

INTERNATIONAL STANDARD



**Magnetic materials –
Part 8-4: Specifications for individual materials – Cold-rolled non-oriented
electrical steel strip and sheet delivered in the fully-processed state**

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INTERNATIONAL
ELECTROTECHNICAL
COMMISSION

ICS 17.220.20; 29.030

ISBN 978-2-8322-5735-7

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CONTENTS

FOREWORD	4
INTRODUCTION	2
1 Scope	7
2 Normative references	7
3 Terms and definitions	8
4 Classification	8
5 Designation	9
6 General requirements	10
6.1 Production process	10
6.2 Form of supply	10
6.3 Delivery condition	10
6.4 Surface condition	10
6.5 Suitability for cutting	11
7 Technical requirements	11
7.1 Magnetic properties	11
7.1.1 General	11
7.1.2 Magnetic polarization	11
7.1.3 Specific total loss	15
7.1.4 Anisotropy of loss	15
7.2 Geometrical characteristics and tolerances	15
7.2.1 Thickness	15
7.2.2 Width	16
7.2.3 Length	17
7.2.4 Edge wave (wave factor)	17
7.2.5 Flatness (wave factor)	17
7.2.5 Residual curvature	18
7.2.6 Edge camber	18
7.3 Technological characteristics	18
7.3.1 Density	18
7.3.2 Stacking factor	18
7.3.3 Number of bends	19
7.3.4 Deviation from the shearing line (internal stress)	19
8 Inspection and testing	19
8.1 General	19
8.2 Selection of samples	19
8.3 Preparation of test specimens	20
8.3.1 Magnetic properties	20
8.3.2 Geometrical characteristics and tolerances	20
8.3.3 Technological characteristics	21
8.4 Test methods	21
8.4.1 General	21
8.4.2 Magnetic properties	21
8.4.3 Geometrical characteristics and tolerances	22
8.4.4 Technological characteristics	22
8.5 Retests	23

9	Marking, labelling and packaging.....	23
10	Complaints	23
11	Information to be supplied by the purchaser	23
	Annex A (informative) Non-specified magnetic properties	25
	Annex B (informative) European steel numbers.....	
	Annex B (informative) Calculation of density values Calculated density of non-oriented electrical steel	27
	Bibliography.....	28
	Table 1 – Technological properties and magnetic properties (magnetic properties are measured by using the Epstein method according to IEC 60404-2)	12
	Table 2 – Technological properties and magnetic properties measured by the Epstein method for strip and sheet of nominal thickness 0,47 mm for use at 60 Hz only (magnetic properties are measured using the Epstein method according to IEC 60404-2)	14
	Table 3 – Tolerances on nominal thickness.....	16
	Table 4 – Tolerances on nominal width	17
	Table A.1 – Non-specified magnetic properties	25

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INTERNATIONAL ELECTROTECHNICAL COMMISSION

MAGNETIC MATERIALS –

**Part 8-4: Specifications for individual materials –
Cold-rolled non-oriented electrical steel strip and sheet
delivered in the fully-processed state**

FOREWORD

- 1) The International Electrotechnical Commission (IEC) is a worldwide organization for standardization comprising all national electrotechnical committees (IEC National Committees). The object of IEC is to promote international co-operation on all questions concerning standardization in the electrical and electronic fields. To this end and in addition to other activities, IEC publishes International Standards, Technical Specifications, Technical Reports, Publicly Available Specifications (PAS) and Guides (hereafter referred to as “IEC Publication(s)”). Their preparation is entrusted to technical committees; any IEC National Committee interested in the subject dealt with may participate in this preparatory work. International, governmental and non-governmental organizations liaising with the IEC also participate in this preparation. IEC collaborates closely with the International Organization for Standardization (ISO) in accordance with conditions determined by agreement between the two organizations.
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This redline version of the official IEC Standard allows the user to identify the changes made to the previous edition IEC 60404-8-4:2013. A vertical bar appears in the margin wherever a change has been made. Additions are in green text, deletions are in strikethrough red text.

IEC 60404-8-4 has been prepared by IEC technical committee 68: Magnetic alloys and steels. It is an International Standard.

This fourth edition cancels and replaces the third edition published in 2013. This edition constitutes a technical revision.

This edition includes the following significant technical changes with respect to the previous edition:

- a) modification of terms and technical requirements concerning geometrical characteristics to be consistent with IEC 60404-9:2018;
- b) insertion of Table 3 – Tolerances on nominal thickness;
- c) change of the length of test specimen for determination of geometrical characteristics from 2 m to 1 m.

The text of this International Standard is based on the following documents:

Draft	Report on voting
68/700/CDV	68/713/RVC

Full information on the voting for its approval can be found in the report on voting indicated in the above table.

The language used for the development of this International Standard is English.

This document was drafted in accordance with ISO/IEC Directives, Part 2, and developed in accordance with ISO/IEC Directives, Part 1 and ISO/IEC Directives, IEC Supplement, available at www.iec.ch/members_experts/refdocs. The main document types developed by IEC are described in greater detail at www.iec.ch/publications.

A list of all parts in the IEC 60404 series, published under the general title *Magnetic materials*, can be found on the IEC website.

The committee has decided that the contents of this document will remain unchanged until the stability date indicated on the IEC website under webstore.iec.ch in the data related to the specific document. At this date, the document will be

- reconfirmed,
- withdrawn,
- replaced by a revised edition, or
- amended.

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INTRODUCTION

This revision of International Standard IEC 60404-8-4 has been prepared by the experts of the Working Group 1 of the IEC Technical Committee 68: Magnetic alloys and steels.

The third edition of IEC 60404-8-4 was issued in 2013. After that, other IEC 60404 standards were revised and IEC TC 68 decided in 2019 at their meeting in Düsseldorf to revise this document to maintain consistency for user's convenience. The revision is made mainly on technical amendments regarding testing and definitions of geometrical characteristics in accordance with IEC 60404-9. The length of test specimen for determination of geometrical characteristics is changed from 2 m to 1 m. The term of “flatness” is divided into “edge wave (wave factor)” and “residual curvature” and the horizontal method is introduced for verification of residual curvature. This revision also includes corrections in order to improve consistency with other standards of the IEC 60404-8 series.

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MAGNETIC MATERIALS –

Part 8-4: Specifications for individual materials – Cold-rolled non-oriented electrical steel strip and sheet delivered in the fully-processed state

1 Scope

This part of IEC 60404 defines the grades of cold-rolled non-oriented electrical steel strip and sheet in nominal thicknesses of 0,35 mm, 0,47 mm, 0,50 mm, 0,65 mm and 1,00 mm. In particular, it ~~specifies~~ gives general requirements, magnetic properties, geometric characteristics, tolerances and technological characteristics, as well as inspection procedure. The nominal thickness 0,47 mm applies to the grades for use at 60 Hz only.

~~This standard gives in Table 2 the magnetic properties of cold-rolled non-oriented electrical steel strip and sheet of nominal thickness 0,47 mm for use at 60 Hz only.~~

~~This standard applies to materials supplied in the fully annealed condition intended for the construction of magnetic circuits. It does not apply to semi-processed material.~~

~~These magnetic materials correspond to class C.21 of IEC 60404-1.~~

This document applies to cold-rolled non-oriented electrical steel strip and sheet supplied in the fully-processed state, i.e. the final annealed condition, in coils or sheets, and intended for the construction of magnetic circuits. This document does not apply to materials supplied in the semi-processed state.

NOTE The cold-rolled non-oriented electrical steel strip and sheet supplied in the semi-processed state is specified in IEC 60404-8-3.

The grades defined in this document correspond to Class C21 of IEC 60404-1.

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.

~~IEC 60050 (all parts), International Electrotechnical Vocabulary (available at <<http://www.electropedia.org>>)~~

IEC 60050-121, *International Electrotechnical Vocabulary – Part 121: Electromagnetism*

IEC 60050-221, *International Electrotechnical Vocabulary – Chapter 221: Magnetic materials and components*

IEC 60404-1, *Magnetic materials – Part 1: Classification*

IEC 60404-2, *Magnetic materials – Part 2: Methods of measurement of the magnetic properties of electrical steel strip and sheet ~~and strip~~ by means of an Epstein frame*

IEC 60404-3, *Magnetic materials – Part 3: Methods of measurement of the magnetic properties of electrical steel strip and sheet by means of a single sheet tester*

IEC 60404-9, *Magnetic materials – Part 9: Methods of determination of the geometrical characteristics of ~~magnetic~~ electrical steel strip and sheet ~~and strip~~*

IEC 60404-13, *Magnetic materials – Part 13: Methods of measurement of ~~density~~, resistivity, density and stacking factor of electrical steel strip and sheet ~~and strip~~*

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

ISO 7799, *Metallic materials – Sheet and strip 3 mm thick or less – Reverse bend test*

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

3 Terms and definitions

For the purposes of this document, the terms and definitions ~~relating to magnetic properties~~ given in IEC 60050-121, IEC 60050-221 and the following apply.

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

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

3.1

edge wave

wave factor

variations of flatness of a length of strip or a sheet taking a form of waves at the slit edge of the product

Note 1 to entry: The edge wave is characterized by the wave factor which is the relation of the height of the wave to its length, expressed as a percentage.

[SOURCE: IEC 60404-9:2018, 3.1]

3.2

residual curvature

variations of flatness of a length of strip or a sheet taking a permanent curvature in the direction of rolling of the product

[SOURCE: IEC 60404-9:2018, 3.2]

3.3

edge camber

greatest distance between a longitudinal edge of a length of strip or a sheet and the line joining the two extremities of the measured length of this edge

[SOURCE: IEC 60404-9:2018, 3.3]

3.2

flatness

~~property of a sheet or a length of strip which is characterized by the wave factor, i.e. by the relation of the height of the wave to its length~~

3.4 deviation from the shearing line

internal stress

~~deviation from the shearing line due to internal stresses~~

greatest distance between corresponding points on the two sheared edges of a length of strip or a sheet sheared in the middle of the width, in parallel to the direction of rolling of the product, which characterizes the internal stress of the materials

[SOURCE: IEC 60404-9:2018, 3.4]

3.5 number of bends

~~number of alternate bends possible before the appearance in the base metal of the first crack visible to the naked eye~~

~~Note 1 to entry:—The number of bends constitutes an indication of the ductility of the material.~~

counts of alternate bending in the reverse bend test prior to the appearance of the first crack in the base metal of the specimen visible to the naked eye or sudden failure occurs by fracture

[SOURCE: IEC TR 63114:2018, 3.2]

4 Classification

The grades covered by this document are classified according to the specified value of maximum specific total loss ~~in watts per kilogram at 1,5 T~~ and according to the nominal thickness of ~~the material (0,35 mm, 0,47 mm, 0,50 mm, 0,65 mm and 1,00mm)~~ the product¹. The products of the nominal thicknesses 0,35 mm, 0,50 mm, 0,65 mm and 1,00 mm are classified according to the specified values tested at a magnetic polarization of 1,5 T and 50 Hz, in watts per kilogram. The product of the nominal thickness 0,47 mm is classified according to the specified value tested at a magnetic polarization of 1,5 T and 60 Hz, in watts per kilogram.

5 Designation

The steel name comprises the following in the order given:

- a) a letter “M” for electrical steel;
- b) one hundred times the specified value of maximum specific total loss at a magnetic polarization of 1,5 T and 50 Hz, in watts per kilogram, ~~at 1,5 T and 50 Hz for the materials given in Table 1 and at 1,5 T and 60 Hz for the materials given in Table 2 and corresponding to the nominal product thickness~~ for the products of the nominal thicknesses 0,35 mm, 0,50 mm, 0,65 mm and 1,00 mm, or at a magnetic polarization of 1,5 T and 60 Hz, in watts per kilogram, for the products of the nominal thickness 0,47 mm;
- c) one hundred times the nominal thickness of the ~~material~~ product, in millimeters;
- d) the characteristic letter “A” for the grades of cold-rolled non-oriented electrical steel strip or sheet supplied in the fully-processed state;
- e) one tenth of the frequency at which the maximum specific total loss is specified, i.e. 5 or 6.

EXAMPLE M250-35A5 for cold-rolled non-oriented electrical steel strip or sheet with a maximum specific total loss of 2,50 W/kg at a magnetic polarization of 1,5 T and 50 Hz, and a nominal thickness of 0,35 mm, supplied in the fully-processed state.

~~NOTE—The corresponding steel numbers used in the European standard are given in Annex B.~~

¹ In the rest of the document, the word “product” is used to mean “strip and sheet”.

6 General requirements

6.1 Production process

The production process of the steel and its chemical composition are left to the discretion of the manufacturer.

6.2 Form of supply

The ~~material~~ product is supplied in coils in the case of strip and in bundles in the case of sheets.

The mass of coils or bundles of sheets shall be agreed between the manufacturer and the purchaser at the time of ~~ordering~~ enquiry and order.

The recommended value for the internal diameter of coils is approximately 508 mm or approximately 610 mm.

Strip shall be of constant width and wound in such a manner that the edges are superimposed in a regular manner and the side faces of the coil are substantially flat.

Coils shall be sufficiently tightly wound in order that they do not collapse under their own weight.

Strip ~~can occasionally~~ may exhibit welds or interleaves resulting from the removal of defective zones, ~~subject to prior agreement~~ if agreed between the ~~parties~~ manufacturer and the purchaser at the time of enquiry and order. If necessary, the marking of welds or interleaves may be agreed between the manufacturer and the purchaser at the time of ~~ordering~~ enquiry and order.

For coils containing welds or interleaves, each part of the strip shall be of the same grade.

The edges of parts welded together shall not be so much out of alignment as to affect the further processing of the ~~material~~ product.

Sheets which make up each bundle shall be stacked so that the side faces of the bundle are substantially flat and approximately perpendicular to the top face.

6.3 Delivery condition

The ~~material~~ products ~~may be~~ are usually supplied either without insulation coating or with insulation coating on one or both sides. If the ~~material~~ product is supplied with insulation coating, the nature of the ~~insulation~~ coating, its properties, the stacking factor and their verification ~~shall be agreed~~ are subject to agreement between the manufacturer and the purchaser at the time of ~~ordering~~ enquiry and order.

NOTE Further information on the classification of surface insulation coatings can be found in IEC 60404-1-1.

6.4 Surface condition

The surfaces shall be smooth and clean, free from grease and rust². Dispersed defects such as scratches, blisters, cracks, etc. are only permitted if they are within the ~~limits of tolerances~~ on thickness ~~tolerances~~, and if they are not detrimental to the correct use of the supplied ~~material~~ product.

~~When an insulation coating is present on the surface of the material, it~~ For products supplied with insulation coating, the coating shall be sufficiently adherent so that it does not become detached during ~~cutting~~ manufacturing operations. During the ~~alternating~~ reverse bend test (see 8.4.4.2), the coating shall not become detached after a bend of 90°. If the coating becomes

² This should not be confused with some coloration of the insulation coating inherent to the manufacturing process.

detached during the test, the ~~piece~~ sample of the product from which the ~~sample~~ test specimen was taken shall be subjected to a shearing test. ~~During this test, it shall not be admissible for large pieces of the coating to become detached.~~ By shearing the sample with well sharpened tools, a detachment of large pieces of the coating shall not be admissible. However, some slight chipping of the coating at the sheared edges shall be tolerated.

6.5 Suitability for cutting

The ~~material~~ product shall be able to be cut or punched without causing premature wear of tools; ~~it shall be able to be cut at any point and into the usual shapes, thus ensuring accurate working with the correct cutting tools. If there are special requirements with regard to a suitability test for cutting or punching, these shall be established by agreement between the manufacturer and the purchaser.~~ The product shall be suitable for cutting or punching accurately into the usual shapes at any point when appropriate cutting or punching tools and technologies are used.

A special requirement concerning suitability for cutting or punching of the product may be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

7 Technical requirements

7.1 Magnetic properties

7.1.1 General

The properties defined in 7.1.2 to 7.1.4 ~~are applicable~~ shall apply to products in the delivery conditions defined in 6.3.

For ~~coated~~ products supplied with insulation coating, the mass of the ~~insulation~~ coating shall be taken into account to determine the magnetic properties.

7.1.2 Magnetic polarization

~~The minimum specified values of magnetic polarization for magnetic field strengths H of 2 500 A/m, 5 000 A/m and 10 000 A/m (expressed as a peak value) shall be as given in Table 1.~~

~~The magnetic polarization shall be determined in an alternating magnetic field at 50 Hz or 60 Hz.~~

The specified values of minimum magnetic polarization, expressed as a peak value, at AC magnetic field strengths H of 2 500 A/m, 5 000 A/m and 10 000 A/m, expressed as a peak value, shall be as given in Table 1 at 50 Hz or Table 2 at 60 Hz.

Table 1 – Technological properties and magnetic properties (magnetic properties are measured by using the Epstein method according to IEC 60404-2)

Steel name	Nominal thickness mm	Maximum specific total loss at 1,5 T W/kg			Minimum magnetic polarization ^a in an alternating magnetic field for at an AC magnetic field strength T			Maximum anisotropy of loss %	Minimum stacking factor	Minimum number of bends	Conventional density ^c kg/dm ³	
		at 50 Hz	at 60 Hz ^b	2 500 A/m	5 000 A/m	10 000 A/m						
M210-35A5	0,35	2,10	2,65	1,49	1,60	1,70	±17	0,95	2	7,60		
M230-35A5		2,30	2,90	1,49	1,60	1,70	±17		2	7,60		
M235-35A5		2,35	2,97	1,49	1,60	1,70	±17		2	7,60		
M250-35A5		2,50	3,14	1,49	1,60	1,70	±17		2	7,60		
M270-35A5		2,70	3,36	1,49	1,60	1,70	±17		2	7,65		
M300-35A5		3,00	3,74	1,49	1,60	1,70	±17		3	7,65		
M330-35A5		3,30	4,12	1,49	1,60	1,70	±17		3	7,65		
M360-35A5		3,60	4,55	1,49	1,60	1,70	±17		3	7,65		
M230-50A5		0,50	2,30	2,95	1,49	1,60	1,70		±17	0,96	2	7,60
M250-50A5			2,50	3,21	1,49	1,60	1,70		±17		2	7,60
M270-50A5	2,70		3,47	1,49	1,60	1,70	±17	2	7,60			
M290-50A5	2,90		3,71	1,49	1,60	1,70	±17	2	7,60			
M310-50A5	3,10		3,95	1,49	1,60	1,70	±14	3	7,65			
M330-50A5	3,30		4,20	1,49	1,60	1,70	±14	3	7,65			
M350-50A5	3,50		4,45	1,50	1,60	1,70	±12	5	7,65			
M400-50A5	4,00		5,10	1,53	1,63	1,73	±12	5	7,70			
M470-50A5	4,70		5,90	1,54	1,64	1,74	±10	10	7,70			
M530-50A5	5,30		6,66	1,56	1,65	1,75	±10	10	7,70			
M600-50A5	6,00	7,53	1,57	1,66	1,76	±10	10	7,75				
M700-50A5	7,00	8,79	1,60	1,69	1,77	±10	10	7,80				
M800-50A5	8,00	10,06	1,60	1,70	1,78	±10	10	7,80				
M940-50A5	9,40	11,84	1,62	1,72	1,81	±8	10	7,85				
M1000-50A5	10,00	12,60	1,62	1,72	1,81	±8	10	7,85				

Steel name	Nominal thickness mm	Maximum specific total loss at 1,5 T W/kg		Minimum magnetic polarization ^a in an alternating magnetic field for an AC magnetic field strength T			Maximum anisotropy of loss %	Minimum stacking factor	Minimum number of bends	Conventional density ^c kg/dm ³
		at 50 Hz	at 60 Hz ^b	2 500 A/m	5 000 A/m	10 000 A/m				
M310-65A5		3,10	4,08	1,49	1,60	1,70	±15	2	7,60	
M330-65A5		3,30	4,30	1,49	1,60	1,70	±15	2	7,60	
M350-65A5		3,50	4,57	1,49	1,60	1,70	±14	2	7,60	
M400-65A5		4,00	5,20	1,52	1,62	1,72	±14	2	7,65	
M470-65A5		4,70	6,13	1,53	1,63	1,73	±12	5	7,65	
M530-65A5	0,65	5,30	6,84	1,54	1,64	1,74	±12	5	7,70	
M600-65A5		6,00	7,71	1,56	1,66	1,76	±10	10	7,75	
M700-65A5		7,00	8,98	1,57	1,67	1,76	±10	10	7,75	
M800-65A5		8,00	10,26	1,60	1,70	1,78	±10	10	7,80	
M1000-65A5		10,00	12,77	1,61	1,71	1,80	±10	10	7,80	
M600-100A5		6,00	8,14	1,53	1,63	1,72	±10	2	7,60	
M700-100A5		7,00	9,38	1,54	1,64	1,73	±8	3	7,65	
M800-100A5	1,00	8,00	10,70	1,56	1,66	1,75	±6	5	7,70	
M1000-100A5		10,00	13,39	1,58	1,68	1,76	±6	10	7,80	
M1300-100A5		13,00	17,34	1,60	1,70	1,78	±6	10	7,80	

^a It has been common practice for many years to give values of magnetic flux density. In fact, the Epstein frame is used to determine magnetic polarization (intrinsic flux density) which is defined as follows in accordance with IEC 60050-121:

$$J = B - \mu_0 H$$

where
 J is the magnetic polarization;
 B is the magnetic flux density;
 μ_0 is the magnetic constant: $4\pi \times 10^{-7} \text{ H m}^{-1}$;
 H is the magnetic field strength.

^b Only for information.

^c Other values may be agreed between the manufacturer and the purchaser at the time of enquiry and order, see Annex B.

Table 2 – Technological properties and magnetic properties measured by the Epstein method for strip and sheet of nominal thickness 0,47 mm for use at 60 Hz only (magnetic properties are measured using the Epstein method according to IEC 60404-2)

Steel name	Nominal thickness mm	Maximum specific total loss at 1,5 T W/kg		Minimum magnetic polarization ^a in an alternating magnetic field for at an AC magnetic field strength T			Maximum anisotropy of loss %	Minimum stacking factor	Minimum number of bends	Conventional density ^c kg/dm ³
		at 50 Hz ^b	at 60 Hz	2 500 A/m	5 000 A/m	10 000 A/m				
M370-47A6		2,92	3,70	1,49	1,60	1,70	±18		2	7,65
M380-47A6		3,00	3,80	1,49	1,60	1,70	±14		3	7,65
M408-47A6		3,22	4,08	1,49	1,60	1,70	±14		3	7,65
M419-47A6		3,31	4,19	1,49	1,60	1,70	±14		3	7,70
M452-47A6	0,47	3,57	4,52	1,50	1,60	1,70	±14	0,96	5	7,70
M507-47A6		4,01	5,07	1,51	1,61	1,71	±14		5	7,70
M638-47A6		5,04	6,38	1,54	1,64	1,74	±12		10	7,75
M836-47A6		6,60	8,36	1,58	1,68	1,77	±12		10	7,80
M990-47A6		7,82	9,90	1,58	1,68	1,77	±12		10	7,80

^a It has been common practice for many years to give values of magnetic flux density. In fact the Epstein frame is used to determine magnetic polarization (intrinsic flux density) which is defined as follows in accordance with IEC 60050-121:

$$J = B - \mu_0 H$$

where

J is the magnetic polarization;

B is the magnetic flux density;

μ_0 is the magnetic constant: $4\pi \times 10^{-7} \text{ H m}^{-1}$;

H is the magnetic field strength.

^b Only for information.

^c Other values may be agreed between the manufacturer and the purchaser at the time of enquiry and order, see Annex B.

7.1.3 Specific total loss

~~The specified values of maximum specific total loss at 50 Hz shall be as given in Table 1. They apply:~~

- ~~— for the nominal thicknesses 0,35 mm, 0,50 mm and 0,65 mm to aged or non-aged test pieces (see 8.3.1);~~
- ~~— for the nominal thickness 1,00 mm to non-aged test pieces.~~

~~Table 2 gives the specified values of maximum specific total loss at 60 Hz for products of 0,47 mm nominal thickness.~~

~~In certain cases, the specified value of maximum specific total loss can be made the subject of agreement for longitudinal test pieces only or for transverse test pieces only.~~

~~The values of the specific total loss are specified for a magnetic polarization of 1,5 T.~~

~~The test shall be made in an alternating magnetic field at 50 Hz or at 60 Hz.~~

The specified values of maximum specific total loss at a magnetic polarization of 1,5 T and 50 Hz shall be as given in Table 1 for products of the nominal thicknesses 0,35 mm, 0,50 mm, 0,65 mm and 1,00 mm. They apply to:

- aged or non-aged test strips (see 8.3.1), for products of the nominal thicknesses 0,35 mm, 0,50 mm and 0,65 mm;
- non-aged test strips, for products of the nominal thickness 1,00 mm.

The specified values of maximum specific total loss at a magnetic polarization of 1,5 T and 60 Hz shall be as given in Table 2, for products of the nominal thickness 0,47 mm.

A special requirement concerning the value of maximum specific total loss measured using test strips cut parallel to the direction of rolling only or test strips cut perpendicular to the direction of rolling only may be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

NOTE Annex A gives non-specified values of maximum specific total loss at a magnetic polarization of 1,0 T and 50 Hz.

7.1.4 Anisotropy of loss

The ~~maximum~~ permitted values of maximum anisotropy of loss at a magnetic polarization of 1,5 T shall be as ~~specified~~ given in Table 1 and Table 2.

A special requirement concerning the declaration of the measured value of anisotropy of loss may be ~~specified by~~ subject to agreement ~~when ordering~~ between the manufacturer and the purchaser at the time of enquiry and order.

7.2 Geometrical characteristics and tolerances

7.2.1 Thickness

The nominal thicknesses of the ~~material~~ product are 0,35 mm, 0,47 mm, 0,50 mm, 0,65 mm and 1,00 mm.

The nominal thickness 0,47 mm applies only to the grades for use at 60 Hz only ~~is also given in Table 2.~~

For thickness tolerance, a distinction is made between

- ~~— the allowable tolerance on the nominal thickness within the same acceptance unit;~~
- the deviation from the nominal thickness within an acceptance unit;
- the difference in thickness in ~~a sheet or in a length of strip in~~ a direction parallel to the direction of rolling in a length of strip or sheet;
- the difference in thickness in a direction perpendicular to the direction of rolling. This tolerance applies only to ~~materials~~ products supplied with a width greater than 150 mm.

~~The allowable tolerance on the nominal thickness within the same acceptance unit shall be $\pm 8\%$ of the nominal value for the nominal thicknesses 0,35 mm, 0,47 mm and 0,50 mm, and $\pm 6\%$ of the nominal value for the nominal thicknesses 0,65 mm and 1,00 mm. The additional thickness due to welds, with respect to the measured thickness of the steel strip or sheet, shall not exceed 0,10 mm.~~

~~The difference in thickness in a sheet or in a length of strip (see 8.3.2) in a direction parallel to the direction of rolling shall not exceed 8 % for nominal thicknesses 0,35 mm, 0,47 mm and 0,50 mm, and 6 % for nominal thicknesses 0,65 mm and 1,00 mm.~~

~~The difference in thickness in a direction perpendicular to the direction of rolling shall not exceed 0,020 mm for nominal thicknesses of 0,35 mm, 0,47 mm and 0,50 mm, and 0,030 mm for the nominal thicknesses of 0,65 mm and 1,00 mm, the measurements being made at least 30 mm from the edges (see 8.4.3.1). These tolerances apply only to materials with a width greater than 150 mm. For narrow strips, other agreements may be reached.~~

At any point, the deviation from the nominal thickness within an acceptance unit shall not exceed the tolerance of Table 3.

The additional thickness due to welds with respect to the measured thickness of the product shall not exceed 0,10 mm.

The difference in thickness in a direction parallel to the direction of rolling in a 1 m length of the product shall not exceed

- 0,030 mm, 0,038 mm and 0,040 mm for products of the nominal thicknesses 0,35 mm, 0,47 mm and 0,50 mm respectively;
- 0,045 mm and 0,060 mm for products of the nominal thicknesses 0,65 mm and 1,00 mm respectively.

Table 3 – Tolerances on nominal thickness

Nominal thickness mm	Tolerance mm
0,35	$\pm 0,030$
0,47	$\pm 0,038$
0,50	$\pm 0,040$
0,65	$\pm 0,045$
1,00	$\pm 0,060$

For products supplied with a width greater than 150 mm, the difference in thickness in a direction perpendicular to the direction of rolling shall not exceed

- 0,020 mm for products of the nominal thicknesses 0,35 mm, 0,47 mm and 0,50 mm;
- 0,030 mm for products of the nominal thicknesses 0,65 mm and 1,00 mm.

The measurements shall be made at any point located at least 20 mm from the edges (see 8.4.3.1). For narrow strips, other agreements may be needed.

7.2.2 Width

The commonly available nominal widths are less than or equal to 1 250 mm.

For the tolerances on width, a distinction is made between ~~material~~ products supplied with slit edges ~~in the as-rolled condition and material delivered with trimmed edges~~ and products supplied with as-rolled edges.

For ~~materials~~ products supplied with ~~trimmed~~ slit edges, the tolerances of Table 4 shall apply.

Table 4 – Tolerances on nominal width

Nominal width l mm	Tolerance ^a mm
$l \leq 150$	+0,2 0
$150 < l \leq 300$	+0,3 0
$300 < l \leq 600$	+0,5 0
$600 < l \leq 1\ 000$	+1,0 0
$1\ 000 < l \leq 1\ 250$ ^b	+1,5 0

^a By agreement ~~when ordering~~ between the manufacturer and the purchaser at the time of enquiry and order, the tolerances on nominal width can be all minus ~~values~~ tolerances.

^b Nominal widths greater than 1 250 mm may be delivered. In this case, the tolerance should be agreed between the manufacturer and the purchaser at the time of enquiry and order.

For ~~materials~~ products supplied with as-rolled edges, the tolerances on ~~nominal width should~~ geometric characteristics shall be subject to agreement ~~when ordering~~ between the manufacturer and the purchaser at the time of enquiry and order.

7.2.3 Length

The verification of length does not apply to the products supplied in coils.

For products supplied in sheets, the tolerance on the length of sheets in relation to the length ordered shall be ${}^{+0,5}_0$ %, but with a maximum of +6 mm.

7.2.4 Edge wave (wave factor)

The verification of edge wave applies only to products supplied with a width greater than 100 mm. The wave factor (see 8.4.3.3), shall not exceed 2 %.

~~7.2.5 Flatness (wave factor)~~

~~The verification of flatness does not apply to material of width less than or equal to 100 mm. The wave factor (see 8.4.3.4), expressed as a percentage, shall not exceed 2.~~

7.2.5 Residual curvature

The verification of residual curvature ~~does not apply to material of width less than or equal to~~ applies only to products supplied with a width greater than 100 mm.

~~A requirement concerning residual curvature can be specified by agreement when ordering; in this case, the distance between the bottom edge of the test specimen and the supporting plate shall not exceed 35 mm for the products of nominal thicknesses 0,35 mm, 0,47 mm, 0,50 mm and 0,65 mm. For the nominal thickness 1,00 mm, this distance shall be subject to an agreement between the manufacturer and the purchaser.~~

A requirement concerning residual curvature may be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

Two methods for the determination of the residual curvature in the direction of rolling of the product are described in IEC 60404-9: a horizontal method and a vertical method. The horizontal method is recommended from the aspect of worker's safety and consistency with ISO standards.

- Horizontal method:

In this method, the maximum distance between the test specimen and a flat surface table, on which the test specimen is placed, shall not exceed 17,5 mm for products of the nominal thicknesses 0,35 mm, 0,47 mm, 0,50 mm and 0,65 mm. A different maximum distance may be agreed by the manufacturer and the purchaser at the time of enquiry and order. For products of the nominal thickness 1,00 mm, this distance shall be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

- Vertical method:

In this method, the maximum distance between the bottom edge of the test specimen and the supporting plate shall not exceed 35 mm for products of the nominal thicknesses 0,35 mm, 0,47 mm, 0,50 mm and 0,65 mm. For products of the nominal thickness 1,00 mm, this distance shall be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

NOTE The horizontal and vertical methods, with the limits 17,5 mm and 35 mm respectively, are not exactly interchangeable. Which method to use can be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

7.2.6 Edge camber

The verification of edge camber applies only to ~~material~~ products supplied with ~~trimmed~~ slit edges and a width greater than 30 mm.

The edge camber shall not exceed for a measuring length of ~~2~~ 1 m:

- ~~2,0~~ 1,0 mm for the nominal width l , $l > 150$ mm;
- ~~4,0~~ 2,0 mm for the nominal width l , $30 \text{ mm} < l \leq 150$ mm.

7.3 Technological characteristics

7.3.1 Density

The density of the ~~material~~ products is not specified.

The conventional values of density ~~of the material are~~ used to calculate the magnetic properties and the stacking factor shall be as given in Table 1 and Table 2. ~~They shall be used to calculate the magnetic properties and the stacking factor, unless otherwise agreed (see Tables 1 and 2, footnote c).~~ Other values may be agreed between the manufacturer and the purchaser at the time of enquiry and order (see Annex B).

7.3.2 Stacking factor

~~The minimum values shall be as specified in Tables 1 and 2, and only apply to non-insulated material.~~

The specified values of minimum stacking factor shall be as given in Table 1 and Table 2, and only apply to products supplied without insulation coating. The values of products supplied with insulation coating are subject to agreement between the manufacture and the purchaser at the time of enquiry and order.

7.3.3 Number of bends

The specified minimum number of bends shall be as ~~specified~~ given in Table 1 and Table 2. The values apply to test specimens cut perpendicular to the direction of rolling.

7.3.4 Deviation from the shearing line (internal stress)

The ~~material~~ products shall be, as far as possible, free from internal stress.

~~The verification of internal stresses does not apply to materials of width less than or equal to 150 mm. The measured gap shall not exceed 2 mm (see 8.3.3.3).~~

The verification of the deviation from the shearing line applies only to products supplied with a width greater than 150 mm. The measured gap shall not exceed 1 mm for a measuring length of 1 m.

8 Inspection and testing

8.1 General

The ~~material~~ products defined by this document can be ordered with or without specific inspection in accordance with ISO 404. However, as a dispensation from ISO 404, in the case of an order without ~~specific~~ inspection, the manufacturer shall supply ~~a certificate~~ an inspection document type 3.1 according to ISO 10474 giving the specific total loss of the supplied ~~material~~ product.

In the case of an order with specific inspection, the type of inspection document in accordance with ISO 10474 shall be specified when ordering. In this case, the delivery is divided into acceptance units.

Each acceptance unit shall comprise 20 t or the remaining fraction thereof of the same grade and the same nominal thickness. Different acceptance units can be adopted by special agreement between the manufacturer and the purchaser at the time of enquiry and order.

For coils of more than 20 t, each coil shall constitute an acceptance unit.

Except by special agreement, the same rules apply to the inspection of deviation from the shearing line (internal stress), suitability for cutting, adherence of ~~surface~~ insulation coating and tolerances on ~~shape and dimensions~~ geometrical characteristics.

When the products are delivered in the form of slit coils, the test results ~~applying~~ made to the parent ~~unit~~ coil of the acceptance unit shall apply.

8.2 Selection of samples

Test samples shall be taken from each acceptance unit.

In the case of coils, the first internal turn and the last external turn of the coil shall be considered as wrapping and not representative of the quality of the rest of the coil. The selection shall be made from the first external or internal turns, excluding the wrapping turn and outside any welding zones or interleaves.

In the case of sheets, the selection shall be made preferably from the upper part of the bundle.

By choosing a suitable order for the execution of the tests, the same sample shall serve to verify the various properties.

8.3 Preparation of test specimens

8.3.1 Magnetic properties

For the measurement of magnetic polarization and specific total loss using the 25 cm Epstein frame in accordance with IEC 60404-2, the test specimen shall consist of a minimum of 16 Epstein test strips having the following dimensions:

- length 280 mm to 320 mm, the lengths being equal within a tolerance of $\pm 0,5$ mm;
- width 30 mm within a tolerance of $\pm 0,2$ mm.

Half the test strips shall be cut parallel to the direction of rolling and the other half of the test strips shall be cut perpendicular to the direction of rolling, giving an even distribution across the width of the material. The test strips shall be carefully cut without deformation. Cutting or punching shall be carried out only with well-sharpened tools. The maximum tolerance between the direction of cutting in relation to the specified direction shall be $\pm 5^\circ$. The permitted tolerance for the angle between the specified direction and the direction of cutting or punching is $\pm 5^\circ$.

As far as possible, the selection of test strips shall be made uniformly across the width of the product. The test strips shall be carefully cut without deformation. The cutting or punching shall be carried out only with well-sharpened tools.

If the width of the material product is insufficient for a sampling of test strips of the prescribed length to be taken across the width, the test strips shall be taken in cut parallel to the direction of rolling only.

In the case of measurements of specific total loss on aged test pieces strips, these the Epstein test strips shall be heated aged by heating at $(225 \pm 5)^\circ\text{C}$ for a duration of 24 h and shall be cooled to ambient temperature of $(23 \pm 5)^\circ\text{C}$. Other ageing treatment conditions can also may be used by agreement between the manufacturer and the purchaser at the time of enquiry and order.

8.3.2 Geometrical characteristics and tolerances

For the measurement of thickness, width, flatness, edge wave (wave factor), residual curvature, deviation from the shearing line (internal stress) and edge camber, the test specimen shall consist of a sheet or a 1 m length of strip or sheet.

For the measurement of residual curvature by the vertical method, the test specimen shall consist of a sample $500^{+2,5}_{0,0}$ mm in length and of width equal to the delivery width of the strip or sheet product.

The tolerance on the length of the test specimen may be agreed between the manufacturer and the purchaser at the time of enquiry and order.

8.3.3 Technological characteristics

8.3.3.1 Stacking factor

The test specimen shall consist of at least 16 strips of the same size; in case of dispute, the test shall be made with 100 strips. The strips shall have a width of at least 20 mm and a surface area of at least 5 000 mm². The widths and lengths of the strips ~~being~~ shall be equal within the tolerances of $\pm 0,2$ mm, ~~as well as their lengths~~ and $\pm 0,5$ mm respectively. The test strips shall be carefully deburred before the test.

Epstein test strips may be used for this test (see IEC 60404-2 and IEC 60404-13).

8.3.3.2 Number of bends

Two test specimens at least 20 mm wide shall be ~~cut~~ taken from outside of the welding zones, perpendicular to the direction of rolling ~~of the sheet~~, at a distance of at least 40 mm from the edge and ~~from~~ at the middle of the width, ~~and outside any welding zones~~. The result of reverse bend test shall be the smaller value of the minimum numbers of bends in the two specimens.

The length of the test specimen depends on the test apparatus used to perform the test.

If the width of the ~~material~~ product is insufficient for ~~transverse~~ a sampling of test specimens of the prescribed length to be taken across the width, the test specimens shall be taken ~~in~~ parallel to the longitudinal axis (the direction of rolling). In this case, the values of Table 1 and Table 2 also apply.

The test specimens shall be carefully cut, without deformation. Epstein test strips may be used for this test (see IEC 60404-2 and IEC TR 63114).

~~8.3.3.3 Internal stresses~~

~~The test specimen shall consist of a sheet or a length of strip of 1 m.~~

8.4 Test methods

8.4.1 General

For each specified property, one test shall be carried out per acceptance unit. Unless otherwise specified, the tests shall be made at an ambient temperature of (23 ± 5) °C.

8.4.2 Magnetic properties

8.4.2.1 Magnetic polarization and specific total loss

The test shall be made using a 25 cm Epstein frame in accordance with IEC 60404-2.

As an alternative to the Epstein method, the single sheet tester (SST) method specified in IEC 60404-3 may be used by agreement between the manufacturer and the purchaser at the time of enquiry and order. In this case, the specified values to be ~~obtained with the single sheet tester may~~ measured by the SST method can be different from those in Table 1 and Table 2, and may be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

8.4.2.2 Anisotropy of loss

Two measurements of the specific total loss in watts per kilogram shall be made, one on 16 Epstein test strips taken perpendicular to the direction of rolling, and one on 16 Epstein test strips taken parallel to the direction of rolling.

The anisotropy of the specific total loss T , expressed as a percentage, is calculated according to the following equation:

$$\cancel{T = \frac{P_1 - P_2}{P_1 + P_2} \times 100}$$

$$T = \frac{P_{TD} - P_{RD}}{P_{TD} + P_{RD}} \times 100 \quad (1)$$

where

P_1 P_{TD} is the specific total loss, in watts per kilogram, measured in the direction perpendicular to the direction of rolling;

P_2 P_{RD} is the specific total loss, in watts per kilogram, measured in the direction parallel to the direction of rolling.

8.4.3 Geometrical characteristics and tolerances

8.4.3.1 Thickness

The measurement of thickness shall be made at any point located ~~more than 30~~ at least 20 mm from the edges. For ~~materials~~ products of a width less than ~~60~~ 40 mm, the measurement of thickness shall be made along the longitudinal axis (the direction of rolling) of the ~~sheet~~ product. This measurement shall be made using a micrometer with an ~~accuracy~~ uncertainty of ~~0,001~~ 0,002 mm or better.

8.4.3.2 Width

The width shall be measured perpendicular to the longitudinal axis (the direction of rolling) of the product with a calibrated measuring instrument.

8.4.3.3 Edge wave (wave factor)

The wave factor shall be determined in accordance with IEC 60404-9.

8.4.3.4 Residual curvature

The residual curvature in the longitudinal ~~direction of the strip~~ axis (the direction of rolling) of the product shall be determined in accordance with IEC 60404-9.

8.4.3.5 Edge camber

The edge camber shall be determined in accordance with IEC 60404-9.

~~8.4.3.4 Flatness (wave factor)~~

~~The wave factor shall be determined in accordance with IEC 60404-9.~~

8.4.4 Technological characteristics

8.4.4.1 Stacking factor

The stacking factor shall be measured in accordance with IEC 60404-13.

8.4.4.2 Number of bends

The test consists of bending the test specimen through 90° alternately to each side of its initial position, according to the method of bending defined by ISO 7799. The radius of bending chosen shall be 5 mm.

A bend of 90° from the initial position with return to the initial position counts as one bend.

The test shall be continued until the specified minimum number of bends given in Table 1 and Table 2 is reached without an occurrence of cracks in the base metal. Alternatively, the test shall be stopped on the appearance of the first crack in the base metal visible to the naked eye, or sudden failure occurs by fracture. The test may be stopped by monitoring a cracking sound from the test specimen or a sudden current change when a constant voltage is applied between the both ends of the test specimen. The occurrence of cracks shall be confirmed by naked eye inspection.

The last bend shall not be counted.

NOTE Further information on the procedure of the reverse bend test can be found in IEC TR 63114.

8.4.4.3 Deviation from the shearing line (Internal stress)

The ~~internal stresses~~ deviation from the shearing line shall be determined in accordance with IEC 60404-9.

8.5 Retests

When a test does not give the specified result, this test shall be repeated on double the number of test specimens from other sheets of the acceptance unit or on other strips from the coils. The delivery shall be considered to conform with the order if all results of additional tests are in accordance with the requirements of this document.

After re-treatment, the manufacturer has the right to present again for test the acceptance units which had not been found to comply with the order.

9 Marking, labelling and packaging

Marking, labelling and packaging of the products may be agreed between the manufacturer and the purchaser at the time of ~~ordering~~ enquiry and order.

10 Complaints

Internal or external defects shall justify a complaint only if they are clearly prejudicial to the method of working or the judicious use of the ~~material~~ product.

The purchaser shall give the manufacturer the opportunity of convincing himself of the fairness of the claim by presenting the ~~material~~ product in dispute and evidence for the complaint.

In all cases, the terms and conditions of complaints shall be made in accordance with ISO 404.

11 Information to be supplied by the purchaser

For ~~materials~~ a product to comply adequately with the requirements of this document, the purchaser shall include the following information in his enquiry or order:

- a) the quantity;

- b) the type of product (strip or sheet);
- c) the number of this document (IEC 60404-8-4);
- d) ~~name or number of~~ the steel name (see Clause 5);
- e) the dimensions of strips or sheets required (including any limitations on the internal and external diameters of a coil) (see 6.2 and 7.2.2);
- f) any limitation on the mass of a coil or a bundle of sheets (see 6.2);
- g) any special requirements about the marking of welds or interleaves (see 6.2);
- h) ~~any requirement for insulation and its classification~~ for products supplied with insulation coating, any requirement about the insulation coating and its properties, the stacking factor and their verification (see 6.3);
- i) any special requirement about the suitability for cutting or punching (see 6.5);
- ~~j) any special requirement about single sheet testing (see 8.4.2.1);~~
- j) any special requirement about the value of maximum specific total loss measured using test strips cut parallel to the direction of rolling only or test strips cut perpendicular to the direction of rolling only (see 7.1.3);
- k) any special requirement about the declaration of the measured value of anisotropy of loss (see 7.1.4);
- l) any special requirement about the thickness measurement and tolerance across the width of narrow strip (see 7.2.1 and 8.4.3.1);
- m) any special requirement about tolerances on the geometric characteristics of products supplied with as-rolled edges (see 7.2.2);
- n) any requirement about the residual curvature (see 7.2.5);
- o) the inspection procedure required including the nature of the related documents (see 8.1);
- p) any special requirement about the specified values to be measured by the single sheet tester (SST) method specified in IEC 60404-3 (see 8.4.2.1);
- q) any requirement about marking, labelling and packaging of the products (see Clause 9).

Annex A (informative)

Non-specified magnetic properties

Table A.1 gives the non-specified magnetic properties.

Table A.1 – Non-specified magnetic properties

Steel name	Maximum specific total loss at 1,0 T and 50 Hz W/kg
M210-35A5	0,90
M230-35A5	0,95
M235-35A5	0,95
M250-35A5	1,00
M270-35A5	1,10
M300-35A5	1,20
M330-35A5	1,30
M360-35A5	1,45
M230-50A5	1,00
M250-50A5	1,05
M270-50A5	1,10
M290-50A5	1,15
M310-50A5	1,25
M330-50A5	1,35
M350-50A5	1,50
M400-50A5	1,70
M470-50A5	2,00
M530-50A5	2,30
M600-50A5	2,60
M700-50A5	3,00
M800-50A5	3,60
M940-50A5	4,20
M1000-50A5	4,40
M310-65A5	1,25
M330-65A5	1,35
M350-65A5	1,50
M400-65A5	1,70
M470-65A5	2,00
M530-65A5	2,30
M600-65A5	2,60
M700-65A5	3,00
M800-65A5	3,60
M1000-65A5	4,40
M600-100A5	2,60
M700-100A5	3,00
M800-100A5	3,60
M1000-100A5	4,40
M1300-100A5	5,80

Annex B
(informative)

European steel numbers

Table B.1 gives the steel numbers of the corresponding steel grades of the European standard EN 10106:2007.

Table B.1—European steel numbers

Steel name	Steel number
M235-35A-5	1.0890
M250-35A-5	1.0800
M270-35A-5	1.0801
M300-35A-5	1.0803
M330-35A-5	1.0804
M250-50A-5	1.0891
M270-50A-5	1.0806
M290-50A-5	1.0807
M310-50A-5	1.0808
M330-50A-5	1.0809
M350-50A-5	1.0810
M400-50A-5	1.0811
M470-50A-5	1.0812
M530-50A-5	1.0813
M600-50A-5	1.0814
M700-50A-5	1.0815
M800-50A-5	1.0816
M940-50A-5	1.0817
M310-65A-5	1.0892
M330-65A-5	1.0819
M350-65A-5	1.0820
M400-65A-5	1.0821
M470-65A-5	1.0823
M530-65A-5	1.0824
M600-65A-5	1.0825
M700-65A-5	1.0826
M800-65A-5	1.0827
M1000-65A-5	1.0829
M600-100A-5	1.0893
M700-100A-5	1.0894
M800-100A-5	1.0895
M1000-100A-5	1.0896
M1300-100A-5	1.0897

Annex B (informative)

Calculation of density values Calculated density of non-oriented electrical steel

A calculated density obtained by Formula (B.1), which is in accordance with ASTM A34/A34M, may be used for the calculation of density values on magnetic properties and the stacking factor by agreement between the manufacturer and the purchaser at the time of enquiry and order (see Tables 1 and 2, footnote c 7.3.1):

$$\rho = [7,865 - 0,065 \times (C_{Si} + 1,7C_{Al})] \quad (B.1)$$

where

- ρ is the numerical value of the calculated density, expressed in kg/dm³;
- C_{Si} is the numerical value mass fraction of silicon content, expressed as a mass fraction in percentage (%);
- C_{Al} is the numerical value mass fraction of aluminum content, expressed as a mass fraction in percentage (%).

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ASTM A34/A34M, *Standard Practice for Sampling and Procurement Testing of Magnetic Materials*

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INTERNATIONAL STANDARD

NORME INTERNATIONALE

Magnetic materials –

Part 8-4: Specifications for individual materials – Cold-rolled non-oriented electrical steel strip and sheet delivered in the fully-processed state

Matériaux magnétiques –

Partie 8-4: Spécifications pour matériaux particuliers – Bandes et tôles magnétiques en acier à grains non orientés, laminées à froid et livrées à l'état fini

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CONTENTS

FOREWORD	4
INTRODUCTION	6
1 Scope	7
2 Normative references	7
3 Terms and definitions	8
4 Classification	9
5 Designation	9
6 General requirements	9
6.1 Production process	9
6.2 Form of supply	9
6.3 Delivery condition	10
6.4 Surface condition	10
6.5 Suitability for cutting	10
7 Technical requirements	10
7.1 Magnetic properties	10
7.1.1 General	10
7.1.2 Magnetic polarization	11
7.1.3 Specific total loss	15
7.1.4 Anisotropy of loss	15
7.2 Geometrical characteristics and tolerances	15
7.2.1 Thickness	15
7.2.2 Width	16
7.2.3 Length	17
7.2.4 Edge wave (wave factor)	17
7.2.5 Residual curvature	17
7.2.6 Edge camber	17
7.3 Technological characteristics	17
7.3.1 Density	17
7.3.2 Stacking factor	18
7.3.3 Number of bends	18
7.3.4 Deviation from the shearing line (internal stress)	18
8 Inspection and testing	18
8.1 General	18
8.2 Selection of samples	18
8.3 Preparation of test specimens	19
8.3.1 Magnetic properties	19
8.3.2 Geometrical characteristics and tolerances	19
8.3.3 Technological characteristics	19
8.4 Test methods	20
8.4.1 General	20
8.4.2 Magnetic properties	20
8.4.3 Geometrical characteristics and tolerances	21
8.4.4 Technological characteristics	21
8.5 Retests	22
9 Marking, labelling and packaging	22

10	Complaints	22
11	Information to be supplied by the purchaser	22
	Annex A (informative) Non-specified magnetic properties	24
	Annex B (informative) Calculated density of non-oriented electrical steel.....	25
	Bibliography.....	26
	Table 1 – Technological properties and magnetic properties (magnetic properties are measured using the Epstein method according to IEC 60404-2).....	12
	Table 2 – Technological properties and magnetic properties for strip and sheet of nominal thickness 0,47 mm for use at 60 Hz only (magnetic properties are measured using the Epstein method according to IEC 60404-2).....	14
	Table 3 – Tolerances on nominal thickness.....	16
	Table 4 – Tolerances on nominal width	16
	Table A.1 – Non-specified magnetic properties	24

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INTERNATIONAL ELECTROTECHNICAL COMMISSION

MAGNETIC MATERIALS –**Part 8-4: Specifications for individual materials –
Cold-rolled non-oriented electrical steel strip and sheet
delivered in the fully-processed state**

FOREWORD

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IEC 60404-8-4 has been prepared by IEC technical committee 68: Magnetic alloys and steels. It is an International Standard.

This fourth edition cancels and replaces the third edition published in 2013. This edition constitutes a technical revision.

This edition includes the following significant technical changes with respect to the previous edition:

- a) modification of terms and technical requirements concerning geometrical characteristics to be consistent with IEC 60404-9:2018;
- b) insertion of Table 3 – Tolerances on nominal thickness;
- c) change of the length of test specimen for determination of geometrical characteristics from 2 m to 1 m.

The text of this International Standard is based on the following documents:

Draft	Report on voting
68/700/CDV	68/713/RVC

Full information on the voting for its approval can be found in the report on voting indicated in the above table.

The language used for the development of this International Standard is English.

This document was drafted in accordance with ISO/IEC Directives, Part 2, and developed in accordance with ISO/IEC Directives, Part 1 and ISO/IEC Directives, IEC Supplement, available at www.iec.ch/members_experts/refdocs. The main document types developed by IEC are described in greater detail at www.iec.ch/publications.

A list of all parts in the IEC 60404 series, published under the general title *Magnetic materials*, can be found on the IEC website.

The committee has decided that the contents of this document will remain unchanged until the stability date indicated on the IEC website under webstore.iec.ch in the data related to the specific document. At this date, the document will be

- reconfirmed,
- withdrawn,
- replaced by a revised edition, or
- amended.

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INTRODUCTION

This revision of International Standard IEC 60404-8-4 has been prepared by the experts of the Working Group 1 of the IEC Technical Committee 68: Magnetic alloys and steels.

The third edition of IEC 60404-8-4 was issued in 2013. After that, other IEC 60404 standards were revised and IEC TC 68 decided in 2019 at their meeting in Düsseldorf to revise this document to maintain consistency for user's convenience. The revision is made mainly on technical amendments regarding testing and definitions of geometrical characteristics in accordance with IEC 60404-9. The length of test specimen for determination of geometrical characteristics is changed from 2 m to 1 m. The term of “flatness” is divided into “edge wave (wave factor)” and “residual curvature” and the horizontal method is introduced for verification of residual curvature. This revision also includes corrections in order to improve consistency with other standards of the IEC 60404-8 series.

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MAGNETIC MATERIALS –

Part 8-4: Specifications for individual materials – Cold-rolled non-oriented electrical steel strip and sheet delivered in the fully-processed state

1 Scope

This part of IEC 60404 defines the grades of cold-rolled non-oriented electrical steel strip and sheet in nominal thicknesses of 0,35 mm, 0,47 mm, 0,50 mm, 0,65 mm and 1,00 mm. In particular, it gives general requirements, magnetic properties, geometric characteristics, tolerances and technological characteristics, as well as inspection procedure. The nominal thickness 0,47 mm applies to the grades for use at 60 Hz only.

This document applies to cold-rolled non-oriented electrical steel strip and sheet supplied in the fully-processed state, i.e. the final annealed condition, in coils or sheets, and intended for the construction of magnetic circuits. This document does not apply to materials supplied in the semi-processed state.

NOTE The cold-rolled non-oriented electrical steel strip and sheet supplied in the semi-processed state is specified in IEC 60404-8-3.

The grades defined in this document correspond to Class C21 of IEC 60404-1.

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.

IEC 60050-121, *International Electrotechnical Vocabulary – Part 121: Electromagnetism*

IEC 60050-221, *International Electrotechnical Vocabulary – Chapter 221: Magnetic materials and components*

IEC 60404-1, *Magnetic materials – Part 1: Classification*

IEC 60404-2, *Magnetic materials – Part 2: Methods of measurement of the magnetic properties of electrical steel strip and sheet by means of an Epstein frame*

IEC 60404-3, *Magnetic materials – Part 3: Methods of measurement of the magnetic properties of electrical steel strip and sheet by means of a single sheet tester*

IEC 60404-9, *Magnetic materials – Part 9: Methods of determination of the geometrical characteristics of electrical steel strip and sheet*

IEC 60404-13, *Magnetic materials – Part 13: Methods of measurement of resistivity, density and stacking factor of electrical steel strip and sheet*

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

ISO 7799, *Metallic materials – Sheet and strip 3 mm thick or less – Reverse bend test*

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

3 Terms and definitions

For the purposes of this document, the terms and definitions given in IEC 60050-121, IEC 60050-221 and the following apply.

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

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

3.1

edge wave

wave factor

variations of flatness of a length of strip or a sheet taking a form of waves at the slit edge of the product

Note 1 to entry: The edge wave is characterized by the wave factor which is the relation of the height of the wave to its length, expressed as a percentage.

[SOURCE: IEC 60404-9:2018, 3.1]

3.2

residual curvature

variations of flatness of a length of strip or a sheet taking a permanent curvature in the direction of rolling of the product

[SOURCE: IEC 60404-9:2018, 3.2]

3.3

edge camber

greatest distance between a longitudinal edge of a length of strip or a sheet and the line joining the two extremities of the measured length of this edge

[SOURCE: IEC 60404-9:2018, 3.3]

3.4

deviation from the shearing line

internal stress

greatest distance between corresponding points on the two sheared edges of a length of strip or a sheet sheared in the middle of the width, in parallel to the direction of rolling of the product, which characterizes the internal stress of the materials

[SOURCE: IEC 60404-9:2018, 3.4]

3.5

number of bends

counts of alternate bending in the reverse bend test prior to the appearance of the first crack in the base metal of the specimen visible to the naked eye or sudden failure occurs by fracture

[SOURCE: IEC TR 63114:2018, 3.2]

4 Classification

The grades covered by this document are classified according to the specified value of maximum specific total loss and according to the nominal thickness of the product¹. The products of the nominal thicknesses 0,35 mm, 0,50 mm, 0,65 mm and 1,00 mm are classified according to the specified values tested at a magnetic polarization of 1,5 T and 50 Hz, in watts per kilogram. The product of the nominal thickness 0,47 mm is classified according to the specified value tested at a magnetic polarization of 1,5 T and 60 Hz, in watts per kilogram.

5 Designation

The steel name comprises the following in the order given:

- a) a letter “M” for electrical steel;
- b) one hundred times the specified value of maximum specific total loss at a magnetic polarization of 1,5 T and 50 Hz, in watts per kilogram, for the products of the nominal thicknesses 0,35 mm, 0,50 mm, 0,65 mm and 1,00 mm, or at a magnetic polarization of 1,5 T and 60 Hz, in watts per kilogram, for the products of the nominal thickness 0,47 mm;
- c) one hundred times the nominal thickness of the product, in millimeters;
- d) the characteristic letter “A” for the grades of cold-rolled non-oriented electrical steel strip or sheet supplied in the fully-processed state;
- e) one tenth of the frequency at which the maximum specific total loss is specified, i.e. 5 or 6.

EXAMPLE M250-35A5 for cold-rolled non-oriented electrical steel strip or sheet with a maximum specific total loss of 2,50 W/kg at a magnetic polarization of 1,5 T and 50 Hz, and a nominal thickness of 0,35 mm, supplied in the fully-processed state.

6 General requirements

6.1 Production process

The production process of the steel and its chemical composition are left to the discretion of the manufacturer.

6.2 Form of supply

The product is supplied in coils in the case of strip and in bundles in the case of sheets.

The mass of coils or bundles of sheets shall be agreed between the manufacturer and the purchaser at the time of enquiry and order.

The recommended value for the internal diameter of coils is approximately 508 mm or approximately 610 mm.

Strip shall be of constant width and wound in such a manner that the edges are superimposed in a regular manner and the side faces of the coil are substantially flat.

Coils shall be sufficiently tightly wound in order that they do not collapse under their own weight.

Strip may exhibit welds or interleaves resulting from the removal of defective zones if agreed between the manufacturer and the purchaser at the time of enquiry and order. If necessary, the marking of welds or interleaves may be agreed between the manufacturer and the purchaser at the time of enquiry and order.

1 In the rest of the document, the word “product” is used to mean “strip and sheet”.

For coils containing welds or interleaves, each part of the strip shall be of the same grade.

The edges of parts welded together shall not be so much out of alignment as to affect the further processing of the product.

Sheets which make up each bundle shall be stacked so that the side faces of the bundle are substantially flat and approximately perpendicular to the top face.

6.3 Delivery condition

The products are usually supplied either without insulation coating or with insulation coating on one or both sides. If the product is supplied with insulation coating, the nature of the coating, its properties, the stacking factor and their verification are subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

NOTE Further information on the classification of surface insulation coatings can be found in IEC 60404-1-1.

6.4 Surface condition

The surfaces shall be smooth and clean, free from grease and rust². Dispersed defects such as scratches, blisters, cracks, etc. are only permitted if they are within the tolerances on thickness and if they are not detrimental to the correct use of the supplied product.

For products supplied with insulation coating, the coating shall be sufficiently adherent so that it does not become detached during manufacturing operations. During the reverse bend test (see 8.4.4.2), the coating shall not become detached after a bend of 90°. If the coating becomes detached during the test, the sample of the product from which the test specimen was taken shall be subjected to a shearing test. By shearing the sample with well sharpened tools, a detachment of large pieces of the coating shall not be admissible. However, some slight chipping of the coating at the sheared edges shall be tolerated.

6.5 Suitability for cutting

The product shall be able to be cut or punched without causing premature wear of tools. The product shall be suitable for cutting or punching accurately into the usual shapes at any point when appropriate cutting or punching tools and technologies are used.

A special requirement concerning suitability for cutting or punching of the product may be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

7 Technical requirements

7.1 Magnetic properties

7.1.1 General

The properties defined in 7.1.2 to 7.1.4 shall apply to products in the delivery conditions defined in 6.3.

For products supplied with insulation coating, the mass of the coating shall be taken into account to determine the magnetic properties.

2 This should not be confused with some coloration of the insulation coating inherent to the manufacturing process.

7.1.2 Magnetic polarization

The specified values of minimum magnetic polarization, expressed as a peak value, at AC magnetic field strengths H of 2 500 A/m, 5 000 A/m and 10 000 A/m, expressed as a peak value, shall be as given in Table 1 at 50 Hz or Table 2 at 60 Hz.

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**Table 1 – Technological properties and magnetic properties
(magnetic properties are measured using the Epstein method according to IEC 60404-2)**

Steel name	Nominal thickness mm	Maximum specific total loss at 1,5 T W/kg		Minimum magnetic polarization ^a at an AC magnetic field strength T			Maximum anisotropy of loss %	Minimum stacking factor	Minimum number of bends	Conventional density ^c kg/dm ³
		at 50 Hz	at 60 Hz ^b	2 500 A/m	5 000 A/m	10 000 A/m				
M210-35A5	0,35	2,10	2,65	1,49	1,60	1,70	±17	0,95	2	7,60
M230-35A5		2,30	2,90	1,49	1,60	1,70	±17		2	7,60
M235-35A5		2,35	2,97	1,49	1,60	1,70	±17		2	7,60
M250-35A5		2,50	3,14	1,49	1,60	1,70	±17		2	7,60
M270-35A5		2,70	3,36	1,49	1,60	1,70	±17		2	7,65
M300-35A5		3,00	3,74	1,49	1,60	1,70	±17		3	7,65
M330-35A5		3,30	4,12	1,49	1,60	1,70	±17		3	7,65
M360-35A5	3,60	4,55	1,49	1,60	1,70	±17	3	7,65		
M230-50A5	0,50	2,30	2,95	1,49	1,60	1,70	±17	0,96	2	7,60
M250-50A5		2,50	3,21	1,49	1,60	1,70	±17		2	7,60
M270-50A5		2,70	3,47	1,49	1,60	1,70	±17		2	7,60
M290-50A5		2,90	3,71	1,49	1,60	1,70	±17		2	7,60
M310-50A5		3,10	3,95	1,49	1,60	1,70	±14		3	7,65
M330-50A5		3,30	4,20	1,49	1,60	1,70	±14		3	7,65
M350-50A5		3,50	4,45	1,50	1,60	1,70	±12		5	7,65
M400-50A5		4,00	5,10	1,53	1,63	1,73	±12		5	7,70
M470-50A5		4,70	5,90	1,54	1,64	1,74	±10		10	7,70
M530-50A5		5,30	6,66	1,56	1,65	1,75	±10		10	7,70
M600-50A5		6,00	7,58	1,57	1,66	1,76	±10		10	7,75
M700-50A5		7,00	8,79	1,60	1,69	1,77	±10		10	7,80
M800-50A5		8,00	10,06	1,60	1,70	1,78	±10		10	7,80
M940-50A5	9,40	11,84	1,62	1,72	1,81	±8	10	7,85		
M1000-50A5	10,00	12,60	1,62	1,72	1,81	±8	10	7,85		

Steel name	Nominal thickness mm	Maximum specific total loss at 1,5 T W/kg		Minimum magnetic polarization ^a at an AC magnetic field strength T			Maximum anisotropy of loss %	Minimum stacking factor	Minimum number of bends	Conventional density ^c kg/dm ³
		at 50 Hz	at 60 Hz ^b	2 500 A/m	5 000 A/m	10 000 A/m				
M310-65A5		3,10	4,08	1,49	1,60	1,70	±15		2	7,60
M330-65A5		3,30	4,30	1,49	1,60	1,70	±15		2	7,60
M350-65A5		3,50	4,57	1,49	1,60	1,70	±14		2	7,60
M400-65A5		4,00	5,20	1,52	1,62	1,72	±14		2	7,65
M470-65A5		4,70	6,13	1,53	1,63	1,73	±12	0,97	5	7,65
M530-65A5	0,65	5,30	6,84	1,54	1,64	1,74	±12		5	7,70
M600-65A5		6,00	7,71	1,56	1,66	1,76	±10		10	7,75
M700-65A5		7,00	8,98	1,57	1,67	1,76	±10		10	7,75
M800-65A5		8,00	10,26	1,60	1,70	1,78	±10		10	7,80
M1000-65A5		10,00	12,77	1,61	1,71	1,80	±10		10	7,80
M600-100A5		6,00	8,14	1,53	1,63	1,72	±10		2	7,60
M700-100A5		7,00	9,38	1,54	1,64	1,73	±8		3	7,65
M800-100A5	1,00	8,00	10,70	1,56	1,66	1,75	±6	0,98	5	7,70
M1000-100A5		10,00	13,39	1,58	1,68	1,76	±6		10	7,80
M1300-100A5		13,00	17,34	1,60	1,70	1,78	±6		10	7,80

^a It has been common practice for many years to give values of magnetic flux density. In fact, the Epstein frame is used to determine magnetic polarization (intrinsic flux density) which is defined as follows in accordance with IEC 60050-121:

$$J = B - \mu_0 H$$

where
 J is the magnetic polarization;
 B is the magnetic flux density;
 μ_0 is the magnetic constant: $4\pi \times 10^{-7} \text{ H m}^{-1}$;
 H is the magnetic field strength.

^b Only for information.

^c Other values may be agreed between the manufacturer and the purchaser at the time of enquiry and order, see Annex B.

Table 2 – Technological properties and magnetic properties for strip and sheet of nominal thickness 0,47 mm for use at 60 Hz only (magnetic properties are measured using the Epstein method according to IEC 60404-2)

Steel name	Nominal thickness mm	Maximum specific total loss at 1,5 T W/kg			Minimum magnetic polarization ^a at an AC magnetic field strength T			Maximum anisotropy of loss %	Minimum stacking factor	Minimum number of bends	Conventional density ^c kg/dm ³
		at 60 Hz			2 500 A/m	5 000 A/m	10 000 A/m				
		at 50 Hz ^b									
M370-47A6		2,92	3,70	1,49	1,60	1,70	±18		2	7,65	
M380-47A6		3,00	3,80	1,49	1,60	1,70	±14		3	7,65	
M408-47A6		3,22	4,08	1,49	1,60	1,70	±14		3	7,65	
M419-47A6		3,31	4,19	1,49	1,60	1,70	±14		3	7,70	
M452-47A6	0,47	3,57	4,52	1,50	1,60	1,70	±14	0,96	5	7,70	
M507-47A6		4,01	5,07	1,51	1,61	1,71	±14		5	7,70	
M638-47A6		5,04	6,38	1,54	1,64	1,74	±12		10	7,75	
M836-47A6		6,60	8,36	1,58	1,68	1,77	±12		10	7,80	
M990-47A6		7,82	9,90	1,58	1,68	1,77	±12		10	7,80	

^a It has been common practice for many years to give values of magnetic flux density. In fact the Epstein frame is used to determine magnetic polarization (intrinsic flux density) which is defined as follows in accordance with IEC 60050-121:

$$J = B - \mu_0 H$$

where

J is the magnetic polarization;

B is the magnetic flux density;

μ_0 is the magnetic constant: $4\pi \times 10^{-7} \text{ H m}^{-1}$;

H is the magnetic field strength.

^b Only for information.

^c Other values may be agreed between the manufacturer and the purchaser at the time of enquiry and order, see Annex B.

7.1.3 Specific total loss

The specified values of maximum specific total loss at a magnetic polarization of 1,5 T and 50 Hz shall be as given in Table 1 for products of the nominal thicknesses 0,35 mm, 0,50 mm, 0,65 mm and 1,00 mm. They apply to:

- aged or non-aged test strips (see 8.3.1), for products of the nominal thicknesses 0,35 mm, 0,50 mm and 0,65 mm;
- non-aged test strips, for products of the nominal thickness 1,00 mm.

The specified values of maximum specific total loss at a magnetic polarization of 1,5 T and 60 Hz shall be as given in Table 2, for products of the nominal thickness 0,47 mm.

A special requirement concerning the value of maximum specific total loss measured using test strips cut parallel to the direction of rolling only or test strips cut perpendicular to the direction of rolling only may be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

NOTE Annex A gives non-specified values of maximum specific total loss at a magnetic polarization of 1,0 T and 50 Hz.

7.1.4 Anisotropy of loss

The permitted values of maximum anisotropy of loss at a magnetic polarization of 1,5 T shall be as given in Table 1 and Table 2.

A special requirement concerning the declaration of the measured value of anisotropy of loss may be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

7.2 Geometrical characteristics and tolerances

7.2.1 Thickness

The nominal thicknesses of the product are 0,35 mm, 0,47 mm, 0,50 mm, 0,65 mm and 1,00 mm.

The nominal thickness 0,47 mm applies only to the grades for use at 60 Hz only.

For thickness tolerance, a distinction is made between

- the deviation from the nominal thickness within an acceptance unit;
- the difference in thickness in a direction parallel to the direction of rolling in a length of strip or sheet;
- the difference in thickness in a direction perpendicular to the direction of rolling. This tolerance applies only to products supplied with a width greater than 150 mm.

At any point, the deviation from the nominal thickness within an acceptance unit shall not exceed the tolerance of Table 3.

The additional thickness due to welds with respect to the measured thickness of the product shall not exceed 0,10 mm.

The difference in thickness in a direction parallel to the direction of rolling in a 1 m length of the product shall not exceed

- 0,030 mm, 0,038 mm and 0,040 mm for products of the nominal thicknesses 0,35 mm, 0,47 mm and 0,50 mm respectively;
- 0,045 mm and 0,060 mm for products of the nominal thicknesses 0,65 mm and 1,00 mm respectively.

Table 3 – Tolerances on nominal thickness

Nominal thickness mm	Tolerance mm
0,35	±0,030
0,47	±0,038
0,50	±0,040
0,65	±0,045
1,00	±0,060

For products supplied with a width greater than 150 mm, the difference in thickness in a direction perpendicular to the direction of rolling shall not exceed

- 0,020 mm for products of the nominal thicknesses 0,35 mm, 0,47 mm and 0,50 mm;
- 0,030 mm for products of the nominal thicknesses 0,65 mm and 1,00 mm.

The measurements shall be made at any point located at least 20 mm from the edges (see 8.4.3.1). For narrow strips, other agreements may be needed.

7.2.2 Width

The commonly available nominal widths are less than or equal to 1 250 mm.

For the tolerances on width, a distinction is made between products supplied with slit edges and products supplied with as-rolled edges.

For products supplied with slit edges, the tolerances of Table 4 shall apply.

Table 4 – Tolerances on nominal width

Nominal width l mm	Tolerance ^a mm
$l \leq 150$	+0,2 0
$150 < l \leq 300$	+0,3 0
$300 < l \leq 600$	+0,5 0
$600 < l \leq 1\ 000$	+1,0 0
$1\ 000 < l \leq 1\ 250$ ^b	+1,5 0
^a By agreement between the manufacturer and the purchaser at the time of enquiry and order, the tolerances on nominal width can be all minus tolerances. ^b Nominal widths greater than 1 250 mm may be delivered. In this case, the tolerance should be agreed between the manufacturer and the purchaser at the time of enquiry and order.	

For products supplied with as-rolled edges, the tolerances on geometric characteristics shall be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

7.2.3 Length

The verification of length does not apply to the products supplied in coils.

For products supplied in sheets, the tolerance on the length of sheets in relation to the length ordered shall be ${}^{+0,5}_0$ %, but with a maximum of +6 mm.

7.2.4 Edge wave (wave factor)

The verification of edge wave applies only to products supplied with a width greater than 100 mm. The wave factor (see 8.4.3.3), shall not exceed 2 %.

7.2.5 Residual curvature

The verification of residual curvature applies only to products supplied with a width greater than 100 mm.

A requirement concerning residual curvature may be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

Two methods for the determination of the residual curvature in the direction of rolling of the product are described in IEC 60404-9: a horizontal method and a vertical method. The horizontal method is recommended from the aspect of worker's safety and consistency with ISO standards.

- Horizontal method:

In this method, the maximum distance between the test specimen and a flat surface table, on which the test specimen is placed, shall not exceed 17,5 mm for products of the nominal thicknesses 0,35 mm, 0,47 mm, 0,50 mm and 0,65 mm. A different maximum distance may be agreed by the manufacturer and the purchaser at the time of enquiry and order. For products of the nominal thickness 1,00 mm, this distance shall be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

- Vertical method:

In this method, the maximum distance between the bottom edge of the test specimen and the supporting plate shall not exceed 35 mm for products of the nominal thicknesses 0,35 mm, 0,47 mm, 0,50 mm and 0,65 mm. For products of the nominal thickness 1,00 mm, this distance shall be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

NOTE The horizontal and vertical methods, with the limits 17,5 mm and 35 mm respectively, are not exactly interchangeable. Which method to use can be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

7.2.6 Edge camber

The verification of edge camber applies only to products supplied with slit edges and a width greater than 30 mm.

The edge camber shall not exceed for a measuring length of 1 m:

- 1,0 mm for the nominal width l , $l > 150$ mm;
- 2,0 mm for the nominal width l , $30 \text{ mm} < l \leq 150$ mm.

7.3 Technological characteristics

7.3.1 Density

The density of the products is not specified.

The conventional values of density used to calculate the magnetic properties and the stacking factor shall be as given in Table 1 and Table 2. Other values may be agreed between the manufacturer and the purchaser at the time of enquiry and order (see Annex B).

7.3.2 Stacking factor

The specified values of minimum stacking factor shall be as given in Table 1 and Table 2, and only apply to products supplied without insulation coating. The values of products supplied with insulation coating are subject to agreement between the manufacture and the purchaser at the time of enquiry and order.

7.3.3 Number of bends

The specified minimum number of bends shall be as given in Table 1 and Table 2. The values apply to test specimens cut perpendicular to the direction of rolling.

7.3.4 Deviation from the shearing line (internal stress)

The products shall be, as far as possible, free from internal stress.

The verification of the deviation from the shearing line applies only to products supplied with a width greater than 150 mm. The measured gap shall not exceed 1 mm for a measuring length of 1 m.

8 Inspection and testing

8.1 General

The products defined by this document can be ordered with or without specific inspection in accordance with ISO 404. However, as a dispensation from ISO 404, in the case of an order without inspection, the manufacturer shall supply an inspection document type 3.1 according to ISO 10474 giving the specific total loss of the supplied product.

In the case of an order with specific inspection, the type of inspection document in accordance with ISO 10474 shall be specified when ordering. In this case, the delivery is divided into acceptance units.

Each acceptance unit shall comprise 20 t or the remaining fraction thereof of the same grade and the same nominal thickness. Different acceptance units can be adopted by special agreement between the manufacturer and the purchaser at the time of enquiry and order.

For coils of more than 20 t, each coil shall constitute an acceptance unit.

Except by special agreement, the same rules apply to the inspection of deviation from the shearing line (internal stress), suitability for cutting, adherence of insulation coating and tolerances on geometrical characteristics.

When the products are delivered in the form of slit coils, the test results made to the parent coil of the acceptance unit shall apply.

8.2 Selection of samples

Test samples shall be taken from each acceptance unit.

In the case of coils, the first internal turn and the last external turn of the coil shall be considered as wrapping and not representative of the quality of the rest of the coil. The selection shall be made from the first external or internal turns, excluding the wrapping turn and outside any welding zones or interleaves.

In the case of sheets, the selection shall be made preferably from the upper part of the bundle.

By choosing a suitable order for the execution of the tests, the same sample shall serve to verify the various properties.

8.3 Preparation of test specimens

8.3.1 Magnetic properties

For the measurement of magnetic polarization and specific total loss using the 25 cm Epstein frame in accordance with IEC 60404-2, the test specimen shall consist of a minimum of 16 Epstein test strips having the following dimensions:

- length 280 mm to 320 mm, the lengths being equal within a tolerance of $\pm 0,5$ mm;
- width 30 mm within a tolerance of $\pm 0,2$ mm.

Half the test strips shall be cut parallel to the direction of rolling and the other half of the test strips shall be cut perpendicular to the direction of rolling. The permitted tolerance for the angle between the specified direction and the direction of cutting or punching is $\pm 5^\circ$.

As far as possible, the selection of test strips shall be made uniformly across the width of the product. The test strips shall be carefully cut without deformation. The cutting or punching shall be carried out only with well-sharpened tools.

If the width of the product is insufficient for a sampling of test strips of the prescribed length to be taken across the width, the test strips shall be cut parallel to the direction of rolling only.

In the case of measurements of specific total loss on aged test strips, the Epstein test strips shall be aged by heating at $(225 \pm 5)^\circ\text{C}$ for a duration of 24 h and shall be cooled to ambient temperature of $(23 \pm 5)^\circ\text{C}$. Other ageing treatment conditions may be used by agreement between the manufacturer and the purchaser at the time of enquiry and order.

8.3.2 Geometrical characteristics and tolerances

For the measurement of thickness, width, edge wave (wave factor), residual curvature, deviation from the shearing line (internal stress) and edge camber, the test specimen shall consist of a 1 m length of strip or sheet.

For the measurement of residual curvature by the vertical method, the test specimen shall consist of a sample $(500^{+2,5}_{0,0})$ mm in length and of width equal to the delivery width of the product.

The tolerance on the length of the test specimen may be agreed between the manufacturer and the purchaser at the time of enquiry and order.

8.3.3 Technological characteristics

8.3.3.1 Stacking factor

The test specimen shall consist of at least 16 strips of the same size; in case of dispute, the test shall be made with 100 strips. The strips shall have a width of at least 20 mm and a surface area of at least $5\,000\text{ mm}^2$. The widths and lengths of the strips shall be equal within the tolerances of $\pm 0,2$ mm and $\pm 0,5$ mm respectively. The test strips shall be carefully deburred before the test.

Epstein test strips may be used for this test (see IEC 60404-2 and IEC 60404-13).

8.3.3.2 Number of bends

Two test specimens at least 20 mm wide shall be taken from outside of the welding zones, perpendicular to the direction of rolling, at a distance of at least 40 mm from the edge and at the middle of the width. The result of reverse bend test shall be the smaller value of the minimum numbers of bends in the two specimens.

The length of the test specimen depends on the test apparatus used to perform the test.

If the width of the product is insufficient for a sampling of test specimens of the prescribed length to be taken across the width, the test specimens shall be taken parallel to the longitudinal axis (the direction of rolling). In this case, the values of Table 1 and Table 2 also apply.

The test specimens shall be carefully cut, without deformation. Epstein test strips may be used for this test (see IEC 60404-2 and IEC TR 63114).

8.4 Test methods

8.4.1 General

For each specified property, one test shall be carried out per acceptance unit. Unless otherwise specified, the tests shall be made at an ambient temperature of (23 ± 5) °C.

8.4.2 Magnetic properties

8.4.2.1 Magnetic polarization and specific total loss

The test shall be made using a 25 cm Epstein frame in accordance with IEC 60404-2.

As an alternative to the Epstein method, the single sheet tester (SST) method specified in IEC 60404-3 may be used by agreement between the manufacturer and the purchaser at the time of enquiry and order. In this case, the specified values to be measured by the SST method can be different from those in Table 1 and Table 2, and may be subject to agreement between the manufacturer and the purchaser at the time of enquiry and order.

8.4.2.2 Anisotropy of loss

Two measurements of the specific total loss in watts per kilogram shall be made, one on 16 Epstein test strips taken perpendicular to the direction of rolling, and one on 16 Epstein test strips taken parallel to the direction of rolling.

The anisotropy of the specific total loss T , expressed as a percentage, is calculated according to the following equation:

$$T = \frac{P_{TD} - P_{RD}}{P_{TD} + P_{RD}} \times 100 \quad (1)$$

where

P_{TD} is the specific total loss, in watts per kilogram, measured in the direction perpendicular to the direction of rolling;

P_{RD} is the specific total loss, in watts per kilogram, measured in the direction parallel to the direction of rolling.

8.4.3 Geometrical characteristics and tolerances

8.4.3.1 Thickness

The measurement of thickness shall be made at any point located at least 20 mm from the edges. For products of a width less than 40 mm, the measurement of thickness shall be made along the longitudinal axis (the direction of rolling) of the product. This measurement shall be made using a micrometer with an uncertainty of 0,002 mm or better.

8.4.3.2 Width

The width shall be measured perpendicular to the longitudinal axis (the direction of rolling) of the product with a calibrated measuring instrument.

8.4.3.3 Edge wave (wave factor)

The wave factor shall be determined in accordance with IEC 60404-9.

8.4.3.4 Residual curvature

The residual curvature in the longitudinal axis (the direction of rolling) of the product shall be determined in accordance with IEC 60404-9.

8.4.3.5 Edge camber

The edge camber shall be determined in accordance with IEC 60404-9.

8.4.4 Technological characteristics

8.4.4.1 Stacking factor

The stacking factor shall be measured in accordance with IEC 60404-13.

8.4.4.2 Number of bends

The test consists of bending the test specimen through 90° alternately to each side of its initial position, according to the method of bending defined by ISO 7799. The radius of bending chosen shall be 5 mm.

A bend of 90° from the initial position with return to the initial position counts as one bend.

The test shall be continued until the specified minimum number of bends given in Table 1 and Table 2 is reached without an occurrence of cracks in the base metal. Alternatively, the test shall be stopped on the appearance of the first crack in the base metal visible to the naked eye, or sudden failure occurs by fracture. The test may be stopped by monitoring a cracking sound from the test specimen or a sudden current change when a constant voltage is applied between the both ends of the test specimen. The occurrence of cracks shall be confirmed by naked eye inspection.

The last bend shall not be counted.

NOTE Further information on the procedure of the reverse bend test can be found in IEC TR 63114.

8.4.4.3 Deviation from the shearing line (Internal stress)

The deviation from the shearing line shall be determined in accordance with IEC 60404-9.

8.5 Retests

When a test does not give the specified result, this test shall be repeated on double the number of test specimens from other sheets of the acceptance unit or on other strips from the coils. The delivery shall be considered to conform with the order if all results of additional tests are in accordance with the requirements of this document.

After re-treatment, the manufacturer has the right to present again for test the acceptance units which had not been found to comply with the order.

9 Marking, labelling and packaging

Marking, labelling and packaging of the products may be agreed between the manufacturer and the purchaser at the time of enquiry and order.

10 Complaints

Internal or external defects shall justify a complaint only if they are clearly prejudicial to the method of working or the judicious use of the product.

The purchaser shall give the manufacturer the opportunity of convincing himself of the fairness of the claim by presenting the product in dispute and evidence for the complaint.

In all cases, the terms and conditions of complaints shall be made in accordance with ISO 404.

11 Information to be supplied by the purchaser

For a product to comply adequately with the requirements of this document, the purchaser shall include the following information in his enquiry or order:

- a) the quantity;
- b) the type of product (strip or sheet);
- c) the number of this document (IEC 60404-8-4);
- d) the steel name (see Clause 5);
- e) the dimensions of strips or sheets required (including any limitations on the internal and external diameters of a coil) (see 6.2 and 7.2.2);
- f) any limitation on the mass of a coil or a bundle of sheets (see 6.2);
- g) any special requirements about the marking of welds or interleaves (see 6.2);
- h) for products supplied with insulation coating, any requirement about the insulation coating and its properties, the stacking factor and their verification (see 6.3);
- i) any special requirement about the suitability for cutting or punching (see 6.5);
- j) any special requirement about the value of maximum specific total loss measured using test strips cut parallel to the direction of rolling only or test strips cut perpendicular to the direction of rolling only (see 7.1.3);
- k) any special requirement about the declaration of the measured value of anisotropy of loss (see 7.1.4);
- l) any special requirement about the thickness measurement and tolerance across the width of narrow strip (see 7.2.1 and 8.4.3.1);
- m) any special requirement about tolerances on the geometric characteristics of products supplied with as-rolled edges (see 7.2.2);
- n) any requirement about the residual curvature (see 7.2.5);

- o) the inspection procedure required including the nature of the related documents (see 8.1);
- p) any special requirement about the specified values to be measured by the single sheet tester (SST) method specified in IEC 60404-3 (see 8.4.2.1);
- q) any requirement about marking, labelling and packaging of the products (see Clause 9).

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Annex A
(informative)

Non-specified magnetic properties

Table A.1 gives the non-specified magnetic properties.

Table A.1 – Non-specified magnetic properties

Steel name	Maximum specific total loss at 1,0 T and 50 Hz W/kg
M210-35A5	0,90
M230-35A5	0,95
M235-35A5	0,95
M250-35A5	1,00
M270-35A5	1,10
M300-35A5	1,20
M330-35A5	1,30
M360-35A5	1,45
M230-50A5	1,00
M250-50A5	1,05
M270-50A5	1,10
M290-50A5	1,15
M310-50A5	1,25
M330-50A5	1,35
M350-50A5	1,50
M400-50A5	1,70
M470-50A5	2,00
M530-50A5	2,30
M600-50A5	2,60
M700-50A5	3,00
M800-50A5	3,60
M940-50A5	4,20
M1000-50A5	4,40
M310-65A5	1,25
M330-65A5	1,35
M350-65A5	1,50
M400-65A5	1,70
M470-65A5	2,00
M530-65A5	2,30
M600-65A5	2,60
M700-65A5	3,00
M800-65A5	3,60
M1000-65A5	4,40
M600-100A5	2,60
M700-100A5	3,00
M800-100A5	3,60
M1000-100A5	4,40
M1300-100A5	5,80

Annex B (informative)

Calculated density of non-oriented electrical steel

A calculated density obtained by Formula (B.1), which is in accordance with ASTM A34/A34M, can be used for the calculation of magnetic properties and the stacking factor by agreement between the manufacturer and the purchaser at the time of enquiry and order (see 7.3.1):

$$\rho = [7,865 - 0,065 \times (C_{Si} + 1,7C_{Al})] \quad (\text{B.1})$$

where

ρ is the calculated density, expressed in kg/dm³;

C_{Si} is the mass fraction of silicon content, expressed in percentage (%);

C_{Al} is the mass fraction of aluminium content, expressed in percentage (%).

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IEC 60404-8-3, *Magnetic materials – Part 8-3: Specifications for individual materials – Cold-rolled electrical non-alloyed and alloyed steel sheet and strip delivered in the semi-processed state*

IEC TR 63114, *Electrical steel – Reverse bend test method of electrical steel strip and sheet*

ASTM A34/A34M, *Standard Practice for Sampling and Procurement Testing of Magnetic Materials*

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SOMMAIRE

AVANT-PROPOS	30
INTRODUCTION	32
1 Domaine d'application	33
2 Références normatives	33
3 Termes et définitions	34
4 Classification	35
5 Désignation	35
6 Exigences générales	35
6.1 Procédé d'élaboration	35
6.2 Mode de livraison	35
6.3 Etat de livraison	36
6.4 Etat de surface	36
6.5 Aptitude au découpage	36
7 Exigences techniques	37
7.1 Caractéristiques magnétiques	37
7.1.1 Généralités	37
7.1.2 Polarisation magnétique	37
7.1.3 Pertes totales spécifiques	41
7.1.4 Anisotropie des pertes	41
7.2 Caractéristiques géométriques et tolérances	41
7.2.1 Epaisseur	41
7.2.2 Largeur	42
7.2.3 Longueur	43
7.2.4 Onde de surface (facteur d'ondulation)	43
7.2.5 Courbure résiduelle	43
7.2.6 Rectitude	44
7.3 Caractéristiques technologiques	44
7.3.1 Masse volumique	44
7.3.2 Facteur de foisonnement	44
7.3.3 Nombre de pliages	44
7.3.4 Ecart par rapport à la ligne de cisailage (contrainte interne)	44
8 Contrôle et essais	45
8.1 Généralités	45
8.2 Prélèvement des échantillons	45
8.3 Préparation des éprouvettes	45
8.3.1 Caractéristiques magnétiques	45
8.3.2 Caractéristiques géométriques et tolérances	46
8.3.3 Caractéristiques technologiques	46
8.4 Méthodes d'essais	47
8.4.1 Généralités	47
8.4.2 Caractéristiques magnétiques	47
8.4.3 Caractéristiques géométriques et tolérances	47
8.4.4 Caractéristiques technologiques	48
8.5 Contre-essais	48
9 Marquage, étiquetage et emballage	48

10 Réclamations.....	49
11 Informations à fournir par l'acheteur	49
Annex A (informative) Caractéristiques magnétiques non spécifiées	50
Annex B (informative) Masse volumique calculée d'un produit magnétique en acier à grains non orientés	51
Bibliographie.....	52

Tableau 1 – Caractéristiques technologiques et magnétiques (les caractéristiques magnétiques sont mesurées à l'aide de la méthode Epstein conformément à l'IEC 60404-2).....	38
Tableau 2 – Caractéristiques technologiques et magnétiques des bandes et tôles d'épaisseur nominale 0,47 mm pour utilisation à 60 Hz seulement (les caractéristiques magnétiques sont mesurées à l'aide de la méthode Epstein conformément à l'IEC 60404-2).....	40
Tableau 3 – Tolérances sur l'épaisseur nominale.....	42
Tableau 4 – Tolérances sur la largeur nominale.....	43
Tableau A.1 – Caractéristiques magnétiques non spécifiées.....	50

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COMMISSION ÉLECTROTECHNIQUE INTERNATIONALE

MATÉRIAUX MAGNÉTIQUES –

**Partie 8-4: Spécifications pour matériaux particuliers –
Bandes et tôles magnétiques en acier à grains non orientés,
laminées à froid et livrées à l'état fini**

AVANT-PROPOS

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L'IEC 60404-8-4 a été établie par le comité d'études 68 de l'IEC: Matériaux magnétiques tels qu'alliages et aciers. Il s'agit d'une Norme internationale.

Cette quatrième édition annule et remplace la troisième édition parue en 2013. Cette édition constitue une révision technique.

Cette édition inclut les modifications techniques majeures suivantes par rapport à l'édition précédente:

- a) modification des termes et des exigences techniques concernant les caractéristiques géométriques dans un souci de cohérence avec l'IEC 60404-9:2018;
- b) insertion du Tableau 3 – Tolérances sur l'épaisseur nominale;

- c) modification de la longueur de l'éprouvette pour la détermination des caractéristiques géométriques de 2 m à 1 m.

Le texte de cette Norme internationale est issu des documents suivants:

Projet	Rapport de vote
68/700/CDV	68/713/RVC

Le rapport de vote indiqué dans le tableau ci-dessus donne toute information sur le vote ayant abouti à son approbation.

La langue employée pour l'élaboration de cette Norme internationale est l'anglais.

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INTRODUCTION

La présente révision de la Norme internationale IEC 60404-8-4 a été établie par les experts du groupe de travail 1 du comité d'études 68 de l'IEC: Matériaux magnétiques tels qu'alliages et aciers.

La troisième édition de l'IEC 60404-8-4 a été publiée en 2013. Après cela, d'autres normes IEC 60404 ont été révisées et le CE 68 de l'IEC a décidé en 2019, lors de sa réunion à Düsseldorf, de réviser le présent document afin de maintenir la cohérence pour la commodité de l'utilisateur. La révision concerne principalement les amendements techniques relatifs aux essais et aux définitions des caractéristiques géométriques conformément à l'IEC 60404-9. La longueur de l'éprouvette pour la détermination des caractéristiques géométriques est modifiée de 2 m à 1 m. Le terme "planéité" est divisé en "onde de surface (facteur d'ondulation)" et "courbure résiduelle" et la méthode horizontale est introduite pour vérification de la courbure résiduelle. La présente révision comprend également des corrections afin d'améliorer la cohérence avec les autres normes de la série IEC 60404-8.

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MATÉRIAUX MAGNÉTIQUES –

Partie 8-4: Spécifications pour matériaux particuliers – Bandes et tôles magnétiques en acier à grains non orientés, laminées à froid et livrées à l'état fini

1 Domaine d'application

La présente partie de l'IEC 60404 définit les qualités des bandes et tôles magnétiques en acier à grains non orientés, laminées à froid, d'épaisseurs nominales 0,35 mm, 0,47 mm, 0,50 mm, 0,65 mm et 1,00 mm. Elle définit notamment les exigences générales, les caractéristiques magnétiques, les caractéristiques géométriques, les tolérances et les caractéristiques technologiques, ainsi que les procédures de contrôle applicables. L'épaisseur nominale 0,47 mm s'applique aux qualités pour utilisation à 60 Hz seulement.

Le présent document s'applique aux bandes et tôles magnétiques en acier à grains non orientés, laminées à froid, livrées à l'état fini, c'est-à-dire à l'état de recuit final, en bobines ou en tôles et destinées à la construction de circuits magnétiques. Le présent document ne s'applique pas aux matériaux livrés à l'état semi-fini.

NOTE Les bandes et tôles magnétiques en acier à grains non orientés, laminées à froid et livrées à l'état semi-fini sont spécifiées dans l'IEC 60404-8-3.

Les qualités définies dans le présent document correspondent à la Classe C21 de l'IEC 60404-1.

2 Références normatives

Les documents suivants sont cités dans le texte de sorte qu'ils constituent, pour tout ou partie de leur contenu, des exigences du présent document. Pour les références datées, seule l'édition citée s'applique. Pour les références non datées, la dernière édition du document de référence s'applique (y compris les éventuels amendements).

IEC 60050-121, *Vocabulaire Electrotechnique International – Partie 121: Electromagnétisme*

IEC 60050-221, *Vocabulaire Electrotechnique International – Chapitre 221: Matériaux et composants magnétiques*

IEC 60404-1, *Matériaux magnétiques – Partie 1: Classification*

IEC 60404-2, *Matériaux magnétiques – Partie 2: Méthodes de mesure des propriétés magnétiques des bandes et tôles magnétiques en acier au moyen d'un cadre Epstein*

IEC 60404-3, *Matériaux magnétiques – Partie 3: Méthodes de mesure des caractéristiques magnétiques des bandes et tôles magnétiques en acier à l'aide de l'essai sur tôle unique*

IEC 60404-9, *Matériaux magnétiques – Partie 9: Méthodes de détermination des caractéristiques géométriques des bandes et tôles magnétiques en acier*

IEC 60404-13, *Matériaux magnétiques – Partie 13: Méthodes de mesure de la résistivité, de la masse volumique et du facteur de foisonnement des bandes et tôles en acier électrique*

ISO 404, *Aciers et produits sidérurgiques – Conditions générales techniques de livraison*

ISO 7799, *Matériaux métalliques – Tôles et feuillards d'épaisseur inférieure ou égale à 3 mm – Essai de pliage alterné*

ISO 10474, *Aciers et produits sidérurgiques – Documents de contrôle*

3 Termes et définitions

Pour les besoins du présent document, les termes et définitions de l'IEC 60050-121 et de l'IEC 60050-221 ainsi que les suivants s'appliquent.

L'ISO et l'IEC tiennent à jour des bases de données terminologiques destinées à être utilisées en normalisation, consultables aux adresses suivantes:

- IEC Electropedia: disponible à l'adresse <http://www.electropedia.org/>
- ISO Online browsing platform: disponible à l'adresse <http://www.iso.org/obp>

3.1

onde de surface

facteur d'ondulation

variations de planéité d'une longueur de bande ou d'une tôle qui prend une forme d'ondes au niveau du bord refendu du produit

Note 1 à l'article: L'onde de surface se caractérise par le facteur d'ondulation qui est le rapport entre la hauteur de l'onde et sa longueur, exprimé en pourcentage.

[SOURCE: IEC 60404-9:2018, 3.1]

3.2

courbure résiduelle

variations de planéité d'une longueur de bande ou d'une tôle qui prend une courbure permanente dans la direction de laminage du produit

[SOURCE: IEC 60404-9:2018, 3.2]

3.3

rectitude

distance la plus grande entre un bord longitudinal d'une longueur de bande ou d'une tôle et la ligne qui joint les deux extrémités de la longueur mesurée de ce bord

[SOURCE: IEC 60404-9:2018, 3.3]

3.4

écart par rapport à la ligne de cisailage

tension interne

distance la plus grande entre des points correspondants de deux bords cisailés d'une longueur de bande ou d'une tôle cisailée au milieu de la largeur, parallèlement à la direction de laminage du produit, qui caractérise la contrainte interne des matériaux

[SOURCE: IEC 60404-9:2018, 3.4]

3.5

nombre de pliages

nombre de pliages alternés dans l'essai de pliage alterné avant l'apparition de la première fissure visible à l'œil nu dans le métal de base de l'éprouvette ou avant qu'une défaillance soudaine se produise par fracture

[SOURCE: IEC TR 63114:2018, 3.2]

4 Classification

Les qualités couvertes par le présent document sont classées selon la valeur spécifiée des pertes totales spécifiques maximales et selon l'épaisseur nominale du produit¹. Les produits d'épaisseurs nominales 0,35 mm, 0,50 mm, 0,65 mm et 1,00 mm sont classés selon les valeurs spécifiées soumises à l'essai pour une polarisation magnétique de 1,5 T et 50 Hz, en watts par kilogramme. Le produit d'épaisseur nominale 0,47 mm est classé d'après la valeur spécifiée soumise à l'essai pour une polarisation magnétique de 1,5 T et 60 Hz, en watts par kilogramme.

5 Désignation

La désignation de l'acier comprend dans l'ordre:

- a) une lettre "M" pour l'acier magnétique;
- b) le centuple de la valeur spécifiée des pertes totales spécifiques maximales pour une polarisation magnétique de 1,5 T et 50 Hz, en watts par kilogramme, pour les produits d'épaisseurs nominales 0,35 mm, 0,50 mm, 0,65 mm et 1,00 mm ou pour une polarisation magnétique de 1,5 T et 60 Hz, en watts par kilogramme, pour les produits d'épaisseur nominale 0,47 mm;
- c) le centuple de l'épaisseur nominale du produit, en millimètres;
- d) la lettre caractéristique "A" pour les qualités des bandes et tôles magnétiques en acier à grains non orientés, laminées à froid, livrées à l'état fini;
- e) le dixième de la fréquence à laquelle les pertes totales spécifiques maximales sont spécifiées, c'est-à-dire 5 ou 6.

EXEMPLE M250-35A5 pour une bande ou tôle magnétique en acier à grains non orientés, laminée à froid, avec des pertes totales spécifiques maximales de 2,50 W/kg pour une polarisation magnétique de 1,5 T et 50 Hz et une épaisseur nominale de 0,35 mm, et livrée à l'état fini.

6 Exigences générales

6.1 Procédé d'élaboration

Le procédé d'élaboration de l'acier et sa composition chimique sont laissés à la discrétion du fabricant.

6.2 Mode de livraison

Le produit est livré en bobines pour les bandes et en paquets pour les tôles.

La masse des bobines ou des paquets pour les tôles doit être fixée par accord entre le fabricant et l'acheteur au moment de la consultation et de la commande.

La valeur recommandée pour le diamètre intérieur des bobines est d'environ 508 mm ou d'environ 610 mm.

1 Dans le reste du document, le mot "produit" est utilisé pour désigner les "bandes et tôles".

La bande doit être de largeur constante et enroulée de sorte que les bords se superposent de manière régulière et que les faces latérales de la bobine soient sensiblement planes.

Les bobines doivent être suffisamment serrées à l'enroulement pour qu'elles ne s'affaissent pas sous leur propre poids.

Les bandes peuvent présenter des soudures ou des discontinuités qui résultent de l'élimination de zones défectueuses en cas d'accord entre le fabricant et l'acheteur au moment de la consultation et de la commande. Si nécessaire, le marquage des soudures ou des discontinuités peut faire l'objet d'un accord entre le fabricant et l'acheteur au moment de la consultation et de la commande.

Pour les bobines qui présentent des soudures ou des discontinuités, chaque partie de bande doit être de même qualité.

Les rives des parties soudées l'une à l'autre ne doivent pas être décalées l'une par rapport à l'autre dans une proportion telle que le traitement ultérieur du produit en soit compromis.

Les tôles qui constituent chaque paquet doivent être empilées de telle sorte que les faces latérales du paquet soient sensiblement planes et approximativement perpendiculaires à la face supérieure.

6.3 Etat de livraison

Les produits sont généralement livrés soit sans revêtement isolant, soit avec revêtement isolant sur une face ou les deux faces. Si le produit est livré avec revêtement isolant, la nature du revêtement, ses propriétés, le facteur de foisonnement et leur vérification font l'objet d'un accord entre le fabricant et l'acheteur au moment de la consultation et de la commande.

NOTE De plus amples informations sur la classification des revêtements isolants de surface peuvent être obtenues dans l'IEC 60404-1-1.

6.4 Etat de surface

Les surfaces doivent être lisses et propres, exemptes de graisses et de rouille². Des défauts dispersés tels que stries, soufflures, fissures, etc. ne sont admis que s'ils se situent dans les limites de tolérance sur l'épaisseur et s'ils ne sont pas préjudiciables à l'utilisation correcte du produit fourni.

Pour les produits livrés avec revêtement isolant, le revêtement doit être suffisamment adhérent pour ne pas se détacher lors des opérations de fabrication. Lors de l'essai de pliage alterné (voir 8.4.4.2), le revêtement ne doit pas se détacher après un pliage à 90°. En cas de décollement du revêtement lors de l'essai, l'échantillon du produit à partir duquel l'éprouvette a été prélevée doit être soumis à un essai de cisailage. En cisillant l'échantillon avec des outils bien affûtés, le décollement de grands morceaux du revêtement ne doit pas être admissible. Cependant, un léger écaillage du revêtement au niveau des bords cisillés doit être toléré.

6.5 Aptitude au découpage

Le produit doit pouvoir être coupé ou poinçonné sans entraîner une usure prématurée des outils. Le produit doit être adapté au découpage ou au poinçonnage précis suivant les formes habituelles en tout point lorsque des outils et des technologies de découpage ou de poinçonnage appropriés sont utilisés.

² Il convient de ne pas confondre cela avec une coloration du revêtement isolant inhérente au processus de fabrication.

Une exigence particulière concernant l'aptitude au découpage ou au poinçonnage du produit peut faire l'objet d'un accord entre le fabricant et l'acheteur au moment de la consultation et de la commande.

7 Exigences techniques

7.1 Caractéristiques magnétiques

7.1.1 Généralités

Les caractéristiques définies du 7.1.2 au 7.1.4 doivent s'appliquer aux produits dans les conditions de livraison définies en 6.3.

Pour les produits livrés avec revêtement isolant, la masse du revêtement doit être prise en compte pour déterminer les caractéristiques magnétiques.

7.1.2 Polarisation magnétique

Les valeurs spécifiées pour la polarisation magnétique minimale, exprimée en valeur de crête, dans le cas d'intensités de champ magnétique en courant alternatif H de 2 500 A/m, 5 000 A/m et 10 000 A/m, exprimées en valeur de crête, doivent correspondre à celles données dans le Tableau 1 à 50 Hz ou dans le Tableau 2 à 60 Hz.

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