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SIST EN 4630:2015

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EUROPEAN STANDARD

EN 4630

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 2014

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Supersedes EN 4630:2007

English Version

**Aerospace series - Steel X4CrNiMo16-5-1 (1.4418) - Air melted -
Hardened and tempered - Forgings - $De \leq 200$ mm - 900 MPa \leq
 $R_m \leq 1\ 050$ MPa**

Série aérospatiale - Acier X4CrNiMo16-5-1 (1.4418) -
Élaboré à l'air - Trempé et revenu - Pièces forgées - $De \leq$
 200 mm - 900 MPa $\leq R_m \leq 1\ 050$ MPa

Luft- und Raumfahrt - Stahl X4CrNiMo16-5-1 (1.4418) -
Lufterschmolzen - Gehärtet- und angelassen -
Schmiedestücke - $De \leq 200$ mm - 900 MPa $\leq R_m \leq 1\ 050$
MPa

This European Standard was approved by CEN on 27 December 2013.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

This document (EN 4630:2014) has been prepared by the Aerospace and Defence Industries Association of Europe - Standardization (ASD-STAN).

After enquiries and votes carried out in accordance with the rules of this Association, this Standard has received the approval of the National Associations and the Official Services of the member countries of ASD, prior to its presentation to CEN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 2015, and conflicting national standards shall be withdrawn at the latest by April 2015.

This document supersedes EN 4630:2007.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

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EN 4630:2014 (E)

Introduction

This standard is part of the series of EN metallic material standards for aerospace applications. The general organization of this series is described in EN 4258.

This standard has been prepared in accordance with EN 4500-005.

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1 Scope

This standard specifies the requirements relating to:

Steel X4CrNiMo16-5-1 (1.4418)
Air melted
Hardened and tempered
Forgings
 $D_e \leq 200$ mm
 $900 \text{ MPa} \leq R_m \leq 1\,050 \text{ MPa}$

for aerospace applications.

NOTE Other common designation:
AIR: Z 8 CND 17-04.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 2950, *Aerospace series — Test method — Wrought heat resisting alloys — Semi-finished products and parts — Conditions for macrographic and micrographic examination — Atlas of structures and defects*

EN 2951, *Aerospace series — Metallic materials — Test method — Micrographic determination of content of non-metallic inclusions* ¹⁾

EN 4050-4, *Aerospace series — Test method for metallic materials — Ultrasonic inspection of bars, plates, forging stock and forgings — Part 4: Acceptance criteria*

EN 4258, *Aerospace series — Metallic materials — General organization of standardization — Links between types of EN standards and their use*

EN 4500-005, *Aerospace series — Metallic materials — Rules for drafting and presentation of material standards — Part 005: Specific rules for steels*

EN 4629, *Aerospace series — Steel X4CrNiMo16-5-1 (1.4418) — Air melted — Softened — Forging stock — $D_e \leq 300$ mm*

EN 4700-006, *Aerospace series — Steel and heat resisting alloys — Wrought products — Technical specification — Part 006: Pre-production and production forgings*

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

AMS 2315, *Determination of delta ferrite content* ²⁾

1) Published as ASD-STAN Prestandard at the date of publication of this standard (www.asd-stan.org).

2) Published as SAE National (US) Society of Automotive Engineers (www.sae.org).

EN 4630:2014 (E)

1	Material designation		Steel X4CrNiMo16-5-1 (1.4418)									
2	Chemical composition %	Element	C	Si	Mn ^a	P ^b	S ^b	N	Cr	Mo	Ni	Fe
		min.	–	–	–	–	–	0,020	15,00	0,80	4,00	Base
		max.	0,06	0,70	1,50	0,030	0,005	–	17,00	1,50	6,00	
3	Method of melting		Air melted									
4.1	Form		Forgings									
4.2	Method of production		Forged from forging stock EN 4629									
4.3	Limit dimension(s)	mm	$D_e \leq 200$									
5	Technical specification		EN 4700-006									

6.1	Delivery condition	Annealed	Hardened and tempered
	Heat treatment	–	$1\ 010\ ^\circ\text{C} \leq \theta \leq 1\ 060\ ^\circ\text{C}$ / OQ or WQ ^c + $550\ ^\circ\text{C} \leq \theta \leq 620\ ^\circ\text{C}$
6.2	Delivery condition code	A	U
7	Use condition	Hardened and tempered	Delivery condition
	Heat treatment	Delivery condition $+ 1\ 010\ ^\circ\text{C} \leq \theta \leq 1\ 060\ ^\circ\text{C}$ / OQ or WQ ^b + Tempered $550\ ^\circ\text{C} \leq \theta \leq 620\ ^\circ\text{C}$	–

Characteristics

8.1	Test sample(s)		EN 4700-006 Procedure A, B, C or D	EN 4700-006 Procedure A or B (separately forged)	EN 4700-006 Procedure C (integral) and Procedure D (machined from forging)
8.2	Test piece(s)		See EN 4700-006.		
8.3	Heat treatment		Annealed	Use condition	Use condition
9	Dimensions concerned	mm	$D \leq 200$	$25 \leq a$ or $D \leq 30$	$D \leq 200$
10	Thickness of cladding on each face	%	–		
11	Direction of test piece		–	L	L LT
12	Temperature	θ	°C		Ambient
13	Proof stress	$R_{p0.2}$	MPa	–	≥ 900
14	T Strength	R_m	MPa	–	$900 \leq R_m \leq 1\ 050$
15	Elongation	A	%	–	≥ 14
16	Reduction of area	Z	%	–	≥ 16 ≥ 12
17	Hardness		HBW ≤ 293	$269 \leq \text{HBW} \leq 331$	$269 \leq \text{HBW} \leq 331$
18	Shear strength	R_c	MPa	–	–
19	Bending	k	–	–	–
20	Impact strength	KV	J	–	$\geq 100\ \text{J}$ at $20\ ^\circ\text{C}$ Notch direction T $\geq 60\ \text{J}$ at $-30\ ^\circ\text{C}$ Notch direction T
					$\geq 120\ \text{J}$ at $20\ ^\circ\text{C}$ Notch direction T $\geq 70\ \text{J}$ at $-40\ ^\circ\text{C}$ Notch direction T
					$\geq 60\ \text{J}$ at $20\ ^\circ\text{C}$ Notch direction L $\geq 35\ \text{J}$ at $-40\ ^\circ\text{C}$ Notch direction L
21	Temperature	θ	°C		
22	Time		h		
23	Stress	σ_a	MPa		
24	Elongation	a	%		
25	Rupture stress	σ_R	MPa		
26	Elongation at rupture	A	%		
27	Notes (see line 98)		a, b, c, d		

30	Microstructure	–	EN 4700-006
		1	See AMS 2315.
		7	The δ ferrite content shall not exceed 5 %.
34	Grain size	–	EN 4700-006
		1	See EN ISO 643.
		7	$G \geq 5$
44	External defects (visual)	–	EN 4700-006
50	Cleanliness/inclusion content (micro cleanness)	–	EN 4700-006
		1	See EN 2951.
		7	Category 2
51	Macrostructure (grain flow)	–	EN 4700-006
		1	See EN 2950.
61	Internal defects	–	EN 4700-006
		1	See EN 4050-4.
		7	Class 4
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95	Marking inspection	–	EN 700-006
96	Dimensional inspection	–	EN 4700-006
98	Notes	–	<p>^a Where a higher impact strength is required, the maximum Mn content may be increased to 2 % subject to agreement between the customer and the supplier.</p> <p>^b For specific welding applications (e.g. high power beam), and after agreement between manufacturer and purchaser, S+P should be equal or less than 0,023 %.</p> <p>^c Air quenching may be used for $D_e \leq 20$ mm.</p>
99	Typical use	–	–