuous process the symbol "T" denotes that the tests are to be carried out for each 25 ton or fraction thereof.

[b] Shall be agreed upon at the time of enquiry and order.

[c] The test unit may be agreed at the time of enquiry and order.

[d] m = mandatory (to be carried out in every case), o = optional, (to be carried out if agreed at the time of enquiry and order), – = is not carried out.

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9 Preparation of samples and test pieces

9.1 Selection and preparation of samples for product analysis

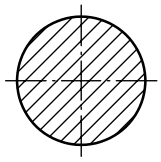
Samples for product analysis shall be taken from the test pieces or samples for mechanical testing or from the same location as the mechanical test samples in accordance with ISO 14284.

9.2 Selection and preparation of samples and test pieces for the mechanical test

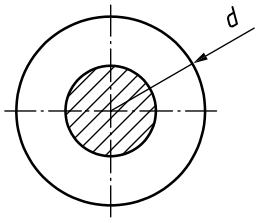
Samples and test pieces shall be taken in accordance with the general requirements of ISO 377. The test piece shall be prepared in accordance with the prescriptions of ISO 6892-1.

— For products with d > 25 mm**:** The test piece for the tensile test shall be taken to conform to the indication given in Figure 1 c).

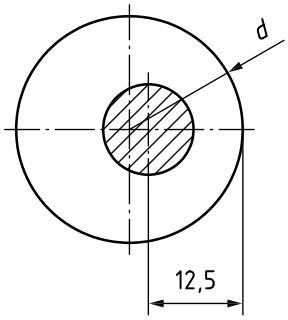
— For products with d ≤ 25 mm**:** The test piece for the tensile test shall be submitted to test without preliminary machining, see Figure 1 a). If test equipment does not allow this, the test piece may be prepared by machining, as shown in Figure 1 b).



a) Full section test piece



b) Round test piece where d ≤ 25 mm



c) Round test piece where d > 25 mm

Figure 1 — Location of test piece for the tensile test

The test piece for the Jominy test (hardenability test) shall be obtained by machining from the samples with d ≤ 40 mm. Depending on the agreements made at the time of ordering, the samples shall be taken from the product concerned, or the billet or bloom originating from the same cast. In the absence of such agreements, the origin of the sample is left to the manufacturer's discretion. The sample shall be obtained by hot rolling or hot forging.

The test piece for evaluation of the core hardening test shall have, as far as possible, the maximum diameter indicated in Table C.10. Test bars with diameters larger than those given in Table C.10 are to be rolled or forged to the maximum diameters of Table C.10. Sampling and sample preparation is left to the manufacturer's discretion, taking into account the indications concerning the test piece for the End Quench test (Jominy test), see ISO 642. The length of the test piece shall be at least four times its diameter.

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10 Test methods

10.1 Chemical analysis

The choice of a suitable physical or chemical analytical method for the analysis shall be at the discretion of the manufacturer. In cases of dispute, the method for product analysis used shall be agreed taking into account the relevant existing International Standards.

NOTE The list of available International Standards on chemical analysis is given in ISO/TR 9769.

10.2 Mechanical tests

The tensile test shall be carried out in accordance with ISO 6892-1.

For the specified yield strength in the tables on mechanical properties in this document, the upper yield strength, R_{eH}, shall be determined.

If a yield phenomenon is not present, the 0,2 % proof strength, $R_{p0,2}$, shall be determined.

10.3 Hardenability and core hardness tests

10.3.1 Verification of hardenability

As far as available, the manufacturer has the option to verify the hardenability by calculation. The calculation method is left to the discretion of the manufacturer. If agreed at the time of enquiry and order, the manufacturer shall give sufficient information about the calculation for the customer to confirm the result.

If a calculation formula is not available or in the case of dispute, an end quench hardenability test shall be carried out in accordance with ISO 642. The temperature for austenitizing shall conform to the relevant tables of Annexes B and C. The hardness values shall be determined in accordance with ISO 6508-1, scale C.

10.3.2 Verification of core hardness

The test piece shall be heated in a furnace with a neutral or reducing atmosphere up to the temperatures indicated in Table C.10. It shall be maintained at that temperature until complete austenitizing takes place.

It shall then be removed from the furnace and quenched immediately in a quenching oil with high cooling capacity until a full equilibrium of temperature is reached, the temperature of the quenching bath being about 50 °C and the rate of movement of the test piece being about 0,25 m/s. The test piece shall then be notched at its midpoint in a direction perpendicular to its longitudinal axis and then broken. One of the fracture surfaces shall be polished (care should be taken to prevent excessive local heating).

The Rockwell hardness at the centre of the fracture surface shall then be determined in accordance with ISO 6508-1, scale C.

10.4 Aptitude to cold forming

10.4.1 Upsetting test for non-alloy and alloy steels of Annexes A, B and C

The surfaces of the end sections of the above test pieces shall be flat and parallel to each other and their initial length (height) shall be $h = 1,5 * d$, where d is the test piece diameter. During the test, the length (height) of the test piece shall be reduced to one third of its initial value.

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Supplementary for treated condition "AC" and diameter less than 25 mm (d < 25 mm), the following may be agreed between the manufacturer and the customer. The surfaces of the end sections of the above test pieces shall be flat and parallel to each other and their initial length (height) shall be h = 2,0*d, where d is the test piece diameter. During the test, the length (height) of the test piece shall be reduced to one quarter of its initial value.

The tests shall be carried out at room temperature. The assessment and acceptance criteria shall also be agreed at time of enquiry and order.

NOTE Hot-rolled surface grooves, which result from rolling scores, on test pieces are not considered as being a cause for rejection.

10.4.2 Upsetting test for stainless steels of Annex D

A test piece with an initial length (height) equal to 1,5 d, where d is the product diameter, is submitted to axial heading by means of a press until its length is reduced to one third of the initial value.

The above test shall be carried out at an ambient temperature and shall be limited to products with a maximum diameter of 15 mm.

The criteria for the assessment of test results shall be agreed at the time of ordering, bearing in mind the end use for which the products are intended.

10.5 Non-destructive testing

Concerning the internal soundness, the products shall be non-destructively tested, preferably with an ultrasonic test and under acceptance criteria to be agreed at the time of enquiry and order.

Concerning the surface of the products, the eddy current test in accordance with ISO 15549 or the magnetic particle test in accordance with ISO 9934-1 shall be performed. The descaling of the test pieces is not requested unless otherwise agreed at the time of enquiry and order. The absence of detectable cracks on the test piece after it has been submitted to magnetic particle inspection shall be considered as evidence that the product concerned is free from surface defects.

10.6 Visual and dimensional test

A sufficient number of products shall be inspected to ensure conformity to the specification. The corresponding International Standards are ISO 683-18, ISO 1035-1, ISO 1035-2, ISO 1035-3, ISO 1035-4, ISO 16124 and ISO 22034-2.

10.7 Retests

Retests shall be as specified in ISO 404.

11 Surface treatment, marking and packaging

11.1 Surface treatment and temporary corrosion protection

Surface treatment can facilitate subsequent cold heading and cold extrusion or partially delay any formation of rust. This treatment can include, e.g. descaling, treatment with lime and/or phosphate and/or adequate protection during transport and storage, and shall be subject to an agreement at the time of enquiry and order.

11.2 Marking

The manufacturer shall mark the products or the bundles or boxes containing the products in a suitable way, so that the identification of the cast, the steel type and the origin of the delivery is possible.

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