



Designation: B691 – 18 (Reapproved 2024)

Standard Specification for Iron-Nickel-Chromium-Molybdenum Alloy (UNS N08367) Rod, Bar, and Wire¹

This standard is issued under the fixed designation B691; 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

1.1 This specification covers iron-nickel-chromium-molybdenum alloy (UNS N08367)² in the form of hot-finished and cold-finished rounds, squares, hexagons, octagons, and rectangles.

1.2 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.

1.3 The following safety hazards caveat pertains only to the test methods portion, Section 12, of this specification: *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, health, and environmental practices, and determine the applicability of regulatory limitations prior to use.*

1.4 *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:*³

[B880 Specification for General Requirements for Chemical Check Analysis Limits for Nickel, Nickel Alloys and Cobalt 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.

Current edition approved April 1, 2024. Published May 2024. Originally approved in 1981. Last previous edition approved in 2018 as B691 – 18. DOI: 10.1520/B0691-24.

² Designation established in accordance with ASTM E527 and SAE J1086, Practice for Numbering Metals and Alloys.

³ 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.

[E8/E8M Test Methods for Tension Testing of Metallic Materials](#)

[E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)

[E1473 Test Methods for Chemical Analysis of Nickel, Cobalt, and High-Temperature Alloys](#)

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 The terms rod, bar, and wire, as used in this specification, are described as follows:

3.1.2 *bar, n*—hot-finished or cold-finished material of round, square, hexagon, octagon, or rectangular solid section in straight lengths.

3.1.3 *rod, n*—hot-finished material of round, square, hexagon, octagon, or rectangular solid section furnished in coils for subsequent cold drawing into finished products.

3.1.4 *wire, n*—cold-finished material of round, square, hexagon, octagon, or rectangle solid section furnished in coils.

4. Ordering Information

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

4.1.1 Quantity (feet, meters, or number of pieces),

4.1.2 Form (rod, bar, wire),

4.1.3 Name of material or UNS number,

4.1.4 Finish (see 8.2),

4.1.5 Dimensions, including length,

4.1.6 Purchaser's inspection, if required (Section 13),

4.1.7 ASTM designation and year of issue, and

4.1.8 Samples for product analysis, if required.

5. Chemical Composition

5.1 The material shall conform to the composition limits specified in [Table 1](#).

5.2 If a product (check) analysis is made by the purchaser, the material shall conform to the permissible variations for product (check) analysis in Specification [B880](#).



TABLE 1 Chemical Requirements

Element	Composition Limits, %	
	N08367	
Carbon	0.030 max	
Manganese	2.00 max	
Silicon	1.00 max	
Phosphorus	0.040 max	
Sulfur	0.030 max	
Chromium	20.00 to 22.00	
Nickel	23.50 to 25.50	
Molybdenum	6.00 to 7.00	
Nitrogen	0.18 to 0.25	
Iron ^A	remainder	
Copper	0.75 max	

^A Iron shall be determined arithmetically by difference.

6. Mechanical Properties and Other Requirements

6.1 The material shall conform to the mechanical property requirements specified in Table 2.

7. Dimensions and Permissible Variations

7.1 Size:

7.1.1 *Rounds*—The permissible variations in size of cold-finished round shall be as given in Table 3. For hot-finished round bars and rod, they shall be as given in Table 4.

7.1.2 *Squares*—The permissible variations in size of cold-finished square bars shall be as given in Table 5. For hot-finished square bars and rods, they shall be as given in Table 4.

7.1.3 *Hexagons and Octagons*—The permissible variations in size of cold-finished hexagons and octagons shall be as given in Table 5. For hot-finished bar and rod hexagons and octagons they shall be as given in Table 6.

7.1.4 *Flats (Rectangles)*—The permissible variations in width and thickness of cold-finished flats shall be as given in Table 7 for bars and for wire in Table 8. For hot-finished flat bars and rods, the tolerances for width and thickness shall be as given in Table 9.

7.2 *Out-of-Round*—Hot-finished rounds and cold-finished rounds (except forging quality), all sizes, in straight lengths, shall not be out-of-round by more than shown in Table 4 and Table 3.

7.3 *Corners*—Cold-finished squares, rectangles, hexagons and octagons will have equal angles and sharp corners.

TABLE 2 Mechanical Properties

	Cold-Finished-Annealed and Hot-Finished-Annealed (All Sizes)	Forging Quality (All Sizes)
	N08367	N08367
Tensile strength, min, ksi (MPa)	95 (655)	^A
Yield strength, 0.2 % offset, min, ksi (MPa)	45 (310)	^A
Elongation in 2 in. or 50 mm, or 4D, min, %	30	^A

^A No tensile properties are required on forging quality.

TABLE 3 Permissible Variations in Diameter Cold-Finished Round Bars and Wire

Specified Diameter, in. (mm)	Diameter tolerance, in. (mm) ^{A,B,C}	
	Plus and Minus	
0.0030 (0.076) to 0.0048 (0.122), excl	0.0001 (0.003)	
0.0048 (0.122) to 0.0080 (0.203), excl	0.0002 (0.005)	
0.0080 (0.203) to 0.0120 (0.305), excl	0.0003 (0.008)	
0.0120 (0.305) to 0.0240 (0.610), excl	0.0004 (0.010)	
0.0240 (0.610) to 0.0330 (0.838), excl	0.0005 (0.013)	
0.0330 (0.838) to 0.0440 (1.118), excl	0.0008 (0.020)	
0.0440 (1.118) to 0.3125 (7.938), excl	0.001 (0.03)	
0.3125 (7.938) to 0.5000 (12.700), excl	0.0015 (0.038)	
0.5000 (12.700) to 1.000 (25.4), excl	0.002 (0.05)	
1.000 (25.4) to 1.500 (38.1), excl	0.0025 (0.06)	
1.500 (38.1) to 4.000 (101.6), incl	0.003 (0.08)	

^A Diameter tolerances are over and under as shown in the above table. Also, rounds can be produced to tolerances all over and nothing under, or all under and nothing over, or any combination of over and under, if the total spread in diameter tolerance for a specified diameter is not less than the total spread shown in the table.

^B The maximum out-of-round tolerance for round wire is one-half of the total size tolerance shown in the above table.

^C When it is necessary to heat treat or heat treat and pickle after cold finishing, size tolerances are double those shown in the table for sizes 0.0240 in. (0.610 mm) and over.

7.4 *Machining Allowances*—When the surfaces of hot-finished material are to be machined, the allowances given in Table 10 are recommended for normal machining operations.

7.5 Length:

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

7.5.2 When bars are ordered in multiple lengths, ¼ in. (6.4 mm) will be allowed for each multiple cut, unless otherwise specified.

7.5.3 The permissible variations in length of hot or cold-finished bars shall be as specified in Table 11 or Table 12 depending upon whether or not the material is specified to be machine-cut after straightening.

7.6 Ends:

7.6.1 Bars ordered to random or nominal lengths will be furnished with either cropped or saw-cut ends.

7.6.2 Bars ordered to cut lengths will be furnished with square saw-cut or machine cut ends.

7.7 Straightness:

7.7.1 The permissible variations in straightness of cold-finished bars shall be as specified in Table 13.

7.7.2 The permissible variations in straightness of hot-finished bars shall be as specified in Table 13.

8. Workmanship, Finish, and Appearance

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

8.2 Finishes available include hot-rolled, hot rolled-annealed-descaled, cold-drawn, ground, turned, and machined.

9. Sampling

9.1 Lot Definition:

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



TABLE 4 Permissible Variations in Size of Hot-Finished Round and Square Bars and Rods

Specified size, in. (mm)	Permissible Variations from Specified Size, in. (mm)		Out-of-Round ^A or Out-of-Square, ^B in. (mm)
	Plus	Minus	
¼ (6.4) to ⅝ (7.9), incl	0.005 (0.13)	0.005 (0.13)	0.008 (0.20)
Over ⅝ (7.9) to ⅞ (11.1), incl	0.006 (0.15)	0.006 (0.15)	0.009 (0.23)
Over ⅞ (11.1) to ⅞ (15.9), incl	0.007 (0.18)	0.007 (0.18)	0.010 (0.25)
Over ⅞ (15.9) to ⅞ (22.2), incl	0.008 (0.20)	0.008 (0.20)	0.012 (0.30)
Over ⅞ (22.2) to 1 (25.4), incl	0.009 (0.23)	0.009 (0.23)	0.013 (0.33)
Over 1 (25.4) to 1⅛ (28.6), incl	0.010 (0.25)	0.010 (0.25)	0.015 (0.38)
Over 1⅛ (28.6) to 1¼ (31.8), incl	0.011 (0.28)	0.011 (0.28)	0.016 (0.41)
Over 1¼ (31.8) to 1⅝ (34.9), incl	0.012 (0.30)	0.012 (0.30)	0.018 (0.46)
Over 1⅝ (34.9) to 1½ (38.1), incl	0.014 (0.36)	0.014 (0.36)	0.021 (0.53)
Over 1½ (38.1) to 2 (50.8), incl	⅙ ₆₄ (0.4)	⅙ ₆₄ (0.4)	0.023 (0.58)
Over 2 (50.8) to 2½ (63.5), incl	⅙ ₃₂ (0.8)	0	0.023 (0.58)
Over 2½ (63.5) to 3 (88.9), incl	⅙ ₆₄ (1.2)	0	0.035 (0.89)
Over 3 (88.9) to 4 (114.3), incl	⅙ ₁₆ (1.6)	0	0.046 (1.17)
Over 4 (114.3) to 5 (139.7), incl	⅙ ₆₄ (2.0)	0	0.058 (1.47)
Over 5 (139.7) to 6 (165.1), incl	⅙ ₈ (3.2)	0	0.070 (1.78)
Over 6 (165.1) to 8 (203.2), incl	⅙ ₃₂ (4.0)	0	0.085 (2.16)

^A Out-of-round is the difference between the maximum and minimum diameters of the bar, measured at the same cross section.

^B Out-of-square section is the difference in the two dimensions at the same cross section of a square bar, each dimension being the distance between opposite faces.

TABLE 5 Permissible Variations in Distance Between Parallel Surfaces of Cold Finished Hexagonal, Octagonal, and Square Bars and Wire

Specified Size, in. (mm)	Permissible Variations from Specified Size, in. (mm) ^A	
	Plus	Minus
0.125 (3.18) to 0.3125 (7.938), excl	0	0.002 (0.05)
0.3125 (7.938) to 0.500 (12.70), excl	0	0.003 (0.08)
0.500 (12.70) to 1.000 (25.40), incl	0	0.004 (0.10)
Over 1 (25.40) to 2 (50.80), incl	0	0.006 (0.15)
Over 2 (50.80) to 3 (76.20), incl	0	0.008 (0.20)
Over 3 (76.20)	0	0.010 (0.25)

^A When it is necessary to heat treat or heat treat and pickle after cold finishing, size tolerances are double those shown in the table.

TABLE 6 Permissible Variations in Size of Hot-Finished Hexagonal and Octagonal Bars and Rods

Specified Sizes Measured Between Opposite Sides, in. (mm)	Permissible Variations from Specified Size, in. (mm)		Maximum Difference, in. (mm), 3 Measure- ments for Hexagons Only
	Plus	Minus	
¼ to ½ (6.4 to 12.7), incl	0.007 (0.18)	0.007 (0.18)	0.011 (0.28)
Over ½ to 1 (12.7) to (25.4), incl	0.010 (0.25)	0.010 (0.25)	0.015 (0.38)
Over 1 (25.4) to 1½ (38.1), incl	0.021 (0.53)	0.021 (0.53)	0.025 (0.64)
Over 1½ (38.1) to 2 (50.8), incl	⅙ ₃₂ (0.8)	⅙ ₃₂ (0.8)	⅙ ₃₂ (0.8)
Over 2 (50.8) to 2½ (63.5), incl	⅙ ₆₄ (1.2)	⅙ ₆₄ (1.2)	⅙ ₆₄ (1.2)
Over 2½ (63.5) to 3 (88.9), incl	⅙ ₁₆ (1.6)	⅙ ₁₆ (1.6)	⅙ ₁₆ (1.6)

9.1.2 Lots for mechanical testing shall consist of the material from one heat, in the same condition (temper), and of the same specified size (excepting length) and cross-section.

9.2 Test Material Selection:

9.2.1 Sampling for Chemical Analysis:

9.2.1.1 An analysis of each lot shall be made by the manufacturer from a representative sample obtained during the pouring of the heat or subsequent processing.

9.2.1.2 If samples for product (check) analysis are specified, a representative sample shall be taken from each lot of finished material.

9.2.2 Sampling for Mechanical Testing—Samples of the material to provide test specimens for mechanical testing shall be taken from such locations in each lot (see 9.1.2) as to be representative of that lot.

10. Number of Tests and Retests

10.1 Chemical Analysis—One test per lot.

10.2 Mechanical Tests and 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, an additional