



SURFACE VEHICLE RECOMMENDED PRACTICE

J827

OCT2013

Issued 1962-06
Reaffirmed 2013-10

Superseding J827 JUL2005

High-Carbon Cast-Steel Shot

RATIONALE

J827 has been reaffirmed to comply with the SAE five year review policy.

1. Scope—This SAE Recommended Practice describes chemical composition and physical characteristic requirements for high-carbon cast-steel shot to be used for shot peening or blast cleaning operations.

1.1 Rationale—This document has been reaffirmed to comply with the SAE 5-Year Review policy.

2. References

2.1 Applicable Publications—The following publications form a part of this specification to the extent specified herein. The latest issue of SAE, ASTM, and ISO publications shall apply.

2.1.1 SAE PUBLICATIONS—Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

SAE J444—Cast Shot and Grit Size Specifications for Peening and Cleaning

SAE J445—Metallic Shot and Grit Mechanical Testing

2.1.2 ASTM PUBLICATIONS—Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM B 215, Method B—Methods of Sampling Finished Lots of Metal Powders

ASTM E 140—Hardness Conversion Tables for Metals (Relationship Between Brinell Hardness, Vickers Hardness, Rockwell Hardness, Rockwell Superficial Hardness, and Knoop Hardness)

ASTM E 384—Test Method for Microhardness of Materials

2.2 Related Publications—The following publications are provided for information purposes only and are not a required part of this document.

2.2.1 ISO PUBLICATIONS—Available from ANSI, 25 West 43rd Street, New York, NY 10036-8002.

ISO 11124 Part 3—High-carbon cast-sheet steel shot and grit

ISO 11125 Part 1—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 1: Sampling

ISO 11125 Part 2—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 2: Determination of particle size distribution

ISO 11125 Part 3—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 3: Determination of hardness

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ISO 11125 Part 4—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 4: Determination of apparent density

ISO 11125 Part 5—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 5: Determination of percentage defective particles and microstructure

ISO 11125 Part 6—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 6: Determination of foreign matter

ISO 11125 Part 7—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 7: Determination of moisture

3. **Description**—High-carbon cast-steel shot is obtained by atomizing molten steel. The shot is heat treated and screened to produce a range of sizes from HCS S70 to HCS S1320 or larger as described in SAE J444. Other sizes are available.
4. **Size Classification**—Cast-steel shot shall be identified by HCS S for shot, followed by three numbers representing the size in ten thousandths of inches, in accordance with SAE J444.

EXAMPLE—HCS330 indicates a cast-steel shot identified by a nominal sieve opening of 050 mm (0.0331 in).

5. **Chemical Composition**—The finished shot shall have the chemical composition shown in Table 1:

TABLE 1—CHEMICAL COMPOSITION

Element	Weight Percent
Carbon	0.80 – 1.2%
Manganese	
HCS S70 to HCS S110	0.35 – 1.2%
HCS S170	0.5 – 1.2%
HCS S230 and up	0.6 – 1.2%
Silicon	0.4% minimum
Sulfur	0.050% maximum
Phosphorous	0.050% maximum

6. **Hardness**
- 6.1 **Standard Hardness**—The hardness of 90% of all shot particles shall be within the range of 40 to 51 HRC.
- 6.2 **Special Hardnesses**—Shot for peening and blast cleaning is manufactured from 40 to 65 HRC. The user may specify a range to suit the application. The minimum hardness range that can be specified is 7 points HRC.
7. **Microstructure**—The microstructure of high-carbon cast-steel shot shall be uniform martensite, tempered to a degree consistent with the hardness range, with fine, well distributed carbides, if any.
8. **General Appearance**—High-carbon cast-steel shot is generally spherical and shall have no more than 20% of the particles with objectionable characteristics. Any one particle tested that has more than one different defect, shall only be counted once.
- 8.1 **Objectionable Characteristics**
- 8.1.1 **PARTICLE SHAPE**—No more than 5% of the particles in a shot sample shall be elongated. An elongated particle is one whose length is in excess of twice the maximum particle width.

- 8.1.2 **VOIDS**—No more than 10% of the particles in a sample shall contain objectionable voids. Such a void is a smooth-surfaced, internal hole whose cross-sectional area is larger than 10% of the cross-section area of the particle.
- 8.1.3 **SHRINKAGE**—No more than 10% of the particles in a sample shall contain objectionable shrinkage. Such a shrinkage is an internal cavity with an irregular dendritic surface whose area is larger than 40% of the particle area.
- 8.1.4 **CRACKS**—No more than 15% of the particles in a shot sample shall contain objectionable cracks. Such a crack is a linear discontinuity longer than three times its width, longer than 20% of the shortest cross section of the particle, and radial in orientation.
- 8.1.5 **MICROSTRUCTURE**—Carbide networks, partial decarburization, grain boundary segregation, or pearlite are undesirable. No more than 15% of the particles tested shall contain these defects.
- 8.1.6 **NONMAGNETIC MATERIAL**—No more than 1% of the shot sample, by weight, shall be of nonmagnetic material.
- 9. Density**—The density of high-carbon cast-steel shot shall be not less than 7 g/cm^3 .

10. Inspection Procedures

- 10.1 Sampling**—Samples for testing shall be representative of each shipment or production lot. The method of sampling shall be ASTM B 215, Method B.
- 10.2 Sample Mounting for Testing**—Shot samples used for testing for hardness, microstructure, and objectionable defects shall be mounted one layer deep in bakelite or other suitable strong metallurgical sample mounting media.

The mounted sample shall be ground to the center of the particles and polished by methods acceptable for microscopic examination. When grinding and polishing the sample, care must be taken not to overheat the sample and affect microstructure and/or hardness.

- 10.3 Hardness Testing**—Hardness measurements shall be taken at the half radius on a minimum of 10 particles in the mounted samples.

The hardness shall be determined by using ASTM E 384 and using a 500 g load for sizes HCS S280 and finer, and 500 or 1000 g load for sizes HCS S330 and larger. Other microhardness test methods may be used as long as a reliable hardness conversion can be obtained by calibrating the test machine against known standards. Approximate conversion to Rockwell C Hardness Numbers can be obtained from ASTM 140 and from manufacturers of hardness testers.

- 10.4 Microstructure**—The mounted and polished sample shall be etched with 2% Nital or other suitable etchant and examined at approximately 500X magnification.
- 10.5 Objectionable Characteristics**—Objectionable characteristics shall be examined at 10X magnification. A minimum of 50 particles contained in the mount shall be evaluated.
- 10.6 Density**—Density shall be determined by placing 50 mL of water or alcohol in a 100 mL graduate, adding 100 g of shot and recording the increase in volume. Dividing 100 g by the volume increase will give the density in g/cm^3 . A pycnometer method may be used for more critical density measurements.

- 10.7 Nonmagnetic Material**—A hand magnet will be used to separate the magnetic shot from the nonmagnetic contaminants. The nonmagnetic contaminants shall be weighed and their percentage of the original sample weight calculated.