



Designation: **A291/A291M – 18a** **A291/A291M – 19**

Standard Specification for Steel Forgings, Carbon and Alloy, for Pinions, Gears and Shafts for Reduction Gears¹

This standard is issued under the fixed designation A291/A291M; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope*

1.1 This specification covers normalized and tempered carbon steel and quenched and tempered alloy steel forgings for pinions, gears, and shafts.

1.2 Several grades of steel are covered as follows:

1.2.1 *Grade 1, Class A*, is normalized and tempered carbon steel.

1.2.2 *Grade 2, Class B, Grade 3, Class C, Grade 3A, Class D, Grades 4 to 7, Classes E, F, G, and H, Grade 8, Class I, and Grade 9, Class J*, are liquid quenched and tempered alloy steel.

1.3 All grades and classes are considered weldable under proper conditions. Welding technique is of fundamental importance and it is presupposed that welding procedure and inspection shall be in accordance with approved methods for the class of material used.

1.4 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

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

[A275/A275M Practice for Magnetic Particle Examination of Steel Forgings](#)

[A388/A388M Practice for Ultrasonic Examination of Steel Forgings](#)

[A788/A788M Specification for Steel Forgings, General Requirements](#)

3. Terminology

3.1 *Definitions:*

3.1.1 *controlling cross section thickness (T_C)*—the diameter of the largest theoretical sphere which can be inscribed within the volume of the forging.

3.1.2 *gears*—rings, disks, cylinders or rectangular bars having gear teeth.

3.1.3 *pinions*—circular cross section forgings of multiple diameter with gear teeth on one or more diameters.

3.1.4 *shafts*—circular cross section forgings of one or more diameters which do not have integral gear teeth.

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 A01.06 on Steel Forgings and Billets.

Current edition approved Nov. 1, 2018/Nov. 1, 2019. Published November 2018/November 2019. Originally approved in 1946. Last previous edition approved in 2018 as A291/A291M/A291/A291M – 18a, –18. DOI: 10.1520/A0291_A0291M-18A-10.1520/A0291_A0291M-19.

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

4. Ordering Information

4.1 Instructions for purchasing forgings to this specification should be in accordance with Specification **A788/A788M**. In addition, a detailed drawing, sketch, or written description of the forging should be included with the inquiry or order.

4.2 Supplementary requirements are provided and shall apply only when specified in the purchase order.

5. Heat Treatment

5.1 Preliminary Heat Treatment:

5.1.1 The forgings shall be given such preliminary heat treatment as is proper for the design and composition. The forgings shall be heated to a suitable temperature for a sufficient length of time for austenitization and shall be suitably cooled to bring about complete transformation.

5.1.2 Forgings may be immediately treated for mechanical properties after preliminary heat treatment or they may be preliminarily machined prior to treatment for mechanical properties.

5.2 *Heat Treatment for Mechanical Properties*—The forging shall be reheated to a temperature above the upper critical temperature and held a sufficient length of time for complete austenitization. Grade 1 shall be air cooled while Grades 2 through 9 shall be liquid quenched.

5.3 *Tempering*—The forgings shall be tempered to develop the specified properties. Minimum tempering temperatures shall be as follows:

Grade	Class	Minimum Tempering Temperature	
		°F	[°C]
1 and 2	A and B	1150	[620]
3, 3A, and 4	C, D, and E	1075	[580]
5, 6, 7	F, G, and H	1050	[565]
8	I	1100	[595]
9	J	1000	[540]

~~The charge~~ For all grades except Grade 1 Class A, the forgings shall be cooled under uniform conditions in the furnace at a maximum rate of 100 °F [55 °C] per h to 600 °F [315 °C].

5.4 *Stress Relief*—If the manufacturer elects to heat treat for mechanical properties prior to machining, the forgings shall be stress relieved after machining (see 5.5) at a temperature that is 50 to 100 °F [30 to 55 °C] below the last previous tempering temperature but in no case below 1000 °F [540 °C]. ~~The~~ For all grades except Grade 1, Class A, the forgings shall be cooled under uniform conditions in the furnace at a maximum rate of 100 °F [55 °C]/h to 600 °F [315 °C].

5.5 Machining:

5.5.1 Machining before heat treatment for mechanical properties may be performed at the option of the manufacturer.

5.5.2 If the producer elects to heat treat for mechanical properties prior to machining, the forgings shall be stress relieved after machining.

5.5.3 *Boring*—Forgings, after being heat treated for mechanical properties and subsequently bored, shall be stress relieved.

6. General Requirements

6.1 Unless otherwise specified herein, the requirements of Specification **A788/A788M** shall apply to forgings supplied to this specification.

7. Chemical Requirements

7.1 The steel shall conform to the requirements for chemical composition prescribed in **Table 1**.

7.2 The limits for elements other than carbon, manganese, phosphorus, sulfur, and silicon in Grade 2 alloy shall be agreed upon between the manufacturer and purchaser.

8. Mechanical Requirements

8.1 Tensile and Impact Requirements:

8.1.1 The material shall conform to the requirements for tensile and impact properties prescribed in **Table 2** and impact properties (see Supplementary Requirement S2) when agreed upon between the purchaser and the supplier.

8.1.2 *Classification*—The dimensions of the controlling cross section thickness (T_C) of the forging at the time of heat treatment determine the mechanical properties to be met within each class (see **Table 2**).

8.1.3 Number, Location, and Orientation of Test Specimens:

8.1.3.1 At least one tension test specimen either longitudinal or tangential at the option of the manufacturer shall be taken from each forging unless a number of forgings are forged and treated in multiple, in which case one tension test specimen shall be taken from each end of the multiple forging. When impact tests are specified in accordance with Supplementary Requirement S2, one set of impact tests shall also be taken from each end of the multiple forging. When agreed upon between the manufacturer and the purchaser, forgings weighing less than 500 lb [225 kg] each at time of heat treatment may be tested in lots; the number of forgings to make up a lot shall be by mutual agreement.



TABLE 1 Chemical Requirements

Element	Composition, %						
	Grade 1	Grade 2	Grade 3	Grade 3A	Grades 4 to 7 Classes E, F, G, and H	Grade 8	Grade 9
	Class A	Class B	Class C	Class D		Class I	Class J
Carbon	0.55 max	0.50 max	0.45 max	0.45 max	0.35–0.50	0.38–0.45	0.25–0.39
Manganese	0.60–0.90	0.40–0.90	0.40–0.90	0.40–0.90	0.40–0.90	0.40–0.70	0.20–0.60
Phosphorus, max	0.040	0.040	0.040	0.040	0.040	0.040	0.015
Sulfur, max	0.040	0.040	0.040	0.040	0.040	0.040	0.015
Silicon, ^A max	0.35	0.35	0.35	0.35	0.35	0.40	0.35
Nickel	0.30 max	^B	0.50 max	1.00–3.00	1.65 min	0.30 max	3.25–4.00
Chromium	0.25 max	^B	1.25 max	1.50 max	0.60 min	1.40–1.80	1.25–1.75
Molybdenum	0.10 max	^B	0.15 min	0.15 min	0.20–0.60	0.30–0.45	0.30–0.70
Vanadium, max	0.06	0.10	0.05	0.10	0.10	0.03	0.05–0.15
Copper, max	0.35	0.35	0.35	0.35	0.35	0.35	0.35
Aluminum	0.85–1.30	...

^A When vacuum carbon deoxidation is used, silicon maximum shall be 0.10 %.

^B Optional with manufacturer and purchaser.

TABLE 2 Mechanical Properties

Grade	Class	Size, Solid Diameter or Thickness, in. ^A		Tensile Strength, min		Yield Strength, 0.2% Offset, min ^B		Elongation in 2 in. [50 mm], min, %		Reduction of Area, min, %		Charpy V-notch FtIb [J]	Brinell Hardness Number Range
		Over	Not Over	ksi	[MPa]	ksi	[MPa]	Longitudinal	Transverse (Tangential)	Longitudinal	Transverse (Tangential)		
1	A	...	10	85	[585]	50	[345]	22	16	45	30	...	170 - 223
		10	...	80	[550]	45	[310]	20	16	37	30	...	
2	B	...	10	95	[655]	70	[485]	20	18	45	34	...	201 - 241
		10	20	95	[655]	70	[485]	20	18	45	34	...	
3, 3A	C, D	...	10	105	[725]	80	[550]	19	16	45	32	...	223 - 262
		10	20	105	[725]	80	[550]	19	16	45	32	...	
4	E	...	10	120	[825]	95	[655]	16	16	40	30	...	248 - 293
		10	20	120	[825]	95	[655]	14	12	35	30	...	
5	F	...	10	140	[965]	115	[795]	16	12	40	30	...	285 - 331
		10	20	135	[930]	110	[760]	14	12	35	30	...	
6	G	...	10	145	[1000]	120	[825]	15	12	40	30	...	302 - 352
		10	20	140	[965]	115	[795]	14	12	35	30	...	
7	H	...	10	170	[1375]	140	[960]	14	10	35	25	...	341 - 415
		10	20	165	[1140]	135	[930]	12	10	30	25	...	
8	I	...	10	160	[1105]	130	[905]	10	10	25	25	...	255 - 302
		...	10	120	[825]	85	[585]	15	...	40	
9	J	20	...	170	[1175]	140	[960]	10	10	30	30	25 [30]	352 - 401

^A 10 in. = 250 mm. 20 in. = 500 mm.

^B For Grade 1, the yield point may be reported in lieu of the 0.2 % offset yield strength.

8.1.3.2 Tension and impact test specimens shall be taken from an extension of the main body of the forging, or from a full-size prolongation left on one end of each individual forging or on both ends of the multiple forging if the forgings are made in multiple. The dimensions of the controlling cross section thickness (T_c) of the forging at the time of heat treatment shall determine the size of prolongations for test specimens.

8.1.3.3 The axis of the longitudinal tension test specimen shall be located at any point 1¼ in. [32 mm] below the surface of the forging or mid-radius if 5 in. [127 mm] diameter and under. The axis of the tangential test specimen shall be located as near to the surface of the forging as practicable.

8.2 Brinell Hardness:

8.2.1 The material shall conform to the requirements for hardness as prescribed in Table 2. Brinell hardness tests shall be made on prepared areas on the forgings after machining to the sizes ordered by the purchaser and after stress relieving if stress relieving is required.

8.2.2 Number and Location of Tests—On each forging 8 in. [200 mm] and over in diameter, four Brinell hardness tests shall be made on the outside surface of that portion of the forging on which teeth will be cut, two tests being made on each end 180° apart and the tests on the two ends shall be 90° apart. On each forging under 8 in. [200 mm] in diameter, two Brinell hardness tests shall be made, one on each end 180° apart. On shaft forgings, two hardness tests shall be made on each end 180° apart.