



Standard Specification for Medium Carbon Anti-Friction Bearing Steel¹

This standard is issued under the fixed designation A 866; 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 medium carbon bearing quality steel to be used in the manufacture of anti-friction bearings.

1.2 Supplementary requirements of an optional nature are provided and when desired shall be so stated in the order.

1.3 The values stated in inch-pound units are to be regarded as the standard.

2. Referenced Documents

2.1 ASTM Standards:

A 29/A29M Specification for Steel Bars, Carbon and Alloy, Hot-Wrought and Cold-Finished, General Requirements for²

A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products³

E 45 Practice for Determining the Inclusion Content of Steel⁴

E 112 Test Methods for Determining Average Grain Size⁴

E 381 Test Method for Macrotech Testing, Inspection and Rating Steel Products, Comprising Bars, Billets, Blooms, and Forgings⁴

E 1019 Test Methods for Determination of Carbon, Sulfur, Nitrogen, Oxygen, and Hydrogen in Steel and in Iron, Nickel, and Cobalt Alloys⁵

E 1077 Test Method for Estimating the Depth of Decarburization of Steel Specimens⁴

3. Ordering Information

3.1 Orders for material under this specification should include the following information:

3.1.1 Quantity (weight or pieces),

3.1.2 Grade identification,

3.1.3 ASTM designation and year of issue,

3.1.4 Dimensions, and

3.1.5 Supplementary requirements, if included.

4. Materials and Manufacture

4.1 Process:

4.1.1 The steel shall be made by a process that is capable of providing a high quality product meeting the requirements of this specification.

5. Chemical Composition and Analysis

5.1 Typical examples of chemical composition are shown in Table 1. Other compositions may be specified.

5.2 An analysis of each heat of steel shall be made by the steel manufacturer in accordance with Test Methods, Practices, and Terminology A 751. The chemical composition thus determined shall conform to the requirements specified in Table 1 for the ordered grade or to other requirements agreed upon between the manufacturer and the purchaser.

5.3 Product analysis may be made by the purchaser in accordance with Test Methods, Practices, and Terminology A 751. Permissible variations in product analysis shall be in accordance with Specification A 29/A 29M.

6. Sizes, Shapes, and Dimensional Tolerances

6.1 The physical size and shape of the material shall be agreed upon between the manufacturer and the purchaser.

6.2 Dimensional tolerances for hot-rolled or hot-rolled and annealed bars, in straight lengths or coils, and cold-finished bars 0.500 in. (12.7 mm) and larger in diameter furnished under this specification shall conform to the requirements specified in the latest edition of Specification A 29/A 29M.

6.3 Dimensional tolerances for cold-finished coils for ball and roller material shall be as shown in Table 2.

6.4 Coil tolerances also apply to cold-finished straight lengths under 0.500 in. in diameter.

7. Quality Tests

7.1 The supplier shall be held responsible for the quality of the material furnished and shall make the necessary tests to ensure this quality. The supplier shall be required to report on the results of the macroetch and micro-inclusion rating tests detailed below. Quality tests shown in 7.2 through 7.4 are based upon procedures established in Practice E 45.

7.2 *Sampling*—Samples taken in accordance with the following paragraphs shall be obtained from 4 by 4 in. (102 by 102 mm) rolled billets or forged sections. Tests may be made on smaller or larger sections by agreement with the purchaser. A minimum 3 to 1 reduction of rolled billets or forged sections is required for strand cast products.

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.28 on Bearing Steels.

Current edition approved June 15, 1994. Published August 1994. Originally published as A 866 – 87. Last previous edition A 866 – 92.

² *Annual Book of ASTM Standards*, Vol 01.05.

³ *Annual Book of ASTM Standards*, Vol 01.03.

⁴ *Annual Book of ASTM Standards*, Vol 03.01.

⁵ *Annual Book of ASTM Standards*, Vol 03.06.

TABLE 1 Chemical Composition^A

AISI/SAE	C	Mn	Si	Cr	Mo	V	UNS
1030	0.28 to 0.34	0.60 to 0.90	0.15 to 0.35	10300
1040	0.37 to 0.44	0.60 to 0.90	0.15 to 0.35	10000
1050	0.48 to 0.55	0.60 to 0.90	0.15 to 0.35	10600
1541	0.36 to 0.44	1.35 to 1.65	0.15 to 0.35	15410
1552	0.47 to 0.55	1.20 to 1.50	0.15 to 0.35	16620
4130	0.28 to 0.33	0.40 to 0.60	0.15 to 0.35	0.80 to 1.10	0.15–0.25	...	41300
4140	0.38 to 0.43	0.75 to 1.00	0.15 to 0.35	0.80 to 1.10	0.15–0.25	...	41400
4150	0.48 to 0.53	0.75 to 1.00	0.15 to 0.35	0.80 to 1.10	0.15–0.25	...	41600
5140	0.38 to 0.43	0.70 to 0.90	0.15 to 0.35	0.70 to 0.90	51400
5150	0.48 to 0.53	0.70 to 0.90	0.15 to 0.35	0.70 to 0.90	51600
6150	0.48 to 0.53	0.70 to 0.90	0.15 to 0.35	0.80 to 1.1015 min.	51600

^A Phosphorus and sulfur contents of these steels are .025 % maximum for bearing quality.

TABLE 2 Dimensional Tolerances for Cold-Finished Coils

Size, in. (mm)	Total Tolerance, in. (mm)
Through 0.096 (2.44)	0.002 (0.05)
Over 0.096 (2.44) to 0.270 (6.86), incl	0.003 (0.08)
Over 0.270 (6.86) to 0.750 (19.1), incl	0.004 (0.10)

TABLE 3 Inclusion Rating

Rating Units	
Thin Series	Heavy Series
A—2.5	A—1.5
B—2.0	B—1.0
C—1.0	C—1.0
D—1.5	D—1.0

7.2.1 For top poured products, a minimum of six samples representing the top and bottom of the first, middle, and last usable ingots shall be examined.

7.2.2 For bottom poured products, a minimum of six samples shall be examined and they shall represent the top and bottom of three ingots. One ingot shall be taken at random from the first usable plate poured, one ingot, at random, from the usable plate poured nearest to the middle of the heat, and one ingot, at random, from the last usable plate poured. When two usable plates constitute a heat, two of the sample ingots shall be selected from the second usable plate poured. Where a single usable plate constitutes a heat, any three random ingots may be selected. Other methods of sampling shall be as agreed upon by manufacturer and purchaser.

7.2.3 For strand cast products, a minimum of six samples representing the first, middle, and last portion of the heat cast shall be examined. At least one sample shall be taken from each strand.

7.3 *Macroetch*—Specimens representative of cross sections of billets shall be macroetched and rated in accordance with Method E 381 in hydrochloric acid and water (1:1) at a temperature of 160 to 180°F (71 to 82°C). Such specimens shall not exceed S2, R2, and C2 of Test Method E 381.

7.4 *Inclusion Rating*—The specimens shall be $\frac{3}{8}$ by $\frac{3}{4}$ in. (9.5 by 19.1 mm) and shall be taken from an area halfway between the center and outside of the billet. The polished face shall be longitudinal to the direction of rolling. The scale used for rating the specimens shall be the Jernkontoret chart described in Practice E 45, Plate III. Plate I is to be used for inclusion exceeding a rating of 2½. Fields with sizes or numbers of all types of inclusions intermediate between configurations shown on the chart shall be classified as the lesser of the rating number. The worst field of each inclusion type from each specimen shall be recorded as the rating for the specimen. Two thirds of all specimens and at least one from each ingot tested, or from the first, middle, and last portion of the strands tested, as well as the average of all specimens, shall not exceed the rating specified in Table 3. If specifically

ordered and certified to Supplementary Requirement S5., Type A inclusion ratings shall not exceed 3.0 thin and 2.0 heavy. See S5.1.

8. Grain Size

8.1 The grain size shall be from 5 to 8 as defined in Test Methods E 112 (see Plate 4, Austenitic Grain Size in Steels), with occasional grains as large as No. 3 permissible. Material not meeting this requirement may be normalized at 1700°F (925°C) or above, and retested.

9. Decarburization and Surface Imperfections

9.1 Decarburization and surface imperfections shall not exceed the limits specified in Tables 4 and 5. Decarburization shall be measured using the microscopical methods described in Test Method E 1077.

10. Microstructure and Hardness

10.1 Material may be ordered as hot rolled or thermally treated. When thermally treated, the acceptance criteria for microstructure and hardness shall be agreed upon between the manufacturer and the purchaser. No hardness limits shall apply for as-hot-rolled materials.

11. Inspection

11.1 The manufacturer shall afford the purchaser's inspector all reasonable facilities necessary to satisfy him that the material is being produced and furnished in accordance with this specification. Mill inspection by the purchaser shall not interfere unnecessarily with the manufacturer's operations. All tests and inspections shall be made at the place of manufacture, unless otherwise agreed to.

12. Certification and Reports

12.1 Upon request of the purchaser in the contract or order, a manufacturer's certification that the material was manufactured and tested in accordance with this specification, together