



Designation: A 727/A 727M – 02

Standard Specification for Carbon Steel Forgings for Piping Components with Inherent Notch Toughness¹

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1. Scope *

1.1 This specification² covers forged carbon steel piping components intended primarily for service in pressure piping systems from –20 to +650°F [–30 to +345°C] where inherent notch toughness is desired, but where notch toughness testing is not required. Included are forged or ring-rolled flanges, forged fittings, and valves made to specified dimensions, or to dimensional standards such as the ASME and API specifications referenced in Section 2.

1.2 This specification is limited to forgings with maximum finished section thicknesses no larger than 2 in. [51 mm].

1.3 It shall be the responsibility of the purchaser to determine whether material meeting the requirements of this specification is satisfactory for the service application.

1.4 Supplementary requirements are provided for use when additional testing or inspection is desired. These shall apply only when specified by the purchaser in the order.

NOTE 1—There are no provisions for impact testing in this specification. When impact testing is required, refer to Specification A 350/A 350M.

1.5 This specification is expressed in both inch-pound units and in SI units. However, unless the order specifies the applicable “M” specification designation (SI units), the material shall be furnished to inch-pound units.

1.6 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 the specification.

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.22 on Steel Forgings and Wrought Fittings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-727 in Section II of that Code.

2. Referenced Documents

2.1 In addition to those reference documents listed in Specification A 961, the following list of standards apply to this specification.

2.2 ASTM Standards:

A 350/A 350M Specification for Carbon and Low-Alloy Steel Forgings, Requiring Notch Toughness Testing for Piping Compounds³

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

A 788 Specification for Steel Forgings, General Requirements⁵

A 961 Specification for Common Requirements for Steel Flanges, Forged Fittings, Valves, and Parts for Piping Applications³

E 59 Practice for Sampling Steel and Iron for Determination of Chemical Composition⁶

2.3 ASME Boiler and Pressure Vessel Codes:⁷

Section II, Material Specifications, Part C

SFA 5.5 Low-Alloy Steel Covered Arc-Welding Electrodes

B 16.5 Steel Pipe Flanges and Flanged Fittings

B 16.10 Face-to-Face and End-to-End Dimensions of Ferrous Valves

B 16.11 Forged Steel Fittings, Socket-Welding and Threaded

B 16.30 Unfired Pressure Vessel Flange Dimensions

2.4 API Standards:⁸

600 Steel Gate Valves with Flanged or Butt-Welding Ends

602 Compact Design Carbon Steel Gate Valves for Refinery Use

605 Large Diameter Carbon Steel Flanges

³ *Annual Book of ASTM Standards*, Vol 01.01.

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

⁵ *Annual Book of ASTM Standards*, Vol 01.05.

⁶ Discontinued; see 1995 *Annual Book of ASTM Standards*, Vol 03.05.

⁷ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5900.

⁸ Available from The American Petroleum Institute (API), 1220 L. St., NW, Washington, DC 20005.

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

2.5 *MSS Standard:*⁹

MSS SP-25 Standard Marking System for Valves, Fittings, Flanges, and Unions

3. General Requirements and Ordering Information

3.1 Product furnished to this specification shall conform to the requirements of Specification A 961, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the requirements of Specification A 961 constitutes nonconformance with this specification. In case of a conflict between the requirements of this specification and Specification A 961, this specification shall prevail.

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

3.2.1 Additional requirements (see 15.1 and 15.2).

4. Materials and Manufacture

4.1 The steel shall be made by one or more of the following processes: open-hearth, basic-oxygen, or electric-furnace, and shall be fully killed, fine-grain practice.

4.2 Forgings shall be manufactured from ingots, blooms, billets, slabs, or bars. These items shall be forged, rolled, or strandcast.

4.3 A sufficient discard shall be made from the ingot to secure freedom from injurious piping and undue segregation.

4.4 The finished product shall be a forging as defined by the Terminology section of Specification A 788.

5. Heat Treatment

5.1 Following plastic working, the forging manufacturer shall heat treat the forgings by normalizing, or normalizing and tempering, or quenching and tempering.

5.1.1 *Normalizing*—The procedure for normalizing shall consist of uniformly heating the forgings to a temperature between 1550 and 1700°F [845 and 925°C], holding a sufficient time to attain uniform temperature throughout, and cooling in still air. The forging shall be at a temperature below 1000°F [540°C] before heating for normalizing.

5.1.2 *Quenching*—The procedure for quenching shall consist of uniformly heating the forging to a temperature between 1550 and 1700°F [845 and 925°C], holding a sufficient time to attain uniform temperature throughout, and quenching into a suitable liquid medium. The forging shall be at a temperature below 1000°F [540°C] before heating for quenching.

5.1.3 *Tempering*—The procedure for tempering shall consist of reheating the forging subsequent to normalizing or quenching to a temperature of at least 1100°F [595°C], but not above the lower transformation temperature, for 30 min/in. [30 min/25 mm] of maximum section thickness, with minimum holding time at tempering temperature not less than 30 min.

6. Chemical Composition

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

TABLE 1 Chemical Requirements

Elements	Composition, %
Carbon	
Heat Analysis	0.25 max
Product Analysis	0.28 max
Manganese	
Heat Analysis	0.90 to 1.35
Product Analysis	0.84 to 1.41
Phosphorus	
Heat Analysis	0.035 max
Product Analysis	0.043 max
Sulfur	
Heat Analysis	0.025 max
Product Analysis	0.033 max
Silicon	
Heat Analysis	0.15 to 0.30
Product Analysis	0.13 to 0.32
Nickel	
Heat Analysis	0.40 ^A
Product Analysis	0.43
Chromium	
Heat Analysis	0.30 ^{AB}
Product Analysis	0.34
Molybdenum	
Heat Analysis	0.12 ^{AB}
Product Analysis	0.13
Copper	
Heat Analysis	0.40 ^A
Product Analysis	0.43
Columbium (Nb)	
Heat Analysis	0.02
Product Analysis	0.03
Vanadium	
Heat Analysis	0.05
Product Analysis	0.055

^A The sum of copper, nickel, chromium and molybdenum shall not exceed 1.00 % on heat analysis.

^B The sum of chromium and molybdenum shall not exceed 0.32 % on heat analysis.

6.2 Steels to which lead has been added shall not be used.

7. Mechanical Requirements

7.1 *Tension Tests:*

7.1.1 *Requirements*—The material shall conform to requirements for tensile properties prescribed in Table 2.

7.1.1.1 The test specimen shall be obtained from a rough or finished production forging, or prolongation thereof, or it may be obtained from separately forged test blanks from the same heat of steel as the production forging. The test blank shall be reduced by forging in a manner similar to that for the products represented, shall receive approximately the same hot working and reduction, be of the same nominal thickness, and receive the same heat treatment as the finished products represented. The test material shall be treated in the same furnace at the same time as the forging it represents, subject to the requirements of 7.1.2.1.

7.1.2 *Number of Tests*—One tension test at room temperature shall be made for each nominal wall thickness $\pm 1/4$ in. [± 6 mm] from each heat in each heat treatment charge.

TABLE 2 Tensile Requirements

Tensile strength, ksi [MPa]	60.0 to 85.0 [415 to 585]
Yield strength, min, ksi [MPa] ^A	36.0 [250]
Elongation in 2 in. or 50 mm, min, %	22
Reduction of area, min, %	30

^A Determined by either the 0.2 % offset method or the 0.5 % extension-under-load method.

⁹ Available from Manufacturers Standardization Society of the Valve and Fittings Industry (MSS), 127 Park St., NE, Vienna, VA 22180-4602.