

STANDARD REFERENCE:

EN 10088-3: 2014 (Hot-rolled and bright products) | EN 10263-5: 2017 (Wire rods, bars and wire for cold heading products)

EN 10272: 2016 (Stainless steel bars for pressure purposes) P.E.D. 2014/68/EU

RODACCIAI REFERENCES AND COMPARABLE STANDARDS

EUROPE		ITALY	GERMANY		FRANCE	UK	USA
EN 10088-3: 2005 EN 10263-5: 2001 EN 10272: 2007		(UNI 6900: 71)	(DIN 17440 - 85)		(NF A 35-574-90)	(BS 970 pt.3 -91)	AISI
Grade	N°		Werkstoff	N°			
X2CrNi18-9	1.4307	-	-	-	Z3 CN 19 - 09	304S15	304L

CHEMICAL COMPOSITION (CAST ANALYSIS) (%)

C / max	Si / max	Mn / max	P / max	S / max	N / max	Cr	Ni
0,030	1,00	2,00	0,045	0,030	0,10	17,50÷19,50	8,0÷10,5

MECHANICAL PROPERTIES - Rough turned (1X) in the annealed condition

Size max (mm)	Hardness HB max***	Rp 0,2 (MPa) min	Rp 1 (MPa) min*	Rm (MPa)**	A5 (%) min**	KV (J) min	Resistance to intergranular corrosion	
							in the delivery condition	in the welded condition
100	215	175	210	500÷700	45	100	YES	YES

* Only for guidance ** The maximum HB values may be raised by 100HB or the tensile strength value may be raised by 200 MPa and the minimum A% value may be lowered to 20% for bars of ≤35 mm

MECHANICAL PROPERTIES - Cold drawn (2H, 2B) and ground bars (2G) in the solution annealed condition

Size max (mm)	Rp 0,2 (MPa) min	Rm (MPa)	A5 (%) min*	KV (J) min
≤ 10	400	600÷930	25	-
> 10 ≤ 16	380	600÷930	25	-
> 16 ≤ 40	175	500÷830	30	100
> 40 ≤ 63	175	500÷830	30	100
> 63 ≤ 100	175	500÷700	45	100

* Values valid only for size ≥5 mm

MECHANICAL PROPERTIES - Cold drawn wire and coils (2H)

Tensile strength levels	+C 600	+C 700	+C 800	+C900	+C 1000	+C 1100	+C 1200	+C 1400	+C 1600
Rm (MPa)	600÷800	700÷900	800÷1000	900÷1100	1000÷1250	1100÷1350	1200÷1450	1400÷1700	1600÷1900

Note: the desired tensile strength level shall be evaluated depending on diameter required



MECHANICAL PROPERTIES - Cold drawn wire and coils in the solution annealed condition (2D)

Size	$0,10 \leq d \leq 0,20$	$0,20 \leq d \leq 0,50$	$0,50 \leq d \leq 1,00$	$1,00 \leq d \leq 3,00$	$3,00 \leq d \leq 5,00$	$5,00 \leq d \leq 16,00$
R _m (MPa) max	1050	1000	950	900	850	800
A (%) min	20	30	30	30	35	35

Note: If skin passed, R_m might be increased by up to 50 MPa

MECHANICAL PROPERTIES - Bars, wire and coils for cold heading

Size mm	As Treated (+AT) or Peeled(+AT+PE)		Cold Drawn (+AT+C)		Cold Drawn + Solution annealed (+AT+C+AT)		Cold Drawn + Solution annealed + Skin passed (+AT+C+AT+LC)	
	R _m (MPa) max	Z (%) min	R _m (MPa) max	Z (%) min	R _m (MPa) max	Z (%) min	R _m (MPa) max	Z (%) min
$\geq 2 \leq 5$	-	-	-	-	680	68	730	63
$> 5 \leq 10$	630	68	800	-	630	68	680	63
$> 10 \leq 25$	630	68	760	-	630	68	-	-
$> 25 \leq 50$	630	68	740	-	630	68	-	-

WORKING TEMPERATURES RECOMMENDED

Operation	Hot forgings deformation	Solution annealing (water, air)
°C	900÷1200	1000÷1100

