
**Heat-treatable steels, alloy steels and
free-cutting steels —**

**Part 3:
Case-hardening steels**

*Aciers pour traitement thermique, aciers alliés et aciers pour
décolletage —*

Partie 3: Aciers pour cémentation

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ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Fax: +41 22 749 09 47
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

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Foreword

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

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

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

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

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

This third edition cancels and replaces the second edition (ISO 683-3:2016), which has been technically revised. The main changes compared with the previous edition are as follows:

- in [Table 1](#), footnote ^a has been added;
- in [Table 3](#), footnote ^e has been changed.

A list of all parts in the ISO 683 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

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Heat-treatable steels, alloy steels and free-cutting steels —

Part 3: Case-hardening steels

1 Scope

This document specifies the technical delivery requirements for

- semi-finished products, hot formed, e.g. blooms, billets, slabs (see NOTE 1),
- bars (see NOTE 1),
- wire rod,
- finished flat products, and
- hammer or drop forgings (see NOTE 1)

manufactured from the case-hardening non-alloy or alloy steels listed in [Table 3](#) and supplied in one of the heat-treatment conditions given for the different types of products in [Table 1](#) and in one of the surface conditions given in [Table 2](#).

The steels are, in general, intended for the manufacture of case-hardened machine parts.

NOTE 1 Hammer-forged semi-finished products (blooms, billets, slabs, etc.), seamless rolled rings and hammer-forged bars are covered under semi-finished products or bars and not under the term “hammer and drop forgings”.

NOTE 2 For International Standards relating to steels complying with the requirements for the chemical composition in [Table 3](#), however, supplied in other product forms or treatment conditions than given above or intended for special applications, and for other related International Standards, see the Bibliography.

In special cases, variations in these technical delivery requirements or additions to them can form the subject of an agreement at the time of enquiry and order (see [5.2](#) and [Annex A](#)).

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

2 Normative references

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

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

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

ISO 642:1999, *Steel — Hardenability test by end quenching (Jominy test)*

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

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

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

ISO 683-3:2019(E)

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

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

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

ISO 6506-1, *Metallic materials — Brinell hardness test — Part 1: Test method*

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

ISO 6929, *Steel products — Vocabulary*

ISO 7788, *Steel — Surface finish of hot-rolled plates and wide flats — Delivery requirements*

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

ISO/TR 9769, *Steel and iron — Review of available methods of analysis*

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

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

3 Terms and definitions

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

NOTE For deviations from these terms and definitions, see NOTE 1 of the Scope and footnote ^a of [Table 2](#).

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

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

3.1
case-hardening steels
steels with a relatively low carbon content, which are carburized or carbonitrided on their surface and subsequently hardened

Note 1 to entry: These steels, after hardening, have a high degree of hardness in the surface zone and good resistance to wear, while the core material is characterized principally by extreme toughness.

Note 2 to entry: Further, possibilities for heat treatment of case-hardening steels are, for example, nitrocarburizing and nitriding.

3.2
non-alloy steel
as defined in ISO 4948-1

3.3
alloy steel
as defined in ISO 4948-1

4 Classification and designation

4.1 Classification

The classification of the relevant steel grades is in accordance with ISO 4948-1 and ISO 4948-2. Steel grades C10E, C10R, C15E, C15R, C16E, C16R and 22Mn6 are non-alloy special steels. All other steel grades covered by this document are alloy special steels.

4.2 Designation

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

A comparison between the designation of steels given in this document with various designation systems is given in [Annex B](#).

5 Information to be supplied by the purchaser

5.1 Mandatory information

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

- a) quantity to be delivered;
- b) designation of the product form (slab, bloom, billet, round bar or square bar, wire rod, wide flats, sheet, plate, strip, forging, etc.);
- c) either the designation of the dimensional standard(s) and the dimensions and tolerances selected from this or these (see [7.8](#)) or, for example, in the case of drop forgings, the designation of the drawing or any other document covering the dimensions and tolerances required for the product;
- d) a reference to this document, i.e. ISO 683-3;
- e) the designation of the steel type given in [Table 3](#);
- f) standard designation for a test report 2.2 or, if required, any other type of inspection document in accordance with ISO 10474 (or in accordance with another regional standard, e.g. EN 10204 or JIS G 0415).

5.2 Options and/or supplementary or special requirements

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

- a) if a heat-treatment condition other than the untreated condition is required, the symbol for this other condition (see [Table 1](#), column 2);
- b) if a surface condition other than "hot worked" or a special surface quality is required, the surface condition (see [Table 2](#)) and the surface quality (see [7.7.3](#));
- c) any requirement for restricted hardenability scatter bands for alloy steels (+HH, +HL; see [7.1.1](#), [Table 6](#) and [Figure 1](#));
- d) if any supplementary requirement shall be complied with, the symbol and, where necessary, the details of this supplementary requirement (see [Annex A](#));
- e) any requirement for the verification of non-metallic inclusion content (see [7.5](#));

- f) verification of hardenability and, if agreed, the information about calculation of the hardenability (see [9.2.2](#));
- g) any requirement concerning suitability of bars and rod for bright drawing (see [7.7.4](#));
- h) any requirement relating to removal of surface defects (see [7.7.5](#)).

5.3 Ordering example

EXAMPLE 50 hot-rolled round bars in accordance with ISO 1035-1 with a nominal diameter of 40 mm and a nominal length of 8 000 mm with diameter tolerance according to class S and with length tolerance according to class L2 of ISO 1035-4 made of steel grade ISO 683-3, 20MnCr5 (see [Table 3](#)) in the heat-treatment condition annealed (+A), surface blast cleaned (+BC) (see [Table 2](#)), product analysis/option [A.3](#) with an inspection certificate 3.1 in accordance with ISO 10474.

50 Round bars ISO 1035 - 40,0S × 8 000L2

ISO 683-3 - 20MnCr5+A+BC, Option A.3

ISO 10474 - 3.1

6 Manufacturing process

6.1 General

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

For minimum reduction ratio or minimum thickness deformation ratio of rolled and forged products, see [A.4](#).

6.2 Deoxidation

All steels shall be deoxidized.

6.3 Heat-treatment condition and surface condition at delivery

6.3.1 Normal condition at delivery

Unless otherwise agreed at the time of enquiry and order, the products shall be delivered in the untreated condition, i.e. hot-worked condition.

6.3.2 Particular heat-treatment condition

If so agreed at the time of enquiry and order, the products shall be delivered in one of the heat-treatment conditions given in [Table 1](#), row numbers 3 to 8.

6.3.3 Particular surface conditions

If so agreed at the time of enquiry and order, the products shall be delivered in one of the particular surface conditions given in [Table 2](#), row numbers 3 to 6.

6.4 Traceability of the cast

The products shall be traceable to the cast, see [Clause 10](#).

7 Requirements

7.1 Chemical composition, hardness and hardenability

7.1.1 General

[Table 1](#) gives a survey on combinations of usual heat-treatment conditions at delivery, product forms and requirements as specified in [Tables 3](#) to [7](#) (chemical composition, hardenability, maximum hardness and hardness range).

7.1.2 Hardenability

Unless otherwise agreed for alloy steels, the hardenability requirements given in [Table 5](#) apply. If agreed at the time of enquiry and order, alloy steels with restricted hardenability scatter bands given in [Table 6](#) or shown in [Figure 1](#) shall be supplied.

A classification of steel grades according to minimum tensile strength as a function of diameter after hardening and tempering is given in [Annex D](#).

7.1.3 Chemical composition

The chemical composition determined by cast analysis shall comply with the values in [Table 3](#).

Permissible deviations between the limiting values for cast analysis and the values for product analysis are given in [Table 4](#).

The product analysis shall be carried out when specified, at the time of the enquiry and order (see [A.3](#)).

7.2 Machinability

All steels are machinable in the conditions “soft-annealed”, “treated to hardness range”, “treated to ferrite/pearlite structure” and “normalized”.

Where improved machinability is required, the grades with a specified sulfur range should be ordered and/or with a specific treatment to improve machinability (see also [Table 3](#), footnote b).

7.3 Cold shearability

7.3.1 Under suitable shearing conditions (avoiding local stress peaks, preheating, application of blades with a profile adapted to that of the product, etc.), all steels are cold shearable in the condition “soft-annealed”.

7.3.2 Steel grades 28Cr4, 28CrS4, 20MnCr5, 20MnCrS5, 24CrMo4, 24CrMoS4, 22CrMoS3-5, 20MoCr4, 20MoCrS4, 16NiCr4, 16NiCrS4, 18NiCr5-4, 17CrNi6-6, 15NiCr13, 17NiCrMo6-4 and 18CrNiMo7-6, are, under suitable conditions, also cold shearable when delivered in the condition “treated to improve shearability” with the hardness requirements given in [Table 7](#).

7.3.3 The non-alloy steels and steels 17Cr3, 17CrS3, 20Cr4, 20CrS4, 16MnCr5, 16MnCrS5, 16MnCrB5, 18CrMo4, 18CrMoS4, 20NiCrMo2-2 and 20NiCrMoS2-2 are, under suitable conditions, cold shearable when delivered in the untreated condition.

7.4 Grain size

Unless otherwise agreed at the time of enquiry and order, the steel shall show a fine grain structure with an austenitic grain size of 5 and finer, when tested in accordance with ISO 643. For verification, see [A.1](#).

7.5 Non-metallic inclusions

7.5.1 Microscopic inclusions

The special steels shall have a certain degree of cleanness, however, verification of the non-metallic inclusion content requires a special agreement. If there is such an agreement at the time of enquiry and order, the microscopic non-metallic inclusion content shall be determined to an agreed procedure and within agreed limits in accordance with ISO 4967 or another regional standard.

For grades with specified minimum sulfur content, the agreement should not include sulphides.

7.5.2 Macroscopic inclusions

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

7.6 Internal soundness

Where appropriate, requirements relating to the internal soundness of the products shall be agreed at the time of inquiry and order (see [A.2](#)).

7.7 Surface condition

7.7.1 All products shall have a smooth surface finish appropriate to the manufacturing processes applied.

7.7.2 Minor surface imperfections which may occur under normal manufacturing conditions, such as prints originating from rolled-in scale, are not to be regarded as defects.

7.7.3 Bars and wire rod are delivered with surface class A in accordance with ISO 9443 and hot-rolled plates and wide flats shall be delivered with a surface in accordance with ISO 7788, unless otherwise agreed at the time of enquiry and order.

Where no International Standard on the surface quality of steel products exists, detailed requirements referring to this characteristic shall, where appropriate, be agreed at the time of enquiry and order.

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

NOTE Bars and wire rod for cold heading and cold extrusion are covered fully by ISO 4954.

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

7.7.5 Removal of surface discontinuities by welding shall only be permitted with the approval of the customer or his/her representative. If surface discontinuities are repaired, the method and maximum depth of removal shall be agreed at the time of enquiry and order.

7.8 Shape, dimensions and tolerances

The nominal dimensions, tolerances on dimensions and shape of the product shall be agreed at the time of enquiry and order, if possible, with reference to the dimensional standards applicable (see [Annex C](#)).

8 Inspection

8.1 Testing procedures and types of documents

8.1.1 Products complying with this document shall be ordered and delivered with one of the inspection documents as specified in ISO 10474 or another standard, e.g. regional standards EN 10204 or JIS G 0415. The type of document shall be agreed upon at the time of enquiry and order. If the order does not contain any specification of this type, a test report shall be issued.

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

- a) confirmation that the material complies with the requirements of the order;
- b) results of the cast analysis for all elements specified in [Table 3](#) for the steel grade concerned.

8.1.3 If, in accordance with the agreements in the order, an inspection certificate 3.1 or 3.2 is to be provided, the specific inspections and tests described in [8.3](#) and [Clause 9](#) shall be carried out and the results shall be confirmed in the inspection certificate.

In addition, the inspection certificate shall cover the following:

- a) confirmation that the material complies with the requirements of the order;
- b) results of the cast analysis for all elements specified in [Table 3](#) for the steel grade concerned;
- c) results of all inspections and tests ordered by supplementary requirements (see [Annex A](#));
- d) the symbol, letters or numbers relating the test certificates, the test pieces and products to each other.

8.2 Frequency of testing

The amount of testing, the sampling conditions and the test methods to be applied for the verification of the requirements shall be in accordance with [Table 9](#).

8.3 Tests to be carried out for specific inspection

8.3.1 General

For non-alloy steels and for alloy steels without requirements concerning the verification of hardenability, the hardness requirements according to [Table 1](#), columns 8.2 and 9.2 and [Table 7](#) are to be verified.

For alloy steels being ordered with the verification of hardenability, unless otherwise agreed, only the hardenability requirements according to [Tables 5](#) and [6](#) are to be verified.

8.3.2 Visual and dimensional inspection

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

9 Test methods

9.1 Chemical analysis

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

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

9.2 Hardness and hardenability tests

9.2.1 Verification of hardness

For products in the heat-treatment conditions +S (treated to improve shearability), +A (soft-annealed), +TH (treated to hardness range), +FP (treated to ferritic-pearlitic structure) and +N (normalized), the hardness shall be measured in accordance with ISO 6506-1 (see [Tables 7](#) and [9](#)).

9.2.2 Verification of hardenability

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

If a calculation formula is not available or in the case of dispute, an end quench hardenability test shall be carried out in accordance with ISO 642 and [Table 9](#). The temperature for quenching shall comply with [Table 8](#). The hardness values shall be determined in accordance with ISO 6508-1, scale C.

9.3 Retests

Retests of case hardening steels and criteria shall be as specified in ISO 404.

10 Marking

The manufacturer shall mark the products or the bundles or boxes containing the products in a suitable way, so that the identification of the cast, the steel type and the origin of the delivery is possible (see [A.5](#)).

Table 1 — Combinations of usual heat-treatment conditions at delivery, product forms and requirements according to Tables 3 to 7

No.	1	2	3	4	5	6	7	8		9				
								Applicable requirements						
		x indicates applicable to		Non-alloy steel grades		Alloy steel grades								
		Semi-finished products		Wire rod		Flat products		Hammer and drop forgings						
		Symbol		Bays		Products		8.1		8.2				
1	Heat-treatment condition at delivery	None or +U	x	x	x	x	x	8.1	8.2	9.1	9.2	9.3		
2	Untreated	None or +U	x	x	x	x	x	—	—	—	—	—		
3	Treated to improve shearability	+S	x	—	—	—	—	Chemical composition according to Tables 3 and 4	Brinell hardness according to Table 7	Column +S	Column +A	Column +TH	Column +FP	Column +N
4	Soft-annealed	+A	x	x	x	x	x	—	—	—	—	—	—	—
5	Treated to hardness range	+TH	—	x	x	x	x	—	—	—	—	—	—	—
6	Treated to ferrite-pearlite structure ^a	+FP	—	x	—	—	x	—	—	—	—	—	—	—
7	Normalized or normalizing forming	+N	—	—	—	x	—	—	—	—	—	—	—	—
8	Others													
		Other treatment conditions, for example certain annealing conditions to achieve a certain structure, may be agreed at the time of enquiry and order.												
		The condition “annealed to achieve a spheroidization of the carbides (+AC)”, as required for cold heading and cold extrusion, is covered in ISO 4954.												
		^a For products of certain grades, a 100 % ferrite-pearlitic structure cannot be achieved, despite an adapted heat-treatment, e.g. isothermal tempering for bars of 18CrNiMo7-6 gives F+P+B structure at any time.												

Table 2 — Surface condition at delivery

No.	1	2	3	4	5	6	7	8	9	
1	Surface condition at delivery		Symbol	x indicates in general applicable to					Hammer and drop forgings (see NOTE 1 to Clause 1)	Notes
				Semi-finished products (as blooms, billets)	Bars	Wire rod	Flat products			
2	Unless otherwise agreed	Hot worked	None or +HW	x ^a	x	x	x	x	—	
3	Particular conditions supplied by agreement	Hot worked and pickled	+PI	x	x	x	x	x	— ^c	
4		Hot worked and blast cleaned	+BC	x	x	x	x	x		
5		Hot worked and rough machined	+RM ^b	—	x	x	—	x		
6		Others	—	—	x	x	x	x		
<p>^a The term “hot worked” also includes the continuously cast (+CC) condition in the case of semi-finished products.</p> <p>^b Until the term “rough machined” is defined by, for example, machining allowances, the details are to be agreed at the time of enquiry and order.</p> <p>^c In addition, certain surface treatments, such as oiled, limed or phosphated, may be agreed upon.</p>										

Table 3 — Steel grades and chemical composition (applicable to cast analysis)^{a,b,c}

Steel name	Mass fraction ^d %								
	C	Si ^e	Mn	P	S	Cr	Mo	Ni	Cu and B
Non-alloy steels									
C10E	0,07 to 0,13	0,15 to 0,40	0,30 to 0,60	0,025	0,035	0,40	0,10	0,40	Cu: 0,30
C10R					0,020 to 0,040				
C15E	0,12 to 0,18	0,15 to 0,40	0,30 to 0,60	0,025	0,035	0,40	0,10	0,40	Cu: 0,30
C15R					0,020 to 0,040				
C16E	0,12 to 0,18	0,15 to 0,40	0,60 to 0,90	0,025	0,035	0,40	0,10	0,40	Cu: 0,30
C16R					0,020 to 0,040				
22Mn6	0,18 to 0,25	0,10 to 0,40	1,30 to 1,65	0,025	0,035	0,40	0,10	0,40	Cu: 0,30
Alloy steels									
17Cr3	0,14 to 0,20	0,15 to 0,40	0,60 to 0,90	0,025	0,035	0,70 to 1,00	—	—	Cu: 0,40
17CrS3					0,020 to 0,040				
20Cr4	0,17 to 0,23	0,15 to 0,40	0,60 to 0,90	0,025	0,035	0,90 to 1,20	—	—	Cu: 0,40
20CrS4					0,020 to 0,040				
28Cr4	0,24 to 0,31	0,40	0,60 to 0,90	0,025	0,035	0,90 to 1,20	—	—	Cu: 0,40
28CrS4					0,020 to 0,040				
16MnCr5	0,14 to 0,19	0,15 to 0,40	1,00 to 1,30	0,025	0,035	0,80 to 1,10	—	—	Cu: 0,40
16MnCrS5					0,020 to 0,040				
16MnCrB5	0,14 to 0,19	0,15 to 0,40	1,00 to 1,30	0,025	0,035	0,80 to 1,10	—	—	Cu: 0,40 B: 0,0008 to 0,0050 ^f
20MnCr5	0,17 to 0,22	0,15 to 0,40	1,10 to 1,40	0,025	0,035	1,00 to 1,30	—	—	Cu: 0,40
20MnCrS5					0,020 to 0,040				
<p>Elements not quoted in this table shall not be intentionally added to the steel without the agreement of the purchaser, other than for the purpose of finishing the heat. All reasonable precautions shall be taken to prevent the addition of such elements from scrap or other materials used in manufacture, which affect the hardenability, mechanical properties and applicability.</p> <p>^a For steels with hardenability requirements (see Tables 5 and 6), except for phosphorus and sulfur, insignificant deviations from the limits for cast analysis are permissible; these deviations shall, however, not exceed in the case of carbon $\pm 0,01$ % and, in all other cases, the values according to Table 4.</p> <p>^b Steels with improved machinability either by higher sulfur levels up to about 0,10 % S (including controlled sulphide morphology) or lead additions may be supplied on request. In the first case, the upper limit of the manganese content may be increased by 0,15 %.</p> <p>^c Additional case-hardening steels, predominantly used for bearings, are covered by ISO 683-17.</p> <p>^d Maximum values unless otherwise stated.</p> <p>^e Steels may be supplied with a lower silicon content. In this case, alternative means of deoxidation shall be used.</p> <p>^f Boron is, in this case, added not for increase of hardenability, but to improve the toughness of the case hardened zone.</p>									

Table 3 (continued)

Steel name	Mass fraction ^d %								
	C	Si ^e	Mn	P	S	Cr	Mo	Ni	Cu and B
18CrMo4	0,15 to 0,21	0,15 to 0,40	0,60 to 0,90	0,025	0,035	0,90 to 1,20	0,15 to 0,25	—	Cu: 0,40
18CrMoS4					0,020 to 0,040				
24CrMo4	0,20 to 0,27	0,10 to 0,40	0,60 to 0,90	0,025	0,035	0,90 to 1,20	0,15 to 0,30	—	Cu: 0,40
24CrMoS4					0,020 to 0,040				
22CrMoS3-5	0,19 to 0,24	0,10 to 0,40	0,70 to 1,00	0,025	0,020 to 0,040	0,70 to 1,00	0,40 to 0,50	—	Cu: 0,40
20MoCr4	0,17 to 0,23	0,10 to 0,40	0,70 to 1,00	0,025	0,035	0,30 to 0,60	0,40 to 0,50	—	Cu: 0,40
20MoCrS4					0,020 to 0,040				
16NiCr4	0,13 to 0,19	0,15 to 0,40	0,70 to 1,00	0,025	0,035	0,60 to 1,00	—	0,80 to 1,10	Cu: 0,40
16NiCrS4					0,020 to 0,040				
18NiCr5-4	0,16 to 0,21	0,15 to 0,40	0,60 to 0,90	0,025	0,035	0,90 to 1,20	—	1,20 to 1,50	Cu: 0,40
17CrNi6-6	0,14 to 0,20	0,15 to 0,40	0,50 to 0,90	0,025	0,035	1,40 to 1,70	—	1,40 to 1,70	Cu: 0,40
15NiCr13	0,12 to 0,18	0,15 to 0,40	0,35 to 0,65	0,025	0,035	0,60 to 0,90	—	3,00 to 3,50	Cu: 0,40
20NiCrMo2-2	0,17 to 0,23	0,15 to 0,40	0,65 to 0,95	0,025	0,035	0,35 to 0,70	0,15 to 0,25	0,40 to 0,70	Cu: 0,40
20NiCrMoS2-2					0,020 to 0,040				
17NiCrMo6-4	0,14 to 0,20	0,15 to 0,40	0,60 to 0,90	0,025	0,035	0,80 to 1,10	0,15 to 0,25	1,20 to 1,60	Cu: 0,40
18CrNiMo7-6	0,15 to 0,21	0,15 to 0,40	0,50 to 0,90	0,025	0,035	1,50 to 1,80	0,25 to 0,35	1,40 to 1,70	Cu: 0,40

Elements not quoted in this table shall not be intentionally added to the steel without the agreement of the purchaser, other than for the purpose of finishing the heat. All reasonable precautions shall be taken to prevent the addition of such elements from scrap or other materials used in manufacture, which affect the hardenability, mechanical properties and applicability.

^a For steels with hardenability requirements (see [Tables 5 and 6](#)), except for phosphorus and sulfur, insignificant deviations from the limits for cast analysis are permissible; these deviations shall, however, not exceed in the case of carbon $\pm 0,01$ % and, in all other cases, the values according to [Table 4](#).

^b Steels with improved machinability either by higher sulfur levels up to about 0,10 % S (including controlled sulphide morphology) or lead additions may be supplied on request. In the first case, the upper limit of the manganese content may be increased by 0,15 %.

^c Additional case-hardening steels, predominantly used for bearings, are covered by ISO 683-17.

^d Maximum values unless otherwise stated.

^e Steels may be supplied with a lower silicon content. In this case, alternative means of deoxidation shall be used.

^f Boron is, in this case, added not for increase of hardenability, but to improve the toughness of the case hardened zone.

Table 4 — Permissible deviations between the product analysis and the limiting values given in [Table 3](#) for the cast analysis

Element	Permissible maximum content or range according to cast analysis mass fraction %	Permissible deviation ^a mass fraction %
C	$0,07 < C \leq 0,27$	$\pm 0,02$
Si	$\leq 0,40$	$\pm 0,03$
Mn	$\leq 1,00$	$\pm 0,04$
	$1,00 < Mn \leq 1,65$	$\pm 0,06$
P	$\leq 0,035$	$+0,005$
S	$\leq 0,040$	$\pm 0,005$
Cr	$\leq 1,80$	$\pm 0,05$
Mo	$\leq 0,30$	$\pm 0,03$
	$0,30 < Mo \leq 0,50$	$\pm 0,04$
Ni	$\leq 1,00$	$\pm 0,03$
	$1,00 < Ni \leq 2,00$	$\pm 0,05$
	$2,00 < Ni \leq 3,50$	$\pm 0,07$
Cu	$\leq 0,40$	$+0,05$
B	$\leq 0,005 0$	$\pm 0,000 3$

^a \pm means that in one cast, the deviation can occur over the upper value or under the lower value of the specified range in [Table 3](#), but not both at the same time.

Table 5 — Hardness limits for steel grades with specified (normal) hardenability (+H-grades; see 7.1.1)

Steel name	Symbol	Limit of range	Hardness HRC at a distance, in millimetres, from quenched end of test piece of												
			1,5	3	5	7	9	11	13	15	20	25	30	35	40
17Cr3 17CrS3	+H	max.	47	44	40	33	29	27	25	24	23	21	—	—	—
		min.	39	35	25	20	—	—	—	—	—	—	—	—	—
20Cr4 20CrS4	+H	max.	49	48	46	42	38	36	34	32	29	27	26	24	23
		min.	41	38	31	26	23	21	—	—	—	—	—	—	—
28Cr4 28CrS4	+H	max.	53	52	51	49	45	42	39	36	33	30	29	28	27
		min.	45	43	39	29	25	22	20	—	—	—	—	—	—
16MnCr5 16MnCrS5 16MnCrB5	+H	max.	47	46	44	41	39	37	35	33	31	30	29	28	27
		min.	39	36	31	28	24	21	—	—	—	—	—	—	—
20MnCr5 20MnCrS5	+H	max.	49	49	48	46	43	42	41	39	37	35	34	33	32
		min.	41	39	36	33	30	28	26	25	23	21	-	-	-
18CrMo4 18CrMoS4	+H	max.	47	46	45	42	39	37	35	34	31	29	28	27	26
		min.	39	37	34	30	27	24	22	21	—	—	—	—	—
24CrMo4 24CrMoS4	+H	max.	52	52	51	50	48	46	43	41	37	35	33	32	31
		min.	44	43	40	37	34	32	29	27	23	21	20	—	—
22CrMoS3-5	+H	max.	50	49	48	47	45	43	41	40	37	35	34	33	32
		min.	42	41	37	33	31	28	26	25	23	22	21	20	—
20MoCr4 20MoCrS4	+H	max.	49	47	44	41	38	35	33	31	28	26	25	24	24
		min.	41	37	31	27	24	22	—	—	—	—	—	—	—
16NiCr4 16NiCrS4	+H	max.	47	46	44	42	40	38	36	34	32	30	29	28	28
		min.	39	36	33	29	27	25	23	22	20	—	—	—	—
18NiCr5-4	+H	max.	49	48	46	44	42	39	37	36	34	32	31	31	30
		min.	41	39	35	32	29	27	25	24	21	20	—	—	—
17CrNi6-6	+H	max.	47	47	46	45	43	42	41	39	37	35	34	34	33
		min.	39	38	36	35	32	30	28	26	24	22	21	20	20
15NiCr13	+H	max.	46	46	46	46	45	44	43	41	38	35	34	34	33
		min.	38	37	36	34	31	29	27	26	24	22	22	21	21
20NiCrMo2-2 20NiCrMoS2-2	+H	max.	49	48	45	42	36	33	31	30	27	25	24	24	23
		min.	41	37	31	25	22	20	—	—	—	—	—	—	—
17NiCrMo6-4	+H	max.	48	48	47	46	45	44	42	41	38	36	35	34	33
		min.	40	39	37	34	30	28	27	26	24	23	22	21	—
18CrNiMo7-6	+H	max.	48	48	48	48	47	47	46	46	44	43	42	41	41
		min.	40	40	39	38	37	36	35	34	32	31	30	29	29

Table 6 — Hardness limits for steels with narrowed hardenability scatterbands (+HH- and +HL-grades)

Steel name	Symbol	Limit of range	Hardness HRC at a distance, in millimetres, from quenched end of test piece (in millimetres) of												
			1,5	3	5	7	9	11	13	15	20	25	30	35	40
17Cr3 17CrS3	+HH	max.	47	44	40	33	29	27	25	24	23	21	—	—	—
		min.	42	38	30	24	20	—	—	—	—	—	—	—	—
	+HL	max.	44	41	35	29	25	23	21	20	—	—	—	—	—
		min.	39	35	25	20	—	—	—	—	—	—	—	—	—
20Cr4 20CrS4	+HH	max.	49	48	46	42	38	36	34	32	29	27	26	24	23
		min.	44	41	36	31	28	26	24	22	—	—	—	—	—
	+HL	max.	46	45	41	37	33	31	29	27	24	22	21	—	—
		min.	41	38	31	26	23	21	—	—	—	—	—	—	—
28Cr4 28CrS4	+HH	max.	53	52	51	49	45	42	39	38	33	30	29	28	27
		min.	48	46	43	36	32	29	26	23	20	—	—	—	—
	+HL	max.	50	49	47	42	38	35	33	30	27	24	23	22	21
		min.	45	43	39	29	25	22	20	—	—	—	—	—	—
16MnCr5 16MnCrS5 16MnCrB5	+HH	max.	47	46	44	41	39	37	35	33	31	30	29	28	27
		min.	42	39	35	32	29	26	24	22	20	—	—	—	—
	+HL	max.	44	43	40	37	34	32	30	28	26	25	24	23	22
		min.	39	36	31	28	24	21	—	—	—	—	—	—	—
20MnCr5 20MnCrS5	+HH	max.	49	49	48	46	43	42	41	39	37	35	34	33	32
		min.	44	42	40	37	34	33	31	30	28	26	25	24	23
	+HL	max.	46	46	44	42	39	37	36	34	32	30	29	28	27
		min.	41	39	36	33	30	28	26	25	23	21	—	—	—
18CrMo4 18CrMoS4	+HH	max.	47	46	45	42	39	37	35	34	31	29	28	27	26
		min.	42	40	38	34	31	28	26	25	22	20	—	—	—
	+HL	max.	44	43	41	38	35	33	31	30	27	25	24	23	22
		min.	39	37	34	30	27	24	22	21	—	—	—	—	—
24CrMo4 24CrMoS4	+HH	max.	52	52	51	50	48	46	43	41	37	35	33	32	31
		min.	47	46	44	41	39	37	34	32	28	26	24	23	22
	+HL	max.	49	49	47	46	43	41	38	36	32	30	29	28	27
		min.	44	43	40	37	34	32	29	27	23	21	20	—	—
22CrMoS3-5	+HH	max.	50	49	48	47	45	43	41	40	37	35	34	33	32
		min.	45	44	41	38	36	33	31	30	28	26	25	24	23
	+HL	max.	47	46	44	42	40	38	36	35	32	31	30	29	28
		min.	42	41	37	33	31	28	26	25	23	22	21	20	—
20MoCr4 20MoCrS4	+HH	max.	49	47	44	41	38	35	33	31	28	26	25	24	24
		min.	44	40	35	32	29	26	24	22	—	—	—	—	—
	+HL	max.	46	44	40	36	33	31	29	27	24	22	21	20	20
		min.	41	37	31	27	24	22	—	—	—	—	—	—	—
16NiCr4 16NiCrS4	+HH	max.	47	46	44	42	40	38	36	34	32	30	29	28	28
		min.	42	39	37	33	31	29	27	26	24	22	21	20	20
	+HL	max.	44	43	40	38	36	34	32	30	28	26	25	24	24
		min.	39	36	33	29	27	25	23	22	20	—	—	—	—

Table 6 (continued)

Steel name	Symbol	Limit of range	Hardness HRC at a distance, in millimetres, from quenched end of test piece (in millimetres) of												
			1,5	3	5	7	9	11	13	15	20	25	30	35	40
18NiCr5-4	+HH	max.	49	48	46	44	42	39	37	36	34	32	31	31	30
		min.	44	42	39	36	33	31	29	28	25	24	23	23	22
	+HL	max.	46	45	42	40	38	35	33	32	30	28	27	27	26
		min.	41	39	35	32	29	27	25	24	21	20	—	—	—
17CrNi6-6	+HH	max.	47	47	46	45	43	42	41	39	37	35	34	34	33
		min.	42	41	39	38	36	34	32	30	28	26	25	25	24
	+HL	max.	44	44	43	42	39	38	37	35	33	31	30	29	29
		min.	39	38	36	35	32	30	28	26	24	22	21	20	20
15NiCr13	+HH	max.	46	46	46	46	45	44	43	41	38	35	34	34	33
		min.	41	40	39	38	36	34	32	31	29	26	26	25	25
	+HL	max.	43	43	43	42	40	39	38	36	33	31	30	30	29
		min.	38	37	36	34	31	29	27	26	24	22	22	21	21
20NiCrMo2-2 20NiCrMoS2-2	+HH	max.	49	48	45	42	36	33	31	30	27	25	24	24	23
		min.	44	41	36	31	27	24	22	21	—	—	—	—	—
	+HL	max.	46	44	40	36	31	29	27	26	23	21	20	20	—
		min.	41	37	31	25	22	20	—	—	—	—	—	—	—
17NiCrMo6-4	+HH	max.	48	48	47	46	45	44	42	41	38	36	35	34	33
		min.	43	42	40	38	35	33	32	31	29	27	26	25	24
	+HL	max.	45	45	44	42	40	39	37	36	33	32	31	30	29
		min.	40	39	37	34	30	28	27	26	24	23	22	21	—
18CrNiMo7-6	+HH	max.	48	48	48	48	47	47	46	46	44	43	42	41	41
		min.	43	43	42	41	40	40	39	38	36	35	34	33	33
	+HL	max.	45	45	45	45	44	43	42	42	40	39	38	37	37
		min.	40	40	39	38	37	36	35	34	32	31	30	29	29

Table 7 — Hardness requirements for products delivered in the conditions “treated to improve shearability (+S)”, “soft-annealed (+A)”, “treated to hardness range (+TH)”, “treated to ferrite-pearlite structure (+FP)” or “normalized (+N)”

Steel name	Brinell hardness in condition							
	+S max.	+A max.	+TH min. max.		+FP min. max.		+N min. max.	
Non-alloy steels								
C10E C10R	—	131	—	—	—	—	85	140
C15E C15R	—	143	—	—	—	—	95	150
C16E C16R	—	156	—	—	—	—	100	155
22Mn6	—	197	149	197	—	—	—	—
Alloy steels								
17Cr3 17CrS3	—	174	—	—	—	—	—	—
20Cr4 20CrS4	—	197	149	197	—	—	—	—
28Cr4 28CrS4	255	217	166	217	156	207	—	—
16MnCr5 16MnCrS5 16MnCrB5	—	207	156	207	140	187	138	187
20MnCr5 20MnCrS5	255	217	170	217	152	201	140	201
18CrMo4 18CrMoS4	—	207	156	207	140	187	—	—
24CrMo4 24CrMoS4	255	212	—	—	—	—	—	—
22CrMoS3-5	255	217	170	217	152	201	—	—
20MoCr4 20MoCrS4	255	207	156	207	140	187	—	—
16NiCr4 16NiCrS4	255	217	166	217	156	207	—	—
18NiCr5-4	255	223	170	223	156	207	—	—
17CrNi6-6	255	229	175	229	156	207	—	—
15NiCr13	255	229	179	229	166	217	—	—
20NiCrMo2-2 20NiCrMoS2-2	—	212	161	212	149	194	—	—
17NiCrMo6-4	255	229	179	229	149	201	—	—
18CrNiMo7-6	255	229	179	229	159	207	—	—

Table 8 — Conditions for heat treating test bars and treatment of the steels

Steel name	End quench test austenitizing temperature ^a	Carburizing temperature ^b	Direct and simple hardening temperature ^{c,d}	Double hardening ^c		Tempering temperature ^e
	°C			°C	Core-hardening temperature ^d	
Non-alloy steels						
C10E C10R	—	880 to 980	830 to 870	880 to 920	780 to 820	150 to 200
C15E C15R	—	880 to 980	830 to 870	880 to 920	780 to 820	150 to 200
C16E C16R	—	880 to 980	830 to 870	880 to 920	780 to 820	150 to 200
22Mn6	—	880 to 980	830 to 870	880 to 920	780 to 820	150 to 200
Alloy steels						
17Cr3 17CrS3	880 ± 5	880 to 980	820 to 860	860 to 900	780 to 820	150 to 200
20Cr4 20CrS4	900 ± 5	880 to 980	820 to 860	860 to 900	780 to 820	150 to 200
28Cr4 28CrS4	850 ± 5	880 to 980	820 to 860	860 to 900	780 to 820	150 to 200
16MnCr5 16MnCrS5 16MnCrB5	900 ± 5	880 to 980	820 to 860	860 to 900	780 to 820	150 to 200
20MnCr5 20MnCrS5	900 ± 5	880 to 980	820 to 860	860 to 900	780 to 820	150 to 200
18CrMo4 18CrMoS4	900 ± 5	880 to 980	820 to 860	860 to 900	780 to 820	150 to 200
24CrMo4 24CrMoS4	900 ± 5	880 to 980	820 to 860	860 to 900	780 to 820	150 to 200
22CrMoS3-5	900 ± 5	880 to 980	820 to 860	860 to 900	780 to 820	150 to 200
20MoCr4 20MoCrS4	910 ± 5	880 to 980	820 to 860	860 to 900	780 to 820	150 to 200
16NiCr4 16NiCrS4	880 ± 5	880 to 980	820 to 860	850 to 890	780 to 820	150 to 200
18NiCr5-4	880 ± 5	880 to 980	820 to 860	840 to 880	780 to 820	150 to 200
17CrNi6-6	870 ± 5	880 to 980	820 to 860	830 to 870	780 to 820	150 to 200
15NiCr13	850 ± 5	880 to 980	810 to 850	840 to 880	780 to 820	150 to 200
<p>The temperatures given for carburizing, direct and simple hardening, core-hardening, case-hardening and tempering are for guidance; the actual temperatures chosen should be those that give the required properties.</p> <p>a Time for austenitizing as a guide: 30 min minimum.</p> <p>b The carburizing temperature depends on the chemical composition of the steel, the mass of the product and the carburizing medium. If the steels are direct hardened, in general, a temperature of 950 °C is not exceeded. For special procedures, for example, under vacuum, higher temperatures (for example 1 020 °C to 1 050 °C) are not unusual.</p> <p>c The kind of quenching agent depends on, for example, the shape of the products, the cooling conditions and the amount of furnace filling.</p> <p>d If the steels are direct hardened and if there is a danger of distortion, they should be quenched from a temperature between the core-hardening and case-hardening temperatures.</p> <p>e Time for tempering as a guide: 1 h minimum.</p>						

Table 8 (continued)

Steel name	End quench test austenitizing temperature ^a	Carburizing temperature ^b	Direct and simple hardening temperature ^{c,d}	Double hardening ^c		Tempering temperature ^e
				Core-hardening temperature ^d	Case-hardening temperature ^d	
	°C	°C	°C	°C	°C	°C
20NiCrMo2-2 20NiCr-MoS2-2	900 ± 5	880 to 980	820 to 860	860 to 900	780 to 820	150 to 200
17NiCrMo6-4	900 ± 5	880 to 980	810 to 850	830 to 870	780 to 820	150 to 200
18CrNiMo7-6	860 ± 5	880 to 980	810 to 850	830 to 870	780 to 820	150 to 200

The temperatures given for carburizing, direct and simple hardening, core-hardening, case-hardening and tempering are for guidance; the actual temperatures chosen should be those that give the required properties.

a Time for austenitizing as a guide: 30 min minimum.

b The carburizing temperature depends on the chemical composition of the steel, the mass of the product and the carburizing medium. If the steels are direct hardened, in general, a temperature of 950 °C is not exceeded. For special procedures, for example, under vacuum, higher temperatures (for example 1 020 °C to 1 050 °C) are not unusual.

c The kind of quenching agent depends on, for example, the shape of the products, the cooling conditions and the amount of furnace filling.

d If the steels are direct hardened and if there is a danger of distortion, they should be quenched from a temperature between the core-hardening and case-hardening temperatures.

e Time for tempering as a guide: 1 h minimum.

Table 9 — Test conditions for the verification of the requirements given in column 1

No.	1	2	Amount of testing		5	6
	Requirements		Number of			
	See Table	Test unit ^a	Sample products per test unit	Tests per sample product		
1	Chemical composition	3 and 4	C	(The cast analysis is given by the manufacturer; for product analysis, see A.3)		
2	Hardenability	5 and 6	C	1	1	In cases of dispute, if possible, the sampling method given in ISO 642:1999, 5.1, a) or b 1) shall be applied. In all other cases, the sampling method, including the method which starts from separately cast and subsequently hot-worked test ingots or from cast and not hot-worked samples is, unless otherwise agreed at the time of enquiry and order, left to the discretion of the manufacturer. The test shall be carried out in conformity with ISO 642. The quenching temperature shall be as specified in Table 8 . The hardness values shall be determined in accordance with method C of ISO 6508-1.
<p>NOTE Verification of the requirements is only necessary if an inspection certificate is ordered and if the requirement is applicable to Table 1, column 8 or 9.</p> <p>^a The tests shall be carried out separately for each cast as indicated by “C”, each dimension as indicated by “D” and each heat-treatment batch as indicated by “T”.</p> <p>Products with different thickness may be grouped if the thicknesses lie in the same dimensional range for mechanical properties and if the differences in thickness do not affect the properties. In cases of doubt, the thinnest and the thickest product shall be tested.</p> <p>^b The general conditions for the selection and preparation of samples and test pieces should be in accordance with ISO 377 and ISO 14284.</p>						

Table 9 (continued)

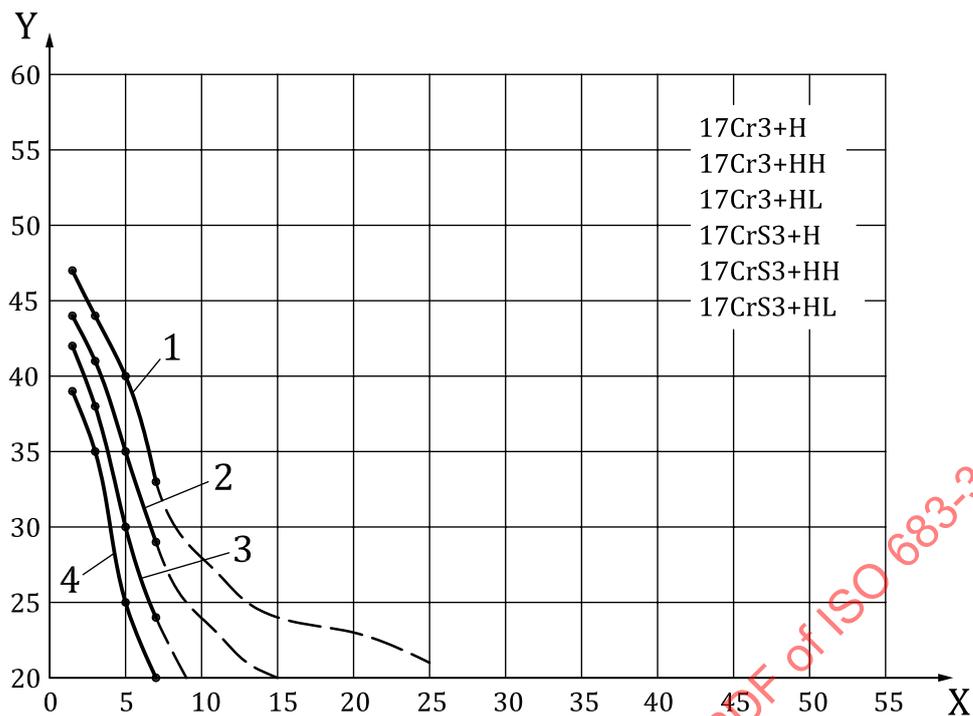
No.	1	2	Amount of testing		Sampling ^b	Test method	
	Requirements		Number of				
	See Table	Test unit ^a	Sample products per test unit	Tests per sample product			
3	Hardness				Hardness tests		
3a	Hardness in the condition +S or +A, +TH or FP	7	C and D and T	1	1	<p>In case of dispute, the hardness shall be measured, if possible, at following point of the surface:</p> <ul style="list-style-type: none"> — in case of round bars at a distance equal to the diameter from one end of the bar. — in case of bars with square and rectangular cross section and in case of flat products at a distance equal to the thickness from one end and 0,25 w (w = width of the product) from one longitudinal edge. <p>If, for example, for hammer and drop forgings, the above requirements prove unrealistic, agreement shall be agreed at the time of enquiry and order about more appropriate position of the hardness indentations.</p> <p>For sample preparation, see ISO 6506-1.</p>	In accordance with ISO 6506-1.
3b	Hardness in the condition +N	7	C	1	1	<p>The test shall be performed near the surface.</p>	In accordance with ISO 6506-1.

NOTE Verification of the requirements is only necessary if an inspection certificate is ordered and if the requirement is applicable to Table 1, column 8 or 9.

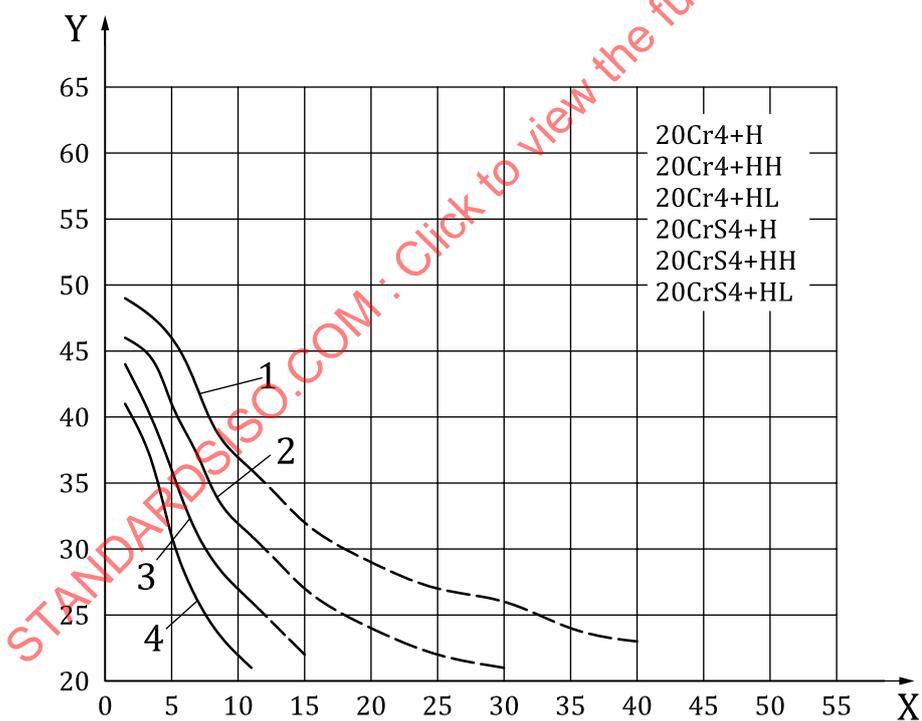
^a The tests shall be carried out separately for each cast as indicated by "C", each dimension as indicated by "D" and each heat-treatment batch as indicated by "T".

Products with different thickness may be grouped if the thicknesses lie in the same dimensional range for mechanical properties and if the differences in thickness do not affect the properties. In cases of doubt, the thinnest and the thickest product shall be tested.

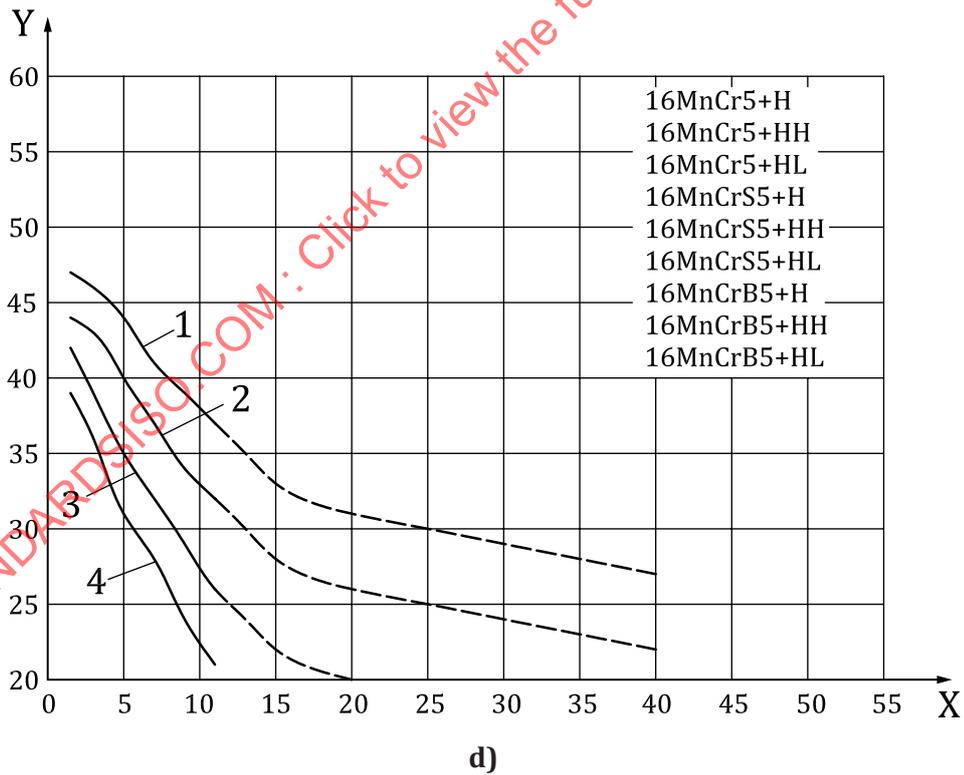
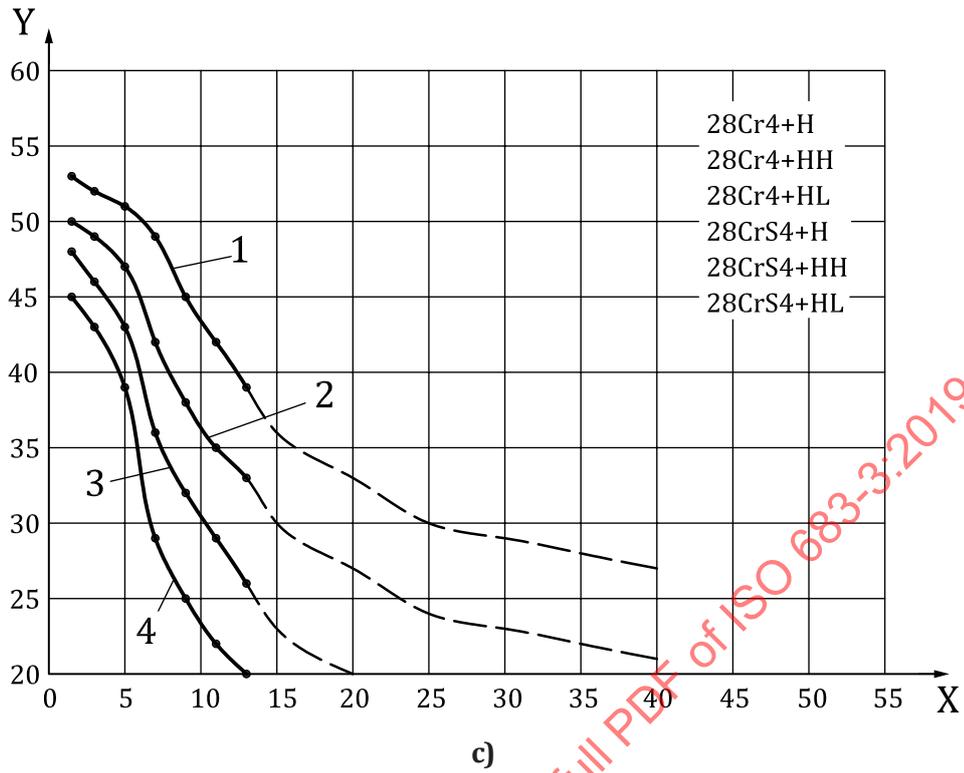
^b The general conditions for the selection and preparation of samples and test pieces should be in accordance with ISO 377 and ISO 14284.

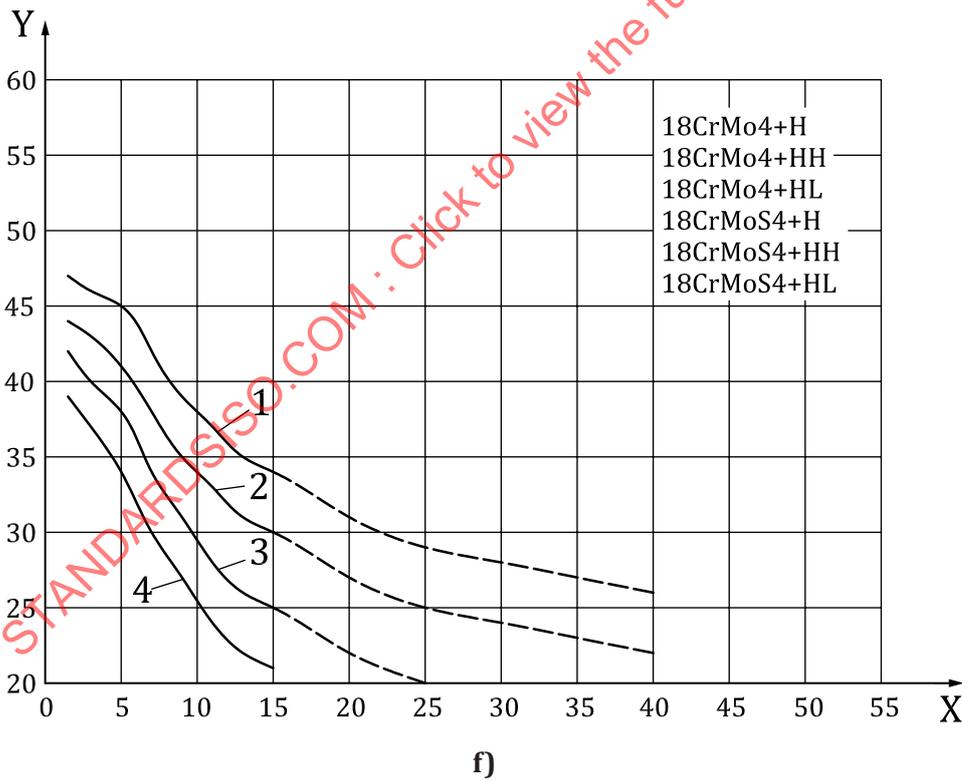
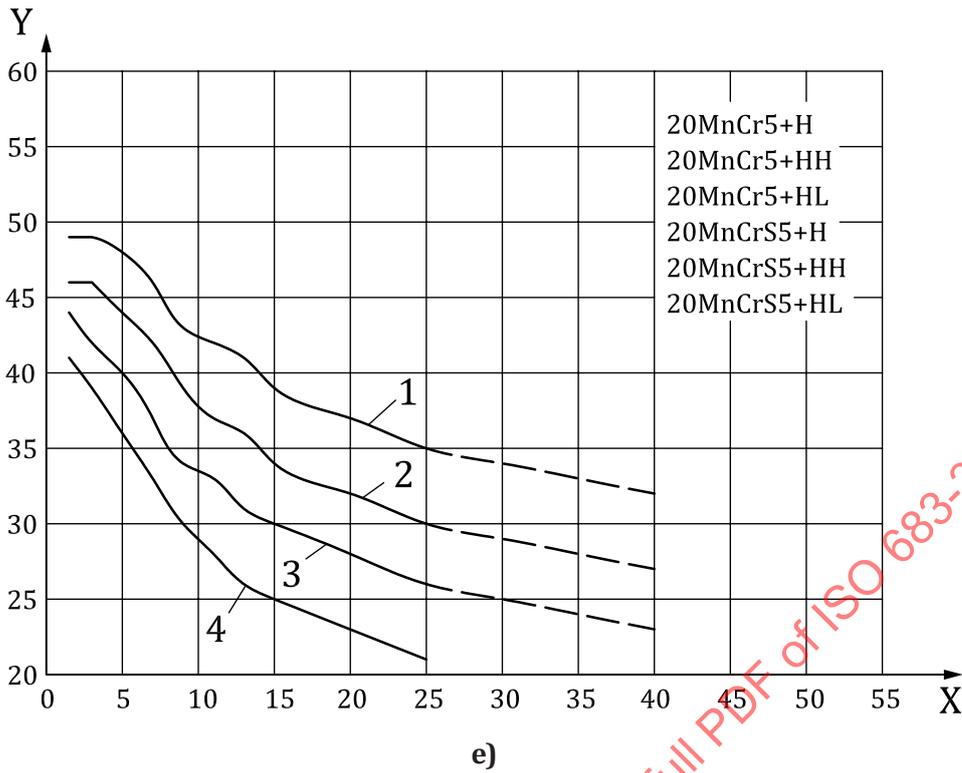


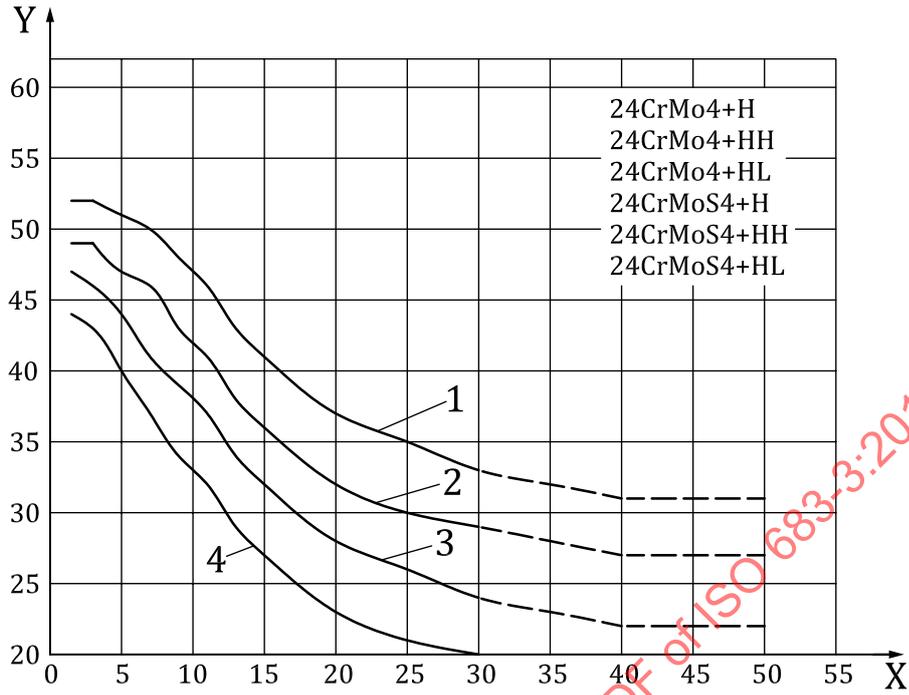
a)



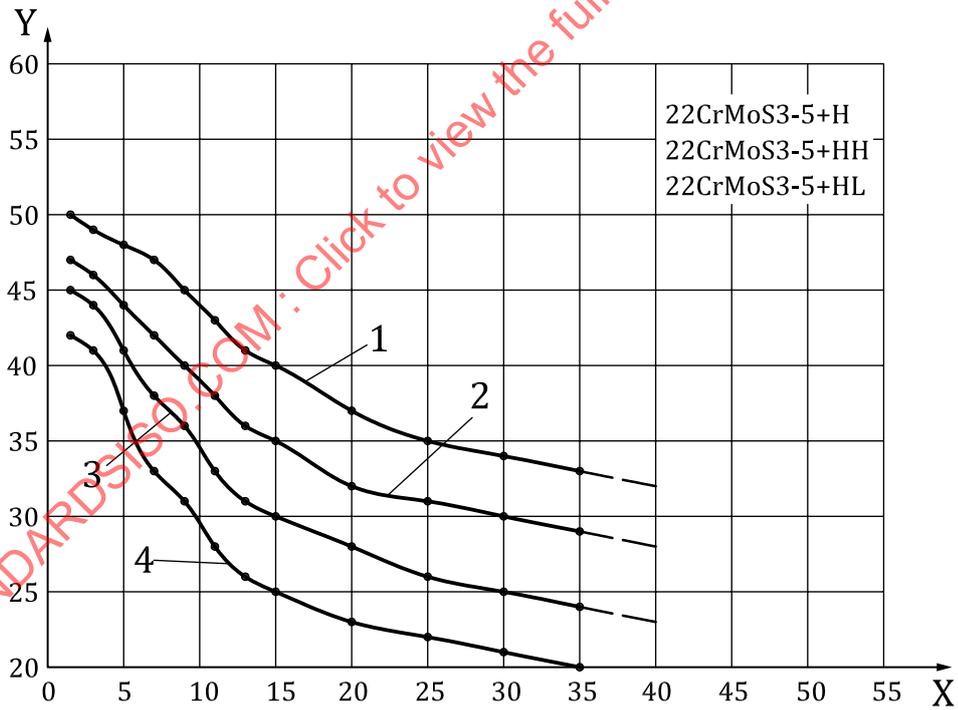
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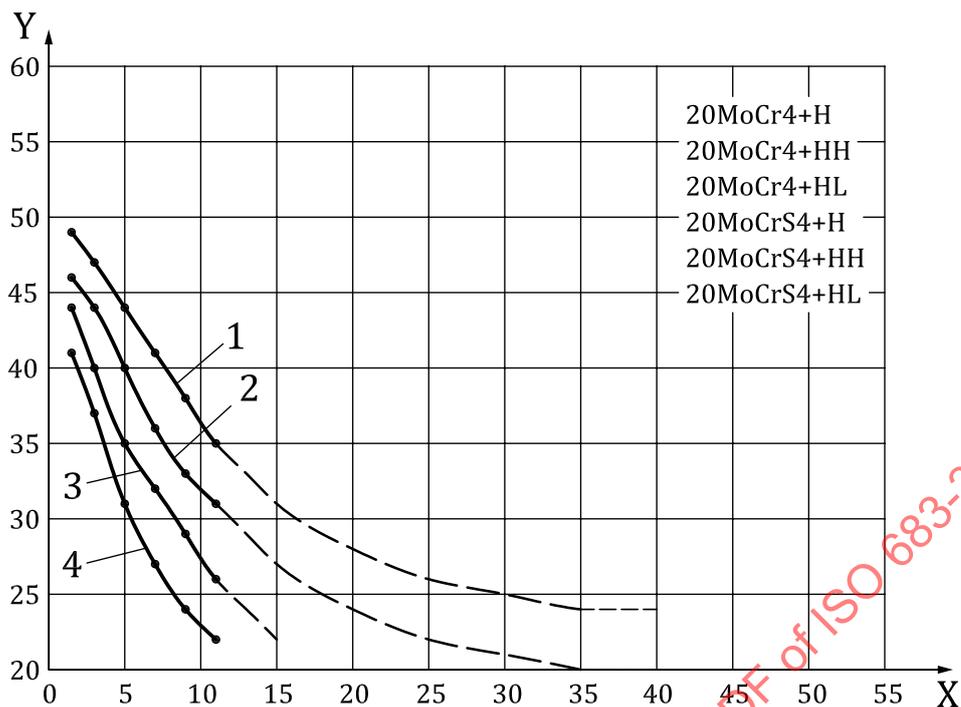




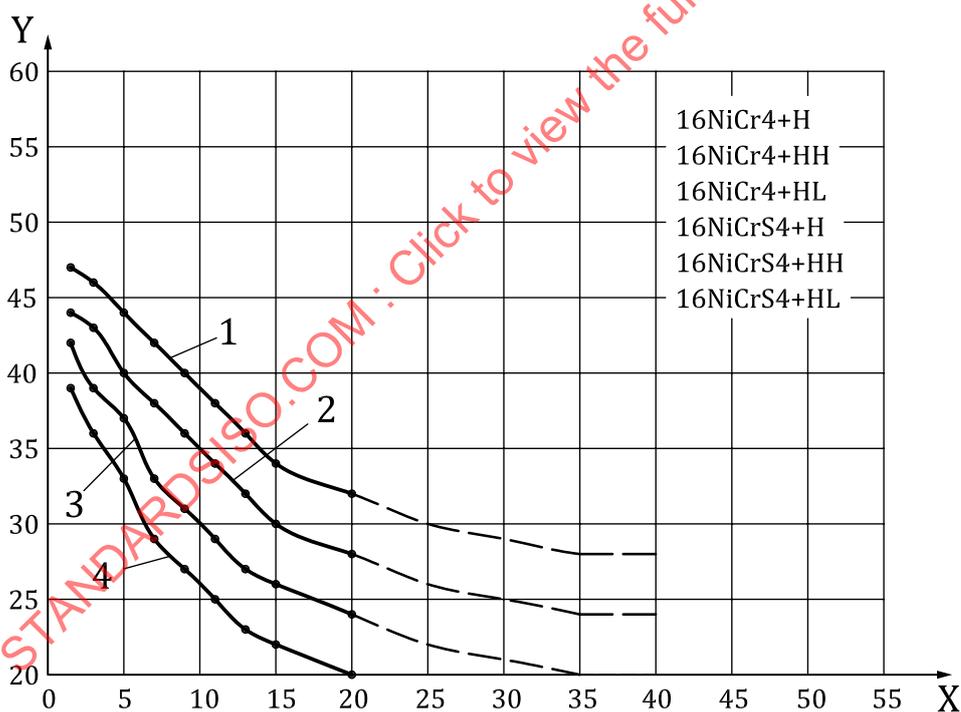
g)



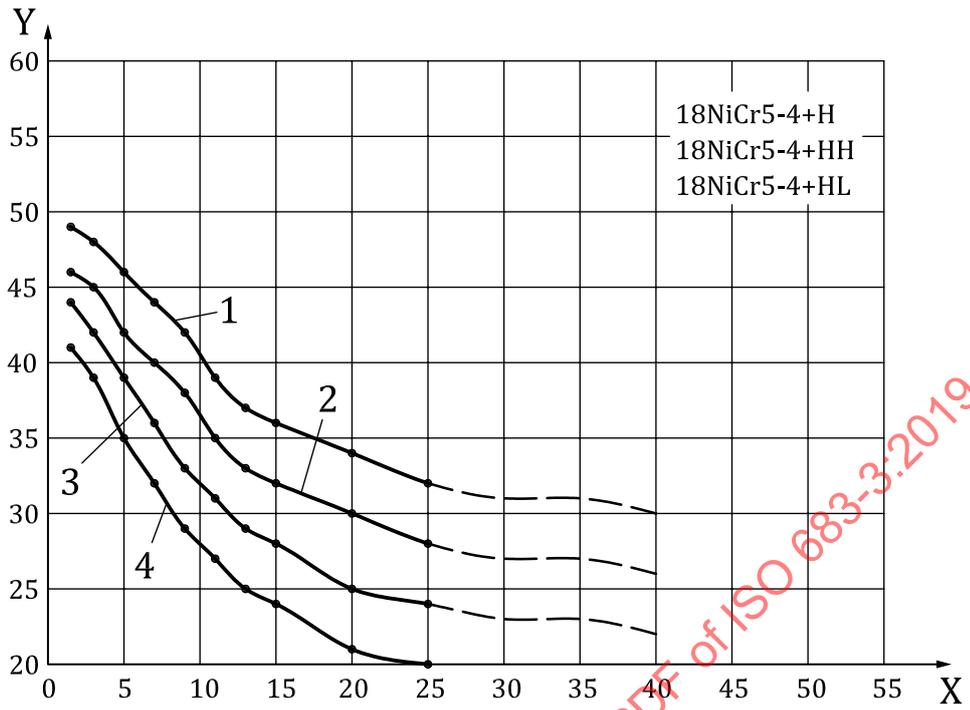
h)



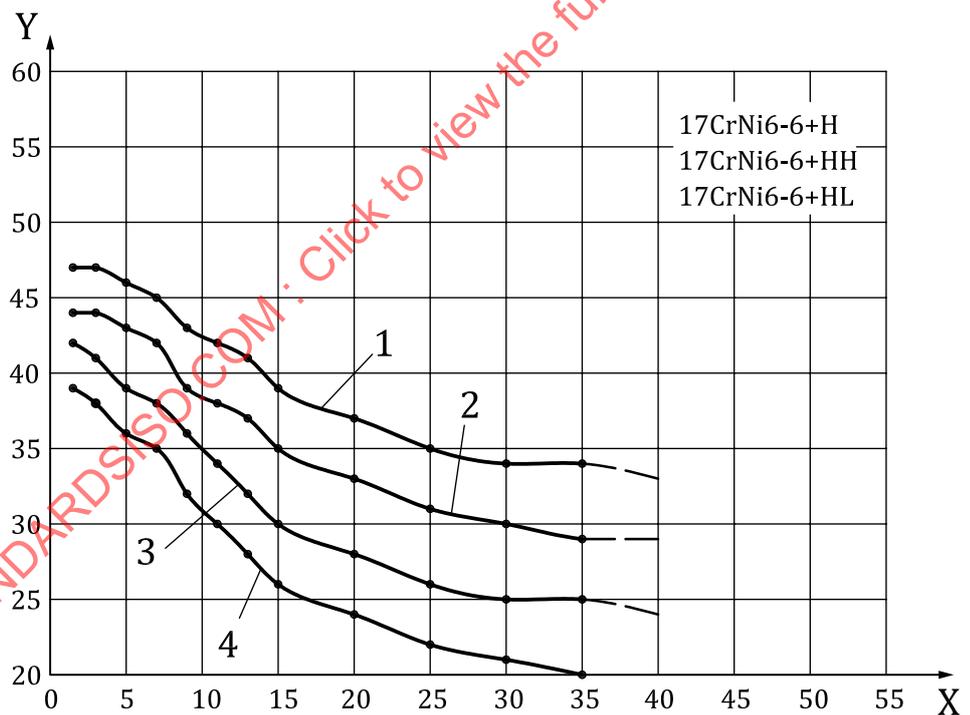
i)



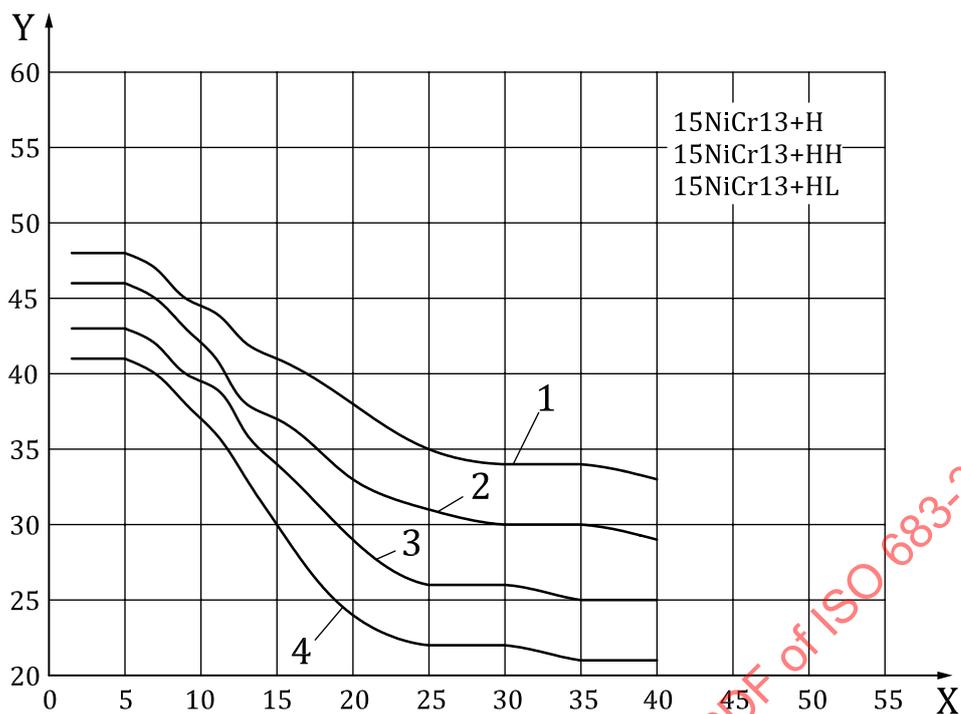
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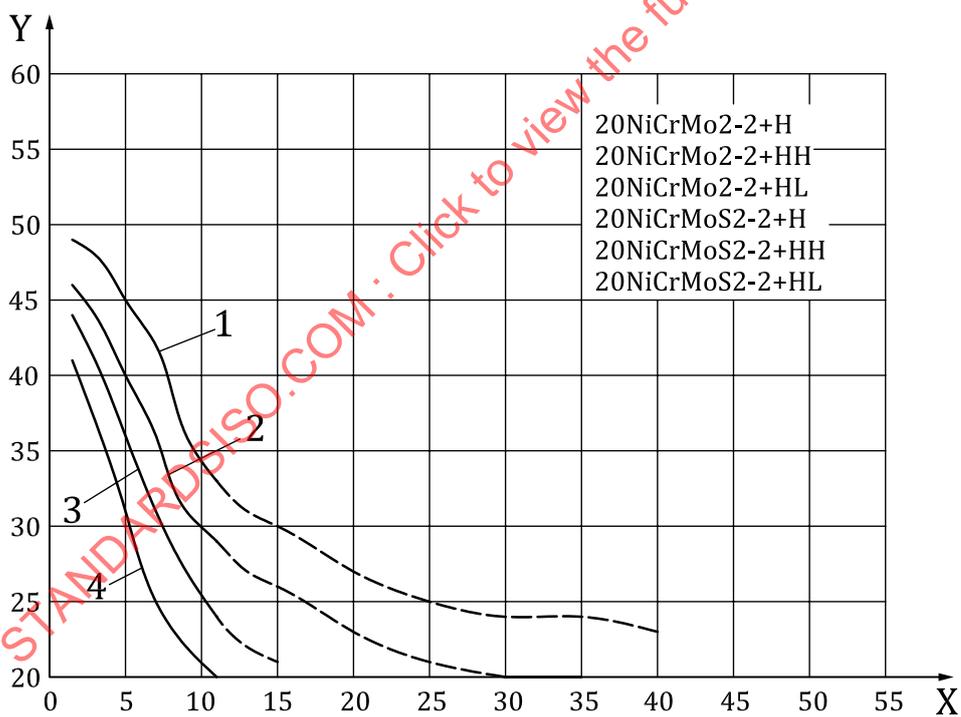
k)



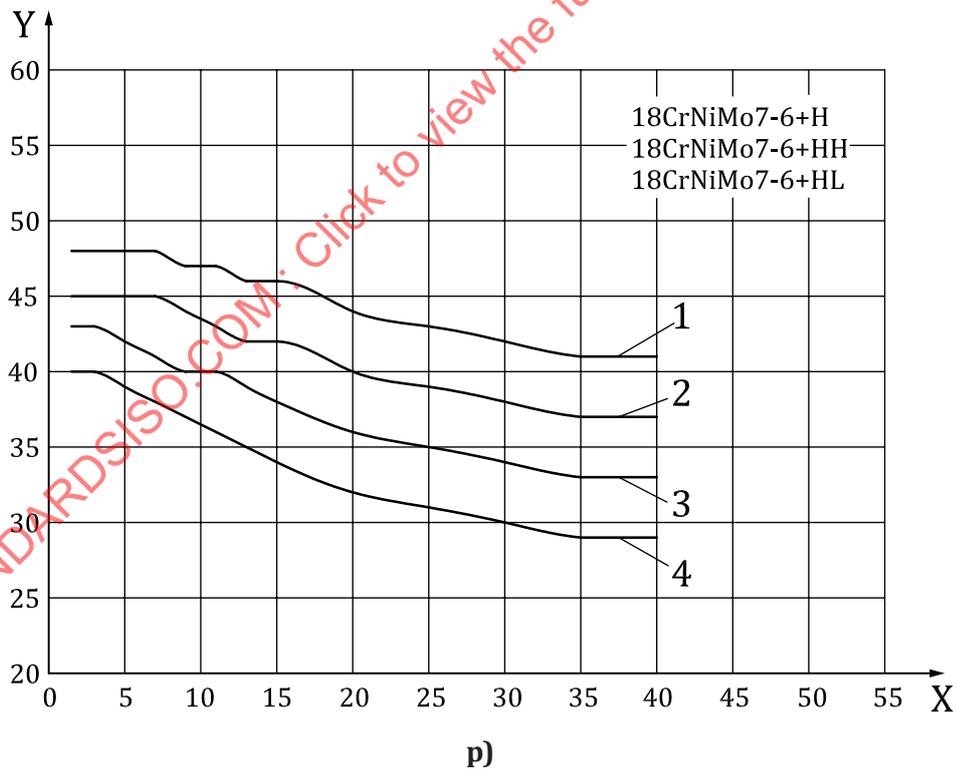
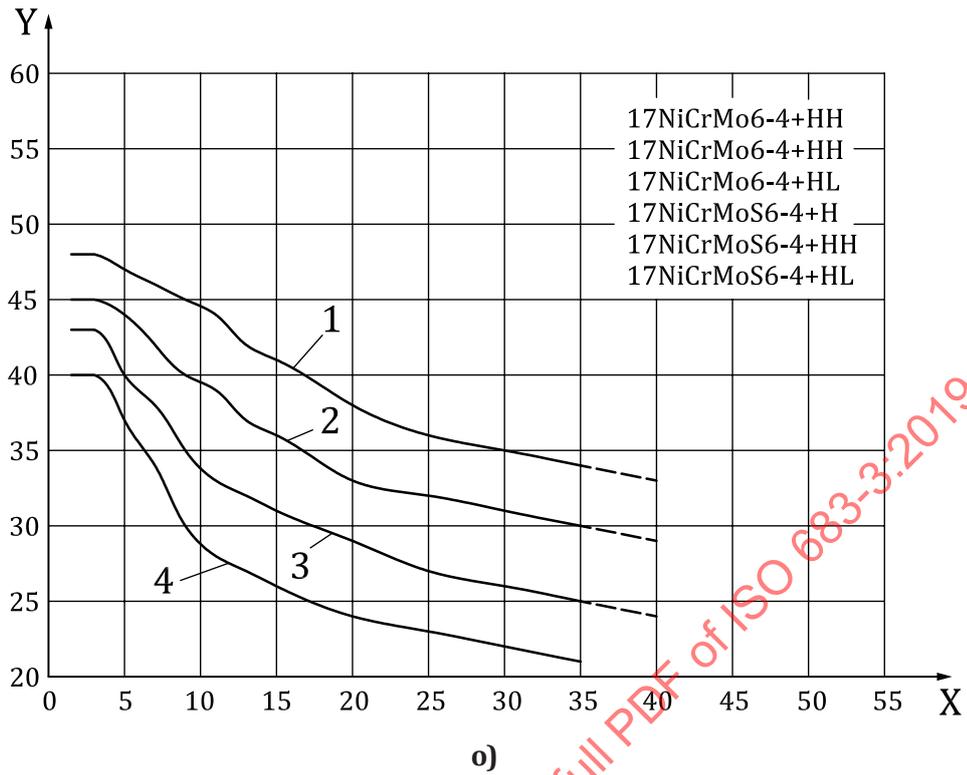
l)



m)



n)



Key

- | | | | |
|---|--|---|-------------------------|
| X | distance from quenched end of test piece, mm | 2 | upper limit, +HL grades |
| Y | hardness, HRC | 3 | lower limit, +HH grades |
| 1 | upper limit | 4 | lower limit |

Figure 1 — Scatter bands for Rockwell C hardness in end quench hardenability test