

Title (en)  
METHOD FOR LOW-PRESSURE CARBONITRIDING USING A REDUCED TEMPERATURE GRADIENT IN AN INITIAL NITRIDATION PHASE

Title (de)  
VERFAHREN FÜR NIEDERDRUCK-CARBONITRIERUNG MIT REDUZIERTEM TEMPERATURGRADIENTEN IN DER ERSTEN NITRIERUNGSPHASE

Title (fr)  
PROCEDE DE CARBONITRURATION BASSE PRESSION, A GRADIENT REDUIT DE TEMPERATURE DANS UNE PHASE DE NITRURATION INITIALE

Publication  
**EP 2773787 B1 20180704 (FR)**

Application  
**EP 12769125 A 20121008**

Priority  
• FR 1159877 A 20111031  
• EP 2012069889 W 20121008

Abstract (en)  
[origin: WO2013064336A1] The invention relates to a method for the low-pressure carbonitriding of steel parts, in particular parts used in the manufacture of automobiles, comprising: a heating step that includes a simple heating phase (M) followed by an initial nitridation phase (Ni) from a temperature between 700° C and 750° C to a temperature between 860° C and 1000° C and is carried out using a reduced temperature gradient relative to the simple heating phase; and alternate cementing (C1-Cn) and nitridation (N1- Nn) steps at constant temperature; wherein the final nitridation step is accompanied with a decrease in temperature immediately before a quenching step (T).

IPC 8 full level  
**C21D 1/18** (2006.01); **C22C 38/00** (2006.01); **C23C 8/02** (2006.01); **C23C 8/32** (2006.01); **C23C 8/34** (2006.01); **C23C 8/80** (2006.01)

CPC (source: EP US)  
**C21D 1/18** (2013.01 - EP US); **C22C 38/00** (2013.01 - EP US); **C23C 8/02** (2013.01 - EP US); **C23C 8/32** (2013.01 - EP US); **C23C 8/34** (2013.01 - EP US); **C23C 8/80** (2013.01 - EP US)

Designated contracting state (EPC)  
AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

DOCDB simple family (publication)  
**FR 2981948 A1 20130503; FR 2981948 B1 20140103**; BR 112014010315 A2 20170502; CN 103946412 A 20140723; CN 103946412 B 20161005; EP 2773787 A1 20140910; EP 2773787 B1 20180704; IN 3952CHN2014 A 20151023; JP 2014532809 A 20141208; JP 6189850 B2 20170830; KR 101945004 B1 20190201; KR 20140101749 A 20140820; MX 2014005220 A 20150305; MX 360731 B 20181114; US 2015101710 A1 20150416; US 9708704 B2 20170718; WO 2013064336 A1 20130510

DOCDB simple family (application)  
**FR 1159877 A 20111031**; BR 112014010315 A 20121008; CN 201280053990 A 20121008; EP 12769125 A 20121008; EP 2012069889 W 20121008; IN 3952CHN2014 A 20140526; JP 2014539274 A 20121008; KR 20147015025 A 20121008; MX 2014005220 A 20121008; US 201214354358 A 20121008