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# Standard Specification for Forged or Rolled 8 and 9% Nickel Alloy Steel Flanges, Fittings, Valves, and Parts for Low-Temperature Service<sup>1</sup>

This standard is issued under the fixed designation A522/A522M; 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.

<sup>ε1</sup> NOTE—Editorially corrected Table 3 in July 2021.

## 1. Scope—Scope\*

1.1 This specification<sup>2</sup> covers 8 and 9 % nickel-alloy steel forged or rolled flanges, fittings, valves, and parts intended for use in welded pressure vessels for low-temperature service. The specification is applicable to forgings with maximum section thickness of 3 in. [75 mm] in the double normalized and tempered condition and 5 in. [125 mm] in the quenched and tempered condition. Forgings under this specification are intended for service at operating temperatures not lower than –320 °F [–196 °C] for Type I or –275 °F [–170 °C] for Type II or higher than 250 °F [121 °C].

1.2 Material under this specification is available in two types having different chemical compositions as follows:

Type	Nominal Nickel Content, %
I	9
II	8

1.3 This specification is expressed in both inch-pound units and SI units. However, unless the order specifies the applicable “M” specification designation (SI units), the material shall be furnished to inch-pound units.

1.4 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 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 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:<sup>3</sup>

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

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.22 on Steel Forgings and Wrought Fittings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications.

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<sup>2</sup> For ASME Boiler and Pressure Vessel Code applications see related Specification SA-522 in Section II of that Code.

<sup>3</sup> 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

**A961/A961M Specification for Common Requirements for Steel Flanges, Forged Fittings, Valves, and Parts for Piping Applications**

**3. General Requirements and Ordering Information**

3.1 Product furnished to this specification shall conform to the requirements of Specification **A961/A961M**, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the requirements of Specification **A961/A961M** constitutes nonconformance with this specification.

3.2 It is the purchaser’s responsibility to specify in the purchase order all ordering information necessary to furnish the needed material. Examples of such information include but are not limited to the ordering information in Specification **A961/A961M** and following:

- 3.2.1 Any supplementary requirements, and
- 3.2.2 Additional requirements, (See **4.5, 4.6, 5.2, 6.1, 7.2, and 10.3**).

**4. Materials and Manufacture**

- 4.1 The steel shall be produced in accordance with the melting process section of Specification **A788/A788M**.
- 4.2 Material for forgings shall consist of ingots, or either forged or rolled blooms, billets, or bars.
- 4.3 The finished product shall be a forging as defined in the Terminology Section of Specification **A788/A788M**.

4.4 ~~Except for flanges of all types, hollow cylindrical shaped~~ Hollow parts may be made from hot-rolled or forged bar, provided that the axial length/longitudinal axis of the part is approximately parallel to the metal flow lines of the stock. Except for all types of flanges, elbows, return bends, tees, and header tees, other longitudinal axis of the bar. Other parts up to and including NPS 4 may be machined from hot-rolled or forged bar.

4.5 Flanges, elbows, return bends, tees, and header tees shall not be machined directly from bar without additional hot working.

4.6 When specified in the order, the manufacturer shall submit for purchaser’s approval a sketch showing the shape of the rough forging before machining.

**5. Chemical Composition**

- 5.1 The steel shall conform to the requirements of **Table 1**.
- 5.2 If required by the purchaser, product analysis may be performed in accordance with the requirements of **A961/A961M**.

**6. Heat Treatment**

6.1 The forgings shall be heat treated by the manufacturer by either of the following methods as mutually agreed upon between the purchaser and the manufacturer.

**TABLE 1 Chemical Requirements**

	Composition, %	
	Type I	Type II
Carbon, max	0.13	0.13
Manganese, max	0.90	0.90
Phosphorus, max	0.025	0.025
Sulfur, max	0.025	0.025
Silicon <sup>A</sup>	0.15–0.30	0.15–0.30
Nickel	8.5–9.5	7.5–8.5

<sup>A</sup> When vacuum carbon deoxidation is used, the maximum silicon content shall be 0.10 %.



6.1.1 *Quenched and Tempered*—Heat to a uniform temperature of 1475 ± 25 °F [800 ± 15 °C]; hold at this temperature for a minimum time of 1 h/in. [2.5 min/mm] of thickness but in no case less than 30 min; quench by immersion in circulating water. Reheat until the forging attains a uniform temperature within the range from 1050 to 1125 °F [565 to 605 °C]; hold at this temperature for a minimum time of 1 h/in. [2.5 min/mm] of thickness but in no case less than 30 min; cool in air or water quench, at a rate not less than 300 °F [165 °C]/h.

6.1.2 *Double Normalized and Tempered*—Heat to a uniform temperature of 1650 °F [900 °C]; hold at this temperature for a minimum time of 1 h/in. [2.5 min/mm] of thickness but in no case less than 30 min; cool in air. Reheat until the forging attains a uniform temperature of 1450 °F [790 °C]; hold at this temperature for a minimum time of 1 h/in. [2.5 min/mm] of thickness but in no case less than 30 min; cool in air. Reheat to a uniform temperature within the range from 1050 to 1125 °F [565 to 605 °C]; hold at this temperature for a minimum time of 1 h/in. [2.5 min/mm] of thickness but in no case less than 30 min; cool in air or water quench, at a rate not less than 300 °F [165 °C]/h.

6.2 When stress relieving is to be performed after fabrication, the recommended stress-relieving treatment is as follows: gradually and uniformly heat the steel to a temperature between 1025 and 1085 °F [550 and 585 °C]; hold for a minimum of 2 h for thicknesses up to 1 in. [25 mm]. For thicknesses over 1 in. [25 mm], a minimum additional holding time in the ratio of 1 h/in. [2.5 min/mm] of thickness in excess of 1 in. [25 mm] shall be added. Cool at a minimum rate of 300 °F [165 °C]/h to a temperature not exceeding 600 °F [315 °C].

**7. Mechanical Properties**

7.1 *Tension Test*—Forgings to Types 1 and 2 shall conform to the tensile requirements of **Table 2**.

7.2 *Impact Test*—The Charpy impact test requirements in **Table 3** shall be met unless Supplementary Requirement S2 of this specification has been specified.

7.2.1 The values for energy absorption and the fracture appearance in percentage of shear fracture for each specimen shall be recorded and reported for information.

**8. Surface Finish, Appearance, and Corrosion Protection**

8.1 The requirements of Specification **A961/A961M** apply to forgings and finished parts.

**9. Number of Tests and Retests**

9.1 At least one tension test and one set of Charpy V-notch impact tests shall be made from each heat in each heat-treatment charge.

9.2 If the results of the mechanical tests do not conform to the specified requirements, the manufacturer may retreat the forgings, but not more than three additional times. Retreatment involves re-austenitizing the forgings. Retests shall be made in accordance with this section.

9.3 If the lateral expansion result from one Charpy impact specimen falls below 0.015 in. [0.38 mm], but not less than 0.010 in. [0.25 mm], and the average test result equals or exceeds 0.015 mm [0.38 mm], then one retest of three additional specimens may be made. The lateral expansion obtained from each of the three retest specimens shall equal or exceed 0.015 in. [0.38 mm].

**10. Test Specimens**

10.1 The test specimens shall be located at any point midway between the center and surface of solid forgings, and at any point

**TABLE 2 Tensile Requirements at Room Temperature**

Tensile strength, min, ksi [MPa]	100 [690]
Yield strength, min, (0.2 % off-set), ksi [MPa]	75 [515]
Elongation in 2 in. [50 mm], min, %	22
Reduction of area, min, %	45

**TABLE 3 Charpy V-Notch Lateral Expansion Requirements For Standard Size [10 X 10 mm] Specimens**

Type	Lateral expansion in. [mm]	Temperature °F [°C] <sup>A</sup>	Report absorbed energy and % shear fracture
1	0.015 [0.38]	–320 [–196]	Yes
2	0.015 [0.38]	–275 [–170]	Yes

<sup>A</sup> Except when Supplementary Requirement S2 is specified.

mid-thickness of the heaviest section of hollow or bored forgings. For solid forgings where test metal is provided on the periphery, test specimens shall be taken at mid-thickness of the test prolongation.

10.2 Tests shall be oriented so that the longitudinal axis of the specimen is parallel to the major direction of grain flow.

10.3 When fabrication requires stress relieving, the purchaser shall specify stress relieving of the test pieces prior to machining of the test specimens. Stress relieving shall be carried out as prescribed in 6.2.

## 11. Method of Impact Testing

11.1 The impact test shall be made in accordance with the simple beam, Charpy type of test.

11.2 Precaution shall be taken so that when broken, the test specimens shall be within  $\pm 3$  °F [1.7 °C] of the specified test temperature.

## 12. Inspection

12.1 The inspector representing the purchaser shall have free entry, at all times while work on the contract of the purchaser is being performed, to all parts of the manufacturer's works that concern the manufacture of the material ordered. The manufacturer shall afford the inspector all reasonable facilities to satisfy the inspector that the material is being furnished in accordance with this specification. All tests (except product analysis) and inspection shall be made at the place of manufacture prior to shipment, unless otherwise specified, and shall be conducted so as not to interfere unnecessarily with the operation of the works. <sup>2-a522m-22</sup>

12.2 The manufacturer shall report to the purchaser or the purchaser's representative the heat treatments applied to the material and to the test blocks and the results of the chemical analysis and mechanical tests made in accordance with this specification and the heat number or his heat identification.

## 13. Rejection

13.1 Unless otherwise specified, any rejection based on tests made in accordance with Section 5 and 7 shall be reported to the manufacturer within 60 days from the receipt of samples or test reports by the purchaser.

13.2 Each forging in which injurious metal defects are exposed during subsequent machining shall be rejected and the manufacturer notified.

## 14. Certification

14.1 See Specification A961/A961M.

14.2 Test reports shall include the following where applicable:

14.2.1 Whether Type 1 or Type 11 material has been supplied and the chemical analysis results in accordance with Section 5,

14.2.2 Type of heat treatment used,