



Designation: A 290 – 95 (Reapproved 1999)

Standard Specification for Carbon and Alloy Steel Forgings for Rings for Reduction Gears¹

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1. Scope

1.1 This specification covers normalized and tempered, and quenched and tempered carbon and alloy steel forged or rolled rings for reduction gears.

1.2 Several classes of steel are covered as follows:

1.2.1 Classes A, B, C, and D are carbon steel.

1.2.2 Classes E, F, G, H, I, J, K, L, M, P, and T are alloy steel.

1.2.3 All classes are considered weldable under proper conditions. Welding techniques are of fundamental importance and it is presupposed that welding procedure and inspection will be in accordance with proper methods for the class of material used.

1.3 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 275/A275M Test Method for Magnetic Particle Examination of Steel Forgings²

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products³

A 388/A388M Practice for Ultrasonic Examination of Heavy Steel Forgings²

E 44 Definitions of Terms Relating to Heat Treatment of Metals⁴

3. Terminology

3.1 *Definitions*—Definitions of the terms used in 5.4.2 may be found in Definitions E 44.

4. Ordering Information

4.1 The purchaser shall specify in the inquiry, contract, and order the class desired and the supplementary requirements, if any, which should apply.

5. Materials and Manufacture

5.1 *Melting Process:*

5.1.1 The steel shall be produced by any of the following primary processes: open hearth; basic oxygen; electric furnace; or vacuum induction (V.I.M.). The primary melting may incorporate separate degassing or refining and may be followed by secondary melting using electroslag remelting (E.S.R.) or vacuum arc remelting (V.A.R.).

5.1.2 The molten steel may be vacuum degassed prior to or during pouring of the ingot.

5.2 *Discard*—Sufficient discard shall be taken from each ingot to secure freedom from piping and undue segregation.

5.3 *Forging Process*—The forgings shall receive their hot mechanical work under a press or a hammer, or in a mill, each of ample power to work the metal uniformly through its section. These forgings shall be upset or punched, trepanned, and expanded.

5.4 *Heat Treatment:*

5.4.1 *Cooling Prior to Heat Treatment*—After forging and before reheating for heat treatment, the forgings shall be allowed to cool in a manner to prevent injury, to accomplish transformation, and prevent flakes.

5.4.2 Heat treatment shall consist of normalizing and tempering for classes A and B and quenching and tempering for all other classes.

5.4.2.1 *Normalizing*—A furnace charge thus treated is termed a normalizing charge.

5.4.2.2 *Quenching*—The forgings shall be completely austenitized and then quenched in a suitable medium. A group thus treated is termed a quenching charge.

5.4.2.3 *Tempering*—A furnace charge thus treated is termed a tempering charge. Minimum tempering temperatures shall be as follows:


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 A01.06 on Steel Forgings and Billets.

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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 01.02.

 **A 290 – 95 (1999)**

Class	Minimum Tempering Temperature	
	°F	(°C)
A and B	1200	(650)
C, D, E, F, G, H, M, P	1100	(595)
I, J, K, L	1050	(565)
T	1000	(540)

5.5 Machining:

5.5.1 Rough machining before heat treatment for mechanical properties may be performed at the option of the producer.

5.5.2 The forgings shall conform to the sizes and shapes specified by the purchaser.

6. Chemical Composition

6.1 *Composition*—The steel shall conform to the requirements for chemical composition prescribed in Table 1. Alternative compositions may be agreed upon in accordance with Supplementary Requirement S1.1.

6.1.1 *Heat Analysis*—An analysis of each heat of steel shall be made by the manufacturer to determine the percentages of the elements prescribed in Table 1. This analysis shall be made from a test sample taken during the pouring of the heat. The chemical composition thus determined shall be reported to the purchaser or his representative and shall conform to the requirements prescribed in Table 1.

6.1.2 *Product Analysis*—An analysis may be made by the purchaser from a forging representing each heat. Samples for analysis may be taken from the forging or from a full-size prolongation at any point midway between the inner and outer surfaces of the ring or samples may be taken from the test specimen. The chemical composition thus determined shall not vary from the requirements prescribed in Table 1 by more than the amounts prescribed in Table 2.

7. Mechanical Properties

7.1 *Tension and Impact Test Requirements*—The requirements for tensile and impact properties shall be as prescribed in Table 3.

7.1.1 *Number, Location, and Orientation of Test Specimens*—On classes requiring tension tests, two tension test specimens and two sets of impact tests shall be taken 180° apart from a full-size prolongation left on one end of each individual forging or both ends of each multiple forging. The test specimens shall be in a tangential direction at midwall of the ring as close as practical to the end of the rough-machined forging face.

7.1.2 *Test Method*—Full-size tension and Charpy V-notch impact tests shall be conducted in accordance with Test Methods and Definitions A 370.

7.2 *Brinell Hardness*—Forgings shall be within the hardness ranges specified in Table 3. The permissible variation of hardness in any forging shall not exceed 30 numbers for all classes except Classes K and L which shall be 40 numbers.

7.2.1 *Number and Location of Tests*—Brinell hardness tests shall be taken on each forging, regardless of weight or class, after final heat treatment and final machining to dimensions shown on the drawing submitted with the purchase order. Each test shall be approximately ¼ of the radial thickness from the outside diameter. The number and location of the hardness tests follows:

Outside Diameter, in. (cm)	Number of Tests
To 40 (102)	1 on each end 180° apart
40 to 80 (102 to 203)	2 on each end 180° apart
80 to 120 (203 to 305)	3 on each end 120° apart
Over 120 (305)	4 on each end 90° apart

7.2.2 *Test Method*—Tests shall be made in accordance with Test Methods and Definitions A 370.

8. Workmanship, Finish, and Appearance

8.1 The forgings shall conform to the sizes and shapes specified by the purchaser, shall be free from injurious defects, and shall have a workmanlike finish.

9. Retests

9.1 If the results of the tension tests do not conform to the requirements specified because a flaw develops in the test specimen during testing, a retest shall be allowed if the defect is not caused by flakes in the steel.

10. Inspection

10.1 The inspector representing the purchaser shall have free entry, at all times while work on the contract of the purchaser is being performed, to all parts of the manufacturer's works that concern the manufacture of the material ordered. The manufacturer shall afford the inspector, without charge, all reasonable facilities to satisfy him that the material is being furnished in accordance with this specification. All tests and inspection shall be made at the place of manufacture prior to shipment, unless otherwise specified, and shall be so conducted as not to interfere unnecessarily with the operation of the works.

TABLE 1 Chemical Requirements

Element	Composition, %					
	Classes A and B	Classes C and D	Classes E and F	Classes G, H, I, J, K, and L	Classes M and P	Class T
Carbon	0.35–0.50	0.40–0.50	0.35–0.45	0.35–0.45	0.38–0.45	0.25–0.39
Manganese	0.60–0.90	0.60–0.90	0.70–1.00	0.60–0.90	0.40–0.70	0.20–0.60
Phosphorus, max	0.040	0.040	0.040	0.040	0.040	0.015
Sulfur, max	0.040	0.040	0.040	0.040	0.040	0.015
Silicon ^A , max	0.35	0.35	0.35	0.35	0.40	0.35
Nickel	0.30 max	0.30 max	0.50 max	1.65–2.00	0.30 max	3.25–4.00
Chromium	0.25 max	0.25 max	0.80–1.15	0.60–0.90	1.40–1.80	1.25–1.75
Molybdenum	0.10 max	0.10 max	0.15–0.25	0.20–0.50	0.30–0.45	0.30–0.70
Vanadium, max	0.06	0.06	0.06	0.10	0.03	0.05–0.15
Copper, max	0.35	0.35	0.35	0.35	0.35	0.35
Aluminum	0.85–1.30	...

^A When vacuum carbon deoxidation is used, silicon maximum shall be 0.10 %.