



Designation: ~~A602 – 94 (Reapproved 2014)~~ A602 – 94 (Reapproved 2018)

Standard Specification for Automotive Malleable Iron Castings¹

This standard is issued under the fixed designation A602; 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.

1. Scope

1.1 This specification covers castings of ferritic, pearlitic, tempered pearlitic, and tempered martensitic grades of malleable iron used in the products of the automotive and allied industries. Castings shall be heat treated to meet this specification.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.

2. Referenced Documents

2.1 *ASTM Standards:*²

E10 Test Method for Brinell Hardness of Metallic Materials

3. Grades

3.1 The specified grades with required hardness range and final heat treatment are shown in **Table 1**.

3.2 The foundry may also produce Grades M4504 and M5003 by liquid quenching and tempering or alloying, or both.

4. Hardness

4.1 The foundry shall exercise the necessary controls and inspection procedures to ensure compliance with the specified hardness range. Hardness readings shall be taken in accordance with Test Method **E10** after sufficient material has been removed from the casting surface to ensure representative hardness readings. The area or areas on the casting where hardness is to be checked shall be established by agreement between supplier and purchaser and shown on the drawing.

5. Microstructure Requirements

5.1 *Grade M3210 Ferritic Malleable Iron:*

5.1.1 The microstructure of Grade M3210 malleable iron shall consist of temper-carbon nodules distributed in a matrix of ferrite.

5.1.2 Because of reaction with the annealing furnace atmosphere, some depletion of carbon and silicon occurs at the surface of the castings. This usually results in a rim which can consist of coarse lamellar pearlite underlying a graphite-free ferritic surface layer. If the pearlite layer is excessive, it can result in poor machinability. The rim, therefore, shall not exceed a depth greater than 0.050 in. (1.27 mm) as measured from the casting surface.

5.1.3 The area below the rim can contain some pearlite; however, it shall not exceed the amount shown in **Fig. 1**.

5.2 *Grades M4504, M5003, M7002, and M8501:*

5.2.1 The microstructure of these other grades of malleable iron shall consist of temper-carbon nodules distributed in a matrix of ferrite and lamellar pearlite or tempered pearlite in air-quenched castings or a matrix of tempered martensite in the case of liquid-quenched castings.

¹ This specification is under the jurisdiction of ASTM Committee **A04** on Iron Castings and is the direct responsibility of Subcommittee **A04.02** on Malleable and Ductile Iron Castings.

Current edition approved April 1, 2014 (Nov. 1, 2018). Published April 2014 (November 2018). Originally approved in 1970. Last previous edition approved in 2009 (2014) as A602 – 94 (2009) (2014). DOI: 10.1520/A0602-94R14.10.1520/A0602-94R18.

² 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.

TABLE 1 Grades of Malleable Iron

| Grade | Casting Hardness Range | Heat Treatment |
|-------|--|------------------------------|
| M3210 | 156 HB max 4.8 BID ^A min | annealed |
| M4504 | 163–217 HB 4.7–4.1 BID ^A | air quenched and tempered |
| M5003 | 187–241 HB 4.4–3.9 BID ^A | air quenched and tempered |
| M5503 | 187–241 HB 4.4–3.9 BID ^A | liquid quenched and tempered |
| M7002 | 229–269 HB 4.0–3.7 BID ^A | liquid quenched and tempered |
| M8501 | 269–302 HB 3.7–3.5 BID ^A | liquid quenched and tempered |

TABLE 1 Grades of Malleable Iron

| Grade | Casting Hardness Range | Heat Treatment |
|-------|--|------------------------------|
| M3210 | 156 HB max 4.8 BID ^A min | annealed |
| M4504 | 163–217 HB 4.7–4.1 BID ^A | air quenched and tempered |
| M5003 | 187–241 HB 4.4–3.9 BID ^A | air quenched and tempered |
| M5503 | 187–241 HB 4.4–3.9 BID ^A | liquid quenched and tempered |
| M7002 | 229–269 HB 4.0–3.7 BID ^A | liquid quenched and tempered |
| M8501 | 269–302 HB 3.7–3.5 BID ^A | liquid quenched and tempered |

^A Brinell impression diameter (BID) is the diameter in millimetres of the impression of a 10-mm ball at 3000-kg load.

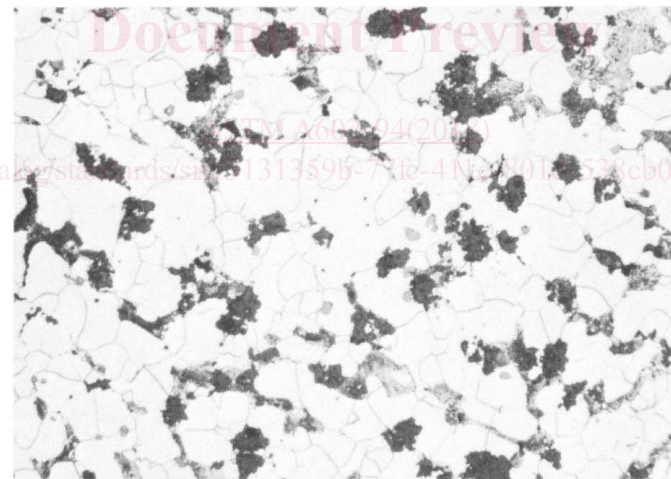


FIG. 1 Reference Photomicrograph Showing Allowable Pearlite in Grade M3210 Iron (100×; (100×; 2 % Nital Etch)

5.2.2 Because of reaction with the annealing furnace atmosphere, some depletion of carbon and silicon occurs at the surface of the castings. This usually results in a rim which can consist of a graphite-free layer sometimes containing more or less combined carbon than the underlying material.

5.3 All grades shall be free of primary graphite.

5.4 All grades shall not exceed 2 % spheroidal primary carbides in the microstructure.

5.5 The maximum surface ferrite layer and denodularized zone shall be measured after polishing, etching in nital, and viewing at 100×.

6. Quality Assurance

6.1 Sampling plans are a matter of agreement between supplier and purchaser. The supplier shall employ adequate equipment and controls to ensure that parts conform to the ~~agreed-upon~~ agreed-upon requirements.

7. General

7.1 Castings furnished to this specification shall be representative of good foundry practice and shall conform to dimensions and tolerances specified on the casting drawing.

7.2 Minor imperfections usually not associated with the structural function may occur in castings. These imperfections often are repairable; however, repairs shall be made only in areas allowed by the purchaser and only by approved methods.

7.3 Additional casting requirements may be agreed upon between the purchaser and supplier. These should appear as additional product requirements on the casting drawing.

8. Keywords

8.1 casting; ferrite; malleable iron; mechanical properties; pearlite; temper carbon nodules; tensile strength; yield strength

APPENDIX

(Nonmandatory Information)

X1. MATERIAL DESCRIPTION OF MALLEABLE IRON

X1.1 Definition and Classification

X1.1.1 *malleable iron*—a cast iron in which the graphite is present as temper-carbon nodules instead of flakes, as in gray iron, or small spherulites, as in ductile iron.

X1.1.2 The term ~~malleable iron~~ “malleable iron” includes all grades of malleable iron, including those with a ferritic, pearlitic, tempered pearlite, or tempered martensite matrix.

X1.2 Chemical Composition

X1.2.1 The chemical composition of malleable iron generally conforms to the following range:

| Element | Composition, % |
|--------------|----------------|
| Total carbon | 2.20–2.90 |
| Silicon | 0.90–1.90 |
| Manganese | 0.15–1.25 |
| Sulfur | 0.02–0.20 |
| Phosphorus | 0.02–0.15 |

X1.2.2 Individual foundries will produce to narrower ranges than those shown above. The composition is controlled such that the molten iron solidifies with all the carbon in the combined form producing a “white iron” structure free of graphite, which is heat treated to specifications.

X1.3 Microstructure

X1.3.1 The microstructure of malleable iron consists of a matrix of ferrite, pearlite, tempered pearlite, or tempered martensite or combinations of these containing temper carbon nodules (see Figs. X1.1-X1.6). The structure of the matrix is controlled by heat treatment or composition, or both.

X1.3.2 The matrix of the M3210 grade of malleable iron is essentially free of combined carbon, but a small amount of pearlite is permitted.

X1.3.3 The matrices of the other grades of malleable iron contain combined carbon as pearlite, tempered pearlite, or tempered martensite.

X1.3.4 Because of reaction with the annealing furnace atmosphere, some depletion of carbon and silicon occurs at the surface of