DIN EN 1561:2024-03 (E)

Founding - Grey cast irons

Contents

Page

European foreword 4

Introduction 5

1 Scope 7

2 Normative references 7

3 Terms and definitions 8

4 Designation 9

5 Order information 9

6 Manufacture 10

7 Requirements 10
7.1 Mechanical properties 10
7.2 Tensile properties 10
7.2.1 General 10
7.2.2 Test pieces machined from cast samples 10
7.2.3 Test pieces machined from samples cut from a casting 11
7.3 Hardness properties 15
7.4 Graphite structure 16

8 Sampling 16
8.1 General 16
8.2 Samples for tensile test 17
8.2.1 Size of cast samples 17
8.2.2 Frequency and number of tests 17
8.2.3 Separately cast samples 18
8.2.4 Side-by-side cast samples 19
8.2.5 Cast-on samples 20
8.2.6 Samples cut from a casting 22
8.3 Samples for hardness test 23

9 Test methods 23
9.1 Tensile test 23
9.2 Brinell hardness test 25
9.3 Graphite structure 25
9.4 Alternative test procedures 25

10 Retests 25
10.1 Need for retests 25
10.2 Test validity 25
10.3 Nonconforming test results 25
10.4 Heat treatment of samples and castings 26

11 Inspection documentation 26

Annex A (informative) Additional information on mechanical and physical properties 27

Annex B (informative) Comparison of grey cast iron material designations according to EN 1560 and ISO/TR 15931 [7] 30

Annex C (informative) Additional information on the relationship between hardness and tensile strength 31

Annex D (informative) Additional information on the relationship between tensile strength, hardness and wall thickness of grey iron castings 33

Annex E (informative) Guidance values for tensile strength determined on samples cut from a casting 36

Annex F (informative) Wedge penetration test 38

Annex G (informative) Significant technical changes between this document and the previous edition 41

Bibliography 42