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**Cold-reduced carbon steel strip with a  
mass fraction of carbon over 0,25 %**

*Feuillards en acier au carbone laminés à froid à teneur en carbone  
supérieure à 0,25 %*

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Published in Switzerland

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## 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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. 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.

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

ISO 4960 was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 12, *Continuous mill flat rolled products*.

This third edition cancels and replaces the second edition (ISO 4960:1999), which has been technically revised.

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# Cold-reduced carbon steel strip with a mass fraction of carbon over 0,25 %

## 1 Scope

**1.1** This International Standard applies to cold-reduced carbon steel strip with a mass fraction of carbon over 0,25 % made from the steels specified in Table 1. It is commonly produced in thicknesses of 6 mm and under, and in widths up to 600 mm exclusive, in coils and cut lengths. The strip is ordered in the as-delivered condition, as specified in 6.1 or Clause 5, and is predominantly used for springs, but also for other highly stressed parts of many different types. Steel designations CS55 to CS95 may be supplied in the quenched and tempered condition.

**1.2** This International Standard does not apply to alloy steels or stainless steels.

**1.3** Cold-reduced carbon steel strip is furnished in the following types:

- a) full hard, where a very stiff, springy product is produced to obtain full hardness after the final rolling (it is intended for flat work not requiring the ability to withstand cold forming);
- b) annealed, which is intended for applications requiring moderate cold forming;
- c) quenched and tempered, which is intended generally for the production of steel springs where the appropriate combination of strength, hardness, toughness and ductility can be achieved;
- d) intermediate hardness, which is intended for applications where cold forming is slight or where a moderately stiff, springy product is needed.

**1.4** Cold-reduced carbon steel strip is characterized by close dimensional tolerances and good surface finish and, in the cold-rolled and quenched and tempered condition, it is possible to attain high values for hardness and tensile strength.

## 2 Normative references

The following referenced documents are indispensable for the application 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.

ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method*

ISO 6508-1, *Metallic materials — Rockwell hardness test — Part 1: Test method (scales A, B, C, D, E, F, G, H, K, N, T)*

ISO 6892, *Metallic materials — Tensile testing — Method of testing at ambient temperature*

### 3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

#### 3.1

##### **cold-reduced carbon steel strip**

product produced from a hot-rolled pickled coil which has been given substantial cold reduction

NOTE The product is characterized by an improved surface, greater uniformity in thickness and improved mechanical properties compared to hot-rolled strip. Cold-reduced strip is also characterized by tighter thickness tolerances than cold-reduced sheet, as well as specified edges.

#### 3.2

##### **skin pass**

light cold rolling of the product

NOTE 1 The purpose of skin passing is one or more of the following:

- a) to minimize the appearance of coil breaks, stretcher strains and fluting
- b) to control the shape;
- c) to obtain the required surface finish.

NOTE 2 Some increase in hardness and some loss in ductility will result from skin passing.

#### 3.3 Edges

Material is normally supplied as described in 3.3.1 and 3.3.2. Other edges may be supplied as agreed between the manufacturer and purchaser.

##### 3.3.1

##### **mill edge**

normal side edge without any definite contour produced in hot rolling

NOTE Mill edges may contain some irregularities, such as cracked or torn edges or thin (feathered) edges.

##### 3.3.2

##### **sheared edge**

normal edge obtained by shearing, slitting or trimming a mill-edge product

NOTE Normal processing does not necessarily provide a definite positioning of the slitting burr.

### 4 Specified qualities appropriate to the particular grade

The cold-reduced carbon steel strip qualities appropriate to the particular grade shall be the following:

- a) full-hard quality: material rolled to the final thickness with a minimum hardness;
- b) annealed quality: annealed to a hardness or tensile strength;
- c) quenched and tempered quality: quenched and tempered steel strip for steel designations of CS55 and over, tempered to properties;
- d) intermediate quality: temper rolled to a hardness range by a controlled amount of cold rolling after annealing.

## 5 Conditions of manufacture

### 5.1 Steelmaking

Unless otherwise agreed, the processes used in making the steel and in manufacturing cold-reduced strip are left to the discretion of the manufacturer. On request, the purchaser shall be informed of the steelmaking process being used.

### 5.2 Chemical composition

The chemical composition (heat analysis) shall not exceed the values given in Tables 1 and 2.

### 5.3 Heat analysis

An analysis of each heat of steel shall be made by the manufacturer, in order to determine compliance with the requirements of Tables 1 and 2. When requested at the time of ordering, this analysis shall be reported to the purchaser or to his representative. Each of the elements listed in Table 1 shall be included in the report of the heat analysis. If one or more of the elements in Table 2 is/are specified, the analysis shall be reported.

### 5.4 Product analysis

A product analysis may be made by the purchaser, in order to verify the specified analysis of the semi-finished or finished steel and shall take into consideration any normal heterogeneity. For killed steels, the sampling method and deviation limits shall be agreed upon between the interested parties at the time of ordering. The product analysis tolerances shall be in accordance with Table 3.

**Table 1 — Chemical composition (heat analysis)**

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Mass fractions in percent

Designation	Carbon	Manganese <sup>a</sup>	Phosphorus <sup>b</sup> max.	Sulfur <sup>b</sup> max.	Silicon <sup>c</sup>
CS30	0,28 to 0,34	0,60 to 0,90	0,035	0,03	0,10 to 0,35
CS35	0,32 to 0,38	0,60 to 0,90	0,035	0,03	0,10 to 0,35
CS40	0,37 to 0,44	0,60 to 0,90	0,035	0,03	0,10 to 0,35
CS45	0,43 to 0,50	0,60 to 0,90	0,035	0,03	0,10 to 0,35
CS50	0,48 to 0,55	0,60 to 0,90	0,035	0,03	0,10 to 0,35
CS55	0,50 to 0,60	0,60 to 0,90	0,035	0,03	0,10 to 0,35
CS60	0,55 to 0,65	0,60 to 0,90	0,035	0,03	0,10 to 0,35
CS65	0,60 to 0,70	0,60 to 0,90	0,035	0,03	0,10 to 0,35
CS70	0,65 to 0,75	0,60 to 0,90	0,035	0,03	0,10 to 0,35
CS75	0,70 to 0,80	0,40 to 0,70	0,035	0,03	0,10 to 0,35
CS85	0,80 to 0,93	0,70 to 1,00	0,035	0,03	0,10 to 0,35
CS95	0,90 to 1,03	0,30 to 0,50	0,035	0,03	0,10 to 0,35

<sup>a</sup> Other manganese values can be specified upon agreement at the time of ordering, provided a range of 0,30 % is maintained.

<sup>b</sup> When specified, phosphorus and sulfur may be ordered to 0,020 % maximum by heat analysis.

<sup>c</sup> Closer silicon ranges can be provided upon agreement at the time of ordering.

Table 2 — Limits on additional chemical elements

Mass fractions in percent

Elements	Heat analysis	Product analysis
	max.	max.
Cu <sup>a</sup> (CS30–CS75)	0,30	0,33
(CS85–CS95)	0,25	0,28
Ni <sup>a</sup> (CS30–CS75)	0,20	0,23
(CS85–CS95)	0,25	0,28
Cr <sup>a, b, c</sup> (CS30–CS75)	0,20	0,24
(CS85–CS95)	0,30	0,34
Mo <sup>a, b</sup>	0,06	0,07
Nb <sup>d</sup>	0,008	0,018
V <sup>d</sup>	0,008	0,018
Ti <sup>d</sup>	0,008	0,018

<sup>a</sup> The sum of copper, nickel, chromium and molybdenum shall not exceed 0,50 % on heat analysis. When one or more of these elements are specified, the sum does not apply; in which case, only the individual limits on the remaining elements will apply.

<sup>b</sup> The sum of chromium and molybdenum shall not exceed 0,16 % on heat analysis. When one or more of these elements are specified, the sum does not apply; in which case, only the individual limits on the remaining elements will apply.

<sup>c</sup> A higher value of Cr may be supplied after agreement between the producer and consumer.

<sup>d</sup> An analysis greater than 0,008 % may be supplied after agreement between the producer and consumer.

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Table 3 — Product analysis

Tolerances in percent

Element	Maximum of specified element	Tolerance over maximum specified
Carbon	> 0,15 to ≤ 0,40	0,04
	> 0,40 to ≤ 0,80	0,05
	> 0,80	0,06
Manganese	≤ 0,60	0,03
	> 0,60 to ≤ 1,15	0,04
Silicon	> 0,30 to ≤ 0,60	0,05
Phosphorus	≤ 0,04	0,01
Sulfur	≤ 0,04	0,01

NOTE The above maximum tolerances are the allowable excesses over the specified requirements, and not the heat analysis.



## 5.5 Surface finish

Cold-reduced carbon steel strip is produced in a regular bright finish by rolling on rolls having a moderately smooth finish (it is not generally applicable to bright plating); or in a dull finish by rolling on rolls roughened by mechanical or chemical means. The dull finish is suitable for lacquer or paint adhesion.

Quenched and tempered strip [see 1.3 c)] may be supplied with the following surface finishes:

- a) grey-blue unpolished;
- b) bright tempered;
- c) rough, medium or fine polished;
- d) polished and temper colored (blue or bronze).

## 5.6 Oiling

As a deterrent to rusting, a coating of oil is usually applied to the product. The oil is not intended as a forming lubricant and should be easily removable using degreasing chemicals. The product may be ordered unoiled, if required, in which case the supplier has limited responsibility if oxidation occurs.

## 5.7 Weldability

This product is suitable for welding if appropriate welding conditions are selected.

## 5.8 Application

It is desirable to identify the specified product for fabrication by the name of the part or by the intended application. Proper identification of the part may include visual examination, prints or description, or a combination of these.

## 5.9 Mechanical properties

### 5.9.1 Hardness ranges

When required [see 6.1 and Clause 16 h)] the hardness shall be as stated in Tables 4, 5 or 7. Intermediate hardness ranges shall be as shown in Table 8, or shall be as agreed upon between the manufacturer and the purchaser.

HV is the Vickers hardness.

HR is the Rockwell hardness. HRB is the Rockwell hardness (type B).

### 5.9.2 Tensile properties

When required [see 6.1 and Clause 16 h)] the tensile properties shall be as stated in Tables 5 and 6, at the time the steel is made available for shipment if the mechanical property designation is specified.