

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

DRAFT
prEN 4800-005

December 2023

ICS 49.025.30

Will supersede EN 4800-005:2010

English Version

Aerospace series - Titanium and titanium alloys - Technical specification - Part 005: Forging stock

Série aérospatiale - Titane et alliages de titane -
Spécification technique - Partie 005 : Produits destinés
à la forge

Luft- und Raumfahrt - Titan und Titanlegierungen -
Technische Lieferbedingungen - Teil 005:
Schmiedevormaterial

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee ASD-STAN.

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.

This draft European Standard was established by CEN 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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and United Kingdom.

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.

Warning : This document is not a European Standard. It is distributed for review and comments. It is subject to change without notice and shall not be referred to as a European Standard.



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	3
Introduction	4
1 Scope	5
2 Normative references	5
3 Terms and definitions	6
4 Wording of order	7
5 Health and safety	7
6 Technical requirements	7
6.1 General	7
6.2 Qualification requirements	8
6.3 Release requirements	8
6.3.1 Release tests	8
6.3.2 Retests	8
6.3.3 Rejection	9
6.3.4 Special tests	9
6.3.5 Capability clause	9
6.3.6 Statistical process control	9
6.3.7 Inspection and test report	9
6.4 Traceability	9
Bibliography	34

<https://standards.iteh.ai>

<https://standards.iteh.ai/catalog/standards/sist/85126ede-0a57-4be5-a358-680631de1d60/osist-pren-4800-005-2024>

European foreword

This document (prEN 4800-005:2023) 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 document has received the approval of the National Associations and the Official Services of the member countries of ASD-STAN, prior to its presentation to CEN.

This document is currently submitted to the CEN Enquiry.

This document will supersede EN 4800-005:2010.

iTeh Standards
(<https://standards.iteh.ai>)
Document Preview

[oSIST prEN 4800-005:2024](https://standards.iteh.ai/catalog/standards/sist/85126ede-0a57-4be5-a358-680631de1d60/osist-pren-4800-005-2024)

<https://standards.iteh.ai/catalog/standards/sist/85126ede-0a57-4be5-a358-680631de1d60/osist-pren-4800-005-2024>

prEN 4800-005:2023 (E)

Introduction

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

iTeh Standards
(<https://standards.iteh.ai>)
Document Preview

[oSIST prEN 4800-005:2024](https://standards.iteh.ai/catalog/standards/sist/85126ede-0a57-4be5-a358-680631de1d60/osist-pren-4800-005-2024)

<https://standards.iteh.ai/catalog/standards/sist/85126ede-0a57-4be5-a358-680631de1d60/osist-pren-4800-005-2024>

1 Scope

This document specifies the requirements for the ordering, manufacture, testing, inspection and delivery of titanium and titanium alloy forging stock. It is intended to be applied when referred to and in conjunction with the European material standard unless otherwise specified on the drawing, order or inspection schedule.

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 2002-001,¹ *Aerospace series — Metallic materials — Test methods — Part 001: Tensile testing at ambient temperature*

EN 2002-002, *Aerospace series — Metallic materials — Test methods — Part 002: Tensile testing at elevated temperature*

EN 2002-005, *Aerospace series — Test methods for metallic materials — Part 005: Uninterrupted creep and stress-rupture testing*

EN 2003-009, *Aerospace series — Test methods — Titanium and titanium alloys — Part 009: Determination of surface contamination*

EN 2032-001, *Aerospace series — Metallic materials — Part 001: Conventional designation*

EN 2032-2, *Aerospace series — Metallic materials — Part 2: Coding of metallurgical condition in delivery condition*

EN 2078, *Aerospace series — Metallic materials — Manufacturing schedule, inspection schedule, inspection and test report — Definition, general principles, preparation and approval*

EN 2954-002, *Aerospace series — Macrostructure of titanium and titanium alloy wrought products — Part 002: Macrostructure of bar, section, forging stock and forgings*

EN 2955, *Aerospace series — Recycling of titanium and titanium alloy scrap*

EN 2957, *Aerospace series — Method of preparation of forged samples*

EN 3114-001, *Aerospace series — Test method — Microstructure of ($\alpha + \beta$) titanium alloy wrought products — Part 001: General requirements*

EN 3114-002, *Aerospace series — Test method — Microstructure of ($\alpha + \beta$) titanium alloy wrought products — Part 002: Microstructure of bars, sections, forging stock and forgings*

EN 3683, *Aerospace series — Test methods — Titanium alloy wrought products — Determination of primary α content — Point count method and line intercept method*

EN 3684, *Aerospace series — Test methods — Titanium alloy wrought products — Determination of β transus temperature — Metallographic method*

¹ Published as ASD-STAN Standard at the date of publication of this document by Aerospace and Defence industries Association of Europe — Standardization (ASD-STAN), <https://www.asd-stan.org/>.

prEN 4800-005:2023 (E)

EN 3873, *Aerospace series — Test methods for metallic materials — Determination of fatigue crack growth rates using Corner-Cracked (CC) test pieces*

EN 3874,² *Aerospace series — Test methods for metallic materials — Constant amplitude force-controlled low cycle fatigue testing*

EN 3976, *Aerospace series — Titanium and titanium alloys — Test method — Chemical analysis for the determination of hydrogen content*

EN 3987, *Aerospace series — Test methods for metallic materials — Constant amplitude force-controlled high cycle fatigue testing*

EN 3988,³ *Aerospace series — Test method for metallic materials — Constant amplitude strain-controlled low cycle fatigue testing*

EN 4050-1, *Aerospace series — Test method for metallic materials — Ultrasonic inspection of bars, plates, forging stock and forgings — Part 1: General requirements*

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

EN 4259, *Aerospace series — Metallic materials — Definition of general terms*

EN ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature (ISO 6892-1:2019)*

EN ISO 6892-2, *Metallic materials — Tensile testing — Part 2: Method of test at elevated temperature (ISO 6892-2:2018)*

EN 9100, *Quality Management Systems — Requirements for Aviation, Space and Defence Organizations*

EN 9133, *Aerospace series — Quality Management Systems — Qualification Procedure for Aerospace Standard Products*

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

EN ISO 12737, *Metallic materials — Determination of plane-strain fracture toughness (ISO 12737)*

TR 2410-002,⁴ *Aerospace series — Metallic materials — Relationship between dimensional standards and material standards*

AMS 2750, *Pyrometry*

² Published as ASD-STAN Standard at the date of publication of this document by Aerospace and Defence industries Association of Europe — Standardization (ASD-STAN), <https://www.asd-stan.org/>.

³ Published as ASD-STAN Standard at the date of publication of this document by Aerospace and Defence industries Association of Europe — Standardization (ASD-STAN), <https://www.asd-stan.org/>.

⁴ Published as ASD-STAN Technical Report at the date of publication of this document by Aerospace and Defence industries Association of Europe — Standardization (ASD-STAN), <https://www.asd-stan.org/>.

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 4259 apply.

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

- ISO Online browsing platform: available at <https://www.iso.org/obp/>
- IEC Electropedia: available at <https://www.electropedia.org/>

4 Wording of order

The order shall clearly indicate:

- quantities to be supplied;
- dates of delivery;
- material standard number;
- delivery condition and metallurgical code of products;
- dimensions and tolerances or reference to an appropriate dimensional standard;
- product designation, when required;
- forwarding address;
- nature and type of packing, if required;
- definition and frequency of any special tests and their retest procedures, if required.

5 Health and safety

The products in the delivery condition shall fulfil the health and safety laws of the area of the country when and where it is to be delivered.

A product safety data sheet shall be available.

6 Technical requirements

6.1 General

The product shall be manufactured in accordance with the requirements of the relevant material standard and the applicable requirements of this specification. A manufacturing schedule shall be established and applied in accordance with EN 2078.

The product shall satisfy the requirements of the material standard and/or order and shall be free from irregularities prejudicial to the subsequent manufacture or use of this product.

Notwithstanding previous acceptance complying with this material standard, any product that is found, at a later stage, to contain such defects shall be rejected.

Unless otherwise specified, the requirements in Table 1 and Table 2 shall apply in conjunction with those of the relevant material standard. Table 1 relates to lines 1 to 29 (inclusive) of the material standard and Table 2 relates to lines 30 onwards in which the sub-line format is also used. Lines 2 to 98 may also be opened in line 100 if the material standard details specific qualification requirements. If a

prEN 4800-005:2023 (E)

specific line number is not shown in Table 1 and Table 2, the requirement is stated in the material standard and/or order.

The requirements of the order and/or material standard shall over-ride the requirements of the technical specification.

6.2 Qualification requirements

Qualification requirements when invoked by the material standard and/or order are detailed in Table 1 and Table 2. Unless otherwise agreed between the manufacturer and purchaser, the qualification phase shall be run on the first three batches.

6.3 Release requirements

6.3.1 Release tests

Release testing shall be the responsibility of the manufacturer.

The purchaser reserves the right to perform any of the inspections and/or tests required by the material standard and/or order.

The test samples shall be representative of the product.

When required the manufacturer shall inform the purchaser of the planned dates for extraction of samples and release testing in order that these operations may be witnessed.

Table 1 and Table 2 detail the requirements for each line of the material standard. Unless otherwise specifically requested by the purchaser, a particular inspection and/or test for release shall be carried out if corresponding acceptance criteria and/or values are stated in the applicable material standard but see also in 6.3.5.

6.3.2 Retests

If the test procedure or test piece preparation is faulty, testing shall be re-applied at the original frequency after rectification of the original cause of failure.

When failure cannot be attributed to faulty testing, or test piece preparation, further test samples shall be selected at twice the original frequency from the product, one of which shall be that on which the original results were obtained unless already withdrawn by the manufacturer after suitable identification of the cause of failure. If all retest results are satisfactory, the batch shall be accepted. If one or more tests are unsatisfactory, the batch shall be:

- rejected; or
- 100 % retested and the conforming products accepted; or

- partially or fully re-heat treated if heat treatment can rectify the cause of the failure and tested as a completely new batch except for chemical composition, for which redetermination of hydrogen content is required. No product or test sample shall be re-heat treated more than twice; or
- cut back and 100 %.

6.3.3 Rejection

Any failure to meet the requirements of the material standard shall be cause for rejection.

6.3.4 Special tests

Special tests may be required by the purchaser. In such cases, the nature of the test, method, frequency and technical requirements shall be specified on the order or inspection schedule and shall be mutually agreed by the manufacturer and purchaser.

6.3.5 Capability clause

Where capability clause is invoked and where sufficient statistical evidence exists, the test shall not be carried out (unless specifically requested by the purchaser). However, this in no way reduces the obligations of the manufacturer to fulfil the requirements. If subsequent testing indicates that the product does not comply with the requirements, the batch shall be rejected.

If sufficient statistical evidence does not exist, the test shall be carried out at a frequency agreed between the manufacturer and the purchaser.

6.3.6 Statistical process control

Reduction in the extent of release testing, other than that defined in 6.3.5 above, may be negotiated with the purchaser on the basis of appropriate statistical process control and/or statistical data.

6.3.7 Inspection and test report

The manufacturer shall furnish, with each delivery, a report conforming to the requirements of EN 2078 stating the following:

- manufacturer's name and address and, if appropriate, identification of the plant;
- order number;
- material standard number;
- delivery condition and metallurgical code of the product;
- quantity and dimensions;
- manufacturing and inspection schedule reference;
- cast and batch number;
- batch and/or test samples heat treatment condition;
- results of the tests and retests if any.

6.4 Traceability

Each product shall be traceable to the cast, production batch and/or heat treatment batch at all stages of manufacture, testing and delivery.