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Standard Specification for Alloy-Steel and Stainless Steel Bolting Materials for High-Temperature Service[1]

This standard is issued under the fixed designation A 193/A 193M; 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.

Note—Corrections were made throughout editorially and the year date was changed on May 11, 2004.

1. Scope*

1.1 This specification[2] covers alloy and stainless steel bolting material for pressure vessels, valves, flanges, and fittings for high-temperature service. The term *bolting material* as used in this specification covers bars, bolts, screws, studs, stud bolts, and wire. Bars and wire shall be hot-wrought. The material may be further processed by centerless grinding or by cold drawing. Austenitic stainless steel may be carbide solution treated or carbide solution treated and strain-hardened. When strain hardened austenitic steel is ordered, the purchaser should take special care to ensure that Appendix X1 is thoroughly understood.

1.2 Several grades are covered, including ferritic steels and austenitic stainless steels designated B5, B8, and so forth. Selection will depend upon design, service conditions, mechanical properties, and high-temperature characteristics.

NOTE 1—The committee formulating this specification has included fifteen steel types that have been rather extensively used for the present purpose. Other compositions will be considered for inclusion by the committee from time to time as the need becomes apparent.

NOTE 2—For grades of alloy-steel bolting material suitable for use at the lower range of high-temperature applications, reference should be made to Specification A 354.

NOTE 3—For grades of alloy-steel bolting material suitable for use in low-temperature applications, reference should be made to Specification A 320/A 320M.

1.3 Nuts for use with this bolting material are covered in Section 13.

1.4 Supplementary Requirements S1 through S10 are provided for use when additional tests or inspection are desired. These shall apply only when specified in the purchase order.

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

1.6 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:* [3]

A 194/A 194M Specification for Carbon and Alloy Steel Nuts for Bolts for High-Pressure or High-Temperature Service, or Both

A 320/A 320M Specification for Alloy/Steel Bolting Materials for Low-Temperature Service

A 354 Specification for Quenched and Tempered Alloy Steel Bolts, Studs, and Other Externally Threaded Fasteners

A 962/A 962M Specification for Common Requirements for Steel Fasteners or Fastener Materials, or Both, Intended for Use at Any Temperature from Cryogenic to the Creep Range

E 18 Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials

E 21 Test Methods for Elevated Temperature Tension Tests of Metallic Materials

E 112 Test Methods for Determining Average Grain Size

E 139 Test Methods for Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials

E 150 Practice for Conducting Creep and Creep-Rupture Tension Tests of Metallic Materials Under Conditions of Rapid Heating and Short Times[4]

E 151 Practice for Tension Tests of Metallic Materials at

[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 Steel Forgings and Wrought Fittings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications.

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[2] For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-193 in Section II of that Code.

[3] For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

[4] Withdrawn.

***A Summary of Changes section appears at the end of this standard.**

Elevated Temperatures with Rapid Heating and Conventional or Rapid Strain Rates[4]
E 292 Test Methods for Conducting Time-for-Rupture Notch Tension Tests of Materials
E 328 Test Methods for Stress-Relaxation Tests for Materials and Structures
E 381 Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings
E 566 Practice for Electromagnetic (Eddy-Current) Sorting of Ferrous Metals
E 709 Guide for Magnetic Particle Examination
F 606 Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, and Rivets

2.2 *ANSI Standards:*[5]
B1.1 Screw Threads
B18.2.1 Square and Hex Bolts and Screws
B18.2.3.1M Metric Hex Cap Screws
B18.3 Hexagon Socket and Spline Socket Screws
B18.3.1M Metric Socket Head Cap Screws

2.3 *AIAG Standard:*[6]
AIAG B-5 02.00 Primary Metals Identification Tag Application Standard

3. General Requirements and Ordering Information

3.1 Material supplied to this material specification shall conform to Specification A 962/A 962M. These requirements outline the testing and retesting methods and procedures, permissible variations in dimensions, and mass, quality and repair of defects, etc.

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 962/A 962M and the following:

3.2.1 Heat-treated condition (that is, normalized and tempered, or quenched and tempered, for the ferritic materials, and carbide solution treated (Class 1), carbide solution treated after finishing (Class 1A), and carbide solution treated and strain-hardened (Classes 2, 2B and 2C), for the austenitic stainless steels; Classes 1B and 1C apply to the carbide solution-treated nitrogen-bearing stainless steels; Class 1D applies to material carbide solution treated by cooling rapidly from the rolling temperature),

3.2.2 Description of items required (that is, bars, bolts, screws, or studs),

3.2.3 Nuts, if required by purchaser, in accordance with 13.1,

3.2.4 Supplementary requirements, if any, and

3.2.5 Special requirements, in accordance with 6.3, 6.5.1, 10.2, 14.1, and 15.1.

3.3 If the requirements of this specification are in conflict with the requirements of Specification A 962/A 962M the requirements of this specification shall prevail.

4. Manufacture (Process)

4.1 The steel shall be produced by any of the following processes: open-hearth, basic-oxygen, electric-furnace, or vacuum-induction melting (VIM). The molten steel may be vacuum-treated prior to or during pouring of the ingot or strand casting.

4.2 *Quality*—See Specification A 962/A 962M for requirements.

5. Discard

5.1 A sufficient discard shall be made to secure freedom from injurious piping and undue segregation.

6. Heat Treatment

6.1 Ferritic steels shall be properly heat treated as best suits the high-temperature characteristics of each grade. Immediately after rolling or forging, the bolting material shall be allowed to cool to a temperature below the cooling transformation range. The materials which are to be furnished in the liquid-quenched condition shall then be uniformly reheated to the proper temperature to refine the grain (a group thus reheated being known as a *quenching charge*) and quenched in a liquid medium under substantially uniform conditions for each quenching charge. Use of water quenching is prohibited for any ferritic grade when heat treatment is part of the fastener manufacturing process. This prohibition does not apply to heat treated bar or to fasteners machined therefrom. Material Grade B16 shall be heated to a temperature range from 1700 to 1750°F [925 to 954°C] and oil quenched. The materials that are to be furnished in the normalized or air-quenched condition shall be reheated to the proper temperature to refine the grain and cooled uniformly in air to a temperature below the transformation temperature range. The material, whether liquid-quenched or normalized, shall then be uniformly reheated for tempering. The minimum tempering temperature shall be as specified in Table 2 and Table 3.

[5] Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

[6] Available from Automotive Industry Action Group, 26200 Lahser, Suite 200, Southfield, MI 48034.

TABLE 1 Chemical Requirements (Composition, percent)[A]

Type	Ferritic Steels			
Grade	B5		B6 and B6X	
UNS Designation	5% Chromium		12 % Chromium	
			S 41000 (410)	
	Range	Product Variation, Over or Under[B]	Range	Product Variation Over or Under[B]
Carbon	0.10 min	0.01 under	0.08–0.15	0.01 over
Manganese, max	1.00	0.03 over	1.00	0.03 over
Phosphorus, max	0.040	0.005 over	0.040	0.005 over
Sulfur, max	0.030	0.005 over	0.030	0.005 over
Silicon	1.00 max	0.05 over	1.00 max	0.05 over
Chromium	4.0–6.0	0.10	11.5–13.5	0.15
Molybdenum	0.40–0.65	0.05	. . .	. . .

Type	Ferritic Steels			
Grade	B7, B7M		B16	
Description	Chromium-Molybdenum[C]		Chromium-Molybdenum-Vanadium	
	Range	Product Variation, Over or Under[B]	Range	Product Variation, Over or Under[B]
Carbon	0.37–0.49[D]	0.02	0.36–0.47	0.02
Manganese	0.65–1.10	0.04	0.45–0.70	0.03
Phosphorus, max	0.035	0.005 over	0.035	0.005 over
Sulfur, max	0.040	0.005 over	0.040	0.005 over
Silicon	0.15–0.35	0.02	0.15–0.35	0.02
Chromium	0.75–1.20	0.05	0.80–1.15	0.05
Molybdenum	0.15–0.25	0.02	0.50–0.65	0.03
Vanadium	. . .	. . .	0.25–0.35	0.03
Aluminum, max %[E]	. . .	. . .	0.015	. . .

Type	Austenitic Steels,[F] Classes 1, 1A, 1D, and 2							
Grade	B8, B8A		B8C, B8CA		B8M, B8MA, B8M2, B8M3		B8P, B8PA	
UNS Designation	S 30400 (304)		S 34700 (347)		S 31600 (316)		S 30500	
	Range	Product Variation, Over or Under[B]	Range	Product Variation, Over or Under[B]	Range	Product Variation, Over or Under[B]	Range	Product Variation, Over or Under[B]
Carbon, max	0.08	0.01 over	0.08	0.01 over	0.08	0.01 over	0.12	0.01 over
Manganese, max	2.00	0.04 over	2.00	0.04 over	2.00	0.04 over	2.00	0.04 over
Phosphorus, max	0.045	0.010 over	0.045	0.010 over	0.045	0.010 over	0.045	0.010 over
Sulfur, max	0.030	0.005 over	0.030	0.005 over	0.030	0.005 over	0.030	0.005 over
Silicon, max	1.00	0.05 over	1.00	0.05 over	1.00	0.05 over	1.00	0.05 over
Chromium	18.0–20.0	0.20	17.0–19.0	0.20	16.0–18.0	0.20	17.0–19.0	0.20
Nickel	8.0–11.0	0.15	9.0–12.0	0.15	10.0–14.0	0.15	11.0–13.0	0.15
Molybdenum	. . .	. . .	. . .	. . .	2.00–3.00	0.10	. . .	. . .
Columbium + tantalum	. . .	. . .	10 x carbon content, min; 1.10 max	0.05 under	. . .	. . .	. . .	. . .

TABLE 1 *Continued*

Type	Austenitic Steels,[F] Classes 1A, 1B, 1D, and 2				
Grade	B8N, B8NA		B8MN, B8MNA		B8MLCuN, B8MLCuNA
UNS Designation	S 30451 (304N)		S 31651 (316N)		S 31254
	Range	Product Variation, Over or Under[B]	Range	Product Variation, Over or Under[B]	Range
Carbon, max	0.08	0.01 over	0.08	0.01 over	0.020
Manganese, max	2.00	0.04 over	2.00	0.04 over	1.00
Phosphorus, max	0.045	0.010 over	0.045	0.010 over	0.030
Sulfur, max	0.030	0.005 over	0.030	0.005 over	0.010
Silicon, max	1.00	0.05 over	1.00	0.05 over	0.80
Chromium	18.0–20.0	0.20	16.0–18.0	0.20	19.5–20.5
Nickel	8.0–11.0	0.15	10.0–13.0	0.15	17.5–18.5
Molybdenum	. . .	. . .	2.00–3.00	0.10	6.0–6.5
Nitrogen	0.10–0.16	0.01	0.10–0.16	0.01	0.18–0.22
Copper	. . .	. . .	. . .	. . .	0.50–1.00

Type	Austenitic Steels[F], Classes 1, 1A, and 2	
Grade	B8T, B8TA	
UNS Designation	S 32100 (321)	
	Range	Product Variation, Over or Under[B]
Carbon, max	0.08	0.01 over
Manganese, max	2.00	0.04 over
Phosphorus, max	0.045	0.010 over
Sulfur, max	0.030	0.005 over
Silicon, max	1.00	0.05 over
Nickel	9.0–12.0	0.15
Chromium	17.0–19.0	0.20
Titanium	5 x (C + N) min, 0.70 max	0.05 under

Type	Austenitic Steels[F], Classes 1C and 1D			
Grade	B8R, B8RA		B8S, B8SA	
UNS Designation	S 20910		S 21800	
	Range	Product Variation, Over or Under[B]	Range	Product Variation, Over or Under[B]
Carbon, max	0.06	0.01 over	0.10	0.01 over
Manganese	4.0–6.0	0.05	7.0–9.0	0.06
Phosphorus, max	0.045	0.005 over	0.060	0.005 over
Sulfur, max	0.030	0.005 over	0.030	0.005 over
Silicon	1.00 max	0.05 over	3.5–4.5	0.15
Chromium	20.5–23.5	0.25	16.0–18.0	0.20
Nickel	11.5–13.5	0.15	8.0–9.0	0.10
Molybdenum	1.50–3.00	0.10	. . .	. . .
Nitrogen	0.20–0.40	0.02	0.08–0.18	0.01
Columbium + tantalum	0.10–0.30	0.05	. . .	. . .
Vanadium	0.10–0.30	0.02	. . .	. . .

Type	Austenitic Steels[F], Classes 1, 1A and 1D			
Grade	B8LN, B8LNA		B8MLN, B8MLNA	
UNS Designation	S 30453		S 31653	
	Range	Product Variation, Over or Under[B]	Range	Product Variation, Over or Under[B]
Carbon, max	0.030	0.005 over	0.030	0.005 over
Manganese	2.00	0.04 over	2.00	0.04 over
Phosphorus, max	0.045	0.010 over	0.045	0.010 over
Sulfur, max	0.030	0.005 over	0.030	0.005 over
Silicon	1.00	0.05 over	1.00	0.05 over
Chromium	18.0–20.0	0.20	16.0–18.0	0.20
Nickel	8.0–11.0	0.15	10.0–13.0	0.15
Molybdenum	. . .	. . .	2.00–3.00	0.10
Nitrogen	0.10–0.16	0.01	0.10–0.16	0.01

[A] The intentional addition of Bi, Se, Te, and Pb is not permitted.

[B] Product analysis—Individual determinations sometimes vary from the specified limits on ranges as shown in the tables. The several determinations of any individual element in a heat may not vary both above and below the specified range.

[C] Typical steel compositions used for this grade include 4140, 4142, 4145, 4140H, 4142H, and 4145H.

[D] For bar sizes over 3½ in. [90 mm], inclusive, the carbon content may be 0.50 %, max. For the B7M grade, a minimum carbon content of 0.28 % is permitted, provided that the required tensile properties are met in the section sizes involved; the use of AISI 4130 or 4130H is allowed.

[E] Total of soluble and insoluble.

[F] Classes 1 and 1D are solution treated. Classes 1, 1B, and some 1C (B8R and B8S) products are made from solution treated material. Class 1A (B8A, B8CA, B8MA, B8PA, B8TA, B8LNA, B8MLNA, B8NA, and B8MNA) and some Class 1C (B9RA and B8SA) products are solution treated in the finished condition. Class 2 products are solution treated and strain hardened.

TABLE 2 Mechanical Requirements — Inch Products

Grade	Diameter, in.	Minimum Tempering Temperature, °F	Tensile Strength, min, ksi	Yield Strength, min, 0.2 % offset, ksi	Elongation in 4D, min, %	Reduction of Area, min, %	Hardness, max
			Ferritic Steels				
B5							
4 to 6 % chromium	up to 4, incl	1100	100	80	16	50	. . .
B6							
13 % chromium	up to 4, incl	1100	110	85	15	50	. . .
B6X							
13 % chromium	up to 4, incl	1100	90	70	16	50	26 HRC
B7							
Chromium-molybdenum	2½ and under	1100	125	105	16	50	321 HB or 35 HRC
	over 2½ to 4	1100	115	95	16	50	321 HB or 35 HRC
	over 4 to 7	1100	100	75	18	50	321 HB or 35 HRC
B7M[A] Chromium-molybdenum	4 and under	1150	100	80	18	50	235 HB or 99 HRB
	over 4 to 7	1150	100	75	18	50	235 BHN or 99 HRB
B16							
Chromium-molybdenum-vanadium	2½ and under	1200	125	105	18	50	321 HB or 35 HRC
	over 2½ to 4	1200	110	95	17	45	321 HB or 35 HRC
	over 4 to 8	1200	100	85	16	45	321 HB or 35 HRC

Grade, Diameter, in.	Heat Treatment[B]	Tensile Strength, min, ksi	Yield Strength, min, 0.2 % offset, ksi	Elongation in 4 D, min %	Reduction of Area, min %	Hardness, max
	Austenitic Steels					
Classes 1 and 1D; B8, B8M, B8P, B8LN, B8MLN, all diameters	carbide solution treated	75	30	30	50	223 HB[C] or 96 HRB
Class 1: B8C, B8T, all diameters	carbide solution treated	75	30	30	50	223 HB[C] or 96HRB
Class 1A: B8A, B8CA, B8MA, B8PA, B8TA, B8LNA, B8MLNA, B8NA, B8MNA B8MLCuNA, all diameters	carbide solution treated in the finished condition	75	30	30	50	192 HB or 90 HRB
Classes 1B and 1D: B8N, B8MN, and B8MLCuN, all diameters	carbide solution treated	80	35	30	40	223 HB[C] or 96 HRB
Classes 1C and 1D: B8R, all diameters	carbide solution treated	100	55	35	55	271 HB or 28 HRC
Class 1C: B8RA, all diameters	carbide solution treated in the finished condition	100	55	35	55	271 HB or 28 HRC
Classes 1C and 1D: B8S, all diameters	carbide solution treated	95	50	35	55	271 HB or 28 HRC
Classes 1C: B8SA, all diameters	carbide solution treated in the finished condition	95	50	35	55	271 HB or 28 HRC
Class 2: B8, B8C, B8P, B8T, and B8N,[D]	carbide solution treated and strain hardened	125	100	12	35	321 HB or 35 HRC
¾ and under						
over ¾ to 1, incl		115	80	15	35	321 HB or 35 HRC
over 1 to 1¼ , incl		105	65	20	35	321 HB or 35 HRC
over 1¼ to 1½ , incl		100	50	28	45	321 HB or 35 HRC
Class 2: B8M, B8MN, B8MLCuN[D]	carbide solution treated and strain hardened	110	95	15	45	321 HB or 35 HRC
¾ and under						
over ¾ to 1 incl		100	80	20	45	321 HB or 35 HRC

TABLE 2 *Continued*

Grade, Diameter, in.	Heat Treatment[B]	Tensile Strength, min, ksi	Yield Strength, min, 0.2 % offset, ksi	Elongation in 4 D, min %	Reduction of Area, min %	Hardness, max
		Austenitic Steels				
Over 1 to 1¼ , incl		95	65	25	45	321 HB or 35 HRC
over 1¼ to 1½ , incl		90	50	30	45	321 HB or 35 HRC
Class 2B: B8, B8M2[D]	carbide solution treated and strain hardened	95	75	25	40	321 HB or 35 HRC
2 and under						
over 2 to 2½ incl		90	65	30	40	321 HB or 35 HRC
over 2½ to 3 incl		80	55	30	40	321 HB or 35 HRC
Class 2C: B8M3[D]	carbide solution treated and strain hardened	85	65	30	60	321 HB or 35 HRC
2 and under						
over 2		85	60	30	60	321 HB or 35 HRC

[A] To meet the tensile requirements, the Brinell hardness shall be over 200 HB (93 HRB).
[B] Class 1 is solution treated. Class 1A is solution treated in the finished condition for corrosion resistance; heat treatment is critical due to physical property requirement. Class 2 is solution treated and strain hardened. Austenitic steels in the strain-hardened condition may not show uniform properties throughout the section particularly in sizes over ¾ in. in diameter.
[C] For sizes ¾ in. in diameter and smaller, a maximum hardness of 241 HB (100 HRB) is permitted.
[D] For diameters 1½ and over, center (core) properties may be lower than indicated by test reports which are based on values determined at ½ radius.

TABLE 3 Mechanical Requirements —Metric Products

Class	Diameter, [mm]	Minimum Tempering Temperature, °C	Tensile Strength, min, MPa	Yield Strength, min, 0.2 % offset, MPa	Elongation in 4D, min, %	Reduction of Area, min, %	Hardness, max
			Ferritic Steels				
B5							
4 to 6 % chromium	up to M100, incl	593	690	550	16	50	. . .
B6							
13 % chromium	up to M100, incl	593	760	585	15	50	. . .
B6X							
13 % chromium	up to M100, incl	593	620	485	16	50	26 HRC
B7							
Chromium-molybdenum	M64 and under	593	860	720	16	50	321 HB or 35 HRC
	over M64 to M100	593	795	655	16	50	321 HB or 35 HRC
	over M100 to M180	593	690	515	18	50	321 HB or 35 HRC
B7M[A]Chromium-molybdenum	M100 and under	620	690	550	18	50	235 HB or 99 HRB
	over M100 to M180	620	690	515	18	50	235 BHN or 99 HRB
B16							
Chromium-molybdenum-vanadium	M64 and under	650	860	725	18	50	321 HB or 35 HRC
	over M64 to M100	650	760	655	17	45	321 HB or 35 HRC
	over M100 to M180	650	690	586	16	45	321 HB or 35 HRC

Class Diameter, mm	Heat Treatment[B]	Tensile Strength, min, MPa	Yield Strength, min, 0.2 % offset, MPa	Elongation in 4 D, min %	Reduction of Area, min %	Hardness, max
	Austenitic Steels					
Classes 1 and 1D; B8, B8M, B8P, B8LN, B8MLN, all diameters	carbide solution treated	515	205	30	50	223 HB[C] or 96 HRB
Class 1: B8C, B8T, all diameters	carbide solution treated	515	205	30	50	223 HB[C] or 96HRB
Class 1A: B8A, B8CA, B8MA, B8PA, B8TA, B8LNA, B8MLNA, B8NA, B8MNA B8MLCuNA, all diameters	carbide solution treated in the finished condition	515	205	30	50	192 HB or 90 HRB
Classes 1B and 1D: B8N, B8MN, and B8MLCuN, all diameters	carbide solution treated	550	240	30	40	223 HB[C] or 96 HRB
Classes 1C and 1D: B8R, all diameters	carbide solution treated	690	380	35	55	271 HB or 28 HRC

TABLE 3 *Continued*

Class Diameter, mm	Heat Treatment[B]	Tensile Strength, min, MPa	Yield Strength, min, 0.2 % offset, MPa	Elongation in 4 D, min %	Reduction of Area, min %	Hardness, max
		Austenitic Steels				
Class 1C: B8RA, all diameters	carbide solution treated in the finished condition	690	380	35	55	271 HB or 28 HRC
Classes 1C and 1D: B8S, all diameters	carbide solution treated	655	345	35	55	271 HB or 28 HRC
Classes 1C: B8SA, all diameters	carbide solution treated in the finished condition	655	345	35	55	271 HB or 28 HRC
Class 2: B8, B8C, B8P, B8T, and B8N,[D] M20 and under	carbide solution treated and strain hardened	860	690	12	35	321 HB or 35 HRC
over M20 to M24, incl		795	550	15	35	321 HB or 35 HRC
over M24 to M30, incl		725	450	20	35	321 HB or 35 HRC
over M30 to M36, incl		690	345	28	45	321 HB or 35 HRC
Class 2: B8M, B8MN, B8MLCuN,[D] M20 and under	carbide solution treated and strain hardened	760	655	15	45	321 HB or 35 HRC
over M20 to M24, incl		690	550	20	45	321 HB or 35 HRC
over M24 to M30, incl		655	450	25	45	321 HB or 35 HRC
over M30 to M36, incl		620	345	30	45	321 HB or 35 HRC
Class 2B: B8, B8M2,[D] M48 and under	carbide solution treated and strain hardened	655	515	25	40	321 HB or 35 HRC
over M48 to M64, incl		620	450	30	40	321 HB or 35 HRC
over M64 to M72, incl		550	380	30	40	321 HB or 35 HRC
Class 2C: B8M3,[D] M48 and under	carbide solution treated and strain hardened	585	450	30	60	321 HB or 35 HRC
over M48		585	415	30	60	321 HB or 35 HRC

[A] To meet the tensile requirements, the Brinell hardness shall be over 200 HB (93 HRB).

[B] Class 1 is solution treated. Class 1A is solution treated in the finished condition for corrosion resistance; heat treatment is critical due to physical property requirement. Class 2 is solution treated and strain hardened. Austenitic steels in the strain-hardened condition may not show uniform properties throughout the section particularly in sizes over M20 mm in diameter

[C] For sizes M20 mm in diameter and smaller, a maximum hardness of 241 HB (100 HRB) is permitted.

[D] For diameters M38 and over, center (core) properties may be lower than indicated by test reports which are based on values determined at ½ radius.

6.1.1 Quenched and tempered or normalized and tempered ferritic material that is subsequently cold drawn for dimensional control shall be stress-relieved after cold drawing. The minimum stress-relief temperature shall be 100°F [55°C] below the tempering temperature. Tests for mechanical properties shall be performed after stress relieving.

6.2 Both B6 and B6X materials shall be held, at the tempering temperature for a minimum time of 1 h. Identification Symbol B 6X material may be furnished in the as-rolled-and-tempered condition. Cold working is permitted with the hardness limitation (26 HRC maximum) of Table 2 for the B 6X grade.

6.3 All austenitic stainless steels shall receive a carbide solution treatment (see 6.3.1-6.3.4 for specific requirements for each class). Classes 1, 1B, 1C (Grades B8R and B8S only), 2, 2B, and 2C can apply to bar, wire, and finished fasteners. Class 1A (all grades) and Class 1C (grades B8RA and B8SA only) can apply to finished fasteners. Class 1D applies only to bar and wire and finished fasteners that are machined directly from Class 1D bar or wire without any subsequent hot or cold working.

6.3.1 *Classes 1 and 1B, and Class 1C Grades B8R and B8S*—After rolling of the bar, forging, or heading, whether done hot or cold, the material shall be heated from ambient temperature and held a sufficient time at a temperature at which the chromium carbide will go into solution and then shall be cooled at a rate sufficient to prevent the precipitation of the carbide.

6.3.2 *Class 1D*—Rolled or forged Grades B8, B8M, B8P, B8LN, B8MLN, B8N, B8MN, B8R, and B8S bar shall be cooled rapidly immediately following hot working while the temperature is above 1750°F [955°C] so that grain boundary carbides are in solution. Class 1D shall be restricted to applications at temperatures less than 850°F [455°C].

6.3.3 *Class 1A and Class 1C Grades B8RA and B8SA*—Finished fasteners shall be carbide solution treated after all rolling, forging, heading, and threading operations are complete. This designation does not apply to starting material such as bar. Fasteners shall be heated from ambient temperature and held a sufficient time at a temperature at which the chromium carbide will go into solution and then shall be cooled at a rate sufficient to prevent the precipitation of the carbide.

6.3.4 *Classes 2, 2B, and 2C*—Material shall be carbide solution treated by heating from ambient temperature and holding a sufficient time at a temperature at which the chromium carbide will go into solution and then cooling at a rate sufficient to prevent the precipitation of the carbide. Following this treatment the material shall then be strain hardened to achieve the required properties.

NOTE 4—Heat treatment following operations performed on a limited portion of the product, such as heading, may result in non-uniform grain size and mechanical properties through the section affected.

6.4 If scale-free bright finish is required, this shall be specified in the purchase order.

6.5 B7 and B7M bolting material shall be heat treated by quenching in a liquid medium and tempering. For B7M

bolting, the final heat treatment, which may be the tempering operation if conducted at 1150°F [620°C] minimum, shall be done after all machining and forming operations, including thread rolling and any type of cutting. Surface preparation for hardness testing, nondestructive evaluation, or ultrasonic bolt tensioning is permitted.

6.5.1 Unless otherwise specified, material for Grade B7 may be heat treated by the Furnace, the Induction or the Electrical Resistance method.

NOTE 5—It should be taken into consideration that stress-relaxation properties may vary from heat lot to heat lot or these properties may vary from one heat treating method to another. The purchaser may specify Supplementary Requirement S8, if stress-relaxation testing is desired.

7. Chemical Composition

7.1 Each alloy shall conform to the chemical composition requirements prescribed in Table 1.

7.2 The steel shall not contain an unspecified element for the ordered grade to the extent that the steel conforms to the requirements of another grade for which that element is a specified element. Furthermore, elements present in concentrations greater than 0.75 weight/% shall be reported.

8. Heat Analysis

8.1 An analysis of each heat of steel shall be made by the manufacturer to determine the percentages of the elements specified in Section 7. The chemical composition thus determined shall be reported to the purchaser or the purchaser's representative, and shall conform to the requirements specified in Section 7. Should the purchaser deem it necessary to have the transition zone of two heats sequentially cast discarded, the purchaser shall invoke Supplementary Requirement S3 of Specification A 788.

9. Mechanical Properties

9.1 *Tensile Properties*:

9.1.1 *Requirements*—The material as represented by the tension specimens shall conform to the requirements prescribed in Table 2 at room temperature after heat treatment. Alternatively, stainless strain hardened headed fasteners (Class 2, 2B, and 2C) shall be tested full size after strain hardening to determine tensile strength and yield strength and shall conform to the requirements prescribed in Table 2. Should the results of full size tests conflict with results of tension specimen tests, full size test results shall prevail.

9.1.2 *Full Size Fasteners, Wedge Tensile Testing*—When applicable, see 12.1.3, headed fasteners shall be wedge tested full size and shall conform to the tensile strength shown in Table 2. The minimum full size breaking strength (lbf) for individual sizes shall be as follows:

$$Ts = UTS \times As \quad (1)$$

where:

Ts = wedge tensile strength,
UTS = tensile strength specified in Table 2, and
As = stress area, square inches, as shown in ANSI B1.1 or calculated as follows:

$$As = 0.785\,(D - (0.974/n))^2 \quad (2)$$

where:

D = nominal thread size, and
n = the number of threads per inch.

9.2 *Hardness Requirements*:

9.2.1 The hardness shall conform to the requirements prescribed in Table 2. Hardness testing shall be performed in accordance with either Specification A 962/A 962M or with Test Methods F 606.

9.2.2 *Grade B7M*—The maximum hardness of the grade shall be 235 HB or 99 HRB. The minimum hardness shall not be less than 200 HB or 93 HRB. Conformance to this hardness shall be ensured by testing the hardness of each stud or bolt by Brinell or Rockwell B methods in accordance with 9.2.1. The use of 100 % electromagnetic testing for hardness as an alternative to 100 % indentation hardness testing is permissible when qualified by sampling using indentation hardness testing. Each lot tested for hardness electromagnetically shall be 100 % examined in accordance with Practice E 566. Following electromagnetic testing for hardness a random sample of a minimum of 100 pieces of each heat of steel in each lot (as defined in 12.1.1) shall be tested by indentation hardness methods. All samples must meet hardness requirements to permit acceptance of the lot. If any one sample is outside of the specified maximum or minimum hardness, the lot shall be rejected and either reprocessed and resampled or tested 100 % by indentation hardness methods. Product that has been 100 % tested and found acceptable shall have a line under the grade symbol.

9.2.2.1 Surface preparation for indentation hardness testing shall be in accordance with Test Methods E 18. Hardness tests shall be performed on the end of the bolt or stud. When this is impractical, the hardness test shall be performed elsewhere.

10. Workmanship, Finish, and Appearance

10.1 Bolts, screws, studs, and stud bolts shall be pointed and shall have a workmanlike finish. Points shall be flat and chamfered or rounded at option of the manufacturer. Length of point on studs and stud bolts shall be not less than one nor more than two complete threads as measured from the extreme end parallel to the axis. Length of studs and stud bolts shall be measured from first thread to first thread.

10.2 Bolt heads shall be in accordance with the dimensions of ANSI B18.2.1 or ANSI B18.2.3.1M. Unless otherwise specified in the purchase order, the Heavy Hex Screws Series should be used, except the maximum body diameter and radius of fillet may be the same as for the Heavy Hex Bolt Series. The body diameter and head fillet radius for sizes of Heavy Hex Cap Screws and Bolts that are not shown in their respective tables in ANSI B18.2.1 or ANSI B18.2.3.1M may be that shown in the corresponding Hex Cap Screw and Bolt Tables respectively. Socket head fasteners shall be in accordance with ANSI B18.3 or ANSI B18.3.1M.

11. Retests

11.1 If the results of the mechanical tests of any test lot do not conform to the requirements specified, the manufacturer may retreat such lot not more than twice, in which case two additional tension tests shall be made from such lot, all of which shall conform to the requirements specified.

12. Test Specimens

12.1 *Number of Tests*—For heat-treated bars, one tension test shall be made for each diameter of each heat represented in each tempering charge. When heat treated without interruption in continuous furnaces, the material in a lot shall be the same heat, same prior condition, same size, and subjected to the same heat treatment. Not fewer than two tension tests are required for each lot containing 20 000 lb [9000 kg] or less. Every additional 10 000 lb [4500 kg] or fraction thereof requires one additional test.

12.1.1 For studs, bolts, screws, and so forth, one tension test shall be made for each diameter of each heat involved in the lot. Each lot shall consist of the following:

Diameter, in. [mm]	Lot Size
1⅛ [30] and under	1500 lb [780 kg] or fraction thereof
Over 1⅛ [30] to 1¾ [42], incl	4500 lb [2000 kg] or fraction thereof
Over 1¾ [42] to 2½ [64], incl	6000 lb [2700 kg] or fraction thereof
Over 2½ [64]	100 pieces or fraction thereof

12.1.2 Tension tests are not required to be made on bolts, screws, studs, or stud bolts that are fabricated from heat-treated bars furnished in accordance with the requirements of this specification and tested in accordance with 12.1, provided they are not given a subsequent heat treatment.

12.1.3 *Full Size Specimens, Headed Fasteners*—Headed fasteners 1½ in. in body diameter and smaller, with body length three times the diameter or longer, and that are produced by upsetting or forging (hot or cold) shall be subjected to full size testing in accordance with 9.1.2. This testing shall be in addition to tensile testing as specified in 9.1.1. The lot size shall be as shown in 12.1.1. Failure shall occur in the body or threaded section with no failure, or indications of failure, such as cracks, at the junction of the head and shank.

13. Nuts

13.1 Bolts, studs, and stud bolts shall be furnished with nuts, when specified in the purchase order. Nuts shall conform to Specification A 194/A 194M.

14. Rejection and Rehearing

14.1 Unless otherwise specified in the basis of purchase, any rejection based on product analysis shall be reported to the manufacturer within 30 days from the receipt of samples by the purchaser.

14.2 Material that shows defects subsequent to its acceptance at the place of manufacture shall be rejected, and the manufacturer shall be notified.

14.3 *Product Analysis*—Samples that represent rejected material shall be preserved for two weeks from the date of the test report. In the case of dissatisfaction with the results of the test, the manufacturer may make claim for a rehearing within that time.

15. Certification

15.1 The producer of the raw material or finished fasteners shall furnish a certification to the purchaser or his representative showing the results of the chemical analysis, macroetch examination (Carbon and Alloy Steels Only), and mechanical tests, and state the method of heat treatment employed.

15.2 Certification shall also include at least the following:

15.2.1 A statement that the material or the fasteners, or both, were manufactured, sampled, tested, and inspected in accordance with the specification and any supplementary requirements or other requirements designated in the purchase order or contract and was found to meet those requirements.

15.2.2 The specification number, year date, and identification symbol.

16. Product Marking

16.1 The marking symbol and manufacturer's identification symbol shall be applied to one end of studs ⅜ in. [10 mm] in diameter and larger and to the heads of bolts ¼ in. [6 mm] in diameter and larger. (If the available area is inadequate, the marking symbol may be placed on one end with the manufacturer's identification symbol placed on the other end.) The marking symbol shall be as shown in Table 4 and Table 5. Grade B7M, which has been 100 % evaluated in conformance with the specification, shall have a line under the marking symbol to distinguish it from B7M produced to previous specification revisions not requiring 100 % hardness testing.

16.2 For bolting materials, including threaded bars, furnished bundled and tagged or boxed, the tags and boxes shall carry the marking symbol for the material identification and the manufacturer's identification symbol or name.

16.3 For purposes of product marking, the manufacturer is considered the organization that certifies the fastener was manufactured, sampled, tested, and inspected in accordance with the specification and the results have been determined to meet the requirements of this specification.

16.4 *Bar Coding*—In addition to the requirements in 16.1, 16.2, and 16.3, bar coding is acceptable as a supplementary identification method. Bar coding should be consistent with AIAG Standard B-5 02.00. If used on small items, the bar code may be applied to the box or a substantially applied tag.

17. Keywords

17.1 hardness; heat treatment

TABLE 4 Marking of Ferritic Steels

Grade	Marking Symbol
B5	B5
B6	B6
B6X	B6X
B7	B7
B7M[A]	B7M
	B7M
B16	B16

[A] For explanations, see 9.2.2 and 16.1.

TABLE 5 Marking of Austenitic Steels

Class	Grade	Marking Symbol
Class 1	B8	B8
	B8C	B8C
	B8M	B8M
	B8P	B8P
	B8T	B8T
	B8LN	B8F or B8LN
	B8MLN	B8G or B8MLN
Class 1A	B8A	B8A
	B8CA	B8B or B8CA
	B8MA	B8D or B8MA
	B8PA	B8H or B8PA
	B8TA	B8J or B8TA
	B8LNA	B8L or B8LNA
	B8MLNA	B8K or B8MLNA
	B8NA	B8V or B8MA
	B8MNA	B8W or B8MNA
	B8MLCuNA	B9K or B8MLCuNA
Class 1B	B8N	B8N
	B8MN	B8Y or B8MN
	B8MLCuN	B9J or B8MLCuN
Class 1C	B8R	B9A or B8R
	B8RA	B9B or B8RA
	B8S	B9D or B8S
	B8SA	B9F or B8SA
Class 1D	B8	B94
	B8M	B95
	B8P	B96
	B8LN	B97
	B8MLN	B98
	B8N	B99
	B8MN	B100
	B8R	B101
	B8S	B102
Class 2	B8	B8
	B8C	B8C
	B8P	B8P
	B8T	B8T
	B8N	B8N
	B8M	B8M
	B8MN	B8Y
	B8MLCuN	B9J
Class 2B	B8M2	B9G or B8M2
	B8	B9
Class 2C	B8M3	B9H or B8M3

SUPPLEMENTARY REQUIREMENTS

These requirements shall not apply unless specified in the order and in the Ordering Information, in which event the specified tests shall be made before shipment of the product.

S1. High-Temperature Tests

S1.1 Tests to determine high temperature properties shall be made in accordance with Test Methods E 21, E 139, and E 292, and Practices E 150 and E 151.

S2. Charpy Impact Tests

S2.1 Charpy impact tests based on the requirements of Specification A 320/A 320M, Sections 6 and 7, shall be made as agreed between the manufacturer and the purchaser. When testing temperatures are as low as those specified in Specification A 320/A 320M, bolting should be ordered to that specification in preference to this specification.

S3. 100 % Hardness Testing of Grade B7M

S3.1 Each Grade B7M bolt or stud shall be tested for hardness by indentation method and shall meet the requirements specified in Table 2.

S4. Hardness Testing of Grade B16

S4.1 For bolts or studs 2½ in. [65 mm] or smaller, the hardness for Grade B16 shall be measured on or near the end of each bolt or stud using one of the methods prescribed in 9.2.1 for the Brinell or Rockwell C test. The hardness shall be in the range 253–319 HB or 25–34 HRC.

S5. Product Marking

S5.1 Marking and manufacturer's identification symbols shall be applied to one end of studs and to the heads of bolts of all sizes. (If the available area is inadequate, the marking symbol may be marked on one end and the manufacturer's identification symbol marked on the other end.) For bolts smaller than ¼ in. [6 mm] in diameter and studs smaller than ⅜ in. [10 mm] in diameter and for ¼ in. [6 mm] in diameter studs requiring more than a total of three symbols, the marking shall be a matter of agreement between the purchaser and the manufacturer.

S6. Stress Relieving

S6.1 A stress-relieving operation shall follow straightening after heat treatment.

S6.2 The minimum stress-relieving temperature shall be 100°F [55°C] below the tempering temperature. Tests for mechanical properties shall be performed after stress relieving.

S7. Magnetic Particle Inspection

S7.1 Bars shall be magnetic particle examined in accordance with Guide E 709. Bars with indications of cracks or seams are subject to rejection if the indications extend more than 3 % of the diameter into the bar.

S8. Stress-Relaxation Testing

S8.1 Stress-Relaxation Testing, when required, shall be done in accordance with Test Methods E 328. The test shall be performed at 850°F [454°C] for a period of 100 h. The initial stress shall be 50 M psi [345 MPa]. The residual stress at 100 h shall be 17 M psi [117 MPa] minimum.

S9. Grain Size Requirements for Non H Grade Austenitic Steels Used Above 1000°F

S9.1 For design metal temperatures above 1000°F [540°C], the material shall have a grain size of No. 7 or coarser as determined in accordance with Test Methods E 112. The grain size so determined shall be reported on the Certificate of Test.

S10. Hardness Testing of Class 2 Bolting Materials for ASME Applications

S10.1 The maximum hardness shall be Rockwell C35 immediately under the thread roots. The hardness shall be taken on a flat area at least ⅛ in. [3 mm] across, prepared by removing threads, and no more material than necessary shall be removed to prepare the flat areas. Hardness determinations shall be made at the same frequency as tensile tests.

S11. Thread Forming

S11.1 Threads shall be formed after heat treatment. Application of this supplemental requirement to grade B7M or the grades listed in 6.3.3 is prohibited.

APPENDIX

(Nonmandatory Information)

X1. STRAIN HARDENING OF AUSTENITIC STEELS

X1.1 Strain hardening is the increase in strength and hardness that results from plastic deformation below the recrystallization temperature (cold work). This effect is produced in austenitic stainless steels by reducing oversized bars or wire to the desired final size by cold drawing or other process. The degree of strain hardening achievable in any alloy is limited by its strain hardening characteristics. In addition, the amount of strain hardening that can be produced is further limited by the variables of the process, such as the total amount of cross-section reduction, die angle, and bar size. In large diameter bars, for example, plastic deformation will occur principally in the outer regions of the bar so that the increased strength and hardness due to strain hardening is achieved predominantly near the surface of the bar. That is, the smaller the bar, the greater the penetration of strain hardening.

X1.2 Thus, the mechanical properties of a given strain hardened fastener are dependent not just on the alloy, but also on the size of bar from which it is machined. The minimum bar size that can be used, however, is established by the configuration of the fastener so that the configuration can affect the strength of the fastener.

X1.3 For example, a stud of a particular alloy and size may be machined from a smaller diameter bar than a bolt of the same alloy and size because a larger diameter bar is required to accommodate the head of the bolt. The stud, therefore, is likely to be stronger than the same size bolt in a given alloy.

SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this specification since the last issue, A 193/A 193M – 04, that may impact the use of this specification. (Approved May 11, 2004).

(*1*) Revised 9.1.1 to permit acceptance of strain hardened fasteners base on full size testing.
(*2*) Revised B6 carbon content in Table 1.
(*3*) Changed "Grade" to "Marking" in Section 17 and Supplementary Requirement S5.
(*4*) Updated Table 5.

Committee A01 has identified the location of selected changes to this specification since the last issue, A 193/A 193M – 03, that may impact the use of this specification. (Approved January 1, 2004).

(*1*) Corrected Yield Strength for Class 2, B8M, B8MN, B8MLCuN ¾ (M20) and under in Tables 2 and 3.
(*2*) Deleted Appendix X2.

Committee A01 has identified the location of selected changes to this specification since the last issue, A 193/A 193M – 01b, that may impact the use of this specification. (Approved May 10, 2003).

(*1*) Revised 4.2 to reference the general requirements specification for macroetch requirements.
(*2*) Revised 6.5 to permit surface conditioning prior to testing.