



Designation: A 649/A 649M – 99 (Reapproved 2003)

Standard Specification for Forged Steel Rolls Used for Corrugating Paper Machinery¹

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1. Scope

1.1 This specification² covers two kinds of rolls used in machinery for producing corrugated paperboard. Rolls are fabricated of forged bodies and trunnions. The trunnions may be bolted or shrink assembled on one or both ends of the body. A seal weld may be made at the body/trunnion interface. Roll shells are made of carbon/manganese, or low alloy steel as hereinafter described, and are heat treated prior to assembly. Pressure rolls are surface hardened. Provision is made in Supplementary Requirement S1 for the optional surface hardening of corrugating rolls.

1.2 Corrugating and pressure rolls made to this specification shall not exceed 30 in. [760 mm] in inside diameter. The wall thickness of the roll body shall not be less than $\frac{1}{2}$ of the inside diameter or 1 in. [25 mm], whichever is greater, but shall not exceed 4 in. [100 mm]. The wall thickness of the corrugating roll is measured at the bottom of the corrugations in the location of the trunnion fit. The maximum operating temperature of the roll is 600°F [315°C] and the maximum allowable working pressure is 250 psi [1.7 MPa]. The minimum design temperature shall be 40°F [4°C] for roll wall thicknesses up to 3 in. [75 mm]. For roll wall thicknesses over 3 in. [75 mm] to 4 in. [100 mm], the minimum design temperature shall be 120°F [50°C]. The maximum stresses on the roll bodies from the combined internal and external loading are limited to 18 750 psi [129 MPa] for the Class 2 pressure roll bodies, and 20 000 psi [138 MPa] for Class 1A, 1B, or 5 pressure or corrugating roll bodies in Grades 1 or 2. For the trunnions, the maximum stresses from the combined internal and external loading are limited to 15 000 psi [103.4 MPa] for Classes 3 or 4, or 20 000 psi [138 MPa] for Classes 1A, 1B, or 5 in Grade 2 only. The Grade 1 strength level is not permissible for trunnions.

1.3 Referring to Table 1, material to Classes 1A, 1B, or 5 shall be used for the manufacture of corrugating or pressure roll shells, and Class 2 shall be used only for pressure roll

shells. Trunnions shall be made from forgings in Classes 1A, 1B, or 5 in Grade 2 strength level as restricted by Footnote B in Table 2 or in forgings in either Class 3 or 4.

1.4 The values stated in either inch-pound units or SI [metric] units are to be regarded separately as standards. Within the text and tables, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independent of the other. Combining values from the two systems may result in nonconformance with the specification.

1.5 Unless the order specifies the applicable “M” specification designation, the material shall be furnished to the inch-pound units.

1.6 Except as specifically required in this standard, all of the provisions of Specification A 788 apply.

2. Referenced Documents

2.1 ASTM Standards:³

- A 275/A 275M Test Method for Magnetic Particle Examination of Steel Forgings
- A 370 Test Methods and Definitions for Mechanical Testing of Steel Products
- A 788 Specification for Steel Forgings, General Requirements
- E 165 Practice for Liquid Penetrant Examination

3. Ordering Information

3.1 Orders for material under this specification shall include the information required by Specification A 788. The purchaser should refer to Specification A 788 for other relevant information.

3.2 The additional ordering information given in Specification A 788 shall be specified as necessary to describe adequately the desired material.

4. Materials and Manufacture

4.1 Forging Process:

4.1.1 Roll body forgings may be made as solid forgings and subsequently bored.

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 A01.06 on Steel Forgings and Billets.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-649/SA-649M in Section II of that Code.

³ For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

TABLE 1 Chemical Requirements

	Composition, %					
	Class 1A	Class 1B	Class 2	Class 3	Class 4	Class 5
Carbon	0.45–0.60	0.40–0.60	0.55 max	0.35 max	0.35 max	0.50–0.60
Manganese	0.55–1.05	0.60–0.95	0.50–0.90	0.40–0.70	0.60–1.05	0.90–1.50
Phosphorus	0.025 max	0.025 max	0.025 max	0.025 max	0.025 max	0.025 max
Sulfur	0.025 max	0.025 max	0.025 max	0.025 max	0.025 max	0.025 max
Silicon ^A	0.15–0.35	0.15–0.35	0.15–0.35 max	0.15–0.35	0.15–0.35 max	0.15–0.35
Nickel	...	1.55–2.00	0.60 max
Chromium	0.80–1.15	0.65–0.95	...	0.80–1.15	...	0.30 max
Molybdenum	0.15–0.50	0.20–0.45	...	0.15–0.25	...	0.15 max

^A When vacuum carbon deoxidation (VCD) is used the silicon content shall be 0.10 % maximum.

TABLE 2 Tensile Requirements

Class	Grade	Yield Strength, min ^A	Tensile Strength, min	Elongation in 2 in. or 50 mm, %, min	Reduction of Area, %, min
		ksi	ksi		
1A, 1B or 5	1	130	150	12.0	30
1A, 1B or 5	2 ^B	65	100	14.0	30
2	...	37.5	75	20.0	50.0
3 or 4	...	30	60	22.0	55

^A 0.2 % offset.

^B For trunnion application, a maximum tensile strength of 125 ksi [860 MPa] applies for Grade 2 of Classes 1A, 1B, or 5.

4.1.2 Trunnions or gudgeons which are to be subsequently assembled to form the roll shall be made as a solid forging or where practical upset from segments cut from billets or bars.

4.2 Heat Treatment:

4.2.1 Heat Treatment for Mechanical Properties (Requirements do not apply to surface treatment):

4.2.1.1 Machining—The forged roll body shall have all surfaces rough machined, including boring, prior to heat treatment for mechanical properties.

4.2.1.2 Roll bodies shall be normalized, liquid quenched, and tempered to produce the required mechanical properties, except that for Class 2 forgings, and when Grade 2 strength requirements are specified, a normalize and temper heat treatment may be applied.

4.2.1.3 The trunnions shall be normalized and tempered or annealed to produce the required mechanical properties.

4.2.2 Surface Hardening of Pressure Roll Forgings—The working face of pressure rolls shall be surface hardened either before or after fitting the trunnions, at the manufacturer's option.

4.3 Assembly and Weld—Except for integrally forged or bolted-on trunnions, the assembly shall be made by shrink fitting trunnions into the prepared body ends. If used, welding of the trunnion to the roll body is restricted to a $\frac{3}{8}$ in. [9.5 mm] max. seal weld, made with low hydrogen materials. A minimum preheat of 400°F [205°C] and a minimum post weld heat treatment of 850°F [455°C] for 8 h shall be used. The maximum post weld heat treatment shall be not higher than $t - 50^\circ\text{F}$ [$t - 28^\circ\text{C}$] where t is the final tempering temperature. All welds shall be machined or ground for the final magnetic particle or liquid penetrant examination.

5. Chemical Composition

5.1 The steel shall conform to the requirements for chemical composition prescribed in Table 1.

6. Mechanical Properties

6.1 Tensile Requirements:

6.1.1 The material shall conform to the requirements for tensile properties prescribed in Table 2 when tested in accordance with Test Methods and Definitions A 370. Tension test specimens shall be the standard round $\frac{1}{2}$ -in. [12.5 mm] diameter, 2-in. [50 mm] gage length. The yield strength prescribed in Table 2 shall be determined by the 0.2 % offset method.

6.1.1.1 Tests for acceptance shall be made after the heat treatment of the forgings, for mechanical properties in accordance with 4.2.1.

6.1.2 Number, Location, and Orientation of Test Specimens:

6.1.2.1 Roll Body Forgings—A full-size prolongation shall be provided on a roll body forging representing each heat of steel in each heat-treatment furnace charge. One longitudinal tension test specimen shall be taken from the prolongation and the axis of the specimen shall be located midway between the inner and outer surfaces of the wall body.

6.1.2.2 Trunnions—Test material shall be provided from each heat of steel in each heat-treatment furnace charge. One longitudinal tension specimen shall be taken from each test piece and the axis of the specimen shall be located at any point midway between the center and surface of the solid forging.

6.2 Hardness:

6.2.1 Roll body forgings shall have a Brinell hardness from 352 HB to 415 HB (Grade 1) or 207 HB to 285 HB (Grade 2). No less than three hardness determinations shall be made on each roll. The hardness readings are to be taken on the outside