



Designation: **B621–02 (Reapproved 2016) B621 – 21**

Standard Specification for Nickel-Iron-Chromium-Molybdenum Alloy (UNS N08320) Rod¹

This standard is issued under the fixed designation B621; 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~~ Scope*

1.1 This specification² covers nickel-iron chromium-molybdenum alloy (UNS N08320)³ rod for use in general corrosive service.

1.2 The following products are covered under this specification:

1.2.1 Rods $\frac{5}{16}$ to $\frac{3}{4}$ in. (7.94 to 19.05 mm) excl in diameter, hot or cold finished, solution annealed and pickled or mechanically descaled.

1.2.2 Rods $\frac{3}{4}$ to $3\frac{1}{2}$ in. (19.05 to 88.9 mm) incl in diameter, hot or cold finished, solution annealed, ground or turned.

1.3 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.

1.4 *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 become familiar with all hazards including those identified in the appropriate Safety Data Sheet (SDS) for this product/material as provided by the manufacturer; to establish appropriate ~~safety~~ safety, health, and ~~health~~ environmental practices, and determine the applicability of regulatory limitations prior to use.*

1.5 *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:⁴

- [B880 Specification for General Requirements for Chemical Check Analysis Limits for Nickel, Nickel Alloys and Cobalt Alloys](#)
- [B899 Terminology Relating to Non-ferrous Metals and Alloys](#)
- [E8 Test Methods for Tension Testing of Metallic Materials \[Metric\] E0008_E0008M](#)
- [E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)
- [E527 Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)
- [E1473 Test Methods for Chemical Analysis of Nickel, Cobalt and High-Temperature Alloys](#)

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.07 on Refined Nickel and Cobalt and Their Alloys.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-621 in Section II of that Code.

³ New designation established in accordance with ASTM E527 and SAE J1086, Recommended Practice for Numbering Metals and Alloys (UNS).

⁴ 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

3. Terminology

3.1 The definitions in Terminology B899 are applicable to this specification.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *rod, n*—a product of round solid section furnished in straight lengths.

4. Ordering Information

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

4.1.1 *Dimensions*—Nominal diameter and length. The shortest useable multiple length shall be specified (Table 1).

4.1.2 *Certification*—State if certification or a report of test results is required (Section 15).

4.1.3 *Purchaser Inspection*—State which tests or inspections are to be witnessed (Section 13).

4.1.4 *Samples for Product (Check) Analysis*—State whether samples shall be furnished (9.2.2).

5. Chemical Composition

5.1 The material shall conform to the composition limits specified in Table 2.

5.2 If a product (check) analysis is made by the purchaser, the material shall conform to the requirements specified in Table 2 subject to the permissible tolerances in Specification B880.

6. Mechanical Properties and Other Requirements

6.1 The mechanical properties of the material at room temperature shall conform to those shown in Table 3.

7. Dimensions, Mass and Permissible Variations

7.1 *Diameter*—The permissible variations from the specified diameter shall be as prescribed in Table 4.

TABLE 1 Permissible Variations in Length of Rods

Random mill lengths	2 to 12 ft (610 to 3660 mm) long with not more than 25 weight % under 4 ft (1.22 m).
Multiple lengths	Furnished in multiples of a specified unit length, within the length limits indicated above. For each multiple, an allowance of ¼ in. (6.35 mm) shall be made for cutting, unless otherwise specified. At the manufacturer's option, individual specified unit lengths may be furnished.
Multiple lengths	Furnished in multiples of a specified unit length, within the length limits indicated above. For each multiple, an allowance of ¼ in. (6.35 mm) shall be made for cutting, unless otherwise specified. At the manufacturer's option, individual specified unit lengths may be furnished.
Nominal lengths	Specified nominal lengths having a range of not less than 2 ft (610 mm) with no short lengths allowed.
Nominal lengths	Specified nominal lengths having a range of not less than 2 ft (610 mm) with no short lengths allowed.
Cut lengths	A specified length to which all rods shall be cut with a permissible variation of + ⅛ in. (3.17 mm) - 0.

TABLE 2 Chemical Requirements

Element	Composition Limits,%
Nickel	25.0–27.0
Iron	remainder ^A
Chromium	21.0–23.0
Molybdenum	4.0–6.0
Manganese, max	2.5
Carbon, max	0.05
Titanium, min	4 × carbon
Silicon, max	1.00
Phosphorus, max	0.04
Sulfur, max	0.03

^A See 12.1.1.

TABLE 3 Mechanical Property Requirements

Tensile Strength, min, psi (MPa)	Yield Strength (0.2 % Offset), min, psi (MPa)	Elongation in 2 in. (50.8) or 4D ^A , min, %
75 000 (517)	28 000 (193)	35

^A D refers to the diameter of the tension specimen.

7.2 *Out of Roundness*—The permissible variation in roundness shall be as prescribed in **Table 4**.

7.3 *Matching Allowances*—When the surfaces of finished material are to be machined, the following allowances are suggested for normal machining operations:

7.3.1 *As-finished (Annealed and Descaled)*—For diameters of $\frac{5}{16}$ to $\frac{11}{16}$ in. (7.94 to 17.46 mm) incl, an allowance of $\frac{1}{16}$ in. (1.59 mm) on the diameter should be made for finish machining.

7.4 *Length*:

7.4.1 Unless multiple, nominal, or cut lengths are specified, random mill lengths shall be furnished.

7.4.2 The permissible variations in length of multiple, nominal, or cut length rod shall be as prescribed in **Table 1**. Where rods are ordered in multiple lengths, an additional $\frac{1}{4}$ in. (6.35 mm) in length shall be allowed for each uncut multiple length.

7.5 *Ends*:

7.5.1 Rods ordered to random or nominal lengths shall be furnished with either cropped or sawed ends.

7.5.2 Rods ordered to cut lengths shall be furnished with square saw cut or machined ends.

7.6 *Weight*—The material covered by this specification shall be assumed to weigh 0.291 lb/in.³ (8.05 g/cm³).

7.7 *Straightness*—The maximum curvature (depth of cord) shall not exceed 0.050 in. multiplied by the length of the cord in feet (0.04 mm multiplied by the length in centimetres).

8. Workmanship, Finish, and Appearance

8.1 The material shall be uniform in quality and condition, smooth, and free of injurious imperfections.

9. Sampling

9.1 *Lots for Chemical Analysis and Mechanical Testing*:

9.1.1 A lot for chemical analysis shall consist of one heat.

TABLE 4 Permissible Variations in Diameter and Out-of-Roundness of Finished Rods

Specified Diameter, in. (mm)	Permissible Variations, in. (mm)		
	Diameter		Out of Roundness, max
	Plus	Minus	
	Hot-Finished, Annealed, and Descaled Rods		
5/16 to 7/16 (7.94–11.11), incl	0.012 (0.30)	0.012 (0.30)	0.018 (0.46)
Over 7/16 to 5/8 (11.11–15.87), incl	0.014 (0.36)	0.014 (0.36)	0.020 (0.51)
Over 5/8 to 3/4 (15.87–19.05), excl	0.016 (0.41)	0.016 (0.41)	0.024 (0.61)
	Hot-Finished, Annealed, and Ground or Turned Rods		
3/4 to 3 1/2 (19.05–88.9), incl	0.010 (0.25)	0	0.008 (0.20)

9.1.2 A lot of bar for mechanical testing shall be defined as the material from one heat in the same condition and specified diameter.

9.2 Sampling for Chemical Analysis:

9.2.1 A representative sample shall be obtained from each heat during pouring or subsequent processing.

9.2.2 Product (check) analysis shall be wholly the responsibility of the purchaser.

9.3 Sampling for Mechanical Testing:

9.3.1 A representative sample shall be taken from each lot of finished material.

10. Number of Tests and Retests

10.1 *Chemical Analysis*—One test per heat.

10.2 *Tension Tests*—One test per lot.

10.3 *Retests*—If the specimen used in the mechanical test of any lot fails to meet the specified requirements, two additional specimens shall be taken from different sample pieces and tested. The results of the tests on both of these specimens shall meet the specified requirements.

11. Specimen Preparation

11.1 Tension test specimens shall be taken from material after final heat-treatment and tested in the direction of fabrication.

11.2 Tension test specimens shall be any of the standard or subsized specimens shown in Test Methods E8.

11.3 In the event of a disagreement, the referee specimen shall be the largest possible round specimen shown in Test Methods E8.

12. Test Methods

12.1 The chemical composition and mechanical properties of the material as enumerated in this specification shall be determined, in case of disagreement, in accordance with the following ASTM methods:

12.1.1 *Chemical Analysis*—Test Methods E1473.

12.1.2 *Tension Test*—Test Methods E8.

12.1.3 *Determining Significant Places*—Practice E29.

12.2 For purposes of determining compliance with the limits in this specification, an observed value or a calculated value shall be rounded in accordance with the rounding method of Practice E29: