



Designation: A564/A564M – 19a

Standard Specification for Hot-Rolled and Cold-Finished Age-Hardening Stainless Steel Bars and Shapes¹

This standard is issued under the fixed designation A564/A564M; 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 specification² covers bars and shapes of age-hardening stainless steels. Hot-finished or cold-finished rounds, squares, hexagons, bar shapes, angles, tees, and channels are included; these shapes may be produced by hot rolling, extruding, or forging. Billets or bars for reforging may be purchased to this specification.

1.2 These steels are generally used for parts requiring corrosion resistance and high strength at room temperature, or at temperatures up to 600 °F [315 °C]; 700 °F [370 °C] for Type 632; 840 °F [450 °C] for Type UNS S46910. They are suitable for machining in the solution-annealed condition after which they may be age-hardened to the mechanical properties specified in Section 7 without danger of cracking or distortion. Type XM-25 is machinable in the as-received fully heat treated condition. Type UNS S46910 is suitable for machining in the solution-annealed, cold-worked, and aged-hardened condition.

1.3 Types 631 and 632 contain a large amount of ferrite in the microstructure and can have low ductility in forgings and larger diameter bars. Applications should be limited to small diameter bar.

1.4 The values stated in either inch-pound units or SI (metric) units are to be regarded separately as standards; within the text and tables, the SI units are shown in [brackets]. The values stated in each system are not exact equivalents; therefore, each system must be used independent of the other. Combining values from the two systems may result in nonconformance with the specification.

1.5 Unless the order specifies an “M” designation, the material shall be furnished to inch-pound units.

NOTE 1—For forgings, see Specification A705/A705M.

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 A01.17 on Flat-Rolled and Wrought Stainless Steel.

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-564/SA-564M in Section II of that Code.

NOTE 2—For billets and bars for forging see Specification A314.

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:*³

A314 Specification for Stainless Steel Billets and Bars for Forging

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A484/A484M Specification for General Requirements for Stainless Steel Bars, Billets, and Forgings

A705/A705M Specification for Age-Hardening Stainless Steel Forgings

A751 Test Methods and Practices for Chemical Analysis of Steel Products

E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

2.2 *Other Documents:*

SAE J1086 Recommended Practice for Numbering Metals and Alloys (UNS)⁴

3. Ordering Information

3.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this specification. Such requirements may include but are not limited to the following:

- 3.1.1 Quantity (weight or number of pieces),
- 3.1.2 Type or UNS designation (Table 1),
- 3.1.3 Specific melt type when required,
- 3.1.4 Heat treated condition (5.1),

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 Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, http://www.sae.org.

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

TABLE 1 Chemical Requirements^A

		Composition, %											
UNS Designation ^B	Type	C	Mn	P	S	Si	Cr	Ni	Al	Mo	Ti	Cu	Other Elements
S17400	630	0.07	1.00	0.040	0.030	1.00	15.00–17.50	3.00–5.00	3.00–5.00	C
S17700	631	0.09	1.00	0.040	0.030	1.00	16.00–18.00	6.50–7.75	0.75–1.50
S15700	632	0.09	1.00	0.040	0.030	1.00	14.00–16.00	6.50–7.75	0.75–1.50	2.00–3.00
S35500	634	0.10–0.15	0.50–1.25	0.040	0.030	0.50	15.00–16.00	4.00–5.00	...	2.50–3.25	D
S17600	635	0.08	1.00	0.040	0.030	1.00	16.00–17.50	6.00–7.50	0.40	...	0.40–1.20
S15500	XM-12	0.07	1.00	0.040	0.030	1.00	14.00–15.50	3.50–5.50	2.50–4.50	C
S13800	XM-13	0.05	0.20	0.010	0.008	0.10	12.25–13.25	7.50–8.50	0.90–1.35	2.00–2.50	E
S45500	XM-16	0.03	0.50	0.015	0.015	0.50	11.00–12.50	7.50–9.50	...	0.50	0.90–1.40	1.50–2.50	F
S45503	...	0.010	0.50	0.010	0.010	0.20	11.00–12.50	7.50–9.50	...	0.50	1.00–1.35	1.50–2.50	F
S45000	XM-25	0.05	1.00	0.030	0.030	1.00	14.00–16.00	5.00–7.00	...	0.50–1.00	...	1.25–1.75	G
S46500	...	0.02	0.25	0.015	0.010	0.25	11.00–12.50	10.75–11.25	...	0.75–1.25	1.50–1.80	...	E
S46910	...	0.030	1.00	0.030	0.015	0.70	11.0–13.0	8.0–10.0	0.15–0.50	3.0–5.0	0.50–1.20	1.5–3.5	...
S10120	...	0.02	0.25	0.015	0.010	0.25	11.00–12.50	9.00–10.50	0.80–1.10	1.75–2.25	0.20–0.50	...	E
S11100	...	0.02	0.25	0.015	0.010	0.25	11.00–12.50	10.25–11.25	1.35–1.75	1.75–2.25	0.20–0.50	...	E

^A Limits are in percent maximum unless shown as a range or stated otherwise.

^B New designation established in accordance with Practice E527 and SAE J1086.

^C Niobium^H 0.15–0.45.

^D Nitrogen 0.07–0.13.

^E Nitrogen 0.01.

^F Niobium 0.10–0.50.

^G Niobium 8 times carbon minimum.

^H Niobium (Nb) and Columbium (Cb) refer to the same element.

3.1.5 Transverse properties when required (7.6),

3.1.6 Finish (Specification A484/A484M),

3.1.7 Surface preparation of shapes (5.2.1),

3.1.8 Size, or applicable dimension including diameter, thickness, width, length, and so forth,

3.1.9 Preparation for delivery (Specification A484/A484M),

3.1.10 Special requirements (refer to 7.4 and 8.3),

3.1.11 Marking requirements (Specification A484/A484M), and

3.1.12 ASTM designation and date of issue if other than that currently published.

3.2 If possible, the intended use of the item should be given on the purchase order especially when the item is ordered for a specific end use or uses.

NOTE 3—A typical ordering description is as follows: 5000 lb [2270 kg] Type 630, Solution-Annealed Cold Finished Centerless Ground, 1½ in. [38.0 mm] round bar, 10 to 12 ft [3.0 to 3.6 m] in length, ASTM A564 dated _____. End use: valve shafts.

4. General Requirements

4.1 In addition to the requirements of this specification, all requirements of the current edition of Specifications A484/A484M shall apply. Failure to comply with the general requirements of Specification A484/A484M constitutes non-conformance with this specification.

5. Materials and Manufacture

5.1 Heat Treatment and Condition:

5.1.1 Material of types other than XM-16, XM-25, and Type 630 shall be furnished in the solution-annealed condition, or in the equalized and oven-tempered condition, as noted in Table 2, unless otherwise specified by the purchaser.

5.1.1.1 Types 630, XM-16, and XM-25 may be furnished in the solution-annealed or age-hardened condition.

5.1.2 Type UNS S46500 and S46910 shall be furnished in solution-annealed condition in accordance with Table 2, or solution-annealed and cold-worked condition in accordance with Table 3, or aged-hardened condition in accordance with Table 4.

5.1.3 Reforging stock shall be supplied in a condition of heat treatment to be selected by the forging manufacturer.

5.2 Shapes may be subjected to either Class A or Class C preparation as specified on the purchase order.

5.2.1 Class A consists of preparation by grinding for the removal of imperfections of a hazardous nature such as fins, tears, and jagged edges provided the underweight tolerance is not exceeded and the maximum depth of grinding at any one point does not exceed 10 % of the thickness of the section.

5.2.2 Class C consists of preparation by grinding for the removal of all visible surface imperfections provided the underweight tolerance is not exceeded and the maximum depth of grinding at any one point does not exceed 10 % of the thickness of the section.

6. Chemical Composition

6.1 Each alloy covered by this specification shall conform to the chemical requirements specified in Table 1.

6.2 Methods and practices relating to chemical analysis required by this specification shall be in accordance with Test Methods, Practices, and Terminology A751.

7. Mechanical Properties Requirements

7.1 The material, as represented by mechanical test specimens, shall conform to the mechanical property requirements specified in Table 2 or Table 3 and shall be capable of developing the properties in Table 4 when heat treated as specified in 5.1.



TABLE 2 Solution Treatment

UNS Designation	Type	Condition	Solution Treatment	Mechanical Test Requirements in Solution Treated Condition ^A							
				Tensile Strength, min		Yield Strength, min ^B		Elongation in 2 in. [50 mm] or 4D, min. %	Reduction of Area, min %	Hardness ^C	
				ksi	[MPa]	ksi	[MPa]			Rockwell C, max	Brinell, max
S17400	630	A	1900 ± 25 °F [1040 ± 15 °C] (cool as required to below 90 °F (32 °C))	38	363
S17700	631	A	1900 ± 25 °F [1040 ± 15 °C] (water quench)	HRB98	229
S15700	632	A	1900 ± 25 °F [1040 ± 15 °C] (water quench)	HRB100	269 ^D
S35500	634 ^E	A	1900 ± 25 °F [1040 ± 15 °C] quench, hold not less than 3 h at minus 100 °F or lower	363 ^E
S17600	635	A	1900 ± 25 °F [1040 ± 15 °C] (air cool)	120	[825]	75	[515]	10	45	32	302
S15500	XM-12	A	1900 ± 25 °F [1040 ± 15 °C] (cool as required to below 90 °F (32 °C))	38	363
S13800	XM-13	A	1700 ± 25 °F [925 ± 15 °C] Cool as required to below 60 °F [16 °C]	38	363
S45500	XM-16	A	1525 ± 25 °F [830 ± 15 °C] (cool rapidly)	36	331
S45000	XM-25	A	1900 ± 25 °F [1040 ± 15 °C] (cool rapidly)	125 ^F	[860]	95	[655]	10	40	32	321
S45503	...	A	1525 ± 25 °F [830 ± 15 °C] (cool rapidly)	36	331
S46500	...	A	1800 ± 25 °F [980 ± 15 °C] (oil or water quench), hold for min. 8 h at minus 100 °F (-73 °C), air warm	36	331
S46910	...	A	1830 – 2050 °F [1000 – 1120 °C] (cool rapidly)	87	[600]	58	[400]	10	...	33	315
S10120	...	A	1545 ± 25 °F [840 ± 14 °C] (cool rapidly below 90 °F [32 °C])	36	331
S11100	...	A	1545 ± 25 °F [840 ± 14 °C] (oil or water quench), hold for minimum of 8 h at -100 °F [-73 °C], ^G air warm	36	331

^A See 7.1.

^B See 7.3.

^C Either Rockwell C hardness or Brinell is permissible. On sizes ½ in. (12.70 mm) and smaller, Rockwell C is preferred.

^D 321 for rounds cold drawn after solution treating.

^E Equalization and over-tempering treatment 1425 ± 50 °F [775 ± 30 °C] for not less than 3 h, cool to room temperature, heat to 1075 ± 25 °F [580 ± 15 °C] for not less than 3 h.

^F Maximum 165 ksi [1140 MPa] tensile strength only for sizes up to ½ in. (13 mm).

^G Required hold time at minus 100 °F [-73 °C] is not mandatory if product is under 2 in. [51 mm] thickness.

TABLE 3 Solution-Annealed and Cold-Worked Condition

UNS Designation	Type	Condition	Mechanical Test Requirements in Solution-Annealed and Cold-Worked Condition								
			Tensile Strength, min		Yield Strength, min		Elongation in 2 in. [50 mm] or 4D, min %	Reduction of Area, min %	Hardness		
			ksi	[MPa]	ksi	[MPa]			Rockwell C, max	Brinell, max	
S46500	...	[Table 2 Condition A] + CW	40	380
S46910	...	CW ½ hard	131	[900]	109	[750]	8	40	380
	...	CW full hard	189	[1300]	175	[1200]	3	55	580



TABLE 4 Mechanical Test Requirements After Age Hardening Heat Treatment^A

Type	Condition	Suggested Hardening and/or Aging Treatment ^{B,C,D}		Applicable Thickness, in. & Test Direction ^E	Tensile Strength, min		Yield Strength, min ^F		Elongation in 2 in. [50 mm] or 4D, min %	Reduction of area, min, %	Hardness ^G		Impact Charpy-V, min	
		Temp, °F [°C]	Time, h		Quench ^H	ksi	[MPa]	ksi			[MPa]	Rockwell C, min		Brinell, min
630	H900	900 [480]	1.0	air cool	Up to 3 in. incl [75 mm] (L) Over 3 in. [75 mm] to 8 in. incl [200 mm] (T)	190	[1310]	170	[1170]	10	40	40	388	...
	H925	925 [495]	4.0	air cool	Up to 3 in. incl [75 mm] (L) Over 3 in. [75 mm] to 8 in. incl [200 mm] (T)	170	[1170]	155	[1070]	10	44	38	375	5
631	H1025	1025 [550]	4.0	air cool	Up to 8 in. incl [200 mm] (L)	155	[1070]	145	[1000]	12	45	35	331	15
	H1075	1075 [580]				145	[1000]	125	[860]	13	45	32	311	20
	H1100	1100 [595]				140	[965]	115	[795]	14	45	31	302	25
	H1150	1150 [620]				135	[930]	105	[725]	16	50	28	277	30
	H1150M	1400 [760] for 2 h, air cool plus 1150 [620] for 4 h, air cool				115	[795]	75	[520]	18	55	24	255	55
	H1150D	1150 [620] for 4 h, air cool plus 1150 [620] for 4 h, air cool				125	[860]	105	[725]	16	50	24	255	30
632	RH950	1750 °F [955 °C] for not less than 10 min, but not more than 1 h, cool rapidly to room temperature. Cool within 24 h to minus 100 ± 10 °F [75 °C], hold not less than 8 h. Warm in air to room temperature. Heat to 950 °F [510 °C], hold 1 h, air cool.			Up to 4 in. incl [100 mm] (L)	185	[1280]	150	[1030]	6	10	41	388	...
	TH1050	Alternative treatment: 1400 °F [760 °C] hold 90 min, cool to 55 ± 5 °F [15 ± 3 °C] within 1 h. Hold not less than 30 min, heat to 1050 °F [565 °C] hold for 90 min, air cool.			Up to 6 in. incl [150 mm] (L)	170	[1170]	140	[965]	6	25	38	352	...
633	RH950	Same as Type 631			Up to 4 in. incl [100 mm] (L)	200	[1380]	175	[1210]	7	25	...	415	...
	TH1050	Same as Type 631			Up to 6 in. incl [150 mm] (L)	180	[1240]	160	[1100]	8	25	...	375	...
634 ^I	H1000	1750 [955] for not less than 10 min, but not more than 1 h. Water quench. Cool to not higher than minus 100 °F [75 °C]. Hold for not less than 3 h. Temper at 1000 °F [540 °C], holding for not less than 3 h.			Up to 12 in. incl [300 mm] (L) Up to 12 in. incl [300 mm] (T)	170	[1170]	155	[1070]	12	25	37	341	...
	H950	1750 [955] for not less than 10 min, but not more than 1 h. Water quench. Cool to not higher than minus 100 °F [75 °C]. Hold for not less than 3 h. Temper at 1000 °F [540 °C], holding for not less than 3 h.			Up to 12 in. incl [300 mm] (L) Up to 12 in. incl [300 mm] (T)	190	[1310]	170	[1170]	10	35	40	388	...
635	H950	1050 [565]	0.5	air cool	Up to 12 in. incl [300 mm] (L)	190	[1310]	170	[1170]	8	25	39	363	...
	H1000	1000 [540]	0.5	air cool	Up to 12 in. incl [300 mm] (L)	180	[1240]	160	[1100]	8	30	37	352	...
	H1050	1050 [565]	0.5	air cool	Up to 12 in. incl [300 mm] (L)	170	[1170]	150	[1035]	10	40	35	331	...
XM-12	H900	900 [480]	1.0	air cool	Up to 12 in. incl [300 mm] (L) Up to 12 in. incl [300 mm] (T)	190	[1310]	170	[1170]	10	35	40	388	...
	H925	925 [495]	4.0	air cool	Up to 12 in. incl [300 mm] (L) Up to 12 in. incl [300 mm] (T)	170	[1170]	155	[1070]	10	38	38	375	5
H1025	1025 [550]	4.0	air cool	Up to 12 in. incl [300 mm] (L)	155	[1070]	145	[1000]	12	45	35	331	15	
					Up to 12 in. incl [300 mm] (L)	170	[1170]	155	[1070]	12	45	35	331	20