

BS EN 4629:2013



BSI Standards Publication

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

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National foreword

This British Standard is the UK implementation of EN 4629:2013. It supersedes BS EN 4629:2007 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee ACE/61/-/15, Steels for Aerospace Purposes.

A list of organizations represented on this committee can be obtained on request to its secretary.

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Amendments issued since publication

Date	Text affected
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English Version

**Aerospace series - Steel X4CrNiMo16-5-1 (1.4418) - Air melted
- Softened - Forging stock - De ≤ 300 mm**

Série aérospatiale - Acier X4CrNiMo16-5-1 (1.4418) -
Élaboré à l'air - Adouci - Demi-produits pour forgeage - De
≤ 300 mm

Luft- und Raumfahrt - Stahl X4CrNiMo16-5-1 (1.4418) -
Lufterschmolzen - Weichgeglüht - Schmiedestücke - De ≤
300 mm

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Management Centre: Avenue Marnix 17, B-1000 Brussels

Contents		Page
Foreword.....		3
Introduction		4
1	Scope.....	5
2	Normative references.....	5

Foreword

This document (EN 4629:2013) 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of an identical text or by endorsement, at the latest by August 2013, and conflicting national standards shall be withdrawn at the latest by August 2013.

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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.

1 Scope

This European Standard specifies the requirements relating to:

Steel X4CrNiMo16-5-1 (1.4418)
Air melted
Softened
Forging stock
 $D_e \leq 300$ mm

for aerospace applications.

NOTE Other designation: Z 8 CND 17-04.
Only the chemical composition of this standard must be considered.

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*

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

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 4700-005, *Aerospace series — Steel and heat resisting alloys — Wrought products — Technical specification — Part 005: Forging stock*

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

AMS 2315, *Determination of delta ferrite content*¹⁾

1) Published as SAE National (US) Society of Automotive Engineers (<http://www.sae.org/>).

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		Forging stock									
4.2	Method of production		–									
4.3	Limit dimension(s)	mm	$D_e \leq 300$									
5	Technical specification		EN 4700-005									

6.1	Delivery condition		Softened									
	Heat treatment		–									
6.2	Delivery condition code		U									
7	Use condition		Delivery condition									
	Heat treatment		–									

Characteristics

8.1	Test sample(s)		See EN 4700-005.					See EN 4700-005.						
8.2	Test piece(s)		See EN 4700-005.					See EN 4700-005.						
8.3	Heat treatment		Use condition					Reference (see line 29).						
9	Dimensions concerned	mm	$D_e \leq 300$					$D_e \leq 300$						
10	Thickness of cladding on each face	%	–					–						
11	Direction of test piece		–					L		LT				
12	Temperature	θ	°C	Ambient					Ambient					
13	Proof stress	$R_{p0,2}$	MPa	–					≥ 700					
14	T	Strength	R_m	MPa	–					$900 \leq R_m \leq 1\ 050$				
15		Elongation	A	%	–					≥ 16		≥ 12		
16		Reduction of area	Z	%	–					–				
17		Hardness		HBW ≤ 293					$269 \leq \text{HBW} \leq 331$					
18	Shear strength	R_c	MPa	–					–					
19	Bending	k	–	–					–					
20	Impact strength	KV	J	–					≥ 120 J at 20 °C Notch direction T ≥ 70 J at – 40 °C Notch direction T		≥ 60 J at 20 °C Notch direction L ≥ 35 J at – 40 °C Notch direction L			
21	C	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											

29	Reference heat treatment	–	Hardened and tempered $1\ 010\ ^\circ\text{C} \leq \theta \leq 1\ 060\ ^\circ\text{C}$ / OQ or WQ + $550\ ^\circ\text{C} \leq \theta \leq 620\ ^\circ\text{C}$
30	Microstructure	–	EN 4700-005
		1	See AMS 2315.
		7	The δ ferrite content shall not exceed 5 %.
44	External defects (visual)	–	EN 4700-005
50	Cleanliness/inclusion content (micro cleanliness)	–	EN 4700-005
		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
95	Marking inspection	–	EN 4700-005
96	Dimensional inspection	–	EN 4700-005
98	Notes	–	^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. ^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 %.
99	Typical use	–	–

100	-	Product qualification	-	Qualification programme to be agreed between manufacturer and purchaser.

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BSI Group Headquarters

389 Chiswick High Road London W4 4AL UK

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