SLOVENSKI STANDARD
oSIST prEN 10270-1:2022

01-oktober-2022

Jeklena žica za vzmeti - 1. del: Patentirana hladno vlečena nelegirana jeklena žica za vzmeti

Steel wire for mechanical springs - Part 1: Patented cold drawn unalloyed spring steel wire

Stahldraht für Federn - Teil 1: Patentiert gezogener unlegierter Federstahldraht

Fils en acier pour ressorts mécaniques - Partie 1 : Fils pour ressorts en acier non allié, patentés, tréfilés à froid

Ta slovenski standard je istoveten z: **prEN 10270-1**

ICS:

77.140.25	Vzmetna jekla	Spring steels
77.140.65	Jeklene žice, jeklene vrvi in verige	Steel wire, wire ropes and link chains

oSIST prEN 10270-1:2022 **en,fr,de**

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

DRAFT
prEN 10270-1

August 2022

ICS 77.140.25

Will supersede EN 10270-1:2011+A1:2017

English Version

Steel wire for mechanical springs - Part 1: Patented cold drawn unalloyed spring steel wire

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This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 459/SC 6.

If this draft becomes a European Standard, 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.

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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

Contents

Page

European foreword

This document (prEN 10270-1:2022) has been prepared by Technical Committee CEN/TC 459 “ECISS – European Committee for Iron and Steel Standardization”[1], the secretariat of which is held by AFNOR.

This document is currently submitted to the CEN Enquiry.

This document will supersede EN 10270-1:2017.

In comparison with the previous edition, the following technical modifications have been made:

— 3.1 added specific requirements for Dynamic duty (D);

— 6.7.3 added “Protection Performance class” .

This European Standards for steel wire for mechanical springs is composed of the following parts:

— *Part 1: Patented cold drawn unalloyed spring steel wire*;

— *Part 2: Oil hardened and tempered spring steel wire*;

— *Part 3: Stainless spring steel wire*.

[1] Through its sub-committee SC 6 “Wire rod and wires” (secretariat: AFNOR).

1 Scope

This document applies to patented cold drawn unalloyed steel wire of circular cross-section for the manufacture of mechanical springs for static duty and dynamic duty applications.

General technical delivery requirements can be found in EN 10021.

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.

EN 10021, *General technical delivery conditions for steel products*

EN 10204, *Metallic products - Types of inspection documents*

EN 10218-1, *Steel wire and wire products - General - Part 1: Test methods*

EN 10218-2, *Steel wire and wire products - General - Part 2: Wire dimensions and tolerances*

EN 10244-2, *Steel wire and wire products - Non-ferrous metallic coatings on steel wire - Part 2: Zinc or zinc alloy coatings*

CEN/TR 10261, *Iron and steel - European standards for the determination of chemical composition*

EN ISO 377, *Steel and steel products - Location and preparation of samples and test pieces for mechanical testing (ISO 377)*

EN ISO 3887, *Steels - Determination of the depth of decarburization (ISO 3887)*

EN ISO 6892-1, *Metallic materials - Tensile testing - Part 1: Method of test at room temperature (ISO 6892-1)*

EN ISO 14284, *Steel and iron - Sampling and preparation of samples for the determination of chemical composition (ISO 14284)*

EN ISO 16120-1, *Non-alloy steel wire rod for conversion to wire - Part 1: General requirements (ISO 16120-1)*

EN ISO 16120-2, *Non-alloy steel wire rod for conversion to wire - Part 2: Specific requirements for general purpose wire rod (ISO 16120-2)*

EN ISO 16120-4, *Non-alloy steel wire rod for conversion to wire - Part 4: Specific requirements for wire rod for special applications (ISO 16120-4)*

3 Terms and definitions

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

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— IEC Electropedia: available at https://www.electropedia.org/

— ISO Online browsing platform: available at https://www.iso.org/obp/

3.1
patented cold drawn wire
wire drawn to size by cold deformation of a starting material that has been subjected to a thermal treatment of patenting (see EN ISO 4885), giving structure suitable for subsequent rolling or drawing

Note 1 to entry: For spring with Dynamic duty (D) according to Table 1, the wire has to be subjected to continuous patenting to achieve a homogeneous microstructure (for example, continuous lead patenting prior to the wire drawing).

4 Classification

The grade of spring wire used depends on the stress level and the nature of the duty. Where springs are subjected to static stresses or infrequent dynamic loading, a wire grade for static duty (S) shall be used. In the other cases with frequent or predominantly dynamic loading and where small coiling ratios or severe bending radius is required, a wire grade for dynamic duty (D) shall be used. Depending on the stress level, spring wire is manufactured in 3 tensile strength grades: low, medium and high.

Table 1 gives an overview of the different grades.

Table 1 — Spring wire grades

Tensile strength [a]	Static	Dynamic
Low tensile strength	SL	—
Medium tensile strength	SM	DM
High tensile strength	SH	DH
[a] For specific applications another tensile strength may be agreed.		

5 Information to be supplied by the purchaser

The purchaser shall clearly state in his enquiry or order the product and following information:

a) the desired quantity;

b) the term spring steel wire or straightened and cut lengths;

c) the number of this document: EN 10270-1;

d) the steel grade (see Tables 1 and 2);

e) the nominal wire diameter selected from Table 3 and for cut length the length and the length tolerance class (see Table 8);

f) the coating indicated by its abbreviation and surface finish (see 6.3);

g) the form of delivery and unit mass (see 6.2);

h) the type of inspection document (see 7.1);

i) any particular agreement.

EXAMPLE 5 t patented cold drawn tempered spring steel wire according to this standard, grade SM, nominal diameter 2,50 mm, phosphate coated on spools of about 300 kg; inspection certificate type 3.1 according to EN 10204:

5 t spring steel wire EN 10270-1 — SM-2,50 ph on spools of about 300 kg; EN 10204:—, 3.1.

6 Requirements

6.1 Material

6.1.1 General

Steel spring wire shall be made from steel grades according to:

— for SL, SM and SH EN ISO 16120-2;

— for DM and DH EN ISO 16120-4.

For general requirements, EN ISO 16120-1 applies.

6.1.2 Chemical composition

The chemical composition according to the heat analysis shall comply with the limit values shown in Table 2. The permissible deviation of the product analysis from the heat analysis shall be in accordance with EN ISO 16120-2 and EN ISO 16120-4 respectively.

Table 2 — Chemical composition, % by mass

Grade	C[a]	Si	Mn[b]	P	S	Cu
SL, SM, SH	0,35 to 1,00	0,10 to 0,30	0,40 to 1,20	0,035 max.	0,035 max.	0,20 max.
DM, DH	0,45 to 1,00	0,10 to 0,30	0,40 to 1,20	0,020 max.	0,025 max.	0,12 max.

[a] Such a wide range is stipulated to accommodate the whole range of sizes. For individual sizes the carbon range is substantially more restricted.

[b] For the manganese content, a different range from the one indicated in the table may be agreed at the time of ordering, with a maximum not exceeding 1,20 % and with a minimum range of 0,20 %.

The addition of micro-alloying elements may be agreed between the manufacturer and the purchaser.

NOTE Some diameter ranges require particular attention for residuals. Therefore, no figures are mentioned for chromium, nickel, molybdenum, tin, etc., leaving room for special arrangements between Purchaser and Supplier, dependent on their mutual processing conditions. This is also the case for the aluminium content.

6.2 Form of delivery

The wire shall be delivered in unit packages of a coil (singles, carriers or formers), spools, spoolless cores or as straight lengths. Unless otherwise agreed at the time of ordering, the form of delivery will be coils; straight lengths shall be supplied in bundles.

6.3 Coating and surface finish

The spring wire may be supplied phosphate coated (ph) either dry drawn or wet drawn, copper coated (cu), zinc (Z) or zinc/aluminium (ZA) coated.

Other coatings, considered as special, can be agreed between the purchaser and the supplier (see Annex A).

If no specific surface finish is specified, the type of finish shall be at the manufacturer's discretion.

In addition, the wire can be ordered with an oiled surface for all surface finishes.

6.4 Mechanical properties

For the tensile strength (Rm) and reduction in area after fracture (Z) the wire grades shall satisfy the values listed in Table 3. Reduction of area shall be measured only for wire diameter 0,80 mm < d.

The range of tensile strength values within a unit package shall not exceed the values of Table 4.

Table 3 — Mechanical properties [a] and quality requirements for wire grades SL, SM, DM, SH and DH

1	2	3	4	5	6	7	8	9	10	11	12
Wire diameter *d*		Tensile strength Rm [b c d] For wire grades					Minimum reduction in area after fracture Z for wire grades SL, SM, SH, DM and DH	Minimum number of twists in the torsion test Nt for wire grades SL, SM, SH, DM and DH [c]	Permissible depth of surface defects for wire grades DM, DH	Permissible decarburization depth for wire grades DM, DH	Mass [h] kg/1 000 m
Nominal size mm	Permissible deviations mm	SL MPa	SM MPa	DM MPa	SH MPa	DH [e] MPa	%		mm	mm	
d = 0,05	±0,003					2 800 to 3 520					0,015 4
0,05 < *d* ≤ 0,06						2 800 to 3 520					0,022 2
0,06 < *d* ≤ 0,07						2 800 to 3 520					0,030 2
0,07 < *d* ≤ 0,08						2 800 to 3 480					0,039 5
0,08 < *d* ≤ 0,09						2 800 to 3 430					0,049 9

1	2	3	4	5	6	7	8	9	10	11	12
0,09 < *d* ≤ 0,10						2 800 to 3 380					0,061 7
0,10 < *d* ≤ 0,11						2 800 to 3 350					0,074 6
0,11 < *d* ≤ 0,12	±0,004					2 800 to 3 320					0,088 8
0,12 < *d* ≤ 0,14						2 800 to 3 250					0,121
0,14 < *d* ≤ 0,16						2 800 to 3 200		coiling test as	- [f]	- [f]	0,158
0,16 < *d* ≤ 0,18						2 800 to 3 160		specified in			0,200
0,18 < *d* ≤ 0,20	±0,005					2 800 to 3 110		7.4.3			0,247
0,20 < *d* ≤ 0,22						2 770 to 3 080					0,298
0,22 < *d* ≤ 0,25						2 720 to 3 010					0,385

1	2	3	4	5	6	7	8	9	10	11	12
0,25 < *d* ≤ 0,28	±0,008					2 680 to 2 970					0,488
0,28 < *d* ≤ 0,30			2 370 to 2 650	2 370 to 2 650	2 660 to 2 940	2 660 to 2 940					0,555
0,30 < *d* ≤ 0,32			2 350 to 2 630	2 350 to 2 630	2 640 to 2 920	2 640 to 2 920					0,631
0,32 < *d* ≤ 0,34			2 330 to 2 600	2 330 to 2 600	2 610 to 2 890	2 610 to 2 890					0,713
0,34 < *d* ≤ 0,36			2 310 to 2 580	2 310 to 2 580	2 590 to 2 870	2 590 to 2 870					0,799
0,36 < *d* ≤ 0,38			2 290 to 2 560	2 290 to 2 560	2 570 to 2 850	2 570 to 2 850					0,890
0,38 < *d* ≤ 0,40			2 270 to 2 550	2 270 to 2 550	2 560 to 2 830	2 560 to 2 830					0,985
0,40 < *d* ≤ 0,43			2 250 to 2 520	2 250 to 2 520	2 530 to 2 800	2 530 to 2 800					1,14
0,43 < *d* ≤ 0,45			2 240 to 2 500	2 240 to 2 500	2 510 to 2 780	2 510 to 2 780					1,25