



Standard Specification for Forged or Rolled 8 and 9% Nickel Alloy Steel Flanges, Fittings, Valves, and Parts for Low-Temperature Service¹

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1. Scope

1.1 This specification² covers 8 and 9 % nickel-alloy steel forged or rolled flanges, fittings, valves, and parts intended for use in welded pressure vessels for low-temperature service. The specification is applicable to forgings with maximum section thickness of 3 in. [75 mm] in the double normalized and tempered condition and 5 in. [125 mm] in the quenched and tempered condition. Forgings under this specification are intended for service at operating temperatures not lower than -320°F [-196°C] for Type I or -275°F [-170°C] for Type II or higher than 250°F [121°C].

1.2 Material under this specification is available in two types having different chemical compositions as follows:

Type	Nominal Nickel Content, %
I	9
II	8

1.3 Supplementary requirements S1 and S2 are optional and shall apply when specified by the purchaser.

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 separately 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 370 Test Methods and Definitions for Mechanical Testing of Steel Products³

A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products³

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.22 on Valves and Fittings.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-522 in Section II of that Code.

³ Annual Book of ASTM Standards, Vol 01.03.

A 788 Specification for Steel Forgings, General Requirements⁴

3. Ordering Information

3.1 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 following:

3.1.1 Quantity,

3.1.2 Size and pressure class or dimensions (Tolerances and surface finishes should be included),

3.1.3 Specification number and type (The year date should be included),

3.1.4 Supplementary requirements, and

3.1.5 Additional requirements, (See 4.4, 13.6, 16.1, 17.1, 17.2, and 18.3).

4. Materials and Manufacture

4.1 The steel shall be produced in accordance with the melting process section of Specification A 788.

4.2 Material for forgings shall consist of ingots, or either forged or rolled blooms, billets, or bars.

4.3 The finished product shall be a forging as defined in the Terminology Section of Specification A 788.

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

5. Chemical Composition

5.1 The steel shall conform to the requirements for chemical composition as prescribed in Table 1. Test Methods, Practices, and Terminology A 751 shall apply.

6. Tensile Requirements

6.1 The forgings shall conform to the tensile property requirements prescribed in Table 2.

6.2 The forgings shall be tested in accordance with the latest issue of Test Methods and Definitions A 370.

7. Impact Requirements

7.1 Impact tests shall be conducted at -320°F [-195°C] for Type I and at -275°F [-170°C] for Type II, except when a

⁴ Annual Book of ASTM Standards, Vol 01.05.

TABLE 1 Chemical Requirements

	Composition, %	
	Type I	Type II
Carbon, max	0.13	0.13
Manganese, max	0.90	0.90
Phosphorus, max		
Heat analysis	0.025	0.025
Product analysis	0.030	0.030
Sulfur, max	0.025	0.025
Silicon ^A		
Heat analysis	0.15–0.30	0.15–0.30
Product analysis	0.13–0.32	0.13–0.32
Nickel		
Heat analysis	8.5–9.5	7.5–8.5
Product analysis	8.40–9.60	7.40–8.60

^AWhen vacuum carbon deoxidation is used, the maximum silicon content shall be 0.10 %.

TABLE 2 Tensile Requirements at Room Temperature

Tensile strength, min, ksi [MPa]	100 [690]
Yield strength, min, (0.2 % off-set), ksi [MPa]	75 [515]
Elongation in 2 in. [50mm], min, %	22
Reduction of area, min, %	45

higher temperature is specified in accordance with Supplementary Requirement S2. Each test shall consist of three specimens and each specimen shall have a lateral expansion opposite the notch of not less than 0.015 in. [15 mils] [0.38 mm].

7.2 The values of energy absorption in footpounds (or joules) and the fracture appearance in percent shear shall be recorded and reported for information.

8. Heat Treatment

8.1 The forgings shall be heat treated by the manufacturer by either of the following methods as mutually agreed upon between the purchaser and the manufacturer.

8.1.1 *Quenched and Tempered*—Heat to a uniform temperature of 1475 ± 25°F [800 ± 15°C]; hold at this temperature for a minimum time of 1 h/in. (2.4 min/mm) of thickness but in no case less than 30 min; quench by immersion in circulating water. Reheat until the forging attains a uniform temperature within the range from 1050 to 1125°F [565 to 605°C]; hold at this temperature for a minimum time of 1 h/in. of thickness but in no case less than 30 min; cool in air or water quench, at a rate not less than 300°F [165°C]/h.

8.1.2 *Double Normalized and Tempered*—Heat to a uniform temperature of 1650°F [900°C]; hold at this temperature for a minimum time of 1 h/in. (2.4 min/mm) of thickness but in no case less than 30 min; cool in air. Reheat until the forging attains a uniform temperature of 1450°F [790°C]; hold at this temperature for a minimum time of 1 h/in. of thickness but in no case less than 30 min; cool in air. Reheat to a uniform temperature within the range from 1050 to 1125°F [565 to 605°C]; hold at this temperature for a minimum time of 1 h/in. of thickness but in no case less than 30 min; cool in air or water quench, at a rate not less than 300°F [165°C]/h.

8.2 When stress relieving is to be performed after fabrication, the recommended stress-relieving treatment is as follows: gradually and uniformly heat the steel to a temperature between 1025 and 1085°F [550 and 585°C]; hold for a

minimum of 2 h for thicknesses up to 1 in. [25 mm]. For thicknesses over 1 in. [25 mm], a minimum additional holding time in the ratio of 1 h/in. (2.4 min/mm) of thickness in excess of 1 in. [25 mm] shall be added. Cool at a minimum rate of 300°F [165°C]/h to a temperature not exceeding 600°F [315°C].

9. Cast or Heat (Formerly Ladle) Analysis

9.1 An analysis of each heat of steel shall be made by the manufacturer to determine percentages of the elements specified in Table 1.

10. Product (Check) Verification Analysis

10.1 An analysis may be made by the purchaser from a forging representing each heat. Samples for analysis shall be taken not less than 1/4 in. [6 mm] below the surface of the forgings, or from tension test specimens. The chemical composition thus determined shall conform to the requirements specified in Table 1.

11. Workmanship, Finish, and Appearance

11.1 The forgings shall have a workman-like finish and shall be free of injurious defects.

12. Number of Tests and Retests

12.1 At least one tension test and one set of impact tests (three specimens) shall be made from each heat in each heat-treatment charge, subject to the provisions of 13.5.

12.2 If any test specimens fail due to mechanical causes, such as testing-equipment failure or improper specimen preparation, the specimens may be discarded and replacement specimens shall be considered as original tests.

12.3 If the results of the mechanical tests do not conform to the specified requirements, the manufacturer may retreat the forgings, but not more than three additional times. Retests shall be made in accordance with this section.

12.4 If the percentage elongation of any tension test specimen is less than that prescribed in Table 2 and any part of the fracture is outside the middle half of the gage length, a retest shall be allowed.

12.5 If the results of mechanical tests do not conform to the specified requirements because a flaw develops in the test specimen, a retest shall be allowed if the defect is not caused by ruptures, cracks, or flakes in the steel.

12.6 If the result from a test on one Charpy impact specimen from a set is below 0.015 in. [0.38 mm] in lateral expansion but not below 0.010 in. [0.25 mm] and the average test result on the set of specimens equals or exceeds 0.015 in. [0.38 mm], one retest of three additional specimens may be made. Each of the test results on the retested specimens shall equal or exceed 0.015 in. [0.38 mm].

13. Test Specimens

13.1 The tension and impact specimens may be obtained from a rough or finished production forging, or prolongation thereof, or from special forged blocks, suitably worked and heat treated with the production forgings. These tension and impact tests may represent all forgings from the same heat and heat treatment charge, provided the maximum thickness of

such forgings is not greater than the thickness of the test forging, prolongation, or special test block. Such special test blocks shall be forged in a manner similar to and shall have a maximum reduction not greater than the forgings represented. The manufacturer shall provide the required extra forgings or test blocks.

13.2 The test specimens shall be located at any point midway between the center and surface of solid forgings, and at any point midthickness of the heaviest section of hollow or bored forgings. For solid forgings where test metal is provided on the periphery, test specimens shall be taken at mid-thickness of the test prolongation.

13.3 Tests shall be oriented so that the longitudinal axis of the specimen is parallel to the major direction of grain flow.

13.4 The tension test specimens shall be machined to the standard specimen form and dimensions shown in Fig. 4 of Test Methods and Definitions A 370. In the case of sections too small to accommodate the standard specimen, the largest practicable small-size specimen shown in Fig. 4 of Test Methods and Definitions A 370 shall be used.

13.5 Standard Charpy V-notch specimens in accordance with Fig. 10 of Test Methods and Definitions A 370 shall be used, except where the material is of insufficient thickness to permit their use, in which case the largest obtainable specimens shown in 20.2.2 of Test Methods and Definitions A 370 shall be used.

13.6 When fabrication requires stress relieving, the purchaser shall specify stress relieving of the test pieces prior to machining of the test specimens. Stress relieving shall be carried out as prescribed in 8.2.

14. Method of Impact Testing

14.1 The impact test shall be made in accordance with the simple beam, Charpy type of test described in the latest issue of Test Methods and Definitions A 370.

14.2 Precaution shall be taken so that when broken, the test specimens shall be within $\pm 3^{\circ}\text{F}$ [1.7°C] of the specified test temperature.

15. Inspection

15.1 The inspector representing the purchaser shall have free entry, at all times while work on the contract of the purchaser is being performed, to all parts of the manufacturer's works that concern the manufacture of the material ordered. The manufacturer shall afford the inspector all reasonable facilities to satisfy the inspector that the material is being furnished in accordance with this specification. All tests (except product analysis) and inspection shall be made at the place of manufacture prior to shipment, unless otherwise specified, and shall be conducted so as not to interfere unnecessarily with the operation of the works.

15.2 The manufacturer shall report to the purchaser or the purchaser's representative the heat treatments applied to the material and to the test blocks and the results of the chemical analysis and mechanical tests made in accordance with this specification and the heat number or his heat identification.

16. Rejection

16.1 Unless otherwise specified, any rejection based on tests

made in accordance with Section 5 shall be reported to the manufacturer within 60 days from the receipt of samples or test reports by the purchaser.

16.2 Each forging in which injurious metal defects are exposed during subsequent machining shall be rejected and the manufacturer notified.

17. Certification

17.1 For forgings made to specified dimensions, when agreed upon by the purchaser, and for forgings made to dimensional standards unless written certification is required by the purchaser, the application of identification marks as required in Section 18 shall be the certification that the forgings have been furnished in accordance with the requirements of this specification.

17.2 Test reports, when required, shall include certification that all requirements of this specification have been met. The manufacturer shall provide the following where applicable:

17.2.1 Whether Type 1 or Type 11 material has been supplied and the chemical analysis results in accordance with Section 6,

17.2.2 Type of heat treatment used,

17.2.3 Results of tension and Charpy impact tests including the impact test temperature, and test coupon stress relief details if applicable,

17.2.4 Results of any additional or supplementary requirements specified by the purchaser, and

17.2.5 The year date and revision letter, if any, of the specification. Note, this information is not required to be marked on the forgings.

18. Product Marking

18.1 Each forging shall be legibly stamped by the manufacturer with the heat number or his heat identification, the manufacturer's name (Note) or trademark, and this specification number, A 522/A 522M, 8NI, or 9NI as applicable, and QT or NNT as applicable.

NOTE 1—For purposes of identification marking, the manufacturer is considered the organization that certifies the piping component was manufactured, sampled, and tested in accordance with this specification and the results have been determined to meet the requirements of this specification.

18.2 Forgings impact tested at temperatures other than that specified in 7.1 shall be marked with the letters LTV following the specification number. These letters shall be followed by the impact test temperature in degrees Fahrenheit. A prefix 0 to the test temperature indicates a temperature below 0°F [-17.8°C], for example LTV0300 indicates -300°F [-184°C].

18.3 The purchaser may specify additional identification marking and the location of all stamping. The type of stamps shall be round or "interrupted-dot" die stamps having a radius of $\frac{1}{32}$ in. [0.8 mm].

18.4 *Bar Coding*—In addition to the requirements in 18.1, 18.2, and 18.3, bar coding is acceptable as a supplemental 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.

tions; pressure containing parts; steel flanges; steel forgings; alloy; steel valves; temperature service applications; low

19. Keywords

19.1 nickel alloy steel; pipe fittings; steel; piping applica-

SUPPLEMENTARY REQUIREMENTS

One or more of the supplementary requirements described below may be included in purchaser's order or contract. When so included, a supplementary requirement shall have the same force as if it were in the body of the specification. Supplementary requirement details not fully described shall be agreed upon between the purchaser and the supplier, but shall not negate any of the requirements in the body of the specification.

S1. Nondestructive Tests

S1.1 *Ultrasonic Tests*—Ultrasonic tests may be made by agreement between manufacturer and purchaser.

S1.2 *Liquid Penetrant Tests*—Liquid penetrant tests may be made by agreement between manufacturer and purchaser.

S2. Other Impact Test Temperatures

S2.1 The purchaser may specify an impact test temperature higher than that in 7.1 but no higher than the minimum intended operating temperature for the forging.

S2.2 Marking shall be in accordance with 18.2.

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