Designation: F 2281 – 03

Standard Specification for Stainless Steel and Nickel Alloy Bolts, Hex Cap Screws, and Studs, for Heat Resistance and High Temperature Applications[1]

This standard is issued under the fixed designation F 2281; 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 the chemical and mechanical requirements for stainless steel and nickel alloy bolts, hex cap screws, and studs, ¼ in. diameter and larger, intended for use at temperatures up to 1800°F (982°C), and in applications where resistance to heat and the effects of high temperature are to be considered. See Appendix X1 for Service Application. A wide variety of materials are covered in this specification which can be used at high temperatures as a function of the specific alloy properties, as well as environmental requirements including corrosive environments.

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

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory requirements prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*

A 262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels[2]

A 276 Specification for Stainless Steel Bars and Shapes[2]

A 342/A 342M Test Methods for Permeability of Feebly Magnetic Materials[3]

A 380 Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment, and Systems[2]

A 484/A 484M Specification for General Requirements for Stainless Steel Bars, Billets, and Forgings[2]

A 493 Specification for Stainless Steel Wire and Wire Rods for Cold Heading and Cold Forging[2]

A 564/A 564M Specification for Hot-Rolled and Cold-Finished Age-Hardening Stainless Steel Bars and Shapes[2]

A 582/A 582M Specification for Free-Machining Stainless Steel Bars[2]

A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products[2]

B 637 Specification for Precipitation-Hardening Nickel Alloy Bars, Forgings, and Forging Stock for High-Temperature Service[4]

B 880 Specification for General Requirements for Chemical Check Analysis Limits for Nickel, Nickel Alloys, and Cobalt Alloys[4]

D 3951 Practice for Commercial Packaging[5]

E 21 Test Methods for Elevated Temperature Tension Tests of Metallic Materials[6]

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications[7]

E 76 Test Methods for Chemical Analysis of Nickel-Copper Alloys[8]

E 139 Test Methods for Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials[6]

E 292 Test Methods for Conducting Time-for-Rupture Notch Tension Tests of Materials[6]

E 353 Test Methods for Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys[8]

E 354 Test Methods for Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys[8]

F 606 Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, and Rivets[9]

F 788/F 788M Specification for Surface Discontinuities of Bolts, Screws, and Studs, Inch and Metric Series[9]

F 1470 Guide for Fastener Sampling for Specified Mechanical Properties and Performance Inspection[9]

[1] This specification is under the jurisdiction of ASTM Committee F16 on Fasteners and is the direct responsibility of Subcommittee F16.04 on Nonferrous Fasteners.

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[2] *Annual Book of ASTM Standards*, Vol 01.03.

[3] *Annual Book of ASTM Standards*, Vol 03.04.

[4] *Annual Book of ASTM Standards*, Vol 02.04.

[5] *Annual Book of ASTM Standards*, Vol 15.09.

[6] *Annual Book of ASTM Standards*, Vol 03.01.

[7] *Annual Book of ASTM Standards*, Vol 14.02.

[8] *Annual Book of ASTM Standards*, Vol 03.05.

[9] *Annual Book of ASTM Standards*, Vol 01.08.

2.2 *ASME Standards:*

B1.1 Unified Inch Screw Threads[10]

B18.2.1 Square and Hex Bolts and Screws, (Inch Series)[10]

3. Terminology

3.1 *Definitions:*

3.1.1 *heat resistance*—the extent to which a material retains useful properties as measured during exposure of the material to a specified temperature and environment for a specified time.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *high temperature*—defined solely for the purpose of this document as a range in temperature from 500°F (260°C) to 1800°F (982°C). Materials listed as high temperature alloys are designed to maintain their anticipated strength and characteristics within this range.

4. Classification

4.1 Three types of material, see Appendix X1 for Service Application, are covered in this specification and are classified into the following:

4.1.1 *Type I*—Heat Resisting Alloys for Continuous Service Applications:

4.1.1.1 *Class A*—Austenitic Grades:

Alloy Grade	UNS Designation
304	S30400
304L	S30403
316	S31600
316L	S31603

4.1.1.2 *Class B*—Martensitic Grades:

Alloy Grade	UNS Designation
410	S41000
416	S41600
431	S43100

4.1.1.3 *Class C*—Ferritic Grades:

Alloy Grade	UNS Designation
430	S43000
430F	S43020

4.1.2 *Type II*—Heat Resisting Alloys for Continuous and Intermittent Service Applications:

Alloy Grade	UNS Designation
309	S30900
310	S31000
321	S32100
330	N08330
347	S34700

4.1.3 *Type III*—High Temperature Alloys for Continuous and Intermittent Service Applications:

4.1.3.1 *Class A*—Nickel based alloy:

Alloy Grade	UNS Designation
600	N06600
601	N06601

4.1.3.2 *Class B*—Precipitation Hardened alloy:

Alloy Grade	UNS Designation
660	S66286

4.1.3.3 *Class C*—Precipitation Hardened alloy:

Alloy Grade	UNS Designation
718	N07718

5. Ordering Information

5.1 Orders for bolts, hex cap screws, and studs under this specification shall include the following information:

5.1.1 ASTM designation and year date. When year date is not specified, the latest issue shall be invoked;

5.1.2 Quantity (number of pieces of each item),

5.1.3 Item name (that is, bolt, hex cap screw, or stud),

5.1.4 Size (nominal diameter, threads per inch, length),

5.1.5 Type, class, and alloy grade (see 4.1), and

5.1.6 Condition (see 6.2.3).

5.2 Orders for bolts, hex cap screws, and studs under this specification may include the following optional requirements:

5.2.1 Forming (see 6.2.1),

5.2.2 Thread type (see 6.2.2),

5.2.3 Corrosion tests (see 13.1.2.1),

5.2.4 Finish (see 11.3),

5.2.5 Test reports (see 19.2), and

5.2.6 Supplementary Requirements, if any, to be specified on the order (see S1 through S8).

6. Materials and Manufacture

6.1 *Material*:

6.1.1 Specifications A 276, A 484, A 493, A 564/A 564M, A 582/A 582M, B 637 are noted for information only as suitable sources of material for the manufacture of bolts, hex cap screws, and studs to this specification.

6.1.2 The bolts, hex cap screws, and studs shall be manufactured from material having a chemical composition conforming to the requirements listed in Table 1 and capable of developing the mechanical property requirements listed in Table 2 for the finished fastener.

6.1.3 Various grades of material having unique heat resisting or high temperature characteristics are specified in this specification. A guide to their application is listed in Appendix X1 to assist in the selection of the fastener material.

6.1.4 The form and condition of the raw material shall be at the option of the manufacturer but shall be such that the finished fastener conforms to all the specified requirements.

6.2 *Manufacture*:

6.2.1 *Forming*—Unless otherwise specified, the fasteners shall be cold formed, hot formed, or machined from suitable material, at the option of manufacturer.

6.2.2 *Threads*—Unless otherwise specified, the threads shall be rolled or cut, at the option of the manufacturer.

6.2.3 *Condition*—The fasteners shall be furnished in one of the following conditions and shall be agreed upon between the manufacturer and the purchaser at the time of the inquiry and order.

[10] Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990.

TABLE 1 Chemical Requirements

Composition, % maximum except as shown										
Alloy	Carbon	Mang.	Phos.	Sulfur	Silicon	Chromium	Nickel	Copper	Moly	Other
Type I, Class A, Heat Resisting Austenitic Grades										
304	0.08	2.00	0.045	0.030	1.00	18.0/20.0	8.0/10.5	1.00		
304L	0.03	2.00	0.045	0.030	1.00	18.0/20.0	8.0/12.0	1.00		
316	0.08	2.00	0.045	0.030	1.00	16.0/18.0	10.0/14.0		2.00/3.00	
316L	0.03	2.00	0.045	0.030	1.00	16.0/18.0	10.0/14.0		2.00/3.00	
Type I, Class B, Heat Resisting Martensitic Grades										
410	0.15	1.00	0.040	0.030	1.00	11.5/13.5				
416	0.15	1.25	0.060	0.15 min	1.00	12.0/14.0			0.60	
431	0.20	1.00	0.040	0.030	1.00	15.0/17.0	1.25/2.50			
Type1, Class C, Heat Resisting Ferritic Grades										
430	0.12	1.00	0.040	0.030	1.00	16.0/18.0				
430F	0.12	1.25	0.060	0.15 min	1.00	16.0/18.0			0.60	
Type II, Heat Resisting Austenitic Grades										
309	0.20	2.00	0.045	0.030	1.00	22.0/24.0	12.0/15.0			
310	0.25	2.00	0.045	0.030	1.50	24.0/26.0	19.0/22.0			
321	0.08	2.00	0.045	0.030	1.00	17.0/19.0	9.0/12.0			Ti5×Cmin
330	0.08	2.00	0.030	0.030	0.75/1.50	17.0/20.0	34.0/37.0			
347	0.08	2.00	0.045	0.030	1.00	17.0/19.0	9.0/13.0			Cb+Ta10×Cmin
Type III, Class A, High Temperature, Nickel Alloy Grades										
600	0.10	1.00		0.015	0.50	14.0/17.0	72.0 min	0.50		Fe 6.0/10.0
601	0.10	1.00		0.015	0.50	21.0/25.0	58.0/63.0	1.00		Al 1.0/1.7 Fe Remainder
Type III, Class B, High Temperature, Precipitation Hardened Grade										
660	0.08	2.00	0.040	0.030	1.00	13.5/16.0	24.0/27.0		1.00/1.75	Ti 1.90/2.30 V 0.10/0.50 Al 0.35 max B 0.003/0.010 Fe Remainder
Type III, Class C, High Temperature, Precipitation Hardened Grade										
718	0.08	0.35	0.015	0.015	0.35	17.0/21.0	50.0/55.0	0.30	2.80/3.30	Ti 0.65/1.15 Co 1.00 max Al 0.20/0.80 B 0.006 max Cb + Ta 4.75/5.50 Fe Remainder

Type	Class	Condition
I	A	A, CWA, HWA
I	B	H, HT
I	C	A, CWA, HWA
II	...	A, CWA, HWA
III	A	A, CWA, HWA
III	B	AH1, AH2 or AH3
III	C	AH4

Condition

A	Machined from annealed or solution-annealed stock thus retaining the properties of the original material
CWA	Cold formed from annealed or solution-annealed stock and then re-annealed
HWA	Hot formed from annealed or solution-annealed stock and then re-annealed
H	Hardened and tempered at 1050°F (565°C) minimum
HT	Hardened and tempered at 525°F (274°C) minimum
AH1	Solution Treated at 1850°F (1010°C) and Precipitation Hardened (Aging)
AH2	Solution Treated at 1700°F (927°C) and Precipitation Hardened (Aging)
AH3	Solution Treated at 1850°F (1010°C) and Double Aged
AH4	Solution Treated at 1725°F (941°C) to 1850°F (1010°C) and Precipitation Hardened (Aging)

6.2.4 *Heat Treatment*:

6.2.4.1 *Condition A—(Austenitic Alloys Type I Class A and Type II)*, shall be heated to 1850 to 1950°F (1010 to 1066°C), held for a sufficient time, then cooled at a rate sufficient to prevent the precipitation of carbides and to provide the specified properties.

6.2.4.2 *Condition A—(Ferritic Alloys Type I Class C)*, shall be heated to 1400 to 1500°F (760 to 816°C), held for a sufficient time, and then air cooled to provide the specified properties.

6.2.4.3 *Condition A—(Nickel Alloy Type III Class A)*, shall be heated to 1600° to 1800°F (871 to 982°C), held for ten to fifteen minutes, and either water quenched or air cooled.

6.2.4.4 *Condition CWA—(Austenitic Alloys Type I Class A and Type II)*, shall be cold formed from annealed or solution annealed stock and then re-annealed or re-solution annealed in accordance with 6.2.4.1 after all cold working (including heading and threading) has been completed.

6.2.4.5 *Condition CWA—(Ferritic Alloys Type I Class C)*, shall be cold formed from annealed or solution annealed stock and then re-annealed or re-solution annealed in accordance with 6.2.4.2 after all cold working (including heading and threading) has been completed.

6.2.4.6 *Condition CWA—(Nickel Alloy Type III Class A)*, shall be cold formed from annealed stock and then re-annealed

TABLE 2 Mechanical Property Requirements at Room Temperature

Alloy Grades	Condition	Marking	Nominal Diameter, in.	Full-Size Tests: Tensile Strength, min, ksi	Full-Size Tests: Yield Strength, min, ksi	Rockwell Hardness	Machined Specimen Tests: Tensile Strength, min, ksi	Machined Specimen Tests: Yield Strength, min, ksi	Machined Specimen Tests: Elongation 4D, min %
Type I, Class A, Heat Resisting Austenitic Grades									
304, 304L	A	F1A	All Diameters	75	30	65 to 95 HRB	75	30	30
	CWA	F1B	All Diameters	75	30	65 to 95 HRB	75	30	30
	HWA	F1C	All Diameters	75	30	65 to 95 HRB	75	30	30
316, 316L	A	F1D	All Diameters	75	30	65 to 95 HRB	75	30	30
	CWA	F1E	All Diameters	75	30	65 to 95 HRB	75	30	30
	HWA	F1F	All Diameters	75	30	65 to 95 HRB	75	30	30
Type I, Class B, Heat Resisting Martensitic Grades									
410, 416	H	F1G	Up to 4 Diameter	110	85	20 to 30 HRC	110	85	15
	HT	F1H	Up to 4 Diameter	160	120	34 to 45 HRC	160	120	12
431	H	F1I	All Diameters	125	100	25 to 32 HRC	125	100	15
	HT	F1J	All Diameters	180	140	40 to 48 HRC	180	140	10
Type I, Class C, Heat Resisting Ferritic Grades									
430, 430F	A	F1K	All Diameters	55	30	65 to 95 HRB	50	25	...
	CWA	F1L	All Diameters	55	30	65 to 95 HRB	50	25	...
	HWA	F1M	All Diameters	55	30	65 to 95 HRB	50	25	...
Type II, Class A Heat Resisting Austenitic Grades									
309, 310	A	F2A	All Diameters	75	30	85 to 95 HRB	75	30	30
	CWA	F2B	All Diameters	75	30	65 to 95 HRB	75	30	30
	HWA	F2C	All Diameters	75	30	65 to 95 HRB	75	30	30
321, 347	A	F2D	All Diameters	75	30	85 to 95 HRB	75	30	30
	CWA	F2E	All Diameters	75	30	65 to 95 HRB	75	30	20
	HWA	F2F	All Diameters	75	30	65 to 95 HRB	75	30	30
330	A	F2G	All Diameters	75	30	85 to 95 HRB	75	30	30
	CWA	F2H	All Diameters	75	30	65 to 95 HRB	75	30	20
	HWA	F2I	All Diameters	75	30	65 to 95 HRB	75	30	30
Type III, Class A, High Temperature, Nickel Alloy Grades									
600, 601	A	F3A	All Diameters	80	25	65 to 85 HRB	75	25	35
	CWA	F3B	All Diameters	80	25	65 to 85 HRB	75	25	35
	HWA	F3C	All Diameters	80	25	65 to 85 HRB	75	25	35
Type III, Class B, High Temperature, Precipitation Hardened Grade									
660	AH1	F3D	All Diameters	130	85	22 to 37 HRC	130	85	15
	AH2	F3E	All Diameters	130	85	22 to 37 HRC	130	85	15
	AH3	F3F	All Diameters	130	85	22 to 37 HRC	130	85	15
Note: Condition AH1 results in increased rupture strength after aging, while Condition AH2 results in better ductility and higher hardness.									
Type III, Class C High Temperature, Precipitation Hardened Grade									
718	AH4	F3G	All Diameters	185	150	36 to 48 HRC	180	150	12

in accordance with 6.2.4.3 after all cold working (including heading and threading) has been completed.

6.2.4.7 *Condition HWA—(Austenitic Alloys Type I Class A and Type II)*, shall be hot formed from annealed or solution-annealed stock and then re-annealed or re-solution annealed in accordance with 6.2.4.1 after all hot forming has been completed.

6.2.4.8 *Condition HWA—(Ferritic Alloys Type I Class C)*, shall be hot formed from annealed or solution-annealed stock and then re-annealed or re-solution annealed in accordance with 6.2.4.2 after all hot forming has been completed.

6.2.4.9 *Condition HWA—(Nickel Alloy Type III Class A)*, shall be hot formed from annealed or solution-annealed stock and then re-annealed or re-solution annealed in accordance with 6.2.4.3 after all hot forming has been completed.

6.2.4.10 *Condition H—(Martensitic Alloys Type I Class B)*, shall be hardened by heating to 1800 to 1900°F (982 to 1038°C), held for at least ½ h and rapid air or oil quenched, then reheated to 1050°F (565°C) minimum for at least 1 h and air cooled to provide the specified properties.

6.2.4.11 *Condition HT—(Martensitic Alloys Type 1 Class B)*, shall be hardened by heating to 1800 to 1900°F (982 to 1038°C), held for at least ½ h and rapid air or oil quenched, then reheated to 525°F (274°C) minimum for at least 1 h and air cooled to provide the specified properties.

6.2.4.12 *Condition AH1—(Precipitation Hardened Alloy Type III Class B)*, shall be solution treated at 1800 to 1900°F (982 to 1038°C), held for 1 h at heat, then cooled rapidly. Precipitation Hardening (Aging) shall be performed by heating to 1300 to 1400°F (704 to 760°C), holding for 12 to 16 h at heat then air cooled. See Note 1.

6.2.4.13 *Condition AH2—(Precipitation Hardened Alloy Type III Class B)*, shall be solution treated at 1650 to 1750°F (899 to 954°C), held for 2 h at heat, then cooled rapidly. Precipitation Hardening (Aging) shall be performed by heating to 1300 to 1400°F (704 to 760°C), holding for 12 to 16 h at heat then air cooled. See Note 1.

NOTE 1—Condition AH1 results in increased rupture strength after aging, while Condition AH2 results in better ductility and higher hardness.

6.2.4.14 *Condition AH3—(Precipitation Hardened Alloy Type III Class B)*, shall be solution treated at 1800 to 1900°F (982 to 1038°C), held for 1 h at heat, then cooled rapidly. Precipitation Hardening (Aging) shall be performed by heating to 1425 ± 25°F (775 ± 14°C) holding for 16 h at heat then air cooled. Heated again to 1200 ± 25°F (650 ± 14°C) holding for 16 h at heat then air cooled.

6.2.4.15 *Condition AH4—(Precipitation Hardened Alloy Type III Class C)*, shall be solution treated at 1725°F (941°C) to 1850°F (1010°C), held at the selected temperature for a time commensurate with cross-sectional thickness, and cooled at a rate equivalent to an air cool or faster. Solution treating temperatures shall be controlled in a range of ±25°F (±14°C). Precipitation Hardening (Aging) shall be performed by heating to 1325°F (718°C) held at heat for 8 h, cooled to 1150°F (621°C) at a rate of 100°F (56°C) per hour, held for 8 h at heat and air cooled. Alternatively, parts may be furnace cooled to 1150°F (621°C) at any rate provided the time at 1150°F (621°C) is adjusted so the total heat treat time is 18 h minimum. Precipitation treatment temperatures and cooling rates shall be controlled in the range of ±15°F (±8°C).

7. Chemical Composition

7.1 *Chemical Composition*—Bolts, hex cap screws, and studs shall conform to the chemical composition requirements prescribed in Table 1 for the specified alloy grade.

7.2 *Product Analysis*:

7.2.1 When a product analysis is made by the purchaser from finished fasteners representing each lot, the chemical composition thus determined shall conform to the requirements listed in Table 1 for the specified alloy grade, subject to the Product Analysis tolerance listed in Specifications A 484 and B 880.

7.2.2 In the event of a discrepancy, a referee chemical analysis of samples, taken from each lot, shall be made in accordance with 14.1 and 15.1.

8. Mechanical Properties

8.1 Bolts, hex cap screws, and studs shall meet the applicable mechanical properties listed in Table 2 for the specified alloy grade and condition when tested at room temperature, in accordance with the mechanical properties requirements specified herein for the type, grade, diameter, and length.

8.2 *Mechanical Test Requirements*:

8.2.1 Bolts and hex cap screws which meet the minimum requirements for length, and have a maximum 160 000 pound tensile load, shall have a full size wedge tensile strength and yield strength test performed as outlined in Section 15. For bolts and hex cap screws which exceed the 160 000 pound limit, a Machined Specimen tensile strength, yield strength, and elongation test performed as outlined in Section 15 may be substituted for the full size wedge test. In addition, for bolts and hex cap screws that are less than the minimum length requiring tension tests, either a full size wedge tensile strength test, full size axial tensile strength test or a Rockwell hardness test shall be required as outlined in Section 15. In all cases, full size wedge tensile strength testing shall be performed whenever possible.

TABLE 3 Elevated Temperature Mechanical Property Requirements for Type III High Temperature Alloys

Temperature		Tensile Strength, ksi	Yield 0.2 % Strength, ksi	Elongation in 2 in., %
°F	°C			
Class A—Nickel Based Alloys Alloy Grade 600 Annealed at 1600°F (871°C)				
600	316	89.0	34.0	45.0
1000	538	82.0	33.0	42.0
1400	760	37.0	26.0	70.0
1800	982	11.0	5.0	115.0
Alloy Grade 601 Annealed at 1800°F (982°C)				
800	427	104.0	54.5	36.0
1000	538	94.8	51.5	34.0
1200	649	73.5	46.5	32.0
1400	760	37.3	36.6	88.0
1800	982	8.7	7.5	173.0
Class B—Precipitation Hardened Alloys Alloy Grade 660				
800	427	138.0	93.0	18.0
1000	538	131.0	87.5	18.0
1100	593	122.0	90.0	21.0
1200	649	104.0	88.0	13.0
1300	704	86.5	86.0	11.0
1400	760	64.0	62.0	18.0
1500	816	36.5	33.0	68.0
Class C—Precipitation Hardened Alloys Alloy Grade 718				
600	316	184.0	156.0	20.0
1000	538	173.0	148.0	16.0
1200	649	145.0	125.0	12.0
1400	760	124.0	116.0	5.0

8.2.2 Studs which meet the minimum requirements for length and have a maximum 160 000 pound tensile load, shall have a full size axial tensile strength test and yield strength test performed as outlined in Section 15. For studs which exceed the 160 000 pound limit, a Machined Specimen tensile strength, yield strength, and elongation test performed as outlined in Section 15 may be substituted for the full size axial test. In addition, for studs that are less than the minimum length requiring tension tests, either a full size axial tensile strength test or a Rockwell hardness test shall be required as outlined in Section 15. In all cases, full size axial tensile strength testing shall be performed whenever possible.

8.3 In the event of a discrepancy between full size wedge test, full size axial test, machined specimen test, and Rockwell hardness test results, the precedence sequence shall be the same as the sequence listed in this section for acceptance purposes. That is, if parts pass axial tensile but fail Rockwell hardness they are acceptable; however, if they fail axial tensile and pass Rockwell hardness they are not acceptable.

8.4 If tests to determine high temperature properties are required on Type III High Temperature Alloys, supplementary requirement S8 shall be specified in the inquiry and order and high temperature testing shall be performed and meet the applicable mechanical properties listed in Table 3.

9. Corrosion Resistance

9.1 *Carbide Precipitation*:

9.1.1 The type I, class A austenitic alloys listed in 4.1.1.1 and all type II austenitic alloys listed in 4.1.2 shall be capable

of passing the test for susceptibility to intergranular corrosion in accordance with Practice E of Practices A 262.

9.1.2 As stated in Practices A 262, samples may be subjected to the faster and more severe screening test in accordance with Practice A. Failing Practice A, specimens may be tested in accordance with Practice E and be considered satisfactory if passing Practice E.

10. Dimensions

10.1 *Bolts and Hex Cap Screws*:

10.1.1 Unless otherwise specified, the dimensions shall be in accordance with the requirements of ASME B18.2.1 for Hex Cap Screws.

10.1.2 When specified, the dimensions of bolts shall be in accordance with the requirements of ASME B18.2.1 (type as specified), or such other dimensions as shall be specified.

10.2 *Studs*:

10.2.1 Dimensions of studs shall be specified by the purchaser.

10.2.2 *Stud Type*:

10.2.2.1 Continuous thread.

10.2.2.2 Double end clamping (also known as stud bolt or bolt stud).

10.2.2.3 Double end interference (also known as tap-end stud).

10.2.2.4 Other studs as shall be specified by the purchaser.

10.2.3 *Threads*—Unless otherwise specified, studs shall have Class 2A threads in accordance with ASME B1.1.

10.2.4 *Points*—Unless otherwise specified, the points shall be flat and chamfered or rounded at the option of the manufacturer.

11. Workmanship, Finish and Appearance

11.1 *Surface Discontinuities*—For fasteners with specified minimum tensile strengths of 90 000 psi and higher the requirements in Specification F 788/F 788M shall apply.

11.2 *Cleaning and Descaling*—The fasteners shall be descaled, or cleaned, or both, in accordance with Specification A 380.

11.3 *Protective Finishes*—Unless otherwise specified, the fasteners shall be furnished without an additive chemical or metallic finish.

12. Sampling

12.1 A lot, for the purposes of selecting test specimens and inspection, shall be as defined in Guide F 1470.

13. Number of Tests and Retests

13.1 *Number of Tests*:

13.1.1 *Mechanical Tests*—The mechanical property requirements listed in Table 2 shall be met for all lots produced and submitted for testing. The manufacturer shall make sample inspections in accordance with Guide F 1470 Detection Process, to ensure the product conforms to the specified requirements. When tests of individual shipments are required, Supplementary Requirement S1 shall be specified in the inquiry and order.

13.1.2 *Corrosion Resistance Tests*:

13.1.2.1 Unless otherwise specified, inspection for corrosion resistance shall be in accordance with the manufacturer's standard quality control practices. No one specific method of inspection is required, but the fasteners shall be produced from suitable raw material and manufactured, by properly controlled practices, to maintain resistance to corrosion. When corrosion tests are required, Supplementary Requirement S6 shall be specified in the inquiry and order, except as noted in 13.1.2.2.

13.1.2.2 Products that have been hot worked shall be solution annealed. Sampling for determination of freedom from precipitated carbides shall be in accordance with Guide F 1470 Detection Process.

13.1.3 Sampling for determination of freedom from surface discontinuities shall be in accordance with Guide F 1470 Detection Process.

14. Specimen Preparation

14.1 *Chemical Tests*—When required, samples for chemical analysis shall be taken by drilling, sawing, milling, turning, clipping, or other such methods capable of producing representative samples.

14.2 *Mechanical Tests*:

14.2.1 When required, machined tension specimens shall be machined from the fastener in accordance with Test Methods F 606. The largest test specimen that can be machined from the bolt, hex cap screw, or stud shall be used.

14.2.2 When required, the hardness shall be determined on the finished fastener in accordance with Test Methods F 606.

14.3 *Corrosion Resistance*—When required, test specimens shall be prepared in accordance with Practices A 262.

15. Test Methods

15.1 *Chemical Analysis*:

15.1.1 The fastener manufacturer may accept the chemical analysis of each heat of raw material purchased and reported on the raw material certification furnished by the raw material producer. The fastener manufacturer is not required to do any further chemical analysis testing provided that precise heat lot traceability has been maintained throughout the manufacturing process on each lot of fasteners produced and delivered.

15.1.2 The chemical composition of stainless steel fasteners shall be determined in accordance with Test Methods A 751.

15.1.3 The chemical composition of nickel alloy fasteners shall be determined in accordance with Test Method E 76, E 353, E 354 or other equivalent method.

15.2 *Mechanical Tests*:

15.2.1 When full-size tests are to be performed, the yield strength, wedge tensile strength, or axial tensile strength, as required by Section 8 above, shall be determined on each sample in accordance with the appropriate methods of Test Methods F 606.

15.2.2 Full-size bolts and hex cap screws subject to tension tests shall be tested using a wedge under the head. The wedge shall be 10° for bolts 0.750-in. nominal diameter and less and 6° for bolts over 0.750-in. diameter.

15.2.3 When machined specimen tests are necessary (see Section 8), the yield strength, tensile strength, and elongation shall be determined on each sample in accordance with Test Methods F 606.