

DIN EN 13261:2020-12 (E)

Railway applications - Wheelsets and bogies - Axles - Product requirements

Contents	Page
European foreword.....	6
Introduction	7
1 Scope.....	8
2 Normative references.....	8
3 Terms and definitions	9
4 Product definition.....	11
4.1 Chemical composition	11
4.1.1 Values to be obtained	11
4.1.2 Sampling methods	11
4.1.3 Analysis method	11
4.2 Mechanical characteristics	11
4.2.1 Characteristics from the tensile testing.....	11
4.2.2 Impact resistance characteristics	14
4.2.3 Fatigue characteristics	16
4.3 Microstructural characteristics	18
4.3.1 Values to be obtained	18
4.3.2 Position of the test piece.....	18
4.3.3 Test method	18
4.4 Material cleanliness	18
4.4.1 Micrographic cleanliness	18
4.4.2 Internal integrity.....	20
4.5 Ultrasonic permeability.....	20
4.5.1 General.....	20
4.5.2 Level to be obtained	20
4.5.3 Test piece	20
4.5.4 Test method	21
4.6 Residual stresses.....	21
4.6.1 General.....	21
4.6.2 Values to be obtained	21
4.6.3 Test piece and measurement point location.....	21
4.6.4 Measurement method	22
4.7 Surface characteristics.....	22
4.7.1 Surface finish	22
4.7.2 Surface integrity	25
4.8 Geometrical and dimensional tolerances.....	26
4.9 Protection against corrosion and mechanical damage	31
4.9.1 Final protection	31
4.9.2 Temporary protection.....	36
4.10 Marking.....	37
5 Alternative manufacturing process.....	37
6 Product qualification	37
7 Conditions of supply of the product	37

Annexe A (informative) Sampling of the material from an axle journal overlength.....	38
A.1 Values to be reached.....	38
A.2 Sampling method	38
A.2.1 Overlength with a diameter identical to the journal diameter.....	38
A.2.2 Overlength with a diameter greater than the journal diameter	38
Annexe B (informative) Test piece drawings	39
Annexe C (normative) Gauge block for measuring ultrasound permeability.....	43
C.1 Gauge block.....	43
C.2 Gauge block tolerances.....	45
C.3 Steel grade of the gauge block.....	45
Annexe D (informative) Position of measurement zones for ultrasound permeability	46
Annexe E (informative) Residual stress measurement with strain gauges and saw cutting	47
Annexe F (informative) Post-machining shot peening method	48
F.1 Shot peening principle.....	48
F.2 Requirements.....	48
F.2.1 Shot peening product	48
F.2.2 Hardness	48
F.2.3 Roughness	48
F.2.4 Coverage rate	48
F.2.5 Fatigue limit.....	48
F.3 Parameters.....	49
F.4 Qualification of the shot-peening process	49
Annexe G (normative) Method to determine the impact resistance of the protective coating	50
G.1 YES.....	50
G.2 Test piece	50
G.3 Equipment	50
G.4 Operating procedure	50
G.5 Expression of results	50
Annexe H (normative) Method to determine the chipping resistance of the protective coating	51
H.1 YES.....	51
H.2 Test piece	51
H.3 Equipment	51
H.4 Operating procedure	51
H.5 Expression of results	51
Annexe I (normative) Method to determine the resistance of the coating to specific corrosive products	53

I.1	YES	53
I.2	Test piece	53
I.3	Equipment	53
I.4	Corrosive products	53
I.5	Operating procedure	54
I.6	Expression of results.....	54
Annexe J (normative) Method to determine the resistance of the protective coating under cyclic mechanical stress.....		55
J.1	Purpose.....	55
J.2	YES	55
J.3	Test piece	55
J.4	Equipment	55
J.5	Operating procedure	55
J.6	Expression of results.....	56
Annexe K (normative) Product qualification.....		57
K.1	Introduction.....	57
K.2	General.....	57
K.3	Requirements.....	58
K.3.1	Requirements to be met by the manufacturer	58
K.3.1.1	General.....	58
K.3.1.2	Quality organisation.....	58
K.3.1.3	Staff qualification	58
K.3.1.4	Equipment	58
K.3.2	Requirements to be met by the product	58
K.4	Qualification procedures.....	59
K.4.1	General.....	59
K.4.2	Documentation required.....	59
K.4.3	Evaluation of production facilities and production process	59
K.4.4	Laboratory tests.....	60
K.5	Validity of the qualification	60
K.5.1	Condition of validity	60
K.5.2	Modification and extension	60
K.5.3	Transfer	60
K.5.4	Expiry	61
K.5.5	Withdrawal.....	61
K.6	Qualification record	61

Annexe L (normative) Conditions of supply of the product	62
L.1 Introduction.....	62
L.2 General	62
L.3 Delivery state	63
L.4 Unit checks.....	63
L.5 Batch sampling check.....	63
L.5.1 Checks to be carried out.....	63
L.5.2 Ultrasonic permeability	64
L.5.3 Surface finish.....	64
L.5.4 Visual inspection.....	65
L.6 Quality plan.....	65
L.6.1 General	65
L.6.2 Objectives	65
L.6.3 Quality Plan terms of application	65
L.7 Permissible repairs.....	66
L.7.1 General	66
L.7.2 Heat treatment	66
L.7.3 Retesting	66
L.7.4 Axle straightening	66
L.7.5 Re-machining	66
Annexe M (normative) Measurement of the hydrogen content of steel for axles at the development stage	67
M.1 General	67
M.2 Sampling	67
M.3 Analysis methods.....	67
M.4 Precautions	67
Annexe ZA (informative) Relationship between this European Standard and the essential requirements of Directive 2016/797/EC to be fulfilled	68
Bibliography	70