

INTERNATIONAL STANDARD



**Magnetic materials –
Part 8-7: Specifications for individual materials – Cold-rolled grain-oriented
electrical steel strip and sheet delivered in the fully-processed state**

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CONTENTS

FOREWORD.....	4
1 Scope.....	6
2 Normative references	6
3 Terms and definitions	7
4 Classification.....	8
5 Designation	8
6 General requirements	8
6.1 Production process	8
6.2 Form of supply	8
6.3 Delivery condition	9
6.4 Surface condition	9
6.5 Suitability for cutting	9
7 Technical requirements	9
7.1 Magnetic properties	9
7.1.1 General	9
7.1.2 Magnetic polarization.....	9
7.1.3 Specific total loss	10
7.2 Geometric characteristics and tolerances.....	11
7.2.1 Thickness	11
7.2.2 Width.....	12
7.2.3 Length	13
7.2.4 Edge camber.....	13
7.2.5 Flatness Edge wave (wave factor)	13
7.2.6 Residual curvature.....	13
7.2.7 Burr height.....	13
7.3 Technological characteristics.....	13
7.3.1 Density.....	13
7.3.2 Stacking factor.....	13
7.3.3 Number of bends	13
7.3.4 Internal stresses.....	13
7.3.5 Insulation coating resistance	14
8 Inspection and testing.....	14
8.1 General.....	14
8.2 Selection of samples.....	14
8.3 Preparation of test specimens.....	15
8.3.1 Magnetic properties	15
8.3.2 Geometrical characteristics and tolerances.....	15
8.3.3 Technological characteristics.....	15
8.4 Test methods	16
8.4.1 General	16
8.4.2 Magnetic properties	16
8.4.3 Geometrical characteristics and tolerances.....	16
8.4.4 Technological characteristics.....	17
8.5 Retests	17
9 Marking, labelling and packaging.....	17

10	Complaints	18
11	Information to be supplied by the purchaser	18
	Annex A (informative) European steel designation	18
	Bibliography.....	20

Table 1	– Technological and magnetic properties of the conventional grades of grain-oriented material electrical steel strip and sheet	10
Table 2	– Technological and magnetic properties of the high permeability grades of grain-oriented material electrical steel strip and sheet	11
Table 3	– Tolerances on nominal width	12

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INTERNATIONAL ELECTROTECHNICAL COMMISSION

MAGNETIC MATERIALS –

**Part 8-7: Specifications for individual materials –
Cold-rolled grain-oriented electrical steel strip
and sheet delivered in the fully-processed state**

FOREWORD

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International Standard IEC 60404-8-7 has been prepared by IEC technical committee 68: Magnetic alloys and steels.

This fourth edition cancels and replaces the third edition published in 2008. This edition constitutes a technical revision.

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

- extension of the range of electrical steels to include the improved grades.

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

CDV	Report on voting
68/545/CDV	68/561/RVC

Full information on the voting for the approval of this International Standard can be found in the report on voting indicated in the above table.

This document has been drafted in accordance with the ISO/IEC Directives, Part 2.

A list of all the 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 "<http://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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MAGNETIC MATERIALS –

Part 8-7: Specifications for individual materials – Cold-rolled grain-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 grain-oriented electrical steel strip and sheet in nominal thicknesses of 0,23 mm, 0,27 mm, 0,30 mm and 0,35 mm. In particular, it gives general requirements, magnetic properties, geometric characteristics, tolerances and technological characteristics, as well as inspection procedures.

This document applies to Goss textured grain-oriented electrical steel strip and sheet supplied in the final annealed condition in coils or sheets, and intended for the construction of magnetic circuits.

The grades are grouped into two classes:

- conventional grades;
- high permeability grades, including grades which may be delivered in the domain refined condition.

They correspond to Class C22 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* (available at <http://www.electropedia.org/>)

IEC 60050-221, *International Electrotechnical Vocabulary – Chapter 221: Magnetic materials and components* (available at <http://www.electropedia.org/>)

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

~~IEC 60404-1-1, *Magnetic materials – Part 1-1: Classification – Surface insulations of electrical steel sheet, strip and laminations*~~

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

IEC 60404-3:1992, *Magnetic materials – Part 3: Methods of measurement of the magnetic properties of magnetic sheet and strip by means of a single sheet tester*
IEC 60404-3:1992/AMD1:2002

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

~~IEC 60404-11, Magnetic materials – Part 11: Method of test for the determination of surface insulation resistance of magnetic sheet and strip~~

IEC 60404-13, Magnetic materials – Part 13: Methods of measurement of density, resistivity and stacking factor of electrical steel 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 of the principal terms relating to magnetic properties~~ given in IEC 60050-121 and 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 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

Note 1 to entry: See IEC 60404-9.

3.2

flatness (wave factor)

the property of a sheet or of 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

NOTE See IEC 60404-9.

3.2

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.

3.3

number of bends

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

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

3.4

internal stresses

stresses which are characterized by a deviation in relation to the line of cutting

4 Classification

The grades covered by this document are classified according to the value of maximum specific total loss in watts per kilogram and according to the nominal thickness of the ~~material~~ **product**¹ (0,23 mm, 0,27 mm, 0,30 mm and 0,35 mm).

5 Designation

The steel name comprises the following in the order given:

- 1) the letter M for electrical steel;
- 2) one hundred times the specified value of maximum specific total loss at 1,7 T and 50 Hz, in watts per kilogram ~~and corresponding to the nominal product thickness~~;
- 3) one hundred times the nominal thickness of the ~~material~~ **product**, in millimetres;
- 4) the characteristic letter
 - S for conventional grades;
 - P for high permeability grades;
- 5) one tenth of the frequency 50 Hz, i.e. 5.

EXAMPLE M140-30S5 for cold-rolled grain-oriented electrical steel strip or sheet of conventional grade with a maximum specific total loss of 1,40 W/kg at 1,7 T and 50 Hz, and a nominal thickness of 0,30 mm, supplied in the fully-processed state.

~~NOTE The corresponding steel numbers used in the relevant European Standard are given in Annex A.~~

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

The recommended value for the internal diameter of coils is approximately 508 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 purchaser** at the time of enquiry and order. If necessary, the marking of welds or interleaves may be agreed **between the manufacturer and purchaser** at the time of enquiry and order.

¹ In the rest of the document, the word "~~material~~ **product**" is used to mean "strip and sheet".

For coils containing repair 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 are substantially flat and approximately perpendicular to the top face.

6.3 Delivery condition

Cold-rolled grain-oriented electrical steel ~~material is~~ products are usually supplied with an insulating coating on both sides. This coating generally consists of an EC-5-G coating on an EC-2 coating in accordance with IEC 60404-1-1².

6.4 Surface condition

The surfaces shall be smooth and clean, free from grease and rust³. Dispersed defects such as scratches, blisters, cracks, etc. are permitted if they are within the limits of the tolerances on thickness and if they are not detrimental to the correct use of the supplied ~~material~~ product.

The insulation coating present on the surface of the ~~material~~ product shall be sufficiently adherent so that it does not become detached during cutting operations or heat treatment under conditions specified by the supplier.

NOTE If the product is to be immersed in a fluid, an agreement between the manufacturer and purchaser, initiated by the purchaser, should be reached to ensure compatibility between the fluid and the coating.

6.5 Suitability for cutting

The ~~material~~ product shall be suitable for cutting accurately into the usual shapes at any point when appropriate cutting tools are used.

7 Technical requirements

7.1 Magnetic properties

7.1.1 General

The properties defined in 7.1.2 and 7.1.3 shall apply to ~~materials~~ products in the delivery condition defined in 6.3 and to the aged condition defined in 8.3.1.

The Epstein strips shall receive a stress relief heat treatment after cutting under conditions specified by the manufacturer.

The single sheet test specimens shall not be heat treated.

7.1.2 Magnetic polarization

The specified minimum values of peak magnetic polarization at the peak magnetic field strength of 800 A/m at 50 Hz or 60 Hz shall be as given in Table 1 and Table 2.

² Other types of coating exist which are used only when particularly specified.

³ Not to be confused with some coloration of the insulating coating inherent to the manufacturing process.

7.1.3 Specific total loss

The specified values of maximum specific total loss at 50 Hz or 60 Hz shall be as given in Table 1 and Table 2.

Table 1 – Technological and magnetic properties of the conventional grades of grain-oriented material electrical steel strip and sheet

Steel name	Nominal thickness mm	Maximum specific total loss at 1,5 T		Maximum specific total loss at 1,7 T		Minimum magnetic polarization for $H = 800 \text{ A/m}^a$ T	Minimum stacking factor
		W/kg		W/kg			
		50 Hz	60 Hz	50 Hz	60 Hz		
M110-23S5	0,23	0,73	0,96	1,10	1,45	1,78	0,945
M120-23S5		0,77	1,01	1,20	1,57	1,78	
M110-27S5	0,27	0,77	1,02	1,10	1,48	1,80	0,950
M120-27S5		0,80	1,07	1,20	1,58	1,78	
M130-27S5		0,85	1,12	1,30	1,68	1,78	
M120-30S5	0,30	0,83	1,13	1,20	1,58	1,80	0,955
M130-30S5		0,85	1,15	1,30	1,71	1,78	
M140-30S5		0,92	1,21	1,40	1,83	1,78	
M135-35S5	0,35	0,97	1,29	1,35	1,78	1,80	0,960
M145-35S5		1,03	1,36	1,45	1,91	1,78	
M155-35S5		1,07	1,41	1,55	2,04	1,78	

^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

$$J = B - \mu_0 H$$

where

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

NOTE The difference between B and J at 800 A/m is equal to 0,001 T.