Replaces:
RN 850-1-2:2023-04-06

Delivery Conditions for quenched and tempered steel

Steel bars and forged shafts of 42CrMo4 for rotors with peripheral speeds > 50 m/s

Content

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Changes

2025-01-22:
The following changed in comparison to RN 850-1-2:2023-04-06:

a) updated references
b) ultrasonic testing outsourced in RN 1934
c) chapter 6 a): correction regarding the authorisation of IACS member societies
d) chapter 6 g): wording for required certificates clarified
e) editorially revised

1 Scope

This factory standard applies to	Material no.:	1.7225
	Material designation:	42CrMo4
	Delivery conditions:	Steel bar / forged shaft hot formed; pre-turned
	Use case:	Rotors with peripheral speeds > 50 m/s

2 References

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

DIN 7527-6:1975-02	Steel Forgings; Machining Allowances and Permissible Variations for Open-die Forged Bars
DIN 50602:1985-09	Metallographic examination; microscopic examination of special steels using standard diagrams to assess the content of non-metallic inclusions
DIN EN 10021	General technical delivery conditions for steel products
DIN EN 10204	Metallic products - Types of inspection documents
DIN EN ISO 642	Steel - Hardenability test by end quenching (Jominy test)
DIN EN ISO 643	Steels - Micrographic determination of the apparent grain size
DIN EN ISO 683-2	Heat-treatable steels, alloy steels and free-cutting steels - Part 2: Alloy steels for quenching and tempering
RN 1550	Material samples
RN 1567	Remanent magnetism in components
RN 1934	Test instruction; Ultrasonic testing
RN 1936	Labelling; Raw material, parts and gearboxes

3 Chemical composition

Table 1 Chemical composition in %

	C	Si	Mn	P	S	Cr	Mo	Ni	V	Cu
min.	0.38		0.60			0.90	0.15			
max.	0.45	0.40	0.90	0.015	0.005	1.20	0.30	0.60		0.30
	Sn	**Al**	**N**	**Ti**	**Nb**	**Sb**	**O_2**	**Ca**	**H_2**	**Al / N**
min.		0.01								
max.	0.05	0.04	0.012	0.05			20 ppm	0.0030	1.7 ppm	3.7

4 Physical characteristics

Table 2 Mechanical properties (Test temperature: 20° C / degree of transformation: φ ≥ 6.0)

Diameter		Rm	$Rp_{0.2}$	A5 [%]		Z [%]		Av [J]	
[mm]		[N/mm²]	[N/mm²]	longit.	transv.	logit.	transv.	longit.	transv.
over	up to	min.	min.	min.	min.	min.	min.	min.	min.
	40	1000	800	12	-	35	-	25	-
40	100	900	650	14	-	40	-	27	-
100	160	850	600	15	12	45	40	32	26
160	250	800	550	17	12	40	34	32	26
250	500	750	500	15	12	50	45	32	24
500	750	700	450	14	12	45	30	28	18
750	1000	650	400	14	12	45	30	28	18

a) Structure, inclusions
- grain size, standard: DIN EN ISO 643 — standard series: Table C.1; G ≥ 6
- purity degree, standard: DIN 50602 — method: K; K4 ≤ 20

b) Hardenability
- Standard: DIN EN ISO 683-2 — scatter band: +HH
- testing: DIN EN ISO 642

end distance [mm]:	5	11	25	40
hardness [HRC]:	55-61	48-59	39-53	36-47

c) Additional properties
- radioactivity: ≤ 0.10 Bq/g

5 Manufacturing

a)	Casting method:	ingot casting		
b)	Melting			
	• making process:	E, LD, ESU (on special request)		
	• post-treatment:	vacuum degassing (VD) for E or LD		
c)	Heat treatment			
	• treatment condition:	+QT, quenched and tempered, stress-relieved annealed after pre-machining		
	• treatment method:	liquid quenching and tempering		
d)	Surface condition			
	• defect depth:	≤ machining allowance		
	• unmachined:	rust-, crack- and scale-free	pre-turned:	max. Rz 40
	• repair by welding:	not permitted		
e)	Manufacturing tolerances:	DIN 7527-6		

6 Other requirements

a)	Steel and forging plant			
	• certified acc. to	DIN EN ISO 9001 ff.		
	• approved by at least one member society of IACS			
b)	Delivery condition			
	• bar length:	5 - 6 m	rod end:	smooth sawn
	• bar weight:	≤ 10 t		
c)	Testing			
	• material identification check:	to be carried out		
	• ultrasonic testing:	RN 1934 for rotors with peripheral speeds > 50 m/s		
d)	Sample material and collection			
	•	RN 1550		
e)	Remanent magnetism			
	•	RN 1567		
f)	Labelling			
	•	RN 1936		

g) Documentation (must be digitally available upon delivery)
- acceptance test certificate 3.1 acc. to DIN EN 10204 per melt and furnace trip or per piece or production lot with specification of primary material and forging ratio
- copy of the acceptance test certificate 3.1 from the steel manufacturer
- evidence of radioactivity and remanent magnetism
- forging schedule (on special request)