

ISO 4954:2018 (E)

Steels for cold heading and cold extruding

Contents

	Foreword
1	Scope
2	Normative references
3	Terms and definitions
4	Classification and designation
4.1	Classification
4.2	Designation
5	Information to be supplied by the purchaser
5.1	Mandatory information
5.2	Options and/or supplementary or special requirements
5.3	Ordering example
6	Manufacturing process
6.1	General
6.2	Deoxidation
6.3	Heat-treatment condition and surface condition at delivery
6.3.1	Heat-treatment condition
6.3.2	Particular surface conditions
6.4	Traceability of the cast
6.5	Statistical evaluation
7	Requirements
7.1	Chemical composition, mechanical properties and hardenability
7.1.1	General
7.1.2	Chemical composition
7.1.3	Mechanical properties
7.1.4	Hardenability (only applicable to steel grades of Annexes B and C)
7.2	Grain size
7.3	Carbide spheroidization (only applicable for steels of Annexes A, B and C)
7.4	Non-metallic inclusions
7.4.1	Microscopic inclusions (only applicable for steels of Annexes B and C)
7.4.2	Macroscopic inclusions
7.5	Internal soundness
7.6	Aptitude to cold forming
7.7	Surface quality
7.7.1	General
7.7.2	Wire rod (only applicable for steels of Annexes A, B and C)
7.7.3	Bars (only applicable for steels of Annexes A, B and C)
7.7.4	Wire rod and bars for stainless steels (only applicable for steels of Annex D)
7.7.5	Bright products
7.7.6	Removal of surface defects
7.7.7	Non-destructive testing of the surface
7.8	Decarburization (only applicable for steels of Annexes B and C)
7.9	Corrosion resistance of stainless steels
7.10	Shape, dimensions and tolerances
8	Inspection
8.1	Testing procedures and types of documents
8.2	Summary of specific inspection and frequency of testing

- 9** **Preparation of samples and test pieces**
 - 9.1** **Selection and preparation of samples for product analysis**
 - 9.2** **Selection and preparation of samples and test pieces for the mechanical test**
- 10** **Test methods**
 - 10.1** **Chemical analysis**
 - 10.2** **Mechanical tests**
 - 10.3** **Hardenability and core hardness tests**
 - 10.3.1** **Verification of hardenability**
 - 10.3.2** **Verification of core hardness**
 - 10.4** **Aptitude to cold forming**
 - 10.4.1** **Upsetting test for non-alloy and alloy steels of Annexes A, B and C**
 - 10.4.2** **Upsetting test for stainless steels of Annex D**
 - 10.5** **Non-destructive testing**
 - 10.6** **Visual and dimensional test**
 - 10.7** **Retests**
- 11** **Surface treatment, marking and packaging**
 - 11.1** **Surface treatment and temporary corrosion protection**
 - 11.2** **Marking**
 - 11.3** **Packaging**
- Annex A** **(normative) Specific requirements for cold heading and cold extruding steels not intended for heat treatment after cold working**
- Annex B** **(normative) Specific requirements for cold heading and cold extruding case-hardening steels**
- Annex C** **(normative) Specific requirements for cold heading and cold extruding steels for quenching and tempering**
- Annex D** **(normative) Specific requirements for cold heading and cold extruding stainless steels**
- Annex E** **(normative) Supplementary or special requirements**
 - E.1** **General**
 - E.2** **Fine grain steel**
 - E.2.1** **General**
 - E.2.2** **Case hardening steels (Annex B)**
 - E.2.3** **Steels for quenching and tempering (Annex C)**
 - E.3** **Carbide spheroidization**
 - E.4** **Non-metallic inclusion content**
 - E.5** **Maximum depth of surface discontinuities**
 - E.6** **Special limits for decarburization and testing for decarburization**
 - E.7** **Corrosion resistance of stainless steel products**
- Annex F** **(informative) Designation of steels given in Annexes A, B, C and D and the comparable grades covered in various designation systems**

Page count: 68