



Designation: F594 – 09 (Reapproved 2020)

Standard Specification for Stainless Steel Nuts¹

This standard is issued under the fixed designation F594; 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 the requirements for stainless steel nuts 0.25 to 1.50 in., inclusive, in nominal diameter in a number of alloys in common use and intended for service applications requiring general corrosion resistance.

1.2 Seven groups of stainless steel alloys are covered, including ten austenitic, two ferritic, four martensitic, and one precipitation hardening.

Group	Alloys ^A	Condition ^B
1	304, 305, 304L 384, 18–9LW, 302HQ ^C	(CW) cold worked ^D
2	316, 316L	(CW) cold worked ^D
3	321, 347	(CW) cold worked ^D
4	430 ^E	(CW) cold worked ^D
5	410 ^F	(H) hardened and tempered
6	431	(H) hardened and tempered
7	630	(AH) aged hardened

^A Unless otherwise specified on the inquiry and order, the choice of an alloy from within a group shall be at the discretion of the fastener manufacturer (see 6.1).

^B See 4.2 for options.

^C When approved by the purchaser, alloys 303, 303Se, or XM1 may be furnished.

^D Sizes 0.75 in. and larger may be hot worked and solution annealed.

^E When approved by the purchaser, alloy 430F may be furnished.

^F When approved by the purchaser, alloy 416 or 416Se may be furnished.

1.3 Supplementary requirements of an optional nature are provided, applicable only when agreed upon by the manufacturer and the purchaser at the time of the inquiry and order.

1.4 Suitable bolts, hex cap screws, and studs for use with nuts included in this specification are covered by Specification F593. Unless otherwise specified, all bolts, hex cap screws, and studs used with these nuts shall conform to the requirements of Specification F593 and shall be of the same alloy group.

1.5 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 This specification is under the jurisdiction of ASTM Committee F16 on Fasteners and is the direct responsibility of Subcommittee F16.04 on Nonferrous Fasteners.

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1.6 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.

1.7 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

- A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels
- A342/A342M Test Methods for Permeability of Weakly Magnetic Materials
- A380 Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment, and Systems
- A493 Specification for Stainless Steel Wire and Wire Rods for Cold Heading and Cold Forging
- A555/A555M Specification for General Requirements for Stainless Steel Wire and Wire Rods
- A564/A564M Specification for Hot-Rolled and Cold-Finished Age-Hardening Stainless Steel Bars and Shapes
- A582/A582M Specification for Free-Machining Stainless Steel Bars
- A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products
- D3951 Practice for Commercial Packaging
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- F593 Specification for Stainless Steel Bolts, Hex Cap Screws, and Studs
- F606 Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, and Rivets (Metric) F0606_F0606M

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

E1470 Test Method for Characterization of Proteins by Electrophoretic Mobility (Withdrawn 2014)³
2.2 ASME Standards:⁴
B1.1 Unified Inch Screw Threads
B18.2.2 Square and Hex Nuts

NOTE 1—The following ASTM standards are noted for information only as suitable sources of material for the manufacture of nuts to this specification:

Specifications **A493**, **A564/A564M**, and **A582/A582M**.

3. Ordering Information

3.1 Orders for nuts under this specification shall include the following:

- 3.1.1 Quantity (number of pieces of each item and size),
- 3.1.2 Name of item,
- 3.1.3 Size (diameter and threads per inch),
- 3.1.4 Alloy group number (see 6.2.1), and
- 3.1.5 Condition (see 4.2).

3.1.6 Orders for nuts under this specification may include the following optional requirements:

- 3.1.6.1 Forming (see 4.1.1),
- 3.1.6.2 Composition (see 6.2),
- 3.1.6.3 Corrosion resistance (see 8.1),
- 3.1.6.4 Thread class (see 9.2),
- 3.1.6.5 Finish (see 10.3),
- 3.1.6.6 Test report (see 17.2),
- 3.1.6.7 Rejection (see 16.1),
- 3.1.6.8 Test rejection (see 16.1), and
- 3.1.6.9 Special packaging (see 19.2).

3.1.7 Supplementary requirements, if any, to be specified on the order (see S1 through S8), and

3.1.8 ASTM specification and date of issue. When date of issue is not specified, fasteners shall be furnished to the latest issue.

NOTE 2—Example: 10 000 pieces, Hex Nut, 0.250 in. –20, Alloy Group 1, Condition CW, Furnish Test Report, Supplementary Requirement S3.

4. Manufacture
4.1 Manufacture:

4.1.1 *Forming*—Unless otherwise specified, the nuts shall be hot formed, cold formed, or machined from suitable material, at the option of the manufacturer.

4.2 *Condition*—The fasteners shall be furnished in the following conditions, unless specified to be furnished in one of the optional conditions:

Alloy Group	Condition Furnished Unless Otherwise Specified	Optional Conditions (must be specified)
1, 2, 3	CW	AF, A, SH
4	CW	A
5	H	HT
6	H	HT
7	AH	none
A—	Machined from annealed or solution annealed stock thus retaining the properties of the original material; or hot formed and solution annealed.	
AF—	Annealed after all threading is completed.	
AH—	Solution annealed and age hardened after forming.	
CW—	Annealed and cold worked. Sizes 0.75 in. and larger may be hot worked and solution annealed.	
H—	Hardened and tempered at 1050 °F (565 °C) minimum.	
HT—	Hardened and tempered at 525 °F (274 °C) minimum.	
SH—	Machined from strain hardened stock.	

5. Heat Treatment

5.1 *Alloy Groups 1, 2, and 3 (Austenitic Alloys 303, 303Se, 304, 304L, 305, 316, 316L, 321, 347, 384, XM1, 18–9LW, and 302HQ):*

5.1.1 *Condition A*—When Condition A is specified, the austenitic alloys shall be heated to 1900 ± 50 °F (1038 ± 28 °C), at which time the chromium carbide will go into the solution, be held for a sufficient time, and then be cooled at a rate sufficient to prevent precipitation of the carbide and to provide the specified properties.

5.1.2 *Condition CW*—When Condition CW is specified, the austenitic alloys shall be annealed as specified in 5.1.1 and then cold worked to develop the specified properties.

5.1.3 *Condition AF*—When Condition AF is specified, the austenitic alloys shall be annealed as specified in 5.1.1 after all cold working, including forming and threading.

5.2 *Alloy Group 4 (Ferritic Alloys 430 and 430F):*

5.2.1 *Condition A*—The ferritic alloys shall be heated to a temperature of 1450 ± 50 °F (788 ± 28 °C), held for an appropriate time, and then air cooled to provide the specified properties.

5.2.2 *Condition CW*—When Condition CW is specified, the ferritic alloys shall be annealed in accordance with 5.2.1, generally by the raw material manufacturer, and then cold worked to develop the specified properties.

5.3 *Alloy Group 5 (Martensitic Alloys 410, 416, and 416Se):*

5.3.1 *Condition H*—When Condition H is specified, the martensitic alloys 410, 416, and 416Se shall be hardened and tempered by heating to 1850 ± 50 °F (1010 ± 28 °C) sufficient for austenitization, held for at least ½ h and rapid air- or oil-quenched, then reheating to 1050 °F (565 °C) minimum for at least 1 h and air cooled to provide the specified properties.

5.3.2 *Condition HT*—When Condition HT is specified, the martensitic alloys 410, 416, and 416Se shall be hardened and tempered by heating to 1850 ± 50 °F (1010 ± 28 °C) sufficient for austenitization, held for at least ½ h and rapid air- or oil-quenched, then reheating to 525 °F (274 °C) minimum for at least 1 h and air cooled to provide the specified properties.

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from Global Engineering Documents, 15 Inverness Way, East Englewood, CO 80112-5704, <http://www.global.ihs.com>.

5.4 Alloy Group 6 (Martensitic Alloy 431):

5.4.1 *Conditions H and HT*—The martensitic alloy 431 shall be hardened and tempered as specified in 5.3.1 and 5.3.2 as applicable.

5.5 Alloy Group 7 (Precipitation Hardening Alloy 630):

5.5.1 *Condition AH*—The precipitation hardening alloy 630 shall be solution annealed and aged by heating to 1900 ± 25 °F (1038 ± 14 °C) for at least ½ h and rapid air or oil quenched to 80 °F (27 °C) maximum, then reheating to a temperature of 1150 ± 15 °F (621 ± 8 °C) for 4 h and air cooled to provide the specified properties.

6. Chemical Composition

6.1 *Alloy Groups*—It is the intent of this specification that fasteners shall be ordered by alloy group numbers that include alloys considered to be chemically equivalent for general purpose use. The alloy groupings are as shown below. When required, however, a specific alloy may be specified as permitted by 6.2.2.

Alloy Group	Alloys
1	304, 305, 304L 384, 18–9LW, 302HQ ^A
2	316, 316L
3	321, 347
4	430 ^B
5	410 ^C
6	431
7	630

^A When approved by the purchaser, alloys 303, 303Se, or XM1 may be furnished.

^B When approved by the purchaser, alloy 430F may be furnished.

^C When approved by the purchaser, alloys 416 or 416Se may be furnished.

6.2 Chemical Composition Limits:

6.2.1 *Ordering by Alloy Group*—Unless otherwise specified on the inquiry and order (see Supplementary Requirement S4), the choice of an alloy from within a group shall be at the discretion of the fastener manufacturer as required by his method of fastener fabrication and material availability. The specific alloy used by the fastener manufacturer shall be clearly identified on any certification required by the order and shall have a chemical composition conforming to the requirements of Table 1 for the specific alloy.

6.2.2 *Ordering by Specific Alloy*—When ordered by a specific alloy number, the fasteners shall conform to the chemical composition limits of Table 1 for the specific alloy.

6.3 Product Analysis:

6.3.1 Product analysis may be made by the purchaser from finished nuts representing each lot. The chemical composition thus determined shall conform to the requirements of Table 1 for the specific alloy subject to the Product Analysis Tolerance in Specification A555/A555M.

6.3.2 In the event of discrepancy, a referee chemical analysis of samples from each lot shall be made in accordance with 14.1.

7. Mechanical Properties

7.1 The finished fasteners shall meet the applicable mechanical properties of Table 2 for the specified alloy group and condition when tested in accordance with the mechanical property requirements as specified herein (see also Table 3).

8. Corrosion Resistance

8.1 Carbide Precipitation:

8.1.1 Rod, bar, and wire in the austenitic Alloy Groups 1, 2, and 3, except the free-machining grades, 303 and 303Se used to make fasteners in accordance with this specification, shall be capable of passing the test for susceptibility to intergranular corrosion as specified in Practice E of Practice A262.

8.1.2 As stated in Practice A262, samples may be subjected to the faster and more severe screening test in accordance with Practice A. Failing Practice A, specimens may be tested in accordance with Practice E and be considered satisfactory if passing Practice E.

9. Dimensions

9.1 Nuts:

9.1.1 Unless otherwise specified, the dimensions shall be in accordance with the requirements of ASME B18.2.2 for Hex Nuts.

9.1.2 When specified, the dimensions of nuts shall be in accordance with the requirements of ASME B18.2.2 (type as specified), or such other dimensions as may be specified.

9.2 *Threads* (see Table 4)—Unless otherwise specified, the nuts shall have Class 2B threads in accordance with ASME B1.1.

10. Workmanship, Finish, and Appearance

10.1 *Workmanship*—The nuts shall have a workmanlike finish, free of injurious burrs, seams, laps, irregular surfaces, and other defects affecting serviceability.

10.2 *Surface Finish*—The nuts shall have a surface finish produced in accordance with Practice A380.

10.3 *Protective Finishes*—Unless otherwise specified, the nuts shall be furnished without an additive chemical or metallic finish.

11. Sampling

11.1 A lot, for the purposes of selecting test specimens, shall consist of not more than 100 000 pieces offered for inspection at one time having the following common characteristics:

11.1.1 One type of item,

11.1.2 Same alloy and condition, and

11.1.3 One nominal diameter and thread series.

12. Number of Tests and Retests

12.1 Number of Tests:

12.1.1 *Mechanical Tests*—The mechanical requirements of this specification shall be met in continuous mass production for stock. The manufacturer shall make sample inspections as specified below to ensure the product conforms to the specified requirements. When tests of individual shipments are required, Supplementary Requirement S1 must be specified in the inquiry and order.

Number of Pieces in Lot	Number of Tests	Acceptance Criteria	
		Acceptance Number	Rejection Number
2 to 50	2	0	1
51 to 500	3	0	1
501 to 35 000	5	0	1
35 001 to 100 000	8	0	1



TABLE 1 Chemical Requirements

Alloy Group	UNS Designation	Alloy	Composition, % maximum except as shown									
			Carbon	Manganese	Phosphorus	Sulfur	Silicon	Chromium	Nickel	Copper	Molybdenum	Others
Austenitic Alloys												
1	S30300	303	0.15	2.00	0.20	0.15 min	1.00	17.0 to 19.0	8.0 to 10.0	...	0.60 max ^A	...
1	S30323	303Se	0.15	2.00	0.20	0.060	1.00	17.0 to 19.0	8.0 to 10.0	Se 0.15 min
1	S30400	304	0.08	2.00	0.045	0.030	1.00	18.0 to 20.0	8.0 to 10.5	1.00
1	S30403	304L	0.03	2.00	0.045	0.030	1.00	18.0 to 20.0	8.0 to 12.0	1.00
1	S30500	305	0.12	2.00	0.045	0.030	1.00	17.0 to 19.0	10.5 to 13.0	1.00
1	S38400	384	0.08	2.00	0.045	0.030	1.00	15.0 to 17.0	17.0 to 19.0
1	S20300	XM1	0.08	5.0 to 6.5	0.040	0.18 to 0.35	1.00	16.0 to 18.0	5.0 to 6.5	1.75 to 2.25	0.50 max ^A	...
1	S30430	18–9LW	0.10	2.00	0.045	0.030	1.00	17.0 to 19.0	8.0 to 10.0	3.0 to 4.0
1	S30433	302HQ	0.03	2.00	0.045	0.030	1.00	17.0 to 19.0	8.0 to 10.0	3.0 to 4.0
2	S31603	316L	0.03	2.00	0.045	0.030	1.00	16.0 to 18.0	10.0 to 14.0	...	2.00–3.00	...
2	S31600	316	0.08	2.00	0.045	0.030	1.00	16.0 to 18.0	10.0 to 14.0	...	2.00–3.00	...
3	S32100	321	0.08	2.00	0.045	0.030	1.00	17.0 to 19.0	9.0 to 12.0	Ti 5 × C min
3	S34700	347	0.08	2.00	0.045	0.030	1.00	17.0 to 19.0	9.0 to 13.0	Cb + Ta 10 × C min
Ferritic Alloys												
4	S43000	430	0.12	1.00	0.040	0.030	1.00	16.0 to 18.0	0.60 max ^A	...
	S43020	430F	0.12	1.25	0.060	0.15 min	1.00	16.0 to 18.0	0.60 max ^A	...
Martensitic Alloys												
5	S41000	410	0.15	1.00	0.040	0.030	1.00	11.5 to 13.5
5	S41600	416	0.15	1.25	0.060	0.15 min	1.00	12.0 to 14.0	0.60 max ^A	...
5	S41623	416Se	0.15	1.25	0.060	0.060	1.00	12.0 to 14.0	Se 0.15 min
6	S43100	431	0.20	1.00	0.040	0.030	1.00	15.0 to 17.0	1.25 to 2.50
Precipitation Hardening Alloy												
7	S17400	630	0.07	1.00	0.040	0.030	1.00	15.0 to 17.5	3.0 to 5.0	3.0 to 5.0	...	Cb + Ta 0.15–0.45

^A At manufacturer's option, determined only when intentionally added.

12.1.2 Corrosion Resistance Tests:

12.1.2.1 Unless otherwise specified, tests for corrosion resistance shall be in accordance with the manufacturer's standard quality control practices. A specific number of tests is not required, but the fasteners shall be produced by manufacturing practices and subjected to tests and inspection to assure compliance with the specified requirements.

12.1.2.2 When specified on the purchase order, not less than one corrosion test to determine freedom from precipitated carbides shall be made to represent each lot.

12.2 Retests:

12.2.1 When tested in accordance with the required sampling plan, a lot shall be subject to rejection if any of the test specimens fail to meet the applicable test requirements.

12.2.2 If the failure of a test specimen is due to improper preparation of the specimen or to incorrect testing technique, the specimen shall be discarded and another specimen substituted.

13. Specimen Preparation

13.1 *Chemical Tests*—When required, samples for chemical analysis shall be taken by drilling, sawing, milling, turning, clipping, or other such methods capable of producing representative samples.

13.2 Mechanical Tests:

13.2.1 Nuts shall be tested in full section.

13.2.2 The hardness shall be determined on the top or bottom face of the nut.