



Designation: A 841/A 841M – 98^{€1}

Standard Specification for Steel Plates for Pressure Vessels, Produced by Thermo-Mechanical Control Process (TMCP)¹

This standard is issued under the fixed designation A 841/A 841M; 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} NOTE—An editorial correction was made in Table 1 in September 1999.

1. Scope

1.1 This specification² covers steel plates produced by the thermo-mechanical control process (TMCP). The plates are intended primarily for use in welded pressure vessels.

1.2 The TMCP method consists of rolling-reduction and cooling rate controls which result in mechanical properties in the finished plate that are equivalent to those attained using conventional rolling and heat treating processes which entail reheating after rolling. A description of the TMCP method is given in Appendix X1.

1.3 Due to the inherent characteristics of the TMCP method, the plates cannot be formed at elevated temperatures without sustaining significant losses in strength and toughness. The plates may be formed and post-weld heat-treated at temperatures not exceeding 1200°F [650°C], providing the requirements of 6.1 are met.

1.4 The maximum nominal thickness of plates furnished under this specification may not exceed 4 in. [100 mm].

1.5 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. Combining values from the two systems may result in nonconformance with this specification.

2. Referenced Documents

2.1 ASTM Standards:

A 20/A 20M Specification for General Requirements for Steel Plates for Pressure Vessels³

A 435/A 435M Specification for Straight-Beam Ultrasonic Examination of Steel Plates³

A 577/A 577M Specification for Ultrasonic Angle-Beam

Examination of Steel Plates³

A 578/A 578M Specification for Straight-Beam Ultrasonic Examination of Plain and Clad Steel Plates for Special Applications³

3. General Requirements and Ordering Information

3.1 Material supplied to this material specification shall conform to Specification A 20/A 20M. These requirements outline the testing and retesting methods and procedures, permissible variations in dimensions, quality and repair of defects, marking, loading, etc.

3.2 Specification A 20/A 20M also establishes the rules for ordering information which should be complied with when purchasing material to this specification.

3.2.1 When the material is to be subjected to warm forming or post-weld heat treatment, the order must indicate the temperatures and times-at-temperature that will be utilized in such operations. (See 6.1 and Specification A 20/A 20M, Supplementary Requirement S3.)

3.3 In addition to the basic requirements of this specification, certain supplementary requirements are available when additional control, testing, or examination is required to meet end use requirements. These include:

- 3.3.1 Vacuum treatment,
- 3.3.2 Additional or special tension testing,
- 3.3.3 Additional or special impact testing, and
- 3.3.4 Nondestructive examination.

3.4 The purchaser is referred to the listed supplementary requirements in this specification and to the detailed requirements in Specification A 20/A 20M.

3.5 If the requirements of this specification are in conflict with the requirements of Specification A 20/A 20M, the requirements of this specification shall prevail.

4. Manufacture

4.1 *Steelmaking Practice*—The steel shall be killed and shall conform to the fine austenitic grain size requirement of Specification A 20/A 20M.

4.2 The plates shall be produced by the thermo-mechanical

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-841/SA-841M in Section II of that Code.

³ *Annual Book of ASTM Standards*, Vol 01.04.

control process.

5. Chemical Composition

5.1 The chemical composition on heat analysis shall conform to the requirements listed in Table 1, except as otherwise provided in Supplementary Requirement S17 of Specification A 20/A 20M when that requirement is involved.

5.2 If a product analysis is made on a sample taken from the standard location (see Specification A 20/A 20M), the results of the analysis shall not deviate from the limits for the heat analysis by more than the values given in Table 2.

6. Mechanical Requirements

6.1 When the material is to be subjected to warm forming or post-weld heat treatment, the test coupons shall be subjected to heat treatment to simulate such fabrication operations. (See 3.2.1 and Specification A 20/A 20M, Supplementary Requirement S3.)

6.2 *Tension Test Requirements*—The plates as represented by the tension-test specimens shall conform to the requirements shown in Table 3.

6.2.1 *Number and Location of Test Coupons*—Two tension tests shall be made from each plate-as-rolled. One test coupon shall be taken from a corner of the plate on each end.

6.3 *Notch Toughness Test Requirements*:

6.3.1 Longitudinal Charpy V-notch tests shall be made in accordance with Specification A 20/A 20M.

TABLE 1 Chemical Requirements

Element	Grade A	Grade B	Grade C
	Composition %	Composition %	Composition %
Carbon, max	0.20	0.15	0.10
Manganese			
t La 1.5 in. [40 mm]	0.70–1.35 ^A	0.70–1.35 ^A	0.70–1.60
t > 1.5 in. [40 mm]	1.00–1.60	1.00–1.60	1.00–1.60
Phosphorus, max	0.030	0.030	0.030
Sulfur, max	0.030	0.025	0.015
Silicon	0.15–0.50	0.15–0.50	0.15–0.50
Copper, max	0.35	0.35	0.35
Nickel, max	0.25	0.60	0.25
Chromium, max	0.25	0.25	0.25
Molybdenum, max	0.08	0.30	0.08
Columbium, max	0.03	0.03	0.06
Vanadium, max	0.06	0.06	0.06
Titanium	^B	^B	0.006–0.02
Aluminum, min	0.020 total or 0.015 acid soluble ^B	0.020 total or 0.015 acid soluble ^B	...

^A Manganese may exceed 1.35 % on heat analysis, up to a maximum of 1.60 %, provided that the carbon equivalent on heat analysis does not exceed 0.47 %, or the value specified in Supplementary Requirement S77 when that requirement is invoked, when based on the following formula:

$$CE = C + Mn/6 + (Cr + Mo + V)/5 + (Ni + Cu)/15 \%$$

When this option is exercised, the manganese content on product analysis shall not exceed the heat analysis content by more than 0.12 %.

^B By agreement, the steel may be produced with titanium, in which case the minimum aluminum content shall not apply. When this option is exercised, the titanium content, by heat analysis, shall be 0.006 % to 0.02 %, and the actual titanium content shall be reported on the test report.

TABLE 2 Product Analysis Tolerances

Element	Specified Limit	Tolerances, %	
		Under, Minimum	Over, Maximum
Carbon	to 0.15, incl over 0.15	0.02 0.03	0.03 0.04
Manganese	to 0.60, incl over 0.60 to 0.90, incl over 0.90 to 1.20, incl over 1.20 to 1.35, incl over 1.35 to 1.65, incl	0.05 0.06 0.08 0.09 0.09	0.06 0.08 0.10 0.11 0.12
Phosphorus	to 0.020, incl over 0.020	0.005 0.010
Sulfur	to 0.020, incl over 0.020	0.005 0.010
Silicon	to 0.30, incl over 0.30 to 0.40, incl over 0.40	0.02 0.05 0.06	0.03 0.05 0.06
Nickel	to 1.00, incl	...	0.03
Chromium	to 0.90, incl	...	0.04
Molybdenum	to 0.20, incl	...	0.01
Copper	to 1.00, incl	...	0.03
Vanadium	to 0.10, incl	...	0.01
Columbium	to 0.10, incl	...	0.01
Aluminum	to 0.15, incl	0.005	0.01

TABLE 3 Tensile Requirements

	Class 1	Class 2
	ksi [MPa]	ksi [MPa]
Yield strength, min:		
to 2.5 in. [to 65 mm]	50 [345]	60 [415]
over 2.5 in. [over 65 mm]	45 [310]	55 [380]
Tensile strength		
to 2.5 in. [to 65 mm]	70–90 [485–620]	80–100 [550–690]
over 2.5 in. [over 65 mm]	65–85 [450–585]	75–95 [515–655]
Elongation in 2 in. [50 mm], min, % ^A :		
to 2.5 in. [to 65 mm]	22	22
over 2.5 in. [over 65 mm]	22	22
Elongation in 8 in. [200 mm], min, % ^A :		
to 2.5 in. [to 65 mm]	18	...
over 2.5 in. [over 65 mm]	18	...

^A See Specification A 20/A 20M for elongation requirements.

6.3.2 Test temperature and absorbed energy should be specified on the order. When test temperature and absorbed energy are not specified, tests shall be conducted at –40°F [–40°C] and the average absorbed energy of three full size specimens shall not be less than 15 ft·lb [20J].

7. Marking

7.1 In addition to the marking required in Specification A 20/A 20M, each plate shall be legibly stamped with the letters “TMC” following the stamped specification designation.

8. Keywords

8.1 pressure containing parts; pressure vessel steel; steel plates; steel plates for pressure vessel applications