



Designation: A 413/A 413M – 01

Standard Specification for Carbon Steel Chain¹

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This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This specification covers carbon steel chain for such applications as railroad cars, construction, industrial uses, load binding, and general purposes other than overhead lifting.

NOTE 1—This specification does not cover carbon steel chain for sprocket applications.

1.2 Three classes of carbon steel chain are covered:

1.2.1 *Grade 30*—Proof coil chain.

1.2.2 *Grade 43*—High test chain.

1.2.3 *Grade 70*—Transport chain.

1.3 The values stated in either acceptable metric units or in other units shall be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system must be used independently of the other, without combining values in any way.

2. Referenced Documents

2.1 *ASTM Standards*:

A 29/A 29M Specification for Steel Bars, Carbon and Alloy, Hot-Wrought and Cold-Finished, General Requirements for²

E 30 Test Methods for Chemical Analysis of Steel, Cast Iron, Open-Hearth Iron and Wrought Iron³

E 44 Definitions of Terms Relating to Heat Treatment of Metals⁴

E 350 Test Methods for Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron and Wrought Iron⁵

E 415 Test Method for Optical Emission Vacuum Spectrometric Analysis of Carbon and Low-Alloy Steel⁶

3. Terminology

3.1 *Definitions of Terms Specific to This Standard*:

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 A01.27 on Steel Chain.

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² *Annual Book of ASTM Standards*, Vol 01.05.

³ Discontinued. See *1995 Annual Book of ASTM Standards*, Vol 03.05.

⁴ Discontinued. See *1993 Annual Book of ASTM Standards*, Vol 01.02.

⁵ *Annual Book of ASTM Standards*, Vol 03.05.

⁶ *Annual Book of ASTM Standards*, Vol 03.06.

3.1.1 *breaking force, minimum*—the minimum force in pounds or newtons at which the chain, during manufacture, has been found by testing to break when a constantly increasing force is applied in direct tension. This test is a manufacturer's attribute acceptance test and shall not be used as criteria for service.

3.1.2 *lot*—for the purpose of acceptance testing, a lot shall consist of 3000 ft [1000 m], or fraction thereof, of the same grade and size chain. If a continuous length of chain exceeds 3000 ft [1000 m], it shall also be considered a lot.

3.1.3 *proof test*—a quality control tensile test applied to chain for the purpose of verifying weld and material quality. It is the minimum force in pounds or newtons which the chain has withstood at the time it left the producer, under a test in which a constantly increasing force has been applied in direct tension to a straight length of chain. Proof test loads are a manufacturing integrity test and shall not be used as criteria for service or design purposes.

3.1.4 *working load limit (WLL)*—the maximum combined static and dynamic load in pounds or kilograms that shall be applied in direct tension to an undamaged straight length of chain.

4. Ordering Information

4.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this specification. Such requirements may include, but are not limited to, the following:

4.1.1 Product to conform to Specification A 413 or A 413M and date of issue,

4.1.2 Grade of chain,

4.1.3 Nominal size of chain (in. or mm),

4.1.4 Quantity of chain (ft or m),

4.1.5 Length of each piece, if required,

4.1.6 Finish, if required,

4.1.7 Certification of test(s), if required, and

4.1.8 Acceptance of inspection by purchaser, if required.

5. Material Requirements

5.1 *Heat Analysis*—The selection of the steel is left to the judgment of the individual chain manufacturer provided the steel meets the following criteria:

Carbon, max, %

0.370

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

Phosphorus, max, %	0.048
Sulfur, max, %	0.058

5.2 *Product Analysis*—The steel used may be analyzed by the purchaser and shall conform to the requirements of 5.1 subject to the product analysis tolerances specified in Specification A 29/A 29M. Test samples may be taken from rods, bars, or finished chain. Samples for analysis shall be so taken as to represent the full cross section of the specimen.

5.3 Test Methods E 30, E 350, or E 415 shall be used for referee purposes.

6. Manufacture

6.1 *Welding Process*—Carbon steel chain may be made by the forge welding, electric welding, or gas welding process.

6.2 *Heat Treatment*—Grades 30 and 43 do not require heat treatment, but may be heat treated at the manufacturer’s discretion. Grade 70, after welding, shall be heat treated. Heat treatment shall include quenching and tempering as described in Definitions E 44.

7. Dimensional Requirements

7.1 The chain shall conform to the dimensional requirements specified in Tables 1-3 for the appropriate grade and size chain.

7.2 *Diameter*—The diameter of the material from which the chain is manufactured shall not be smaller than the material diameter listed in Tables 1-3 within the following tolerance: -7% . Oversized material may be used for all applications.

8. Workmanship, Finish, and Appearance

8.1 The chain at the time of shipment shall be free of discontinuities that would prevent the chain from enduring the working load limit forces.

8.2 The manufacturer may apply a surface treatment or coating of their own choice for identification or corrosion resistance unless the customer specifies otherwise.

9. Mechanical Requirements

9.1 *Proof Test*—All chain shall be tested to at least the proof load prescribed in Tables 1-3 for the appropriate grade and size chain. When so tested it shall withstand these loads without loss of chain integrity. Links or chain segments that do not withstand the proof test load shall be removed from the chain.

9.2 *Breaking Force*—The breaking force test specimen shall consist of a length from the lot containing at least the number of links in Table 4. All chain that is heat treated shall be in the quenched and tempered condition before the breaking force is measured.

9.2.1 Fixtures for securing chain in a testing machine shall be properly designed to support securely the shoulder of the link (see Note 2). The opening in the fixture shall not be more than 125 % of the stock diameter being tested. Links engaged in the testing fixture shall not be considered part of the test specimen.

NOTE 2—“U” bolts of the same or larger diameter and the same or greater strength may be used to secure the chain to the jaws of the testing machine.

9.2.2 Test specimens shall meet or exceed the minimum breaking force values given in Tables 1-3 for the appropriate grade and size chain.

9.3 Elongation:

9.3.1 All chain which is heat treated (see 6.2) must be in the quenched and tempered condition before the elongation is measured.

9.3.2 The elongation test specimen shall consist of a length from the lot containing at least the number of links in Table 4.

9.3.3 A positive load not exceeding 10 % of the proof test shall be applied for determining the original gage length ($L\{0\}$).

9.3.4 The elongation shall be based on the total extension at fracture. This is expressed as a percentage of the change in length (ΔL) divided by the original gage length ($L\{0\}$). The elongation may be determined by the equation below or by autographic recorder or side scale.

$$\text{Elongation (\%)} = \left\{ \frac{\Delta L}{L\{0\}} \right\} \times 100$$

where:

ΔL = test specimen final length at fracture – test specimen original gage length ($L\{0\}$), and

$L\{0\}$ = original gage length (sum of the inside lengths of the test chain links, not counting the fixture links, or as determined in 9.3.3).

9.3.5 The elongation shall be a minimum of 15 %.

9.4 One test for breaking strength and elongation shall be made from each lot. The elongation and breaking force tests may be performed at the same time on the same test specimen.

TABLE 1 Grade 30 Proof Coil Chain

Nominal Chain Size		Material Diameter		Working Load Limit, max		Proof Test, ^A min		Minimum Breaking Force ^A		Inside Length, max		Inside Width, min	
in.	mm	in.	mm	lb	kg	lb	kN	lb	kN	in.	mm	in.	mm
1/8	4.0	0.156	4.0	400	180	800	3.6	1600	7.2	0.94	23.9	0.25	6.4
3/16	5.5	0.217	5.5	800	365	1600	7.2	3200	14.4	0.98	24.8	0.30	7.7
1/4	7.0	0.276	7.0	1300	580	2600	11.6	5200	23.2	1.24	31.5	0.38	9.8
5/16	8.0	0.331	8.4	1900	860	3800	16.9	7600	33.8	1.29	32.8	0.44	11.2
3/8	10.0	0.394	10.0	2650	1200	5300	23.6	10 600	47.2	1.38	35.0	0.55	14.0
7/16	11.9	0.488	11.9	3700	1680	7400	32.9	14 800	65.8	1.64	41.6	0.65	16.6
1/2	13.0	0.512	13.0	4500	2030	9000	40.0	18 000	80.0	1.79	45.5	0.72	18.2
5/8	16.0	0.630	16.0	6900	3130	13 800	61.3	27 600	122.6	2.20	56.0	0.79	20.0
3/4	20.0	0.787	20.0	10 600	4800	21 200	94.3	42 400	188.6	2.76	70.0	0.98	25.0
7/8	22.0	0.866	22.0	12 800	5810	25 600	114.1	51 200	228.2	3.03	77.0	1.08	27.5
1	26.0	1.02	26.0	17 900	8140	35 800	159.1	71 600	318.2	3.58	90.9	1.25	31.7

^A The proof test and minimum breaking force loads shall not be used as criteria for service or design purposes (see Section 4).