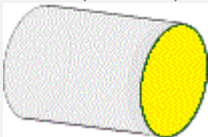


## 8620 CASE HARDENING STEEL

8620 is a low nickel - chromium - molybdenum medium hardenability, case hardening (carburizing) steel, generally supplied in the as rolled condition with a maximum brinell hardness of 280 (Rc30). Characterised by good core strength and toughness in small to medium sections with case hardness up to Rc62 when carburized, hardened and tempered. 8620 can also be used (uncarburized) as a high tensile steel, which when suitably hardened and tempered can be utilized for various applications requiring good tensile strength and reasonable toughness. Pre hardened and tempered (uncarburized) 8620 can be further surface hardened by nitriding but will not respond satisfactorily to flame or induction hardening due to its low carbon content. 8620 (carburized) is used extensively by all industry sectors for light to medium stressed components and shafts requiring high surface wear resistance with reasonable core strength and impact properties. Typical uses are: Arbors, Bearings, Bushings, Cam Shafts, Differential Pinions, Guide Pins, King Pins, Pistons Pins, Splined Shafts, Ratchets, Sleeves etc

Colour Code	Stocked Sizes		
Yellow (Bar End)	Rounds	10 mm to 260 mm Diameter	
	<b>Bar Finish</b>		
	Peeled, Turned or Hot Rolled		

### Related Specifications

Australia	AS 1444-1996-8620/8620H
Germany	W.Nr 1.6523 DIN 21NiCrMo2
Great Britain	BS970: PART 3: 1991 805 M20 BS970: 1955 - EN362
Japan	JISG 4052 SNCM 220H
USA	SAE 8620 AISI 8620 ASTM A29/A29M 1991 8620 UNS G86200

### Chemical Composition

	Min. %	Max. %
Carbon	0.17	0.23
Silicon	0.10	0.40
Manganese	0.60	0.95
Nickel	0.35	0.75
Chromium	0.35	0.75
Molybdenum	0.15	0.25
Phosphorous	0	0.04
Sulphur	0	0.04

### Typical Mechanical Properties For Core - Carburised and Oil Quenched at 840 °C

Section Size		11 mm	30 mm	63 mm
Tensile Strength Mpa	Min	980	780	690
	Max	1270	1080	930
Yield Strength Mpa	Min	785	590	490

Elongation 5.65√S <sub>0</sub> %	Min	9	10	11
Charpy Impact J	Min	41	41	
Hardness HB	Min	290	235	205
	Max	375	320	275
Hardness RC	Min	31	23	16
	Max	41	35	29

#### Typical Mechanical Properties - As Rolled

Tensile Strength Mpa		820		
Yield Strength Mpa		590		
Elongation on 5.65√S <sub>0</sub> %		22		
Hardness	HB	240		
	Rc	24		

#### Typical Mechanical Properties - Water Quenched at 830°C and Tempered as Indicated \*

Tempering Temperature °C		205	425	650
Tensile Strength Mpa		1050	930	700
Yield Strength Mpa		765	800	556
Elongation on 5.65√S <sub>0</sub> %		18	20	30
Izod Impact J		80	110	140
Hardness	HB	311	275	207
	Rc	34	29	16

\*Section Size 25 mm

Can be used in the Hardened and Tempered (uncarburised) condition for shock resisting shafts and parts with tensile strengths up to 800 Mpa, plus reasonable toughness possible in sections up to 100 mm. 8620 is however generally used in the carburised condition with heat treatment details as follows.

#### Forging

Heat to 1150°C and hold until temperature is uniform throughout the section. Soaking time at forging temperature should be as short as possible to avoid heavy scaling and excessive grain growth. This will vary depending on furnace conditions but 15 minutes per 25 mm of section may be used as a guide. Do not forge below 850°C.

Following completion of forging operation, work piece should be cooled as slowly as possible in sand or dry lime etc.

Note: Case hardening steels due to their low carbon content are less susceptible to cracking than medium or high carbon steels, and may therefore be heated and cooled more rapidly.

#### Heat Treatment

##### Annealing

Heat to 820°C - 850°C, hold until temperature is uniform throughout the section and cool in furnace.

##### Carburizing

Pack, salt or gas carburize at 900°C - 925°C, holding for sufficient time to develop the required case depth and carbon content, followed by a suitable hardening and tempering cycle to optimise case and core properties.

##### Hardening

Refer Refining & Hardening.

##### Nitriding

8620 suitably hardened and tempered (uncarburised) will respond to nitriding giving a surface hardness up to Rc 60. Nitriding is carried out at 490°C - 530°C followed by slow cooling (no quench), reducing the problem of distortion. During the initial heat treatment the tempering temperature employed should be higher than the nitriding temperature.

##### Normalizing

Heat to 900°C - 925°C, hold until temperature is uniform throughout the section. Soak for 10 - 15 minutes and cool in still air.

##### Refining & Hardening

##### Core Refine

Slow cool from carburizing temperature and re-heat to 840°C - 870°C, hold until temperature is uniform throughout the section, quench as required in water, oil or air cool.

**Case Hardening**

Following core refining, re-heat to 780°C - 820°C, hold until temperature is uniform throughout the section, and quench in oil. Temper immediately while still hand warm.

**Single Refine\***

**Direct Quench:** Cool from carburizing temperature to 820 °C - 840 °C, hold until temperature is uniform throughout the section. Quench in oil. Temper immediately while still hand warm. **Or:** Cool from carburizing temperature to room temperature, re-heat to 820 °C - 840 °C and hold until temperature is uniform throughout the section and quench in oil. Temper immediately.

\*Suitable for fine grained steels only.

**Stress Relieving**

Heat to 630°C - 650°C, hold until temperature is uniform throughout the section, soak for 1 hour per 25 mm section, and cool in still air.

**Tempering**

Heat to 150°C - 200°C as required, hold until temperature is uniform throughout the section, soak for 1 - 2 hours per 25 mm of section, and cool in still air. N.B. Tempering will improve the toughness of both case and core, with only a slight reduction in core strength and case hardness. It will also reduce the susceptibility of the case to grinding cracks.

**Notes on Heat Treatment**

Heating temperatures, rate of heating, cooling and soaking times will vary due to factors such as work piece size/shape also furnace type employed, quenching medium and work piece transfer facilities etc.. Please consult your heat treater for best results.

**Machining**

8620 in the as rolled as supplied condition, has very good machinability and all operations such as turning, drilling, milling and tapping etc. can be carried out satisfactorily as per machine manufacturers recommendations for suitable tool type - feeds and speeds.

**Welding**

8620 is readily weldable in the as rolled as supplied condition. Following welding, the work piece immediately upon cooling to hand warm should be stress relieved at 630°C - 650°C if possible.

N.B. Welding in the carburized and heat treated condition is not recommended.

**Welding Procedure**

Welding of 8620 should always be carried out using low hydrogen electrodes - please consult your welding consumables supplier.

**Suggested Pre-heat Temperature**

Section	40mm	50mm	75mm	150mm
°C	25	40	100	150

**Post Welding**

Allow to cool in still air. Alternatively cover in sand or dry lime etc..

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