

INTERNATIONAL STANDARD

ISO
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Second edition
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High yield strength flat steel products —

Part 2:

Products supplied in the normalized or controlled rolled condition

Produits plats en acier à haute limite d'élasticité

Part 2: Produits livrés à l'état normalisé ou de laminage contrôlé

ISO 4950-2:1995

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ISO 4950-2:1995(E)

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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 4950-2 was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 3, *Steels for structural purposes*.

This second edition cancels and replaces the first edition (ISO 4950-2:1981), which has been technically revised.

ISO 4950 consists of the following parts, under the general title *High yield strength flat steel products*:

- *Part 1: General requirements*
- *Part 2: Products supplied in the normalized or controlled rolled condition*
- *Part 3: Products supplied in the heat-treated (quenched + tempered) condition*

Annex A of this part of ISO 4950 is for information only.

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High yield strength flat steel products —

Part 2:

Products supplied in the normalized or controlled rolled condition

1 Scope

This part of ISO 4950 specifies the chemical composition and the mechanical properties of high yield strength flat steel products supplied in the normalized or/equivalent condition. For the method of manufacture, acceptance conditions and marking of these products, see ISO 4950-1.

It applies to hot-rolled plates, wide strip in coils of width greater than or equal to 600 mm, and wide flats in the thickness range 3 mm to 150 mm, in steels supplied after normalizing or controlled rolling, having a minimum specified yield strength of 355 N/mm² to 460 N/mm² for thicknesses up to and including 16 mm.

This part of ISO 4950 does not apply to products covered by other standards, such as

- flat products from continuous mills (see ISO 4996),
- flat products for subsequent forming operations (see ISO 5951),
- plates for pressure vessels (see ISO 9328-4).

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 4950. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 4950 are encouraged to investigate the possibility of applying the most recent editions of

the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 4950-1:1995, *High yield strength flat steel products — Part 1: General requirements*.

ISO 4996:1991, *Hot-rolled steel sheet of high yield stress structural quality*.

ISO 5951:1993, *Hot-rolled steel sheet of higher yield strength with improved formability*.

ISO 9328-4:1991, *Steel plates and strip for pressure purposes — Technical delivery conditions — Part 4: Weldable fine grain steels with high proof stress supplied in the normalized or quenched and tempered condition*.

3 Manufacture

3.1 Deoxidation process

All steels shall be from casts with added elements that are capable of producing a fine grain. In addition, steels of quality DD shall be supplied as non-rimming steel, while steels of quality E shall be supplied as fully killed steel.

3.2 Delivery condition

The products shall be delivered in the normalized or normalized and tempered condition or, unless otherwise agreed at the time of ordering, in an equivalent condition obtained by controlled rolling¹⁾.

1) Plates produced by controlled rolling may be subject to deterioration of their properties if they are subsequently hot formed.

Table 1 — Chemical composition (ladle analysis)

Grade	Quality	Chemical composition [% (m/m)] ¹⁾												
		C max.	Mn ²⁾ max.	Si max.	P max.	S max.	Nb ³⁾	V ³⁾	Al (total) ³⁾ min.	Ti ³⁾	Cr max.	Ni max.	Mo max.	Cu ⁴⁾ max.
E 355	DD	0,18	0,9 to 1,6	0,50	0,030	0,030	0,015 to 0,060	0,02 to 0,10	0,020	0,02 to 0,20	0,25	0,30	0,10	0,35
	E	0,18	0,9 to 1,6	0,50	0,025	0,025	0,015 to 0,060	0,02 to 0,10	0,020	0,02 to 0,20	0,25	0,30	0,10	0,35
E 460	CC	0,20	1,0 to 1,7	0,50	0,040	0,040	0,015 to 0,060	0,02 to 0,20	0,020	0,02 to 0,20	0,70	1,0	0,40	0,70
	DD	0,20	1,0 to 1,7	0,50	0,030	0,030	0,015 to 0,060	0,02 to 0,20	0,020	0,02 to 0,20	0,70	1,0	0,40	0,70
	E	0,20	1,0 to 1,7	0,50	0,025	0,025	0,015 to 0,060	0,02 to 0,20	0,020	0,02 to 0,20	0,70	1,0	0,40	0,70

1) As the chemical composition influences the welding characteristics, if the purchaser so requests, the producer shall, at the time of the order being placed, indicate the type of steel which he will supply and the maximum values or the range of the alloying elements which will be used in that steel.

2) For products of thickness up to and including 6 mm, the manganese content may be reduced by 0,2 % (m/m).

3) The steels shall contain, in the percentage indicated in the table, at least one of the grain-refining elements. If these elements are used in combination, the content for at least one of them shall be not less than the specified minimum value.

4) By agreement at the time of ordering, the maximum copper content may be 0,30 % (m/m).

4 General requirements

4.1 Chemical composition

4.1.1 Ladle analysis

Table 1 gives the chemical composition limits for the ladle analysis.

All elements other than those mentioned in table 1 and added intentionally shall be indicated to the purchaser.

$$C_{eq} = C + \frac{Mn}{6} + \frac{Cr + Mo + V}{5} + \frac{Ni + Cu}{15}$$

may be agreed on ordering (where C, Mn, Cr, Mo, V, Ni and Cu are the contents, expressed as percentage by mass, of the respective elements).

4.1.2 Product analysis

A product analysis may be required by the purchaser; in this case, it shall be specified when ordering.

Table 2 gives the permitted deviations for the product analysis relative to the values for ladle analysis given in table 1.

4.2 Mechanical properties

The steels in the normalized and tempered or controlled rolled conditions, shall comply with the mechanical properties specified in table 3 when they are determined on test pieces prepared in accordance with the requirements of 5.3 of ISO 4950-1:1995.

4.3 Weldability

A maximum value of the carbon equivalent (C_{eq}), expressed as a percentage by mass, based on the International Institute of Welding (IIW) formula, i.e.:

Table 2 — Permissible deviations for the product analysis relative to the specified ladle analysis

Values in percentage by mass

Element	Specified limits	Permissible deviation ¹⁾
C	≤ 0,20	+ 0,02
Mn	≤ 1,70	± 0,10
Si	≤ 0,50	+ 0,05
P and S	≤ 0,040	+ 0,005
Nb	≤ 0,060	± 0,005
V	≤ 0,20	+ 0,02 − 0,01
Ti	≤ 0,20	+ 0,02 − 0,01
Cr	≤ 0,70	+ 0,05
Ni	≤ 1,0	+ 0,05
Mo	≤ 0,40	+ 0,05
Cu	≤ 0,35 > 0,35	+ 0,05 + 0,07

1) The deviations apply either above or below the specified limits of the range, but not simultaneously.