



NSAI
Standards

Irish Standard
I.S. EN 1559-2:2014

Founding - Technical conditions of delivery - Part 2: Additional requirements for steel castings

I.S. EN 1559-2:2014

Incorporating amendments/corrigenda/National Annexes issued since publication:

The National Standards Authority of Ireland (NSAI) produces the following categories of formal documents:

I.S. xxx: Irish Standard — national specification based on the consensus of an expert panel and subject to public consultation.

S.R. xxx: Standard Recommendation — recommendation based on the consensus of an expert panel and subject to public consultation.

SWiFT xxx: A rapidly developed recommendatory document based on the consensus of the participants of an NSAI workshop.

This document replaces/revises/consolidates the NSAI adoption of the document(s) indicated on the CEN/CENELEC cover/Foreword and the following National document(s):

NOTE: The date of any NSAI previous adoption may not match the date of its original CEN/CENELEC document.

This document is based on:

EN 1559-2:2014

Published:

2014-10-01

*This document was published
under the authority of the NSAI
and comes into effect on:*

2014-10-18

ICS number:

77.140.80

NOTE: If blank see CEN/CENELEC cover page

NSAI
1 Swift Square,
Northwood, Santry
Dublin 9

T +353 1 807 3800
F +353 1 807 3838
E standards@nsai.ie
W NSAI.ie

Sales:
T +353 1 857 6730
F +353 1 857 6729
W standards.ie

Údarás um Chaighdeáin Náisiúnta na hÉireann

EUROPEAN STANDARD

EN 1559-2

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 2014

ICS 77.140.80

Supersedes EN 1559-2:2000

English Version

Founding - Technical conditions of delivery - Part 2: Additional requirements for steel castings

Fonderie - Conditions techniques de fourniture - Partie 2:
Spécifications complémentaires pour les pièces moulées en
acier

Gießereiwesen - Technische Lieferbedingungen - Teil 2:
Zusätzliche Anforderungen an Stahlgussstücke

This European Standard was approved by CEN on 18 July 2014.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

Contents

Page

Foreword.....	3
Introduction	4
1 Scope	5
2 Normative references	5
3 Terms and definitions	6
4 Information to be supplied by the purchaser	8
4.1 • Mandatory information.....	8
4.2 •• Optional information	8
4.3 ■ Drawings, patterns and tools	8
4.4 ■ Information on the mass	8
4.5 ■ Preliminary sample.....	8
4.6 ■ Initial sample	8
5 Designations	8
6 Manufacture.....	8
6.1 Manufacturing process	8
6.2 Welding operations.....	8
6.3 Further processing	9
7 Requirements	9
7.1 ■ General	9
7.2 Material	9
7.3 Casting.....	11
8 Inspection	14
8.1 ■ General	14
8.2 ■ Type of inspection documents and type of inspection	14
8.3 ■ Test unit.....	14
8.4 Samples	14
8.5 Test procedures	16
8.6 ■ Invalidation of test results	17
8.7 Retests	17
8.8 ■ Sorting and reprocessing	18
9 Marking	18
10 ■ Packaging and surface protection.....	18
11 ■ Complaints	18
Annex A (informative) Mandatory and/or optional information checklist	19
Annex B (informative) Significant technical changes between this European Standard and the previous edition	23
Bibliography	24

Foreword

This document (EN 1559-2:2014) has been prepared by Technical Committee ECISS/TC 111 “Steel castings and forgings”, the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 2015 and conflicting national standards shall be withdrawn at the latest by April 2015.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 1559-2:2000.

Within its programme of work, Technical Committee ECISS/TC 111 included the revision of the following standard:

EN 1559-2, *Founding - Technical conditions of delivery - Part 2: Additional requirements for steel castings*

Annex B provides details of significant technical changes between this European Standard and the previous edition.

This European Standard is one of a series of European Standards for technical delivery conditions for castings. The other standards in this series are:

- EN 1559-1, *Founding - Technical conditions of delivery - Part 1: General*;
- EN 1559-3, *Founding - Technical conditions of delivery - Part 3: Additional requirements for iron castings*;
- EN 1559-4, *Founding - Technical conditions of delivery - Part 4: Additional requirements for aluminium castings*;
- EN 1559-5, *Founding - Technical conditions of delivery - Part 5: Additional requirements for magnesium castings*;
- EN 1559-6, *Founding - Technical conditions of delivery - Part 6: Additional requirements for zinc castings*.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

EN 1559-2:2014 (E)

Introduction

In order to assist manufacturers and purchasers to prepare proper contractual arrangements and prevent misunderstanding, CEN/TC 190 approved the preparation of a series of standards covering technical delivery conditions. These have been prepared as separate parts.

This European Standard covers the additional technical delivery conditions for all the steel casting materials and has the same structure for clauses as EN 1559-1 "*Founding - Technical conditions of delivery – Part 1: General*".

This European Standard cannot be used alone for compiling a specification for ordering and supplying steel castings, but as a complement to EN 1559-1.

The structure of this European Standard is as follows:

- clauses and subclauses preceded by ■ indicate no additional conditions to EN 1559-1:2011;
- clauses and subclauses marked with a single dot • indicate that conditions shall be agreed at the time of enquiry and order;
- subclauses and paragraphs marked with two dots •• indicate that conditions can be agreed at the time of enquiry and order (optional);
- subclauses without dot marking are mandatory.

Annex A gives a checklist for quick information about different points that shall or may be agreed by the time of acceptance of the order. It relates to the applicable clauses or subclauses of EN 1559-1:2011 and EN 1559-2:2014.

1 Scope

This part of EN 1559 specifies the additional technical delivery conditions for steel castings unless other conditions have been agreed at the time of enquiry and order.

This European Standard is also applicable to nickel and cobalt alloy castings.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 1369, *Founding - Magnetic particle testing*

EN 1370, *Founding - Examination of surface condition*

EN 1371-1, *Founding - Liquid penetrant testing - Part 1: Sand, gravity die and low pressure die castings*

EN 1371-2, *Founding - Liquid penetrant inspection - Part 2: Investment castings*

EN 1559-1:2011, *Founding - Technical conditions of delivery - Part 1: General*

EN 10027-1, *Designation systems for steels - Part 1: Steel names*

EN 10027-2, *Designation systems for steels - Part 2: Numerical system*

EN 12680-1, *Founding - Ultrasonic examination - Part 1: Steel castings for general purposes*

EN 12680-2, *Founding - Ultrasonic examination - Part 2: Steel castings for highly stressed components*

EN 12681, *Founding - Radiographic examination*

EN 13018, *Non-destructive testing - Visual testing - General principles*

EN 14784-1, *Non-destructive testing - Industrial computed radiography with storage phosphor imaging plates - Part 1: Classification of systems*

EN 14784-2, *Non-destructive testing - Industrial computed radiography with storage phosphor imaging plates - Part 2: General principles for testing of metallic materials using X-rays and gamma rays*

EN ISO 148-1, *Metallic materials - Charpy pendulum impact test - Part 1: Test method (ISO 148-1)*

EN ISO 3452-1, *Non-destructive testing - Penetrant testing - Part 1: General principles (ISO 3452-1)*

EN ISO 3651-1, *Determination of resistance to intergranular corrosion of stainless steels - Part 1: Austenitic and ferritic-austenitic (duplex) stainless steels - Corrosion test in nitric acid medium by measurement of loss in mass (Huey test) (ISO 3651-1)*

EN ISO 3651-2, *Determination of resistance to intergranular corrosion of stainless steels - Part 2: Ferritic, austenitic and ferritic-austenitic (duplex) stainless steels - Corrosion test in media containing sulfuric acid (ISO 3651-2)*

This is a free preview. Purchase the entire publication at the link below:

[Product Page](#)

-
- Looking for additional Standards? Visit Intertek Inform Infostore
 - Learn about LexConnect, All Jurisdictions, Standards referenced in Australian legislation
-