



Standard Specification for Steel, Sheet, Cold-Rolled, Carbon, Structural, High-Strength Low-Alloy and High-Strength Low-Alloy with Improved Formability¹

This standard is issued under the fixed designation A 1008/A 1008M; 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 cold-rolled structural, high-strength low-alloy, and high-strength low-alloy with improved formability steel sheet, in coils and cut lengths.

1.2 Cold rolled steel sheet is available in the designations as listed in 4.1.

1.3 This specification does not apply to steel strip as described in Specification A 109.

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 are not exact equivalents; therefore, each system must be used independently of the other.

2. Referenced Documents

2.1 ASTM Standards:

A 109 Specification for Steel, Strip, Carbon, Cold Rolled²

A 366/A 366M Specification for Commercial Steel (CS), Sheet, Carbon (0.15 Maximum Percentage), Cold-Rolled³

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products⁴

A 568/A 568M Specification for Steel, Sheet, Carbon, and High-Strength, Low-Alloy, Hot-Rolled and Cold-Rolled, General Requirements for⁴

A 620/A 620M Specification for Drawing Steel (DS), Sheet, Carbon, Cold-Rolled³

A 941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys⁵

E 517 Test Method for Plastic Strain Ratio r for Sheet Metal⁶

E 646 Test Method for Tensile Strain-Hardening Exponents (n-Values) of Metallic Sheet Materials⁶

3. Terminology

3.1 Definitions:

3.1.1 For definitions of other terms used in this specification, refer to Terminology A 941.

3.1.2 *stabilization*—the addition of one or more nitride- or carbide-forming elements, or both, such as titanium and columbium, to control the level of the interstitial elements of carbon and nitrogen in the steel.

3.1.2.1 *Discussion*—Stabilizing improves formability and increases resistance to aging.

3.1.3 *vacuum degassing*—a process of refining liquid steel in which the liquid is exposed to a vacuum as part of a special technique for removing impurities or for decarburizing the steel.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *aging*—loss of ductility with an increase in hardness, yield strength, and tensile strength that occurs when steel that has been slightly cold worked (such as by temper rolling) is stored for some time.

3.2.1.1 *Discussion*—Aging increases the tendency of a steel to exhibit stretcher strains and fluting.

4. Classification

4.1 Cold-rolled steel sheet is available in the following designations:

4.1.1 Commercial Steel (CS Types A, B, and C),

4.1.2 Drawing Steel (DS Types A and B),

NOTE 1—CS Type B and DS Type B describe the most common product previously included, respectively, in Specifications A 366/A 366M and A 620/A 620M.

4.1.3 Deep Drawing Steel (DDS),

4.1.4 Extra Deep Drawing Steel (EDDS),

4.1.5 Structural Steel (SS grades 25[170], 30[205], 33[230] Types 1 and 2, 40[275] Types 1 and 2, and 80[550]),

4.1.6 High-Strength Low-Alloy Steel (HSLAS, in classes 1 and 2, in grades 45[310], 50[340], 55[380], 60[410], 65[450], and 70[480] in Classes 1 and 2), and

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² Discontinued and replaced by A 109/A 109M. See 1997 *Annual Book of ASTM Standards*, Vol. 01.03.

³ Discontinued; see 2000 *Annual Book of ASTM Standards*, Vol 01.03. Replaced by A 1008/A 1008M.

⁴ *Annual Book of ASTM Standards*, Vol 01.03.

⁵ *Annual Book of ASTM Standards*, Vol 01.01.

⁶ *Annual Book of ASTM Standards*, Vol 03.01.

*A Summary of Changes section appears at the end of this standard.

4.1.7 High-Strength Low-Alloy Steel with Improved Formability (HSLAS-F grades 50[340], 60[410], 70[480], and 80[550]).

4.1.7.1 HSLAS-F steel has improved formability when compared to HSLAS. The steel is fully deoxidized, made to fine grain practice and includes microalloying elements such as columbium, vanadium, zirconium, etc. The steel may be treated to achieve inclusion control.

4.2 Cold-rolled steel sheet is supplied for either exposed or unexposed applications. Within the latter category, cold-rolled sheet is specified either “temper rolled” or “annealed last.” For details on processing, attributes and limitations, and inspection standards, refer to Specification **A 568/A 568M**.

5. Ordering Information

5.1 It is the purchaser’s responsibility to specify in the purchase order all ordering information necessary to describe the required material. Examples of such information include, but are not limited to, the following:

- 5.1.1 ASTM specification number and year of issue;
- 5.1.2 Name of material and designation (cold-rolled steel sheet) (include grade, type, and class, as appropriate, for CS, DS, DDS, EDDS, SS, HSLAS, or HSLAS-F) (see 4.1);
 - 5.1.2.1 When a type is not specified for CS or DS, Type B will be furnished (see 4.1);
 - 5.1.2.2 When a class is not specified for HSLAS, Class 1 will be furnished (see 4.1);
 - 5.1.2.3 When a type is not specified for SS33[230] and SS40[275], Type 1 will be furnished (see 4.1);
- 5.1.3 Classification (either exposed, unexposed, temper rolled, or annealed last) (see 4.2);
- 5.1.4 Finish (see 9.1);
- 5.1.5 Oiled or not oiled, as required (see 9.2);
- 5.1.6 Dimensions (thickness, thickness tolerance table (see 5.1.6.1), width, and whether cut lengths or coils);
 - 5.1.6.1 As agreed upon between the purchaser and the producer, material ordered to this specification will be supplied to meet the applicable thickness tolerance table shown in Specification **A 568/A 568M**;

NOTE 2—Not all producers are capable of meeting all the limitations of the thickness tolerance tables in Specification **A 568/A 568M**. The purchaser should contact the producer regarding possible limitations prior to placing an order.

- 5.1.7 Coil size (must include inside diameter, outside diameter, and maximum weight);
- 5.1.8 Copper bearing steel (if required);
- 5.1.9 Quantity;
- 5.1.10 Application (part identification and description);
- 5.1.11 Special requirements (if required), or supplementary requirement S1 for HSLAS; and
- 5.1.12 A report of heat analysis will be supplied, if requested, for CS, DS, DDS, and EDDS. For materials with required mechanical properties, SS, HSLAS, and HSLAS-F, a report is required of heat analysis and mechanical properties as determined by the tension test.

NOTE 3—A typical ordering description is as follows: ASTM A 1008-XX, cold rolled steel sheet, CS Type A, exposed, matte finish, oiled, 0.035 by 30 in. by coil, ID 24 in., OD 48 in., max weight 15 000 lbs,

thickness tolerance Table 18 of Specification **A 568/A 568M**, 100 000 lb, for part No. 4560, Door Panel.

or:

ASTM A 1008M-XX, cold-rolled steel sheet, SS grade 275, unexposed, matte finish, oiled, 0.88 mm by 760 mm by 2440 mm, thickness tolerance Table A1.15 of Specification **A 568/A 568M**, 10 000 kg, for shelf bracket.

6. General Requirements for Delivery

6.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification **A 568/A 568M** unless otherwise provided herein.

7. Chemical Composition

7.1 The heat analysis of the steel shall conform to the chemical composition requirements of the appropriate designation shown in **Table 1** for CS, DS, DDS, and EDDS and in **Table 2** for SS, HSLAS, and HSLAS-F.

7.2 Each of the elements listed in **Table 1** and **Table 2** shall be included in the report of the heat analysis. When the amount of copper, nickel, chromium, or molybdenum is less than 0.02 %, the analysis may be reported as < 0.02 %. When the amount of vanadium, columbium, or titanium is less than 0.008 %, the analysis may be reported as < 0.008 %.

7.3 Sheet steel grades defined by this specification are suitable for welding if appropriate welding conditions are selected. For certain welding processes, more restrictive composition limits may be desirable and should be requested at the time of inquiry and ordering.

8. Mechanical Properties

8.1 *CS, DS, DDS, and EDDS:*

8.1.1 Typical nonmandatory mechanical properties for CS, DS, DDS and EDDS are shown in **Table 3**.

8.1.2 The material shall be capable of being bent, at room temperature, in any direction through 180° flat on itself without cracking on the outside of the bent portion (see Section 14 of Test Methods and Definitions **A 370**).

8.1.3 Sheet of these designations except for EDDS may be subject to aging dependent upon processing factors such as the method of annealing (continuous annealing or box annealing), and chemical composition. For additional information on aging, see Appendix X1 of Specification **A 568/A 568M**.

8.1.4 EDDS steel is stabilized to be nonaging and so is not subject to stretcher strains and fluting. Other steels may be processed to be nonaging; please consult your supplier.

8.2 *SS, HSLAS and HSLAS-F:*

8.2.1 The available strength grades for SS, HSLAS and HSLAS-F are shown in **Table 4**.

8.2.2 *Tension Tests:*

8.2.2.1 *Requirements*—Material as represented by the test specimen shall conform to the mechanical property requirements specified in **Table 4**. These requirements do not apply to the uncropped ends of unprocessed coils.

8.2.2.2 *Number of Tests*—Two tension tests shall be made from each heat or from each 50 tons [45 000 kg]. When the amount of finished material from a heat is less than 50 tons [145 000 kg], one test shall be made. When material rolled from heat differs 0.050 in. [1.27 mm] or more in thickness, one tension test shall be made from the thickest and thinnest material regardless of the weight represented.

**TABLE 1 Chemical Composition^A
For Cold Rolled Steel Sheet Designations CS, DS, DDS, and EDDS**

Designation	Composition, % Heat Analysis (Element Maximum Unless Otherwise Shown)													
	C	Mn	P	S	Al	Si	Cu ^B	Ni ^B	Cr ^{B,C}	Mo ^B	V	Cb	Ti	N
CS Type A ^{D,E,F,G}	0.10	0.60	0.030	0.035	0.20 ^H	0.20	0.15	0.06	0.008	0.008	0.008 ^I	...
CS Type B ^D	0.02 to 0.15	0.60	0.030	0.035	0.20 ^H	0.20	0.15	0.06	0.008	0.008	0.008 ^I	...
CS Type C ^{D,E,F,G}	0.08	0.60	0.10	0.035	0.20 ^H	0.20	0.15	0.06	0.008	0.008	0.008 ^I	...
DS Type A ^{E,J}	0.08	0.50	0.020	0.030	0.01 min	...	0.20	0.20	0.15	0.06	0.008	0.008	0.008 ^I	...
DS Type B	0.02 to 0.08	0.50	0.020	0.030	0.02 min	...	0.20	0.20	0.15	0.06	0.008	0.008	0.008 ^I	...
DDS ^{F,G}	0.06	0.50	0.020	0.025	0.01 min	...	0.20	0.20	0.15	0.06	0.008	0.008	0.008 ^I	...
EDDS ^K	0.02	0.40	0.020	0.020	0.01 min	...	0.10	0.10	0.15	0.03	0.008	0.10	0.15	...

^A Where an ellipsis (. . .) appears in the table, there is no requirement, but the analysis result shall be reported.

^B The sum of copper, nickel, chromium, and molybdenum shall not exceed 0.50 % on heat analysis. When one or more of these elements is specified by the purchaser, the sum does not apply, in which case only the individual limits on the remaining elements shall apply.

^C Chromium is permitted, at the producer's option, to 0.25 % maximum when the carbon content is less than or equal to 0.05 %. In such case the limit on the sum of the four elements in Footnote B does not apply.

^D When an aluminum deoxidized steel is required for the application, Commercial Steel (CS) may be ordered to a minimum of 0.01 % total aluminum.

^E Specify Type B to avoid carbon levels below 0.02 %.

^F May be furnished as a vacuum degassed or chemically stabilized steel, or both, at the producer's option.

^G For carbon levels less than or equal to 0.02 %, columbium or titanium, or both, may be used as stabilizing elements at the producer's option. In such cases, the applicable limit for columbium shall be 0.10 % max. and the limit on titanium shall be 0.15 % max.

^H When copper steel is specified, the copper limit is a minimum requirement. When copper steel is not specified, the copper limit is a maximum requirement.

^I Except for EDDS, titanium is permitted, at producer's option, to 0.025 % provided the ratio of % titanium to % nitrogen does not exceed 3.4.

^J DS Type A may be furnished as a vacuum degassed steel, at the producers option.

^K Shall be furnished as a vacuum degassed and stabilized steel.

**TABLE 2 Chemical Composition^A
For Cold Rolled Steel Sheet Designations SS, HSLAS, and HSLAS-F**

Designation	% Heat Analysis, Element Maximum unless otherwise shown												
	C	Mn	P	S	Al	Si	Cu ^{B,C}	Ni ^B	Cr ^B	Mo ^B	V	Cb	N
SS:													
Grade 25 [170]	0.20	0.60	0.035	0.035	0.20	0.20	0.15	0.06	0.008	0.008	...
Grade 30 [205]	0.20	0.60	0.035	0.035	0.20	0.20	0.15	0.06	0.008	0.008	...
Grade 33 [230] Type 1	0.20	0.60	0.035	0.035	0.20	0.20	0.15	0.06	0.008	0.008	...
Grade 33 [230] Type 2	0.15	0.60	0.20	0.035	0.20	0.20	0.15	0.06	0.008	0.008	...
Grade 40 [275] Type 1	0.20	0.90	0.035	0.035	0.20	0.20	0.15	0.06	0.008	0.008	...
Grade 40 [275] Type 2	0.15	0.60	0.20	0.035	0.20	0.20	0.15	0.06	0.008	0.008	...
Grade 80 [550]	0.20	0.60	0.035	0.035	0.20	0.20	0.15	0.06	0.008	0.008	...
HSLAS: ^D													
Grade 45 [310] Class 1	0.22	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	...
Grade 45 [310] Class 2	0.15	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	...
Grade 50 [340] Class 1	0.23	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	...
Grade 50 [340] Class 2	0.15	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	...
Grade 55 [380] Class 1	0.25	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	...
Grade 55 [380] Class 2	0.15	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	...
Grade 60 [410] Class 1	0.26	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	...
Grade 60 [410] Class 2	0.15	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	0.020
Grade 65 [450] Class 1	0.26	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	0.012
Grade 65 [450] Class 2	0.15	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	0.020
Grade 70 [480] Class 1	0.26	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	0.012
Grade 70 [480] Class 2	0.15	1.65	0.04	0.04	0.20	0.20	0.15	0.06	0.01 min	0.005 min	0.020
HSLAS-F: ^E													
Grade 50[340], 60[410], 70[480], and 80[550]	0.15	1.65	0.020	0.025	0.20	0.20	0.15	0.06

^A Where an ellipsis (. . .) appears in the table, there is no requirement but, the analysis shall be reported.

^B The sum of copper, nickel, chromium, and molybdenum shall not exceed 0.50 %. When one or more of these elements are specified by the purchaser, the sum does not apply, in which case, only the individual limits on the remaining unspecified elements will apply.

^C When copper is specified, the copper limit is a minimum requirement. When copper steel is not specified, the copper limit is a maximum requirement.

^D For HSLAS steels, columbium and vanadium may be added singly or in combination.

^E These steels shall also contain one or more of the following elements: Vanadium, Titanium, and Columbium. Other alloying elements may be present, but are not required.

8.2.2.3 Tension test specimens shall be taken at a point immediately adjacent to the material to be qualified.

8.2.2.4 Tension test specimens shall be taken from the full thickness of the sheet.

8.2.2.5 Tension test specimens shall be taken from a location approximately halfway between the center of the sheet and the edge of the material as rolled.