

DIN EN 10294-2:2012-04 (E)

Hollow bars for machining - Technical delivery conditions - Part 2: Stainless steels with specified machinability properties

Contents		Page
Foreword		4
1	Scope	5
2	Normative references	5
3	Terms and definitions	6
4	Symbols	6
5	Classification and designation	7
5.1	Classification	7
5.2	Designation	7
6	Information to be supplied by the purchaser	7
6.1	Mandatory information	7
6.2	Options	7
6.3	Example of an order	8
7	Manufacturing process	8
7.1	Material making process	8
7.2	Manufacturing and delivery conditions	8
7.2.1	Manufacturing	8
7.2.2	Delivery conditions	8
8	Requirements	9
8.1	General	9
8.2	Chemical composition	9
8.2.1	Cast analysis	9
8.2.2	Product analysis	9
8.3	Mechanical properties	11
8.4	Corrosion resistance	14
8.5	Machinability	14
8.5.1	Guaranteed cutting speeds (semi-roughing and finishing)	15
8.6	Appearance and soundness	15
8.6.1	Appearance	15
8.6.2	Soundness	16
8.7	Straightness	16
8.8	Preparation of ends	16
8.9	Dimensions, masses and tolerances	16
8.9.1	Outside diameter and inside diameter	16
8.9.2	Mass	16
8.9.3	Lengths	16
8.9.4	Tolerances	20
8.9.5	Dimensions achievable after machining	21
9	Inspection	21
9.1	Type of inspection	21
9.2	Inspection documents	21
9.2.1	Types of inspection documents	21
9.2.2	Content of inspection documents	21

9.3	Summary of inspection and testing	22
10	Sampling	22
10.1	Test unit	22
10.1.1	Number of samples per test unit	22
10.2	Preparation of samples and test pieces	23
10.2.1	General	23
10.2.2	Test piece for the tensile test	23
10.2.3	Test piece for the intergranular corrosion test	23
11	Test methods	23
11.1	Chemical analysis	23
11.2	Tensile test	23
11.3	Dimensional inspection	23
11.4	Visual examination	23
11.5	Intergranular corrosion test	23
11.6	Non-destructive test	24
11.7	Machining data	24
11.8	Retests, sorting and reprocessing	24
12	Marking	24
13	Temporary corrosion protection	24
Annex A (normative)	Method for establishing machining data	25