

Delivery Conditions for quenched and tempered steel

Steel bars and forged shafts of 34CrNiMo6 for rotors with peripheral speeds < 50 m/s

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NOTE: In the event of deviating specifications regarding chemical analysis, mechanical properties or tolerances in the drawing, the latter shall take precedence!

Changes

2023-04-06:
The following changed in comparison to RN 1560-2:2021-03-12:

- a) transfer to new numbering system
- b) updated references
- c) editorially revised

Responsible division: PK	Editor M. Förste	Approval: see doc. workflow	Technical reference: C. Eschert	Page: 1 / 5
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1 Scope

This Factory Standard applies to	Material no.:	1.6582
	Material designation:	34CrNiMo6
	Delivery conditions:	steel bar / forged shaft hot formed; unmachined / pre-turned
	Use case:	rotors with peripheral speeds < 50 m/s

2 References

The following documents, cited in part or in whole, shall apply for the use of this standard. In the case of dated references, only the referenced edition applies; in the case of undated references, the latest edition of the referenced document (including all amendments) applies. The applicable version of the standards listed below shall apply to all contents not covered by this factory standard.

DIN 7527-6:1975-2	Steel Forgings; Machining Allowances and Permissible Variations for Open-die Forged Bars
DIN 50125	Testing of metallic materials - Tensile test pieces
DIN 50602:1985-09	Metallographic examination; microscopic examination of special steels using standard diagrams to assess the content of non-metallic inclusions
EN 10021	General technical delivery conditions for steel products
EN 10060	Hot rolled round steel bars - Dimensions and tolerances on shape and dimensions
EN 10204	Metallic products - Types of inspection documents
EN 10228-3	Non-destructive testing of steel forgings - Part 3: Ultrasonic testing of ferritic or martensitic steel forgings
EN 10277	Bright steel products - Technical delivery conditions
EN ISO 148-1	Metallic materials - Charpy pendulum impact test - Part 1: Test method
EN ISO 642	Steel - Hardenability test by end quenching (Jominy test)
EN ISO 643	Steels - Micrographic determination of the apparent grain size
EN ISO 683-2	Heat-treatable steels, alloy steels and free-cutting steels - Part 2: Alloy steels for quenching and tempering
EN ISO 9712	Non-destructive testing - Qualification and certification of NDT personnel
RN 72	Packaging and Preservation; Supply parts for production
RN 1550	Material samples
RN 1567	Remanent magnetism in components
RN 1936	Labelling; Raw material, parts and gearboxes

3 Chemical composition

Table 1 Chemical composition in %

	C	Si	Mn	P	S	Cr	Mo	Ni	V	Cu
min.	0,30		0,50			1,30	0,15	1,30		
max.	0,38	0,40	0,80	0,020	0,010	1,70	0,30	1,70		0,30
	Sn	Al	N	Ti	Nb	Sb	O ₂	Ca	H ₂	Al / N
min.		0,02	0,008							
max.	0,05	0,05	0,015				25 ppm		2,0 ppm	4,0

4 Physical characteristics

Table 2 Mechanical properties

(Test temperature: 20° C)

Diameter		Rm		Rp _{0,2}	A5 [%]			Z [%]			Av [J]		
[mm]		[N/mm ²]	[N/mm ²]	[N/mm ²]	longit.	tang.	transv.	longit.	tang.	transv.	longit.	tang.	transv.
over	up to	min.	max. ¹⁾	min.	min.	min.	min.	min.	min.	min.	min.	min.	min.
	40	1100	1400	900	10	8	-	45	25	-	45	31	-
40	100	1000	1300	800	11	9	7	50	25	15	45	31	-
100	160	950	1250	700	12	10	8	55	35	25	45	31	21
160	250	900	1200	650	13	11	9	55	35	25	45	31	21
250	500	850	1150	600	14	12	10	50	35	25	45	31	21
500	750	800	1100	550	15	13	11	45	30	20	45	31	21
750	1000	750	1050	500	15	13	11	45	30	20	45	31	21

¹⁾ deviating from EN ISO 683-2

a) Structure, inclusions

- grain size, standard: [EN ISO 643](#) Standard series: [Table C.1; G ≥ 5](#)
- purity degree, standard: [DIN 50602](#) method: [K; K4 ≤ 20](#)

b) Hardenability

- Standard: [EN ISO 683-2](#) scatter band: **+HH**
- testing: [EN ISO 642](#)
- end distance [mm]: 5 11 25 40
- hardness [HRC]: [53-58](#) [51-57](#) [50-57](#) [50-57](#)

c) Additional properties

- radioactivity: [≤ 0,10 Bq/g](#)

5 Manufacturing

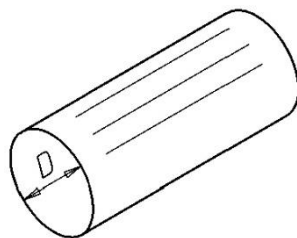
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- a) Casting method and forging ratio
- bar $\varnothing < 180$ mm: continuous or ingot casting
 - bar $\varnothing \geq 250$ mm: forged
- bar $\varnothing \geq 180$ mm: ingot casting
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- b) Forging reduction ratio (VG)
- forged: VG $\geq 5,0$
 - ingot casting, forged: VG $\geq 3,0$
- hot rolled: VG $\geq 4,0$
-
- c) Melting
- making process: E, LD, ESU (on special request)
 - post-treatment: vacuum degassing (VD) for E or LD
-
- d) Heat treatment
- treatment condition: +QT
 - treatment method: liquid quenching and tempering
-
- e) Surface condition
- defect depth: \leq machining allowance
- unmachined: crack- and scale-free
 - repair by welding: only after approval by REINTJES
- preturned (on request): Ra 6,3 (max. Rz 63)
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- f) Manufacturing tolerances
- forged: DIN 7527-6
 - rolled: EN 10060

6 Testing

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- a) Ultrasonic testing
- standard: EN 10228-3
 - scanning acc. to: Table 3, 1a, grid scanning
 - type of testing: marginal and core zone testing
 - probe specification: 4 MHz (normal and TR probe)
 - sound attenuation: ≤ 6 dB/m
 - examiner qualification: EN ISO 9712, stage 2
 - testing accuracy:
 - steel bar, pre-turned / dipping bath

	<u>diameter</u>	<u>quality class</u>
zone 1 (gearing):	$D \geq 0,3 \times dw$	4
zone 2 (power transmission):	$D < 0,3 \times dw$	4
 - steel bar, unmachined

entire diameter range:	$0 < D \leq dw$	3
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dw = bar diameter

Figure 1 Steel bar

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- b) Material identification check: to be carried out

7 Other requirements

- a) Steel and forging plant
- certified acc. to: [DIN EN ISO 9001 ff.](#)
 - approved by at least two member societies of IACS
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- b) Delivery condition
- bar length: $\leq 6,3$ m end faces: [mechanically separated](#)
 - bar weight: ≤ 10 t peeled bars (+SH): [EN 10277, Tol. h10](#)
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- c) Packaging and preservation
- [RN 72](#)
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- d) Sample material and collection
- [RN 1550](#)
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- e) Remanent magnetism
- [RN 1567](#)
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- f) Labelling
- [RN 1936](#)
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- g) Documentation (must be digitally available upon delivery)
- acceptance test certificate EN 10204 - 3.1 per melt and furnace trip or per piece or production lot with specification of primary material and forging ratio
 - copy of the acceptance test certificate 3.1 from the steel manufacturer
 - evidence of radioactivity and remanent magnetism
 - forging schedule (on special request)