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American Association State
Highway and Transportation Officials Standard
AASHTO No.: M 222

Standard Specification for High-Strength Low-Alloy Structural Steel, up to 50 ksi [345 MPa] Minimum Yield Point, with Atmospheric Corrosion Resistance[1]

This standard is issued under the fixed designation A588/A588M; 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 U.S. Department of Defense.

1. Scope*

1.1 This specification covers high-strength low-alloy structural steel shapes, plates, and bars for welded, riveted, or bolted construction but intended primarily for use in welded bridges and buildings where savings in weight or added durability are important. The atmospheric corrosion resistance of this steel in most environments is substantially better than that of carbon structural steels with or without copper addition (see Note 1). When properly exposed to the atmosphere, this steel is suitable for many applications in the bare (unpainted) condition. This specification is limited to material up to 8 in. [200 mm] inclusive in thickness.

NOTE 1—For methods of estimating the atmospheric corrosion resistance of low-alloy steels, see Guide G101.

1.2 When the steel is to be welded, a welding procedure suitable for the grade of steel and intended use or service is to be utilized. See Appendix X3 of Specification A6/A6M for information on weldability.

1.3 *Units*—This specification is expressed in both inch-pound units and in SI units; however, unless the purchase order or contract specifies the applicable M specification designation (SI units), the inch-pound units shall apply. 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 is to be used independently of the ~~other, without combining values in any way.~~other. Combining values from the two systems may result in nonconformances with the standard.

1.4 The text of this specification contains notes, footnotes, or both, that provide explanatory material. Such notes and footnotes, excluding those in tables and figures, do not contain any mandatory requirements.

1.5 For structural products produced from coil and furnished without heat treatment or with stress relieving only, the additional requirements, including additional testing requirements and the reporting of additional test results, of Specification A6/A6M apply.

1.6 *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]

A6/A6M Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling

G101 Guide for Estimating the Atmospheric Corrosion Resistance of Low-Alloy Steels

3. General Requirements for Delivery

3.1 ~~Structural products~~ Product furnished ~~under~~to this specification shall conform to the requirements of ~~the current edition of~~ Specification A6/A6M, ~~for the specific structural product ordered, unless a~~ including any supplementary requirements indicated

[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 A01.02 on Structural Steel for Bridges, Buildings, Rolling Stock and Ships.

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[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.

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

TABLE 1 Chemical Requirements (Heat Analysis)

NOTE 1—Where ". . ." appears in this table, there is no requirement.

Element	Composition, %		
	Grade A	Grade B	Grade K
Carbon[A]	0.19 max	0.20 max	0.17 max
Manganese[A]	0.80–1.25	0.75–1.35	0.50–1.20
Phosphorus[C]	0.030 max	0.030 max	0.030 max
Sulfur[C]	0.030 max	0.030 max	0.030 max
Silicon	0.30–0.65	0.15–0.50	0.25–0.50
Nickel	0.40 max	0.50 max	0.40 max
Chromium	0.40–0.65	0.40–0.70	0.40–0.70
Molybdenum	...	...	0.10 max
Copper	0.25–0.40	0.20–0.40	0.30–0.50
Vanadium	0.02–0.10	0.01–0.10	...
~~Columbium~~	~~...~~	~~...~~	~~0.005–0.05[B]~~
Columbium/ niobium[D]	...	...	0.005–0.05[B]

[A] For each reduction of 0.01 percentage point below the specified maximum for carbon, an increase of 0.06 percentage point above the specified maximum for manganese is permitted, up to a maximum of 1.50 %.

[B] For plates under ½ in. [13 mm] in thickness, the minimum columbium (niobium) is waived.

[C] A maximum phosphorus content of 0.04 % and a maximum sulfur content of 0.05 % are permitted for the following materials:

- Structural shapes
- Bars
- Plates with widths up to and including 15 in. [380 mm]

[D] Columbium (Cb) and niobium (Nb) are considered interchangeable names for the same element and both names are acceptable.

in the purchase order or contract. Failure to comply with the general requirements of Specification A6/A6M ~~conflict exists, in which case this specification~~ constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A6/A6M, this specification shall prevail.

3.2 Coils are excluded from qualification to this specification until they are processed into a finished structural product. Structural products produced from coil means structural products that have been cut to individual lengths from a coil. The processor directly controls, or is responsible for, the operations involved in the processing of a coil into a finished structural product. Such operations include decoiling, leveling or straightening, hot-forming or cold-forming (if applicable), cutting to length, testing, inspection, conditioning, heat treatment (if applicable), packaging, marking, loading for shipment, and certification.

NOTE 2—For structural products produced from coil and furnished without heat treatment or with stress relieving only, two test results are to be reported for each qualifying coil. Additional requirements regarding structural products produced from coil are described in Specification A6/A6M.

4. Materials and Manufacture

4.1 The steel shall be made to fine grain practice.

5. Chemical Composition

5.1 The heat analysis shall conform to the requirements prescribed in Table 1.

5.2 The steel shall conform on product analysis to the requirements prescribed in Table 1, subject to the product analysis tolerances in Specification A6/A6M.

5.3 The atmospheric corrosion-resistance index, calculated on the basis of the heat analysis of the steel, as described in Guide G101 ~~=Predictive~~ (Predictive Method Based on the Data of Larabee and ~~Coburn,~~Coburn), shall be 6.0 or higher.

NOTE 3—The user is cautioned that the Guide G101 predictive equation (Predictive Method Based on the Data of Larabee and Coburn) for calculation of an atmospheric corrosion-resistance index has only been verified for the composition limits stated in the guide.

5.4 When required, the manufacturer shall supply evidence of corrosion resistance satisfactory to the purchaser.

6. ~~Tensile Requirements~~Tension Test

6.1 The material as represented by the test specimens shall conform to the requirements for tensile properties prescribed in Table 2.

7. Keywords

7.1 atmospheric corrosion resistance; bars; bolted construction; bridges; buildings; durability; high-strength; low-alloy; plates; riveted construction; shapes; steel; structural steel; weight; welded construction