

ISO 643

Fourth edition

2014

**Steels — Micrographic
determination of the
apparent grain size**

Aciers — Détermination
micrographique de la grosseur
de grain apparente

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Contents

Page

| | | |
|------------------------------|---|-----------|
| Foreword | iv | |
| 1 | Scope | 2 |
| 2 | Normative references | 2 |
| 3 | Terms and definitions | 2 |
| 4 | Symbols and abbreviated terms | 3 |
| 5 | Principle | 3 |
| 6 | Selection and preparation of the specimen | 5 |
| 6.1 | Test location | 5 |
| 6.2 | Revealing ferritic grain boundaries | 6 |
| 6.3 | Revealing austenitic and prior-austenitic grain boundaries | 6 |
| 7 | Characterization of grain size | 11 |
| 7.1 | Characterization by an index | 11 |
| 7.2 | Characterization by the intercept method | 12 |
| 8 | Test report | 15 |
| Annex A (informative) | Summary of methods for revealing ferritic, austenitic or prior-austenitic grain boundaries in steels | 16 |
| Annex B (normative) | Determination of grain size — Standard charts taken from ASTM E112 | 17 |
| Annex C (normative) | Evaluation method | 32 |

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules given in the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

~~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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)
~~ISO 643 was prepared by Technical Committee~~

The committee responsible for this document is ISO/TC 17, Steel, Subcommittee SC 7, Methods of testing (other than mechanical tests and chemical analysis).

This ~~third~~^{fourth} edition cancels and replaces the ~~second~~^{third} edition (ISO 643:2003~~2012~~), of which it constitutes a minor revision. A note was added after the first paragraph of 7.1.2.

Steels — Micrographic determination of the apparent grain size

1 Scope

This International Standard specifies a micrographic method of determining apparent ferritic or austenitic grain size in steels. It describes the methods of revealing grain boundaries and of estimating the mean grain size of specimens with unimodal size distribution. Although grains are three-dimensional in shape, the metallographic sectioning plane can cut through a grain at any point from a grain corner, to the maximum diameter of the grain, thus, producing a range of apparent grain sizes on the two-dimensional plane, even in a sample with a perfectly consistent grain size.

2 Normative references

The following documents, in whole or in part, are normatively referenced documents in this document and are indispensable for their 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 3785, *Steel/Metallic materials — Designation of test piece/specimen axes in relation to product texture*

ISO 14250, *Steel — Metallographic characterization of duplex grain size and distributions*

ASTM E112, *Standard Test Methods for Determining Average Grain Size*

3 Terms and definitions

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

3.1

grain

closed polygonal shape with more or less curved sides, which can be revealed on a flat cross-section through the sample, polished and prepared for micrographic examination

~~A distinction is made between:~~

3.1.1

austenitic grain

crystal with a face-centered cubic crystal structure which may, or may not, contain annealing twins

3.1.2

ferritic grain

crystal with a body-centered cubic crystal structure which never contains annealing twins¹⁾

~~1) — Ferritic grain size is generally estimated for non-alloy steels with a carbon content of 0,25 % or less. If pearlite islands of identical dimensions to those of the ferrite grains are present, the islands are then counted as ferrite grains.~~

Note 1 to entry: Ferritic grain size is generally estimated for non-alloy steels with a carbon content of 0,25 % or less. If pearlite islands of identical dimensions to those of the ferrite grains are present, the islands are then counted as ferrite grains.

**3.2
index**

positive, zero, or possibly negative number G which is derived from the mean number m of grains counted in an area of 1 mm^2 of the section of the specimen

NOTE By definition, $G = \frac{m}{16}$ where $m = 16$; the other indices are obtained by the formula

$$m = 8 \times 2^G$$

**3.3
intercept**

N
number of grains intercepted by a test line, either straight or curved

Note 1 to entry: See Figure 1.

NOTE — Note 2 to entry: Straight test lines will normally end within a grain. These end segments are counted as $1/2$ an interception. \bar{N} is the average of a number of counts of the number of grains intercepted by the test line applied randomly at various locations. \bar{N} is divided by the true line length, L_T , usually measured in millimetres, in order to obtain the number of grains intercepted per unit length, \bar{N}_L .

**3.4
intersection**

P
number of intersection points between grain boundaries and a test line, either straight or curved

Note 1 to entry: See Figure 1.

NOTE — Note 2 to entry: \bar{P} is the average of a number of counts of the number of grain boundaries intersected by the test line applied randomly at various locations. \bar{P} is divided by the true line length, L_T , usually measured in millimetres, in order to obtain the number of grain boundary intersections per unit length, \bar{P}_L .

4 Symbols and abbreviated terms

The symbols used are given in Table 1.

5 Principle

The grain size is revealed by micrographic examination of a polished section of the specimen prepared by an appropriate method for the type of steel and for the information sought.

NOTE If the order or the International Standard defining the product does not stipulate the method of revealing the grain, the choice of this method is left to the manufacturer.

This average size is characterized either

a) by an index obtained

— usually by comparison with standard charts for the measurement of grain size;

— or by counting to determine the average number of grains per unit area;

b) or by the mean value of the intercepted segment.

643_ed4fig1a.EPS

Interception, N , counts for a straight line on a single-phase grain structure where the arrows point to six intercepts and two line segments ending within grain ($2 \times 1/2 = 1 N$) and $N = 7$

643_ed4fig1b.EPS

Intersection, P , counts for a straight test line placed over a single-phase grain structure where the arrows point to seven intersection points and $P = 7$

~~Interception, N , counts for a straight line on a single-phase grain structure where the arrows point to 6 intercepts and two line segments ending within grain ($2 \times 1/2 = 1 N$) and $N = 7$~~

~~Intersection, P , counts for a straight test line placed over a single-phase grain structure where the arrows point to 7 intersection points and $P = 7$~~

Figure 1 — Examples of intersection, P , and interception, N

Table 1 — Symbols

| Symbols | Definition | Value |
|-----------|--|--|
| \bar{a} | Mean area of grain in square millimetres | $\bar{a} = \frac{1}{m}$ |
| A_F | Apparent area of the test figure in square millimetres | — |
| \bar{d} | Mean grain diameter in millimetres | $\bar{d} = \frac{1}{\sqrt{m}}$ |
| D | Diameter of the circle on the ground glass screen of the microscope or on a photomicrograph enclosing the image of the reference surface of the test piece | 79,8 mm (area = 5 000 mm ²) |
| g | Linear magnification (to be noted as a reference) of the microscopic image | In principle 100 |
| G | Equivalent index of grain size | — |
| K | Conversion factor from linear magnification $\times g$ to linear magnification $\times 100$ | $K = \frac{g}{100}$ |

| | | |
|-------------|--|--|
| l | Mean lineal intercept length, generally expressed in millimetres | $l = 1/\bar{N}_L = 1/\bar{P}_L$ |
| L_T | True length of the test line divided by the magnification, in millimetres | — |
| m | Number of grains per square millimetre of test piece surface in the area examined | $m = 2 n_{100}$ (magnification $\times 100$) $m = 2 K^2 n_g$ (magnification $\times g$) |
| M | Number of the closest standard chart picture where g is not 100 | — |
| n_g | Total equivalent number of grains examined on the image of diameter D (with a magnification $\times g$) | — |
| n_1 | Number of grains completely inside the circle of diameter D | — |
| n_2 | Number of grains intersected by the circle of diameter D | — |
| n_{100} | Total equivalent number of grains examined on the image of diameter D (with magnification $\times 100$) | $n_{100} = n_1 + \frac{n_2}{2}$ |
| \bar{N} | Mean number of grains intercepted per unit length L | — |
| \bar{N}_L | Mean number of grains intercepted per unit length of the line | $\bar{N}_L = \bar{N} / L_T$ |
| N_x | Number of intercepts per millimetre in the longitudinal direction ^a | — |
| N_y | Number of intercepts per millimetre in the transverse direction ^a | — |
| N_z | Number of intercepts per millimetre in the perpendicular direction ^a | — |
| \bar{P} | Mean number of counts of the number of grain boundaries intersected by the test line applied randomly at various locations | — |
| \bar{P}_L | Mean number of grain boundary intersections per unit length of test line | $\bar{P}_L = \bar{P} / L_T$ |

^a The method for designating the direction conforms to ISO 3785.

6 Selection and preparation of the specimen

6.1 Test location

If the order, or the International Standard defining the product, does not specify the number of specimens and the point at which they are to be taken from the product, these are left to the manufacturer, although it has been shown that precision of grain size determination increases the higher the number of specimens assessed. Therefore, it is recommended that two or more sections be assessed. Care shall be taken to ensure that the specimens are representative of the bulk of the product (i.e. avoid heavily deformed material such as that found at the extreme end of certain products or where shearing has been used to remove the specimen, etc.). The specimens shall be polished in accordance with the usual methods.

Unless otherwise stated by the product standard or by agreement with the customer, the polished face of the specimen shall be longitudinal, i.e. parallel to the principal axis of deformation in wrought products. Measurements of the grain size on a transverse plane will be biased if the grain shape is not equiaxial.

6.2 Revealing ferritic grain boundaries

The ferritic grains shall be revealed by etching with nital (ethanolic 2 % to 3 % nitric acid solution) or with an appropriate reagent.

6.3 Revealing austenitic and prior-austenitic grain boundaries

6.3.1 General

In the case of steels having a single-phase or two-phase austenitic structure (delta ferrite grains in an austenitic matrix) at ambient temperature, the grain shall be revealed by an etching solution. For single-phase austenitic stainless steels, the most commonly used chemical etchants are glyceric acid, Kalling's reagent (No. 2) and Marble's reagent. The best electrolytic etch for single- or two-phase stainless steels is aqueous 60 % nitric acid at 1,4 V d.c. for 60 s to 120 s, as it reveals the grain boundaries but not the twin boundaries. Aqueous 10 % oxalic acid, 6 V d.c., up to 60 s, is commonly used but is less effective than electrolytic 60 % HNO₃.

For other steels, one or other of the methods specified below shall be used depending on the information required.

- “Bechet-Beaujard” method by etching with aqueous saturated picric acid solution (see 6.3.2);
- “Kohn” method by controlled oxidation (see 6.3.3);
- “McQuaid-Ehn” method by carburization (see 6.3.4);
- grain boundary sensitization method (see 6.3.7);
- other methods specially agreed upon when ordering.

NOTE The first three methods are for prior-austenitic grain boundaries while the others are for austenitic Mn or austenitic stainless steel (see Annex A).

If comparative tests are carried out for the different methods, it is essential to use the same heat treatment conditions. Results may vary considerably from one method to the other.

6.3.2 “Bechet-Beaujard” method by etching with aqueous saturated picric acid solution

6.3.2.1 Field of application

This method reveals austenitic grains formed during heat treatment of the specimen. It is applicable to specimens which have a martensitic or bainitic structure. For this etch to work, there shall be at least 0,005 % P.

6.3.2.2 Preparation

The Bechet-Beaujard etchant is normally used on a heat-treated steel specimen. Normally, no subsequent heat treatment is necessary if the specimen has a martensitic or bainitic structure. If this is not the case, heat treatment is necessary.

If the conditions for treating the test piece are not provided for by the International Standard defining the product and there is no specification to the contrary, the following conditions shall be applied in the case of heat-treated structural carbon steels and low-alloy steels:

- 1,5 h at (850 ± 10) °C for steels whose carbon content is greater than 0,35 %;
- 1,5 h at (880 ± 10) °C for steels whose carbon content is less than or equal to 0,35 %.

After this treatment, the test piece shall be quenched into water or oil.

6.3.2.3 Polishing and etching

A flat specimen surface shall be polished for micrographic examination. It shall be etched for an adequate period of time by means of an aqueous solution saturated with picric acid together with at least 0,5 % sodium alkylsulfonate or another appropriate wetting agent.

NOTE The period of etching may vary from a few minutes to more than one hour. Heating of the solution to 60-°C may improve the etching action and reduce etching time.

Several successive etching and polishing operations are sometimes necessary to ensure a sufficient contrast between the grain boundaries and the general base of the specimen. In the case of through-hardened steel, tempering may be carried out before selecting the specimen.

WARNING: — When heating solutions containing picric acid, caution shall be taken to avoid the solution boiling dry as picric acid can become explosive.

6.3.2.4 Result

The prior-austenite grain boundaries shall be immediately apparent on microscopic examination.

6.3.3 “Kohn” method by controlled oxidation

6.3.3.1 Field of application

This method shows up the austenitic grain pattern formed by preferential oxidation of the boundaries during austenitization at the temperature of a given heat treatment.

6.3.3.2 Preparation

One surface of the specimen shall be polished. The rest of its surface shall not show any traces of oxide. The specimen shall be placed in a laboratory furnace in which either a vacuum of 1 Pa is attained or an inert gas is circulated (e.g. purified argon). Heat treat the specimen in accordance with the austenitizing procedure specified by the customer, or as defined by the International Standard governing the product.

At the end of this specified heating period, air shall be introduced into the furnace for a period of 10 s to 15 s.

The specimen shall then be water-quenched. The specimen can usually be directly examined using a microscope.

NOTE 1 The oxidation method can be done without the inert atmosphere.

NOTE 2 The oxide adhering to the previously polished surface should be removed by light polishing with a fine abrasive, taking care that the oxide network which has formed on the grain boundaries is retained; then the polishing should be completed by the usual methods. The specimen should then be etched using Vilella's reagent:

— picric acid — 1 g;

— hydrochloric acid 5 ml;

— ethanol — 100 ml.

6.3.3.3 Result

The preferential oxidation of the boundaries shows up the pattern of austenitic grains.