



Standard Specification for Carbon Steel Forgings, for General-Purpose Piping¹

This standard is issued under the fixed designation A 181/A 181M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification² covers nonstandard as-forged fittings, valve components, and parts for general service. Forgings made to this specification are limited to a maximum weight of 10 000 lb [4540 kg]. Larger forgings may be ordered to Specification A 266/A 266M.

1.2 Two grades of material are covered, designated as Classes 60 and 70, respectively, and are classified in accordance with their chemical composition and mechanical properties as specified in 5.1 and 6.1.

1.3 Class 60 was formerly designated Grade I and Class 70 was formerly designated Grade II.

1.4 This specification is expressed in both inch-pound units and SI units. However, unless the order specifies the applicable “M” specification designation (SI units), the material shall be furnished to inch-pound units.

1.5 The values stated in either inch-pound units or SI units are to be regarded as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification.

2. Referenced Documents

2.1 ASTM Standards:

A 266/A 266M Specification for Carbon Steel Forgings for Pressure Vessel Components³

A 788 Specification for Steel Forgings, General Requirements³

A 961 Specification for Common Requirements for Steel Flanges, Forged Fittings Valves, and Parts for Piping Applications⁴

2.2 AIAG Standard:

AIAG B-5 02.00 Primary Metals Identification Tag Application Standard⁵

3. General Requirements and Ordering Information

3.1 Product furnished to this specification shall conform to the requirements of Specification A 961, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the requirements of Specification A 961 constitutes non-conformance with this specification.

3.2 It is the purchaser’s responsibility to specify in the purchase order all ordering information necessary to purchase the needed material. Examples of such information include but are not limited to the ordering information in Specification A 961 and the following:

3.2.1 Supplementary requirements, and

3.2.2 Additional requirements (See 4.3, 9.1, 10.2, 12.1, and 12.2).

3.3 If the requirements of this specification are in conflict with the requirements of Specification A 961, the requirements of this specification shall prevail.

4. Materials and Manufacture

4.1 Except for flanges of all types, hollow, cylindrically shaped parts may be machined from hot-rolled or forged bar, provided that the axial length of the part is approximately parallel to the metal flow lines of the stock. Other parts, excluding flanges of all types, up to and including NPS 4 may be machined from hot-rolled or forged bar. Elbows, return bends, tees, and header tees shall not be machined directly from bar stock.

4.2 Except as permitted in 4.1, the finished product shall be a forging as defined in the Terminology section (exclusively) of Specification A 788.

4.3 When specified in the order, the manufacturer shall submit for approval of the purchaser a sketch showing the shape of the rough forging before machining.

4.4 Forgings shall be protected against sudden or too rapid cooling from the rolling or forging while passing through the critical range.

4.5 Heat treatment is neither required nor prohibited, but when applied, heat treatment shall consist of tempering,

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.22 on Valves, Fittings, Bolting, and Flanges for High and Subatmospheric Temperatures.

Current edition approved Sept. 10, 2000. Published November 2000. Originally published as A 181 – 35. Last previous edition A 181/A 181M – 95b.

² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-181 in Section II of that Code.

³ *Annual Book of ASTM Standards*, Vol 01.05.

⁴ *Annual Book of ASTM Standards*, Vol 01.01.

⁵ Available from Automotive Industry Action Group, 26200 Lahser, Suite 200, Southfield, MI 48034.

annealing, normalizing, or normalizing and tempering.

5. Chemical Composition

5.1 An analysis of each heat shall be made by the manufacturer to determine the percentages of the elements specified in Table 1. The chemical composition thus determined shall conform to the requirements in Table 1.

6. Mechanical Properties

6.1 The material shall conform to the requirements as to tensile properties prescribed in Table 2.

7. Number of Tests

7.1 One tension test shall be made from each heat.

7.2 If any test specimen is defectively machined, it may be discarded and another specimen substituted.

8. Retests

8.1 When one or more representative test specimens do not conform to specification requirements for the tested characteristic, only a single retest for each nonconforming characteristic may be performed to establish product acceptability. Retests shall be performed on twice the number of representative specimens that were originally nonconforming. When any retest specimen does not conform to specification requirements for the characteristic in question, the lot represented by that specimen shall be rejected, heat-treated or reheat-treated in accordance with 4.5, and tested in accordance with Sections 6, and 7.

9. Reports of Testing

9.1 Upon request of the purchaser in the contract or order, a report of the test results and chemical analyses shall be furnished. The specification designation included on reports of testing shall include year of issue and revision letter, if any.

10. Repair by Welding

10.1 Repair welding, by the manufacturer, is permissible for

TABLE 1 Chemical Requirements

Element	Composition, % Classes 60 and 70
Carbon, max	0.35
Manganese, max	1.10 ^A
Phosphorus, max	0.05
Silicon	0.10-0.35
Sulfur, max	0.05

^A Manganese may be increased to 1.35 % max provided the carbon is reduced 0.01 % for each 0.06 % increase in manganese over the limit shown in the table.

TABLE 2 Tensile Requirements

	Class 60	Class 70
Tensile strength, min, ksi [MPa]	60 [415]	70 [485]
Yield strength, ^A min, ksi [MPa]	30 [205]	36 [250]
Elongation in 2 in. [50 mm], min, %	22	18
Reduction of area, min, %	35	24

^A Determined by either the 0.2 % offset method or the 0.5 % extension-under-load method.

parts made to dimensional standards such as those of ANSI or equivalent standards.

10.2 Prior approval of the purchaser shall be required to weld repair special parts made to the purchaser’s requirements.

10.3 The composition of the weld deposits shall be similar to the base metal and in accordance with the procedure qualification for the applicable material. Welding shall be accomplished with a weld procedure designed to produce low hydrogen in the weldment. Short-circuit gas metal arc welding is permissible only with the approval of the purchaser.

11. Marking of Forgings

11.1 Identification marks consisting of the manufacturer’s symbol or name (Note), designation of service rating, Specification number, grade, and size shall be legibly forged or stamped on each forging, and in such a position as not to injure the usefulness of the forgings.

11.2 *Bar Coding*—In addition to the requirements in 11.1 bar coding is acceptable as a supplementary identification method. The purchaser may specify in the order a specific bar coding system to be used. The bar coding system, if applied at the discretion of the supplier, should be consistent with one of the published industry standards for bar coding. If used on small parts the bar code may be applied to the box or a substantially applied tag.

12. Certificate of Compliance

12.1 When specified in the purchase order or contract, a producer’s or supplier’s certification shall be furnished to the purchaser that the material was manufactured, sampled, tested, and inspected in accordance with this specification and has been found to meet the requirements. The specification designation included on certificates of compliance shall include year of issue and revision letter, if any.

12.2 When specified in the purchase order or contract, a report of the test results shall be furnished.

13. Keywords

13.1 pipe fittings; steel; piping applications; pressure containing parts; steel forgings; carbon; steel valves

SUPPLEMENTARY REQUIREMENTS

S1. Carbon Equivalent

S1.1 The maximum carbon equivalent based on heat analysis shall be as follows:

Class	Maximum Carbon Equivalent Value	
	Maximum Section Thickness Less Than or Equal to 2 in.	Maximum Section Thickness Greater Than 2 in.
60	0.45	0.46
70	0.47	0.48

S1.2 Determine the carbon equivalent (CE) as follows:

$$CE = \frac{Mn}{6} + \frac{(Cr + Mo + V)}{5} + \frac{(Ni + Cu)}{15}$$

S1.3 A lower maximum carbon equivalent may be agreed upon between the supplier and the purchaser.

S1.4 When this Supplementary Requirement is invoked, all elements in the carbon equivalent formula shall be analyzed and the amounts reported.

The American Society for Testing and Materials takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).