



Standard Specification for UNS N08020, UNS N08024, and UNS N08026 Nickel Alloy Bar and Wire¹

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1. Scope

1.1 This specification² covers UNS N08020, UNS N08026, and UNS N08024 bar and wire other than required for reforging.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 ASTM Standards:

- A 262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels³
- E 8 Test Methods for Tension Testing of Metallic Materials⁴
- E 1473 Test Methods for Chemical Analysis of Nickel, Cobalt, and High-Temperature Alloys⁵

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

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

3.1.2 *bars*, n —hot-finished rounds, squares, octagons, and hexagons: $\frac{1}{4}$ in. (6.35 mm) and over in diameter or size. Hot-finished flats: $\frac{1}{4}$ to 10 in. (254 mm), inclusive, in width, $\frac{1}{8}$ in. (3.175 mm) and over in thickness. Cold-finished rounds, squares, octagons, hexagons, and shapes: over $\frac{1}{2}$ in. (12.7 mm) in diameter or size. Cold-finished flats: $\frac{3}{8}$ in. (9.525 mm) and over in width (see Discussion(1)), $\frac{1}{8}$ in. and over in thickness (see Discussion(2)).

3.1.2.1 *Discussion*—(1) Widths less than $\frac{3}{8}$ in. (9.525 mm) and thicknesses less than $\frac{3}{16}$ in. (4.75 mm) are generally described as flat wire.

3.1.2.2 *Discussion*—(2) Thicknesses $\frac{1}{8}$ in. (3.175 mm) to under $\frac{3}{16}$ in. (4.75 mm) can be cold-rolled strip as well as bar.

¹ This specification is under the jurisdiction of ASTM Committee B-2 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.07 on Refined Nickel and Cobalt, and Alloys Containing Nickel or Cobalt or Both as Principal Constituents.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-473 in Section II of that Code.

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.

3.1.3 *wire*, n —cold finished only: round, square, octagon, hexagon, and shape wire, $\frac{1}{2}$ in. (12.7 mm) and under in diameter or size. Cold-finished only: flat wire, $\frac{3}{16}$ in. (4.76 mm) to under $\frac{3}{8}$ in. (9.525 mm) in width, 0.010 in. (0.254 mm) to under $\frac{3}{16}$ in. in thickness.

4. Ordering Information

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

- 4.1.1 Quantity (weight or number of pieces),
- 4.1.2 Name of material or UNS number,
- 4.1.3 Form (bar or wire),
- 4.1.4 Dimensions,
- 4.1.5 Condition,
- 4.1.6 Finish,
- 4.1.7 ASTM designation and year of issue,
- 4.1.8 Inspection (15.1),
- 4.1.9 Supplementary requirements, if any, and
- 4.1.10 If possible, the intended end use.

NOTE 1—A typical ordering description is as follows: 200 bars, UNS N08020, 1 in. (25.4 mm) round by 10 to 14 ft (3.0 to 3.6 m), centerless ground, Specification B 473.

5. Materials and Manufacture

5.1 *Heat Treatment*—The product of UNS N08020 alloy shall be furnished in the stabilized-annealed condition. The product of UNS N08026 alloy shall be furnished in the solution-annealed condition. The product of UNS N08024 alloy shall be furnished in the annealed condition.

NOTE 2—The recommended annealing temperatures all followed by quenching in water or rapidly cooling by other means are as follows: 1700 to 1850°F (927 to 1010°C) for UNS N08020, 2050 to 2200°F (1121 to 1204°C) for UNS N08026, and 1925 to 1975°F (1052 to 1079°C) for UNS N08024.

6. Chemical Composition

6.1 The material shall conform to the requirements as to chemical composition prescribed in Table 1.

6.2 If a product (check) analysis is performed by the purchaser, the material shall conform to the product (check)

TABLE 1 Chemical Requirements

Element	Composition, %		
	UNS N08026	UNS N08020	UNS N08024
Carbon, max	0.03	0.07	0.03
Manganese, max	1.00	2.00	1.00
Phosphorus, max	0.03	0.045	0.035
Sulfur, max	0.03	0.035	0.035
Silicon, max	0.50	1.00	0.50
Nickel	33.00 to 37.20	32.00 to 38.00	35.00 to 40.00
Chromium	22.00 to 26.00	19.00 to 21.00	22.50 to 25.00
Molybdenum	5.00 to 6.70	2.00 to 3.00	3.50 to 5.00
Copper	2.00 to 4.00	3.00 to 4.00	0.50 to 1.50
Columbium (Nb) + tantalum	...	8 × carbon–1.00	0.15 to 0.35
Nitrogen	0.10 to 0.16
Iron	remainder ^A	remainder ^A	remainder ^A

^A By difference

analysis variations prescribed in Table 2.

7. Condition

7.1 Bars shall be furnished annealed and either hot finished or cold finished. Strain-hardened material is available only as cold finished.

7.2 Wire will be furnished only as annealed and cold finished.

8. Mechanical Properties

8.1 The material shall conform to the applicable requirements as to mechanical properties prescribed in Table 3.

9. Dimensions and Permissible Variations

9.1 Bar—Bars shall conform to the variations in dimensions prescribed in Tables 4-12, inclusive, as applicable.

9.2 Wire—Wire shall conform to the permissible variations in dimensions prescribed in Tables 13-17, inclusive, as applicable.

10. Workmanship, Finish, and Appearance

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

11. Sampling

11.1 Lot:

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

11.1.2 A lot for mechanical properties shall consist of all material from the same heat, nominal diameter or thickness, of each heat-treatment charge.

11.2 Test Material Selection:

11.2.1 Chemical Analysis—Representative samples shall be taken during pouring or subsequent processing.

11.2.1.1 Check analysis shall be wholly the responsibility of the purchaser.

11.2.2 Mechanical Properties—Samples of the material to provide test specimens shall be taken from such locations in each lot as to be representative of that lot.

12. Number of Tests

12.1 Chemical Analysis—One test per lot.

12.2 Mechanical Properties—One test per lot.

13. Specimen Preparation

13.1 Tension test specimens shall be taken from the material after final heat treatment, and shall be selected in the longitudinal direction. The tension test specimens shall conform to the appropriate sections of Test Methods E 8.

14. Test Methods

14.1 The chemical composition and mechanical properties of the material as enumerated in this specification shall, in case of disagreement, be determined in accordance with the following methods:

Test	ASTM Designations
Chemical analysis	E 1473 ^A
Tension	E 8

^A Iron shall be determined arithmetically by difference.

15. Inspection

15.1 If specified, source inspection of the material by the purchaser at the manufacturer’s plant shall be made as agreed upon between the purchaser and the manufacturer as part of the purchase contract.

16. Rejection and Rehearing

16.1 Material that fails to conform to the requirements of this specification may be rejected. Rejection should be reported to the producer or supplier promptly and in writing. In case of dissatisfaction with the results of the test, the producer or supplier may make claim for a rehearing.

TABLE 2 Product Analysis Tolerances

Elements	Tolerances Over the Maximum Limit or Under the Minimum Limit		
	UNS N08026	UNS N08020	UNS N08024
Carbon	0.005	0.01	0.005
Manganese	0.03	0.04	0.03
Phosphorus	0.005	0.005	0.005
Sulfur	0.005	0.005	0.005
Silicon	0.05	0.05	0.05
Chromium	0.25	0.25	0.25
Nickel	0.30	0.30	0.30
Molybdenum	0.10	0.10	0.10
Columbium (Nb) + tantalum	...	0.05	0.05
Copper	0.10	0.10	0.10
Nitrogen	0.01

TABLE 3 Mechanical Property Requirements^A

Condition	Diameter or Thickness, in. (mm)	Tensile Strength, min		Yield Strength, min		Elongation in 2 in. (50.8 mm), min, %	Reduction of area, min, %
		ksi	MPa	ksi	MPa		
Annealed, hot finished or cold finished	All	80	551	35	241	30.0 ^B	50.0
Annealed, strain-hardened	Up to 2 (50.8) incl	90	620	60	415	15.0	40.0

^A For wire only, tensile strength 90 to 120.0 ksi (620 to 830 MPa); no requirements on yield strength, elongation, and reduction of area.

^B Cold-finished shapes require only 15 %, minimum, elongation.

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

	Permissible Variations from Specified Size, in. (mm)		Out-of-Round ^A or Out-of-Square, ^B in. (mm)
	Over	Under	
1/4 (6.35) to 5/16 (7.94), incl ^{C,D}	<i>E</i>	<i>E</i>	<i>E</i>
Over 5/16 (7.94) to 7/16 (11.11), incl ^{C,D}	0.006 (0.15)	0.006 (0.15)	0.009 (0.23)
Over 7/16 (11.11) to 5/8 (15.88), incl ^{C,D}	0.007 (0.18)	0.007 (0.18)	0.010 (0.25)
Over 5/8 (15.88) to 7/8 (22.22), incl	0.008 (0.20)	0.008 (0.20)	0.012 (0.30)
Over 7/8 (22.22) to 1 (25.40), incl	0.009 (0.23)	0.009 (0.23)	0.013 (0.33)
Over 1 (25.40) to 1 1/8 (28.58), incl	0.010 (0.25)	0.010 (0.25)	0.015 (0.38)
Over 1 1/8 (28.58) to 1 1/4 (31.75), incl	0.011 (0.28)	0.011 (0.28)	0.016 (0.41)
Over 1 1/4 (31.75) to 1 3/8 (34.92), incl	0.012 (0.30)	0.012 (0.30)	0.018 (0.46)
Over 1 3/8 (34.92) to 1 1/2 (38.10), incl	0.014 (0.36)	0.014 (0.36)	0.021 (0.53)
Over 1 1/2 (38.10) to 2 (50.80), incl	1/64 (0.40)	1/64 (0.40)	0.023 (0.58)
Over 2 (50.80) to 2 1/2 (63.50), incl	1/32 (0.79)	0	0.023 (0.58)
Over 2 1/2 (63.50) to 3 1/2 (88.90), incl	3/64 (1.19)	0	0.035 (0.89)
Over 3 1/2 (88.90) to 4 1/2 (114.30), incl	1/16 (1.59)	0	0.046 (1.17)
† Over 4 1/2 (114.30) to 5 1/2 (139.70), incl	5/64 (1.98)	0	0.058 (1.47)
Over 5 1/2 (139.70) to 6 1/2 (165.10), incl	1/8 (3.18)	0	0.070 (1.78)
Over 6 1/2 (165.10) to 8 (203.20), incl	5/32 (3.97)	0	0.085 (2.18)

^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.

^C Size tolerances have not been evolved for rounds in the size range of 1/4 to 5/16 in. (6.35 to 7.94 mm), inclusive. Size tolerances have not been evolved for round sections in the size range of 1/4 in. to approximately 5/8 in. (6.35 to 15.88 mm) in diameter which are produced on rod mills in coils.

^D Variations in size of coiled product made on rod mills are greater than size tolerances for product made on bar mills.

^E Squares in this size are not produced as hot-rolled products.

† Editorially corrected.

TABLE 5 Permissible Variations in Size of Hot-Rolled Hexagonal and Octagonal Bars

Specified Sizes Measured Between Opposite Sides, in. (mm)	Permissible Variations from Specified Size, in. (mm)		Maximum Difference in 3 Measurements for Hexagons only, in. (mm)
	Over	Under	
1/4 (6.35) to 1/2 (12.70), incl	0.007 (0.18)	0.007 (0.18)	0.011 (0.28)
Over 1/2 (12.70) to 1 (25.40), incl	0.010 (0.25)	0.010 (0.25)	0.015 (0.38)
Over 1 (25.40) to 1 1/2 (38.10), incl	0.021 (0.53)	0.021 (0.53)	0.025 (0.64)
Over 1 1/2 (38.10) to 2 (50.80), incl	1/32 (0.79)	1/32 (0.79)	1/32 (0.79)
Over 2 (50.80) to 2 1/2 (63.50), incl	3/64 (1.19)	3/64 (1.19)	3/64 (1.19)
Over 2 1/2 (63.50) to 3 1/2 (88.90), incl	1/16 (1.59)	1/16 (1.59)	1/16 (1.59)

17. Certification

17.1 When specified in the purchase order or contract, a producer's or supplier's certification shall be furnished to the purchaser that the material was manufactured, sampled, tested, and inspected in accordance with this specification and has been found to meet the requirements. When specified in the purchase order or contract, a report of the test results shall be furnished.

18. Product Marking

18.1 Each bundle or box shall be properly tagged with metal tags showing heat number, grade, condition, specification number and size to assure proper identification.

19. Packaging and Package Marking

19.1 Bars or wire shall be bundled or boxed in such a manner as to assure safe delivery to their destination when properly transported by any common carrier.

20. Keywords

20.1 bar; UNS N08020; UNS N08024; UNS N08026; wire