



Designation: ~~E352 – 18^{ε1}~~ E352 – 23

Standard Test Methods for Chemical Analysis of Tool Steels and Other Similar Medium- and High-Alloy Steels¹

This standard is issued under the fixed designation E352; 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.

^{ε1} NOTE—An editorial correction was made in Table 5 in February 2022.

1. Scope

1.1 These test methods cover the chemical analysis of tool steels and other similar medium- and high-alloy steels having chemical compositions within the following limits:

Element	Composition Range, %
Aluminum	0.005 to 1.5
Boron	0.001 to 0.10
Carbon	0.03 to 2.50
Chromium	0.10 to 14.0
Cobalt	0.10 to 14.0
Copper	0.01 to 2.0
Lead	0.001 to 0.01
Manganese	0.10 to 15.00
Molybdenum	0.01 to 10.00
Nickel	0.02 to 4.00
Nitrogen	0.001 to 0.20
Phosphorus	0.002 to 0.05
Silicon	0.10 to 2.50
Sulfur	0.002 to 0.40
Tungsten	0.01 to 21.00
Vanadium	0.02 to 5.50

1.2 The test methods in this standard are contained in the sections indicated below:

Test Method	Sections
Carbon, Total, by the Combustion— Thermal Conductivity Method— <i>Discontinued 1986</i>	125–135
Carbon, Total, by the Combustion Gravimetric Method— <i>Discontinued 2012</i>	78–88
Chromium by the Atomic Absorption Spectrometry Method (0.006 % to 1.00 %)	174–183
Chromium by the Peroxydisulfate Oxidation—Titration Method (0.10 % to 14.00 %)	184–192
Chromium by the Peroxydisulfate-Oxidation Titrimetric Method— <i>Discontinued 1980</i>	117–124

¹ These test methods are under the jurisdiction of the ASTM Committee E01 on Analytical Chemistry for Metals, Ores, and Related Materials and are the direct responsibility of Subcommittee E01.01 on Iron, Steel, and Ferroalloys.

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	Sections
Cobalt by the Ion-Exchange— Potentiometric Titration Method	(2 % to 14 %) 52–59
Cobalt by the Nitroso-R-Salt Spectrophotometric Method	(0.10 % to 5.0 %) 60–69
Copper by the Neocuproine Spectrophotometric Method	(0.01 % to 2.00 %) 89–98
Copper by the Sulfide Precipitation- Electrodeposition Gravimetric Method	(0.01 % to 2.0 %) 70–77
Lead by the Ion-Exchange—Atomic Absorption Spectrometry Method	(0.001 % to 0.01 %) 99–108
Manganese by the Periodate Spectrophotometric Method	(0.10 % to 5.00 %) 9–18
Molybdenum by the Ion Exchange— 8-Hydroxyquinoline Gravimetric Method	203–210
Molybdenum by the Thiocyanate Spectrophotometric Method	(0.01 % to 1.50 %) 162–173
Nickel by the Dimethylglyoxime Gravimetric Method	(0.1 % to 4.0 %) 144–151
Phosphorus by the Alkalimetric Method	(0.01 % to 0.05 %) 136–143
Phosphorus by the Molybdenum Blue Spectrophotometric Method	(0.002 % to 0.05 %) 19–29
Silicon by the Gravimetric Method	(0.10 % to 2.50 %) 45–51
Sulfur by the Gravimetric Method— <i>Discontinued 1988</i>	29–35
Sulfur by the Combustion-Iodate Titration Method— <i>Discontinued 2012</i>	36–44
Sulfur by the Chromatographic Gravimetric Method— <i>Discontinued 1980</i>	109–116
Tin by the Solvent Extraction— Atomic Absorption Spectrometry Method	(0.002 % to 0.10 %) 152–161
Vanadium by the Atomic Absorption Spectrometry Method	(0.006 % to 0.15 %) 193–202

1.3 Test methods for the determination of carbon and sulfur not included in this standard can be found in Test Methods **E1019**.

1.4 Some of the composition ranges given in **1.1** are too broad to be covered by a single test method and therefore this standard contains multiple test methods for some elements. The user must select the proper test method by matching the information given in the Scope and Interference sections of each test method with the composition of the alloy to be analyzed.

1.5 The values stated in SI units are to be regarded as standard.

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.* Specific hazards statements are given in Section **6** and in special “Warning” paragraphs throughout these test methods.

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

D1193 Specification for Reagent Water

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E50 Practices for Apparatus, Reagents, and Safety Considerations for Chemical Analysis of Metals, Ores, and Related Materials

E60 Practice for Analysis of Metals, Ores, and Related Materials by Spectrophotometry

E135 Terminology Relating to Analytical Chemistry for Metals, Ores, and Related Materials

E173 Practice for Conducting Interlaboratory Studies of Methods for Chemical Analysis of Metals (Withdrawn 1997)³

E350 Test Methods for Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

E351 Test Methods for Chemical Analysis of Cast Iron—All Types

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.

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

[E353 Test Methods for Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys](#)

[E354 Test Methods for Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys](#)

[E882 Guide for Accountability and Quality Control in the Chemical Analysis Laboratory](#)

[E1019 Test Methods for Determination of Carbon, Sulfur, Nitrogen, and Oxygen in Steel, Iron, Nickel, and Cobalt Alloys by Various Combustion and Inert Gas Fusion Techniques](#)

[E1024 Guide for Chemical Analysis of Metals and Metal Bearing Ores by Flame Atomic Absorption Spectrophotometry \(Withdrawn 2004\)³](#)

[E1601 Practice for Conducting an Interlaboratory Study to Evaluate the Performance of an Analytical Method](#)

[E1806 Practice for Sampling Steel and Iron for Determination of Chemical Composition](#)

2.2 *Other Document:*⁴

[ISO 5725 Precision of Test Methods—Determination of Repeatability and Reproducibility for Inter-Laboratory Tests](#)

3. Terminology

3.1 For definitions of terms used in these test methods, refer to Terminology [E135](#).

4. Significance and Use

4.1 These test methods for the chemical analysis of metals and alloys are primarily intended as referee methods to test such materials for compliance with compositional specifications particularly those under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel, and Related Alloys. It is assumed that all who use these test methods will be trained analysts capable of performing common laboratory procedures skillfully and safely. It is expected that work will be performed in a properly equipped laboratory under appropriate quality control practices such as those described in Guide [E882](#).

5. Apparatus, Reagents, and Instrumental Practices

5.1 *Apparatus*—Specialized apparatus requirements are listed in the “Apparatus” Section in each method.

5.1.1 In the methods specifying spectrophotometric testing, the cells utilized to contain the reference material solutions and sample solutions in spectrophotometers are referred to as “absorption cells”. Please note that the radiant energy passed through the cells can be measured as absorbance or transmittance. These methods refer to absorbance measurements. Refer to Practices [E60](#) for details. <https://standards.iteh.ai/catalog/standards/astm/49232022-80b4-44e3-8066-a12e7d23e7d7/astm-e352-23>

5.2 *Reagents:*

5.2.1 *Purity of Reagents*—~~Reagent grade chemicals shall be used in all tests. Unless otherwise indicated, all reagents used in these test methods shall conform to the “Reagent Grade” Specifications of the American Chemical Society Committee on Analytical Reagents of the American Chemical Society where such specifications are available.~~⁵ Other chemicals may be used, provided it is first ascertained that they are of sufficiently high purity to permit their use without adversely affecting the expected performance of the determination, as indicated in the section on “Precision and Bias.”

5.2.2 *Purity of Water*—Unless otherwise indicated, references to water shall ~~be understood to mean reagent water as conforming to Type I or Type II of Specification~~ [D1193](#). Type III or IV may be used if they effect no measurable change in the blank or sample.

5.3 *Spectrophotometric Practice*—Spectrophotometric practice prescribed in these test methods shall conform to Practice [E60](#).

6. Hazards

6.1 For precautions to be observed in the use of certain reagents and equipment in these methods, refer to Practices [E50](#).

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁵ “Reagent Chemicals, American Chemical Society Specifications,” American Chemical Society, Washington, ~~DC~~-DC, www.acs.org. For suggestions on the testing of Reagents not listed by the American Chemical Society, see the *United States Pharmacopeia and National Formulary*, U.S. Pharmacopeial Convention, Inc. (USPC), Rockville, ~~MD~~-MD, www.usp.org.

7. Sampling

7.1 For procedures to sample the material, refer to Practice **E1806**.

8. Interlaboratory Studies and Rounding Calculated Values

8.1 These test methods have been evaluated in accordance with Practice **E173** (withdrawn 1997) or ISO 5725. Practice **E173** has been replaced by Practice **E1601**. The Reproducibility, R2, of **E173** corresponds to the Reproducibility Index, R, of **E1601**. The Repeatability, R1, of **E173** corresponds to the Repeatability Index, r, of **E1601**.

8.2 Rounding of test results obtained using these test methods shall be performed as directed in ASTM **E29**, Rounding Method, unless an alternative rounding method is specified by the customer or applicable material specification.

MANGANESE BY THE METAPERIODATE SPECTROPHOTOMETRIC METHOD

9. Scope

9.1 This method covers the determination of manganese from 0.10 % to 5.00 %.

10. Summary of Method

10.1 Manganous ions are oxidized to permanganate ions by treatment with periodate. Tungsten when present at compositions greater than 0.5 % is kept in solution with phosphoric acid. Solutions of the samples are fumed with HClO₄ so that the effect of periodate is limited to the oxidation of manganese. Spectrophotometric absorbance measurement is made at 545 nm.

11. Concentration Range

11.1 The recommended concentration range is 0.15 mg to 0.8 mg of manganese per 50 mL of solution, using a 1-cm cell (**Note 1**) and a spectrophotometer with a band width of 10 nm or less.

NOTE 1—This method has been written for cells having a 1-cm light path and a “narrow-band” instrument. The concentration range depends upon band width and spectral region used as well as cell optical path length. Cells having other dimensions may be used, provided suitable adjustments can be made in the amounts of sample and reagents used.

12. Stability of Color

12.1 The color is stable for at least 24 h.

13. Interferences

13.1 HClO₄ treatment, which is used in the procedure, yields solutions which can be highly colored due to the presence of Cr (VI) ions. Although these ions and other colored ions in the sample solution undergo no further change in color quality upon treatment with metaperiodate ion, the following precautions must be observed when filter spectrophotometers are used: Select a filter with maximum transmittance between 545 nm and 565 nm. The filter must transmit not more than 5 % of its maximum at a wavelength shorter than 530 nm. The band width of the filter should be less than 30 nm when measured at 50 % of its maximum transmittance. Similar restrictions apply with respect to the wavelength region employed when other “wide-band” instruments are used.

13.2 The spectral transmittance curve of permanganate ions exhibits two useful minima, one at approximately 526 nm, and the other at 545 nm. The latter is recommended when a “narrow-band” spectrophotometer is used.

13.3 Tungsten, when present in amounts of more than 0.5 % interferes by producing a turbidity in the final solution. A special procedure is provided for use with samples containing more than 0.5 % tungsten which eliminates the problem by preventing the precipitation of the tungsten.

14. Reagents

14.1 *Manganese, Standard Solution* (1 mL = 0.032 mg Mn)—Transfer the equivalent of 0.4000 g of assayed, high-purity manganese (purity: 99.99 % minimum), to a 500-mL volumetric flask and dissolve in 20 mL of HNO₃ by heating. Cool, dilute to volume, and mix. Using a pipet, transfer 20 mL to a 500-mL volumetric flask, dilute to volume, and mix.

14.2 *Nitric-Phosphoric Acid Mixture*—Cautiously, while stirring, add 100 mL of HNO₃ and 400 mL of H₃PO₄ to 400 mL of water. Cool, dilute to 1 L, and mix. Prepare fresh as needed.

14.3 *Potassium Metaperiodate Solution* (7.5 g/L)—Dissolve 7.5 g of potassium metaperiodate (KIO₄) in 200 mL of hot HNO₃ (1 + 1), add 400 mL of H₃PO₄, cool, dilute to 1 L, and mix.

14.4 *Water, Pretreated with Metaperiodate*—Add 20 mL of KIO₄ solution to 1 L of water, mix, heat at not less than 90 °C for 20 min to 30 min, and cool. Use this water to dilute solutions to volume that have been treated with KIO₄ solution to oxidize manganese, and thus avoid reduction of permanganate ions by any reducing agents in the untreated water. (**Caution**—Avoid the use of this water for other purposes.)

15. Preparation of Calibration Curve

15.1 *Calibration Solutions*—Using pipets, transfer 5 mL, 10 mL, 15 mL, 20 mL, and 25 mL of manganese standard solution (1 mL = 0.032 mg Mn) to 50-mL borosilicate glass volumetric flasks, and, if necessary, dilute to approximately 25 mL. Proceed as directed in 15.3.

15.2 *Reference Solution*—Transfer approximately 25 mL of water to a 50-mL borosilicate glass volumetric flask. Proceed as directed in 15.3.

15.3 *Color Development*—Add 10 mL of KIO₄ solution, and heat the solutions at not less than 90 °C for 20 min to 30 min (**Note 2**). Cool, dilute to volume with pretreated water, and mix.

NOTE 2—Immersing the flasks in a boiling water bath is a preferred means of heating them for the specified period to ensure complete color development.

15.4 *Spectrophotometry:*

15.4.1 *Multiple-Cell Spectrophotometer*—Measure the cell correction using the Reference Solution (15.2) in absorption cells with a 1-cm light path and using a light band centered at 545 nm. Using the test cell, take the spectrophotometric absorbance readings of the calibration solutions versus the Reference Solution (15.2)

15.4.2 *Single-Cell Spectrophotometer*—Transfer a suitable portion of the Reference Solution (15.2) to an absorption cell with a 1-cm light path and adjust the spectrophotometer to the initial setting, using a light band centered at 545 nm. While maintaining this adjustment, take the spectrophotometric absorbance readings of the calibration solutions.

15.5 *Calibration Curve*—Follow the instrument manufacturer's instructions for generating the calibration curve. Plot the net spectrophotometric absorbance readings of the calibration solutions against the milligrams of manganese per 50 mL of solution.

16. Procedure

16.1 *Test Solutions*—Select and weigh a sample as follows:

Manganese, %	Sample Mass, g	Tolerance in Sample Mass, mg	Dilution, mL	Aliquot Volume, mL
0.10 to 0.5	0.80	0.5	100	20
0.45 to 1.0	0.35	0.3	100	20
0.85 to 2.0	0.80	0.5	500	20
0.95 to 5.0	0.80	0.5	500	10

Transfer it to a 300-mL Erlenmeyer flask.

16.1.1 *For Samples Containing Not More Than 0.5 % Tungsten:*

16.1.1.1 To dissolve samples that do not require HF, add 8 mL to 10 mL of HCl (1 + 1), and heat. Add HNO₃ as needed to hasten dissolution, and then add 3 mL to 4 mL in excess. When dissolution is complete, cool, then add 10 mL of HClO₄; evaporate to fumes to oxidize chromium, if present, and to expel HCl. Continue fuming until salts begin to separate. Cool, add 50 mL of water, and digest if necessary to dissolve the salts. Cool and transfer the solution to either a 100-mL or 500-mL volumetric flask as indicated in 16.1. Proceed to 16.1.3.

16.1.1.2 For samples whose dissolution is hastened by HF, add 8 mL to 10 mL of HCl (1 + 1), and heat. Add HNO₃ and a few drops of HF as needed to hasten dissolution, and then add 3 mL to 4 mL of HNO₃. When dissolution is complete, cool, then add 10 mL of HClO₄, evaporate to fumes to oxidize chromium, if present, and to expel HCl. Continue fuming until salts begin to separate. Cool, add 50 mL of water, digest if necessary to dissolve the salts, cool, and transfer the solution to either a 100-mL or 500-mL volumetric flask as indicated in 16.1. Proceed to 16.1.3.

16.1.2 *For Samples Containing More Than 0.5 % Tungsten:*

16.1.2.1 To dissolve samples that do not require HF, add 8 mL to 10 mL of H₃PO₄, 10 mL of HClO₄, 5 mL to 6 mL of H₂SO₄, and 3 mL to 4 mL of HNO₃. Heat moderately until the sample is decomposed, and then heat to copious white fumes for 10 min to 12 min or until the chromium is oxidized and the HCl is expelled, but avoid heating to fumes of SO₃. Cool, add 50 mL of water, and digest, if necessary, to dissolve the salts. Transfer the solution to either a 100-mL or 500-mL volumetric flask as directed in 16.1. Proceed to 16.1.3.

16.1.2.2 For samples whose dissolution is hastened by HF, add 8 mL to 10 mL of H₃PO₄, 10 mL of HClO₄, 5 mL to 6 mL of H₂SO₄, 3 mL to 4 mL of HNO₃, and a few drops of HF. Heat moderately until the sample is decomposed, and then heat to copious white fumes for 10 min to 12 min or until the chromium is oxidized and the HCl is expelled, but avoid heating to fumes of SO₃. Cool, add 50 mL of water, digest, if necessary, to dissolve the salts, cool, and transfer the solution to either a 100-mL or 500-mL volumetric flask as directed in 16.1. Proceed to 16.1.3.

16.1.3 Cool the solution to room temperature, dilute to volume, and mix. Allow insoluble matter to settle, or dry-filter through a coarse paper and discard the first 15 mL to 20 mL of the filtrate, before taking aliquots.

16.1.4 Using a pipet, transfer 10 mL to 20 mL aliquots, as specified in 16.1 to two 50-mL borosilicate glass volumetric flasks. Treat one portion as directed in 16.3. Treat the other portion as directed in 16.4.1.

16.2 *Reagent Blank Solution*—Carry a reagent blank through the entire procedure using the same amounts of all reagents with the sample omitted.

16.3 *Color Development*—Proceed as directed in 15.3.

16.4 *Reference Solutions:*

16.4.1 *Background Color Solution*—To one of the sample aliquots in a 50-mL volumetric flask, add 10 mL of nitric-phosphoric acid mixture, and heat the solution at not less than 90 °C for 20 min to 30 min (Note 2). Cool, dilute to volume (with untreated water), and mix.

16.4.2 *Reagent Blank Reference Solution*—Transfer the reagent blank solution (16.2) to the same size volumetric flask as used for the test solutions and transfer the same size aliquots as used for the test solutions to two 50-mL volumetric flasks. Treat one portion as directed in 16.3 and use as reference solution for test samples. Treat the other as directed in 16.4.1 and use as reference solution for Background Color Solutions.

16.5 *Spectrophotometry*—Establish the cell corrections with the Reagent Blank Reference solution to be used as a reference solution for Background Color solutions. Take the spectrophotometric absorbance readings of the Background Color Solutions and the test solutions versus the respective Reagent Blank Reference Solutions as directed in 15.4.

**TABLE 1 Statistical Information—Manganese by the
Metaperiodate Spectrophotometric Method**

Test Specimen	Manganese Found, %	Repeatability (R_1 , E173)	Reproducibility (R_2 , E173)
1. Special W high-speed tool steel (NIST 440, 0.15 Mn)	0.160	0.012	0.035
2. Tool steel (NIST 153a, 0.192 Mn)	0.183	0.005	0.010
3. W high-speed tool steel (NIST 441, 0.27 Mn)	0.268	0.010	0.034
4. Alloy Steel (NIST, 159, a, 0.807 Mn)	0.819	0.010	0.034
5. Low Alloy Steel (NIST 100b, 1.89 Mn)	1.91	0.02	0.04
6. Stainless Steel (NIST 444, 4.62 Mn)	4.60	0.04	0.13

17. Calculation

17.1 Convert the net spectrophotometric absorbance reading of the test solution and of the background color solution to milligrams of manganese by means of the calibration curve. Calculate the percentage of manganese as follows:

$$\text{Manganese, \%} = (A - B)/(C \times 10) \quad (1)$$

where:

- A = manganese, mg, found in 50 mL of the final test solution,
- B = apparent manganese, mg, found in 50 mL of the final background color solution, and
- C = sample mass, g, represented in 50 mL of the final test solution.

18. Precision and Bias

18.1 *Precision*—Nine laboratories cooperated in testing this method and obtained the data summarized in [Table 1](#).

18.2 *Bias*—The accuracy of this test method has been deemed satisfactory based upon the data for the certified reference materials in [Table 1](#). Users are encouraged to use these or similar reference materials to verify that the test method is performing accurately in their laboratories.

PHOSPHORUS BY THE MOLYBDENUM BLUE SPECTROPHOTOMETRIC METHOD

19. Scope

19.1 This test method covers the determination of phosphorus from 0.002 % to 0.05 %.

20. Summary of Method

20.1 The sample is dissolved in mixed acids and the solution is fumed with HClO_4 . Ammonium molybdate is added to react with the phosphorus to form the heteropoly phosphomolybdate. This species is then reduced with hydrazine sulfate to form the molybdenum blue complex. Spectrophotometric absorbance measurement is made at 650 nm or 825 nm, depending upon the concentration.

21. Concentration Range

21.1 The recommended concentration range is from 0.005 mg to 0.05 mg of phosphorus per 100 mL of solution when measured at 825 nm and from 0.05 mg to 0.3 mg of phosphorus per 100 mL of solution when measured at 650 nm, using a 1-cm cell.

NOTE 3—This test method has been written for cells having a 1-cm light path. Cells having other dimensions may be used, provided suitable adjustments can be made in the amounts of sample and reagents used.

22. Stability of Color

22.1 The molybdenum blue complex is stable for at least 2 h.

23. Interferences

23.1 None of the elements usually present interfere except arsenic which is removed by volatilization as the bromide. The interference of tungsten at compositions greater than 0.5 % is avoided by proceeding directly with a small sample mass rather than an aliquot portion of a larger sample.

24. Apparatus

24.1 Glassware must be phosphorus- and arsenic-free. Boil the glassware with HCl and rinse with water before use. It is recommended that the glassware used for this determination be reserved for this use only. Many detergents contain phosphorus and must not be used for cleaning purposes.

25. Reagents

25.1 *Ammonium Molybdate Solution* (20 g/L)—Cautiously, while stirring and cooling, add 300 mL of H₂SO₄ to 500 mL of water and cool. Add 20 g of ammonium heptamolybdate ((NH₄)₆Mo₇O₂₄·4H₂O), cautiously dilute to 1 L, and mix.

25.2 *Ammonium Molybdate-Hydrazine Sulfate Solution*—Dilute 250 mL of the ammonium molybdate solution to 600 mL, add 100 mL of the hydrazine sulfate solution, dilute to 1 L, and mix. Do not use a solution that has stood for more than 1 h.

25.3 *Hydrazine Sulfate Solution* (1.5 g/L)—Dissolve 1.5 g of hydrazine sulfate ((NH₂)₂·H₂SO₄) in water, dilute to 1 L, and mix. Discard any unused solution after 24 h.

25.4 *Phosphorus Standard Solution A* (1 mL = 1.0 mg P)—Transfer 2.292 g of anhydrous disodium hydrogen phosphate (Na₂HPO₄), previously dried to constant mass at 105 °C, to a 500-mL volumetric flask; dissolve in about 100 mL of water, dilute to volume, and mix.

25.5 *Phosphorus Standard Solution B* (1 mL = 0.01 mg P)—Using a pipet, transfer 10 mL of Solution A (1 mL = 1.0 mg P) to a 1-L volumetric flask, add 50 mL of HClO₄ (1 + 5), dilute to volume, and mix.

25.6 *Phosphorus Standard Solution C* (1 mL = 0.10 mg P)—Using a pipet, transfer 50 mL of Solution A (1 mL = 1.0 mg P) to a 500-mL volumetric flask, add 50 mL of HClO₄ (1 + 5), dilute to volume, and mix.

25.7 *Sodium Sulfite Solution* (100 g/L)—Dissolve 100 g of sodium sulfite (Na₂SO₃) in water, dilute to 1 L, and mix.

26. Preparation of Calibration Curve for Concentrations from 0.005 mg/100 mL to 0.05 mg/100 mL

26.1 *Calibration Solutions*—Using pipets, transfer 5 mL, 10 mL, 15 mL, 25 mL, and 50 mL of Phosphorus Standard Solution B (1 mL = 0.01 mg P) to 100-mL volumetric flasks. Add 20 mL of HClO₄, dilute to volume, and mix. Using a pipet, transfer 10 mL of each solution to a 100-mL borosilicate glass volumetric flask. Proceed as directed in 26.3.

26.2 *Reagent Blank*—Transfer 12 mL of HClO₄ (1 + 5) to a 100-mL borosilicate glass volumetric flask.

26.3 Color Development:

26.3.1 Add 15 mL of Na₂SO₃ solution, boil gently for 30 s, and add 50 mL of ammonium molybdate-hydrazine sulfate solution that has been prepared within the hour.

26.3.2 Heat the solutions at not less than 90 °C for 20 min, quickly cool, dilute to volume, and mix.

NOTE 4—Immersing the flasks in a boiling water bath is the preferred means of heating them for complete color development.

26.4 *Reference Solution*—Water.

26.5 *Spectrophotometry*:

26.5.1 *Multiple-Cell Spectrophotometer*—Measure the reagent blank (which includes the cell correction) versus the reference solution (26.4) using absorption cells with a 1-cm light path and using a light band centered at 825 nm. Using the test cell, take the spectrophotometric absorbance readings of the calibration solutions versus the reference solution.

26.5.2 *Single-Cell Spectrophotometer*—Transfer a suitable portion of the reference solution (26.4) to an absorption cell with a 1-cm light path and adjust the spectrophotometer to the initial setting using a light band centered at 825 nm. While maintaining this adjustment, take the spectrophotometric absorbance readings of the reagent blank solution and of the calibration solutions.

26.6 *Calibration Curve*—Follow the instrument manufacturer's instructions for generating the calibration curve. Plot the net spectrophotometric absorbance readings of the calibration solutions against the milligrams of phosphorus per 100 mL of solution.

27. Procedure

27.1 *For Samples Containing Less Than 0.5 % Tungsten*:

27.1.1 *Test Solution*:

27.1.1.1 Transfer a 1.0-g sample, weighed to the nearest 0.5 mg, to a 250-mL Erlenmeyer flask.

27.1.1.2 Add 15 mL of a freshly prepared mixture of 1 volume of HNO₃ and 3 volumes of HCl, slowly and in small portions. When the reaction has ceased, add 10 mL of HClO₄ and evaporate to fumes. Remove the flask immediately to avoid undue loss of HClO₄, cool, and add 20 mL of HBr (1 + 4). Evaporate the solution to copious white fumes and then, without delay, fume strongly enough to cause the white fumes to clear the neck of the flask, and continue at this rate for 1 min.

27.1.1.3 Cool the solution, add 60 mL of HClO₄ (1 + 5), and swirl to dissolve the salts. Transfer to a 100-mL volumetric flask, cool, dilute to volume, and mix. Allow insoluble matter to settle or dry filter the solution. Using a pipet, transfer 10-mL portions to two 100-mL borosilicate glass volumetric flasks; treat one as directed in 27.1.3 and the other as directed in 27.1.4.2.

27.1.2 *Reagent Blank Solution*—Carry a reagent blank through the entire procedure using the same amount of all reagents with the sample omitted.

27.1.3 *Color Development*—Proceed with one of the 10-mL portions obtained in 27.1.1.3, as directed in 26.3.

27.1.4 *Reference Solutions*:

27.1.4.1 *Water*—Use this as the reference solution for the reagent blank solution.

27.1.4.2 *Background Color Reference Solution*—Add 15 mL of Na₂SO₃ solution to the second 10-mL portion obtained in 27.1.1.3. Boil gently for 30 s, add 50 mL of H₂SO₄ (3 + 37), cool, dilute to volume, and mix. Use this as the reference solution for the test solution.

27.1.5 *Spectrophotometry*—Take the spectrophotometric absorbance readings of the reagent blank solution and of the test solution (using the respective reference solutions) as directed in 26.5.

27.2 *For Samples Containing More Than 0.5 % Tungsten*:

27.2.1 *Test Solution*:

27.2.1.1 Transfer 0.100-g samples, weighed to the nearest 0.1 mg, to two 100-mL Erlenmeyer flasks.

27.2.1.2 Add 5 mL of a mixture of 1 volume of HNO₃ and 3 volumes of HCl. When the reaction has ceased, add 2.5 mL of HClO₄

and 5 mL of HBr (1 + 4). Evaporate the solutions to copious white fumes; then, without delay, fume strongly enough to cause the white fumes to clear the neck of the flasks, and continue at this rate for 1 min.

27.2.1.3 Cool the solutions, and add 10 mL of water. Filter through a 9-cm fine paper collecting the filtrate in a 100-mL borosilicate glass volumetric flask. Wash the paper and insoluble matter 5 times with 3-mL portions of water. Treat one solution as directed in 27.2.3 and the other as directed in 27.2.4.

27.2.2 *Reagent Blank Solution*—Proceed as directed in 27.2.1.2 and 27.2.1.3.

27.2.3 *Color Development*—Proceed as directed in 26.3.

27.2.4 *Reference Solutions*:

27.2.4.1 *Water*—Use this as the reference solution for the reagent blank solution.

27.2.4.2 *Background Color Reference Solution*—Add 15 mL of Na₂SO₃ solution to the second 10-mL portion obtained in 27.2.1.3. Boil gently for 30 s, add 50 mL of H₂SO₄ (3 + 37), cool, dilute to volume, and mix. Use this as the reference solution for the test solution.

27.2.5 *Spectrophotometry*—Proceed as directed in 27.1.5.

28. Calculation

28.1 Convert the net spectrophotometric absorbance reading of the test solution and of the reagent blank solution to milligrams of phosphorus by means of the appropriate calibration curve. Calculate the percent of phosphorus as follows:

$$\text{Phosphorus, \%} = (A - B)(C \times 10) \quad (2)$$

where:

A = phosphorus found in 100 mL of the final test solution, mg,

B = phosphorus found in 100 mL of the final reagent blank solution, mg, and

C = sample represented in 100 mL of the final test solution, g.

29. Precision and Bias

29.1 *Precision*—Eight laboratories cooperated in testing this method and obtained the data summarized in Table 2.

29.2 *Bias*—The accuracy of this test method has been deemed satisfactory based upon the data for the certified reference materials in Table 2. Users are encouraged to use these or similar reference materials to verify that the test method is performing accurately in their laboratories.

TABLE 2 Statistical Information—Phosphorus – Molybdenum Blue – Spectrophotometric Method

Test Specimen	Phosphorus Found, %	Repeatability (<i>R</i> ₁ , E173)	Reproducibility (<i>R</i> ₂ , E173)
1. Tool steel 5Mo-6W-4Cr-2V (NIST 132a, 0.029 P)	0.029	0.011	0.008
2. Tool steel 8Co-9Mo-2W-4Cr-2V (NIST 153a, 0.023 P)	0.023	0.008	0.007
3. Tool steel 18W-4Cr-1V (NIST 50c, 0.022 P)	0.022	0.005	0.007

SULFUR BY THE GRAVIMETRIC METHOD

(This method, which consisted of Sections 29 through 35 of this standard, was discontinued in 1988.)

SULFUR BY THE COMBUSTION-IODATE TITRATION METHOD

(This method, which consisted of Sections 36 through 44 of this standard, was discontinued in 2012.)

SILICON BY THE GRAVIMETRIC METHOD

45. Scope

45.1 This method covers the determination of silicon from 0.10 % to 2.50 %.

46. Summary of Method

46.1 After dissolution of the sample, silicic acid is dehydrated by fuming with H_2SO_4 or HClO_4 . The solution is filtered, and the impure silica is ignited and weighed. The silica is then volatilized with HF. The residue is ignited and weighed; the loss in mass represents silica.

47. Interferences

47.1 The elements normally present do not interfere if their compositions are under the maximum limits shown in 1.1.

48. Reagents

48.1 The analyst should ensure by analyzing blanks and other checks that possible silicon contamination of reagents will not significantly bias the results.

48.2 Perchloric Acid (HClO_4):

48.2.1 Select a lot of HClO_4 that contains not more than 0.0002 % silicon for the analysis of samples containing silicon in the range from 0.02 % to 0.10 % and not more than 0.0004 % silicon for samples containing more than 0.10 % by determining duplicate values for silicon as directed in 48.2.2 – 48.2.6.

48.2.2 Transfer 15 mL of HClO_4 (Note 5) to each of two 400-mL beakers. To one of the beakers transfer an additional 50 mL of HClO_4 . Using a pipet, transfer 20 mL of Na_2SiO_3 solution (1 mL = 1.00 mg Si) to each of the beakers. Evaporate the solutions to fumes and heat for 15 min to 20 min at such a rate that HClO_4 refluxes on the sides of the beakers. Cool sufficiently, and add 100 mL of water (40 °C to 50 °C).

NOTE 5—The 15-mL addition of HClO_4 can be from the same lot as the one to be tested. Once a lot has been established as having less than 0.0002 % silicon, it should preferably be used for the 15-mL addition in all subsequent tests of other lots of acid.

48.2.3 Add paper pulp and filter immediately, using low-ash 11-cm medium-porosity filter papers. Transfer the precipitates to the papers, and scrub the beakers thoroughly with a rubber-tipped rod. Wash the papers and precipitates alternately with 3 mL to 5 mL portions of hot HCl (1 + 19) and hot water, for a total of 6 times. Finally wash the papers twice with H_2SO_4 (1 + 49). Transfer the papers to platinum crucibles.

48.2.4 Dry the papers and heat at 600 °C until the carbon is removed. Finally ignite at 1100 °C to 1150 °C to constant mass (at least 30 min). Cool in a desiccator and weigh.

48.2.5 Add enough H_2SO_4 (1 + 1) to moisten the SiO_2 , and add 3 mL to 5 mL of HF. Evaporate to dryness and then heat at a gradually increasing rate until H_2SO_4 is removed. Ignite for 15 min at 1100 °C to 1150 °C, cool in a desiccator, and weigh.

48.2.6 Calculate the percent of silicon as follows:

$$\text{Silicon, \%} = [(A - B) - (C - D)] \times 0.4674E \times 100 \quad (3)$$

where:

- A = initial mass of crucible plus impure SiO₂ when 65 mL of HClO₄ was taken, g,
- B = final mass of crucible plus impurities when 65 mL of HClO₄ was taken, g,
- C = initial mass of crucible plus impure SiO₂ when 15 mL of HClO₄ was taken, g,
- D = final mass of crucible plus impurities when 15 mL of HClO₄ was taken, g, and
- E = nominal mass (80 g) of 50 mL of HClO₄.

48.3 *Sodium Silicate Solution*—Transfer 11.0 g of sodium silicate (Na₂SiO₃·9H₂O) to a 400-mL beaker. Add 150 mL of water and dissolve the salt. Filter through a medium paper, collecting the filtrate in a 1-L volumetric flask, dilute to volume, and mix. Store in a polyethylene bottle. Use this solution to determine the suitability of the HClO₄.

48.4 *Tartaric Acid Solution* (20.6 g/L)—Dissolve 20.6 g of tartaric acid (C₄H₆O₆) in water, dilute to 1 L, and filter.

48.5 *Water*—Use freshly prepared Type II water known to be free of silicon. Water distilled from glass, demineralized in columns containing silicon compounds, or stored for extended periods in glass, or combination thereof, has been known to absorb silicon.

49. Procedure

49.1 Select and weigh a sample as follows:

Silicon, %	Sample Mass, g	Tolerance in Sample Mass, mg	Dehydrating Acid, mL	
			H ₂ SO ₄ (1 + 4)	HClO ₄
0.1 to 0.1	4.0	4	150	60
1.0 to 1.75	3.0	3	100	50
1.75 to 2.50	2.0	2	100	40

Transfer it to a 400-mL beaker or a 300-mL porcelain casserole. Proceed as directed in 49.2 if tungsten is greater than 0.5% or if tungsten is less than 0.5%, proceed as directed in 49.2 or 49.3.

<https://standards.iteh.ai/catalog/standards/astm/49232022-80b4-44e3-8066-a12e7d23e7d7/astm-e352-23>
 49.2 *Sulfuric Acid Dehydration* (H₂SO₄):

49.2.1 Add amounts of HCl or HNO₃, or mixtures and dilutions of these acids, that are sufficient to dissolve the sample; and then add the H₂SO₄ (1 + 4) as specified in 49.1, and cover. Heat until dissolution is complete. Remove and rinse the cover glass; substitute a ribbed cover glass.

49.2.2 Evaporate until salts begin to separate; at this point evaporate the solution rapidly to the first appearance of fumes and fume strongly for 2 min to 3 min. Cool sufficiently, and add 100 mL of water (40 °C to 50 °C). Stir to dissolve the salts and heat, if necessary, but do not boil. Proceed immediately as directed in 49.4.

49.3 *Perchloric Acid* (HClO₄) *Dehydration*:

49.3.1 Add amounts of HCl or HNO₃, or mixtures and dilutions of these acids, which are sufficient to dissolve the sample, and cover. Heat until dissolution is complete. Add HNO₃ to provide a total of 35 mL to 40 mL, followed by HClO₄ as specified in the table in 49.1. Remove and rinse the cover glass; substitute a ribbed cover glass.

49.3.2 Evaporate the solution to fumes and heat for 15 min to 20 min at such a rate that the HClO₄ refluxes on the sides of the container. Cool sufficiently and add 100 mL of water (40 °C to 50 °C). Stir to dissolve the salts and heat to boiling. If the sample solution contains more than 100 mg of chromium, add, while stirring, 1 mL of tartaric acid solution for each 25 mg of chromium.

49.4 Add paper pulp and filter immediately, on a low-ash 11-cm medium-porosity filter paper. Collect the filtrate in a 600-mL beaker. Transfer the precipitate to the paper, and scrub the container thoroughly with a rubber-tipped rod. Wash the paper and precipitate alternately with 3 mL to 5 mL portions of hot HCl (1 + 19) and hot water until iron salts are removed but for not more

than a total of ten washings. If the HClO₄ dehydration method was followed, wash the paper twice more with H₂SO₄ (1 + 49), but do not collect these washings in the filtrate; discard the washings. Transfer the paper to a platinum crucible and reserve.

49.5 Add 15 mL of HNO₃ to the filtrate, stir, and evaporate in accordance with either 49.2 or 49.3, depending upon the dehydrating acid used. Filter immediately, using a low-ash, 9-cm 100-porosity filter paper, and wash as directed in 49.4.

49.6 Transfer the paper and precipitate to the reserved platinum crucible. Dry the papers and then heat the crucible at 600 °C until the carbon is removed. Finally ignite at 1100 °C to 1150 °C to constant mass (at least 30 min). Cool in a desiccator and weigh.

49.7 Add enough H₂SO₄ (1 + 1) to moisten the impure SiO₂, and add 3 mL to 5 mL of HF. Evaporate to dryness and then heat at a gradually increasing rate until H₂SO₄ is removed. Ignite at 1100 °C to 1150 °C for 15 min, cool in a desiccator, and weigh. If the sample contains more than 0.5 % tungsten, ignite at 750 °C instead of 1100 °C to 1150 °C after volatilization of SiO₂.

50. Calculation

50.1 Calculate the percent of silicon as follows:

$$\text{Silicon, \%} = [(A - B) \times 0.4674]C \times 100 \quad (4)$$

where:

A = initial mass of crucible and impure SiO₂, g,

B = final mass of crucible and residue, g, and

C = sample used, g.

51. Precision and Bias

51.1 *Precision*—Eleven laboratories cooperated in testing this method and obtained the data summarized in Table 3. Samples with tungsten below 0.5 % were not available for testing the HClO₄ dehydration procedure; neither were samples available with tungsten greater than 0.5 % for testing the H₂SO₄ dehydration procedure near the upper limit of the scope.

51.2 *Bias*—Either this method has no bias, or this method is subject to bias under certain sample conditions. Only one certified reference material was available for testing during the interlaboratory study, see Table 3. The user of this method is encouraged to utilize accepted reference materials, if available, to determine the presence or absence of bias.

COBALT BY THE ION-EXCHANGE—POTENTIOMETRIC TITRATION METHOD

52. Scope

52.1 This method covers the determination of cobalt from 2 % to 14 %.

53. Summary of Method

53.1 Cobalt is separated from interfering elements by selective elution from an anion-exchange column using HCl. The cobalt is oxidized to the trivalent state with ferricyanide, and the excess ferricyanide is titrated potentiometrically with cobalt solution.

TABLE 3 Statistical Information—Silicon – Gravimetric Method

Test Specimen	Silicon Found, %	Repeatability (<i>R</i> ₁ , E173)	Reproducibility (<i>R</i> ₂ , E173)
H ₂ SO ₄ Dehydration			
1. Tool steel 5Mo-6W-4Cr-2V (NIST 132a, 0.19 Si)	0.193	0.019	0.031

54. Interferences

54.1 The elements normally present do not interfere if their compositions are under the maximum limits shown in 1.1.

55. Apparatus

55.1 *Ion-Exchange Column*, approximately 25 mm in diameter and 300 mm in length, tapered at one end, and provided with a stopcock to control the flow rate, and a second, lower stopcock to stop the flow. A Jones Reductor (Fig. 1) may be adapted to this method. A reservoir for the eluants may be added at the top of the column.

55.2 *pH meter*, with a platinum and a saturated calomel electrode.

56. Reagents

56.1 *Ammonium Citrate Solution* (200 g/l)—Dissolve 200 g of di-ammonium hydrogen citrate in water and dilute to 1 L.

56.2 *Bromine*

56.3 *Cobalt, Standard Solution* (1mL = 1.5 mg of Co):

56.3.1 *Preparation*—Dry a weighing bottle in an oven at 130 °C for 1 h, cool in a desiccator, and weigh. Transfer 3.945 g of cobalt sulfate (CoSO₄)⁶ that has been heated at 550 °C for 1 h to the weighing bottle. Dry the bottle and contents at 130 °C for 1 h, cool in desiccator, stopper the bottle, and weigh. The difference in mass is the amount of CoSO₄ taken. Transfer the weighed CoSO₄ to a 400-mL beaker, rinse the weighing bottle with water, and transfer the rinsings to the beaker. Add 150 mL of water and 20 mL of HNO₃, and heat to dissolve the salts. Cool, transfer to a 1-L volumetric flask, dilute to volume, and mix.

56.3.2 *Standardization*—Calculate the cobalt concentration as follows:

$$\text{Cobalt, mg/mL} = \text{mass of CoSO}_4, \text{ g} \times 0.38026 \tag{5}$$

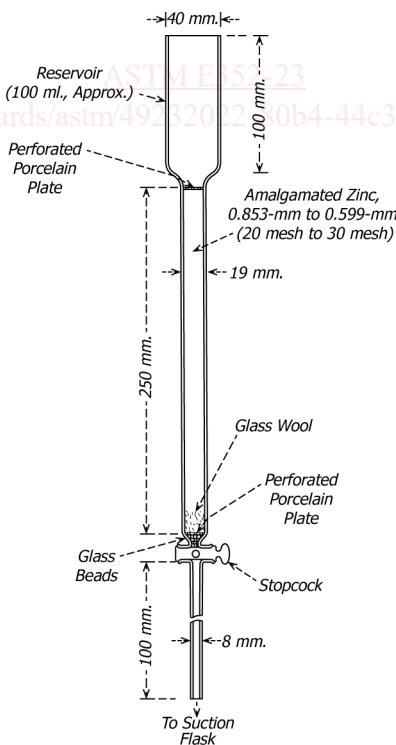


FIG. 1 Jones Reductor

⁶ Cobalt sulfate (99.9 % minimum) prepared from the hexamine salt by G. Frederick Smith Chemical Co., Columbus, OH, is satisfactory for this purpose.