



Standard Specification for Steel Castings Suitable for Pressure Service¹

This standard is issued under the fixed designation A 487/A 487M; 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 specification² covers low-alloy steels and martensitic stainless steels in the normalized and tempered, or quenched and tempered, condition suitable for pressure-containing parts. The weldability of the classes in this specification varies from readily weldable to weldable only with adequate precautions, and the weldability of each class should be considered prior to assembly by fusion welding.

1.2 Selection will depend on design, mechanical, and service conditions. Users should note that hardenability of some of the grades mentioned may restrict the maximum size at which the required mechanical properties are obtained.

1.3 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. Inch-pound units are applicable for material ordered to Specification A 487 and SI units for material ordered to Specification A 487M.

2. Referenced Documents

2.1 ASTM Standards:

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

A 488/A 488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel⁴

A 703/A 703M Specification for Steel Castings, General Requirements, for Pressure-Containing Parts⁴

E 165 Test Method for Liquid Penetrant Examination⁵

E 709 Guide for Magnetic Particle Examination⁵

2.2 American Society of Mechanical Engineers:

ASME Boiler and Pressure Vessel Code, Section IX⁶

2.3 *Manufacturers Standardization Society of the Valve and Fittings Industry Standards:*⁷

SP-55 Quality Standard for Steel Castings-Visual Method

3. General Conditions for Delivery

3.1 Material furnished to this specification shall conform to the requirements of Specification A 703/A 703M including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A 703/A 703M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A 703/A 703M, this specification shall prevail.

4. Ordering Information

4.1 The inquiry and order should include or indicate the following:

4.1.1 A description of the casting by pattern number or drawing (dimensional tolerances shall be included on the casting drawing),

4.1.2 ASTM designation and year of issue,

4.1.3 Grade and class of steel,

4.1.4 Options in the specification, and

4.1.5 The supplementary requirements desired including the standard of acceptance.

5. Heat Treatment

5.1 All castings shall receive a heat treatment indicated in Table 1. Preliminary heat treatment prior to final heat treatment as well as multiple tempering is permitted.

5.2 Heat treatment shall be performed after the castings have been allowed to cool below the transformation range.

5.3 The furnace temperature for heat treating shall be effectively controlled by use of recording-type pyrometers.

6. Chemical Composition

6.1 The steel shall conform to the requirements as to chemical composition prescribed in Table 2. Product analysis tolerance shall conform to the product analysis tolerance shown in Specification A 703/A 703M. Product analysis tolerances for stainless grades are not presently applicable pending development of these limits.

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 A01.18 on Castings.

Current edition approved Dec. 15, 1993. Published April 1994. Originally published as A 487 – 63T. Last previous edition A 487/A 487M – 91.

² For ASME Boiler and Pressure Vessel Code applications see related Specifications SA-487 in Section II of that code.

³ *Annual Book of ASTM Standards*, Vol 01.03.

⁴ *Annual Book of ASTM Standards*, Vol 01.02.

⁵ *Annual Book of ASTM Standards*, Vol 03.03.

⁶ Available from American Society of Mechanical Engineers, 345 E. 47th St., New York, NY 10017.

⁷ Available from Manufacturer's Standardization Society of the Valve and Fittings Industry, 127 Park St., N.E. Vienna, VA 22180.


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TABLE 1 Heat Treat Requirement

Grade	Class	Austenitizing Temperature, min, °F [°C]	Media ^A	Quenching Cool Below °F [°C]	Tempering Temperature, °F [°C] ^B
1	A	1600 [870]	A	450 [230]	1100 [595]
1	B	1600 [870]	L	500 [260]	1100 [595]
1	C	1600 [870]	A or L	500 [260]	1150 [620]
2	A	1600 [870]	A	450 [230]	1100 [595]
2	B	1600 [870]	L	500 [260]	1100 [595]
2	C	1600 [870]	A or L	500 [260]	1150 [620]
4	A	1600 [870]	A or L	500 [260]	1100 [595]
4	B	1600 [870]	L	500 [260]	1100 [595]
4	C	1600 [870]	A or L	500 [260]	1150 [620]
4	D	1600 [870]	L	500 [260]	1150 [620]
4	E	1600 [870]	L	500 [260]	1100 [595]
6	A	1550 [845]	A	500 [260]	1100 [595]
6	B	1550 [845]	L	500 [260]	1100 [595]
7	A	1650 [900]	L	600 [315]	1100 [595]
8	A	1750 [955]	A	500 [260]	1250 [675]
8	B	1750 [955]	L	500 [260]	1250 [675]
8	C	1750 [955]	L	500 [260]	1250 [675]
9	A	1600 [870]	A or L	500 [260]	1100 [595]
9	B	1600 [870]	L	500 [260]	1100 [595]
9	C	1600 [870]	A or L	500 [260]	1150 [620]
9	D	1600 [870]	L	500 [260]	1150 [620]
9	E	1600 [870]	L	500 [260]	1100 [595]
10	A	1550 [845]	A	500 [260]	1100 [595]
10	B	1550 [845]	L	500 [260]	1100 [595]
11	A	1650 [900]	A	600 [315]	1100 [595]
11	B	1650 [900]	L	600 [315]	1100 [595]
12	A	1750 [955]	A	600 [315]	1100 [595]
12	B	1750 [955]	L	400 [205]	1100 [595]
13	A	1550 [845]	A	500 [260]	1100 [595]
13	B	1550 [845]	L	500 [260]	1100 [595]
14	A	1550 [845]	L	500 [260]	1100 [595]
16 (J31200)	A	1600 [870] ^C	A	600 [315]	1100 [595]
CA15	A	1750 [955]	A or L	400 [205]	900 [480]
CA15	B	1750 [955]	A or L	400 [205]	1100 [595]
CA15	C	1750 [955]	A or L	400 [205]	1150 [620] ^{DE}
CA15	D	1750 [955]	A or L	400 [205]	1150 [620] ^{DE}
CA15M	A	1750 [955]	A or L	400 [205]	1100 [595]
CA6NM	A	1850 [1010]	A or L	200 [95]	1050–1150 [565–620]
CA6NM	B	1850 [1010]	A or L	200 [95]	1225–1275 [665–690] ^{E,F} 1050–1150 [565–620] ^G

^AA = air, L = Liquid.

^BMinimum temperature unless range is specified.

^CDouble austenitize.

^DDouble temper with the final temper at a lower temperature than the intermediate temper.

^EAir cool to below 200°F [95°C] after first temper.

^FIntermediate.

^GFinal.

7. Tensile Requirements

7.1 Tensile properties of steel used for the castings shall conform to the requirements prescribed in Table 3.

8. Quality

8.1 The surface of the casting shall be free of adhering sand, scale, cracks, and hot tears as determined by visual examination. Other surface discontinuities shall meet the visual acceptance standards specified in the order. Visual Method SP-55 or other visual standards may be used to define acceptable surface discontinuities and finish. Unacceptable visual surface discontinuities shall be removed and their removal verified by visual examination of the resultant cavities. When methods involving high temperatures are used in the removal and repair of discontinuities, the casting shall be preheated to at least the minimum temperature in Table 4.

8.2 The castings shall not be peened, plugged, or impregnated to stop leaks.

9. Repair By Welding

9.1 For castings, other than those intended for use under ASME Boiler and Pressure Vessel Code, repairs shall be made using procedures and welders qualified under Practice A 488/A 488M.

9.2 On castings intended for use under the ASME Boiler and Pressure Vessel Code, repairs shall be made by procedures and welders qualified under Section IX of that code.

9.3 After repair welding, all castings shall be postweld heat treated in accordance with Table 4 or reheat treated in accordance with Table 1.

9.4 Weld repairs shall be inspected using the same quality standards as are used to inspect the castings. Re-examination of the weld repair by radiography when Supplementary Requirement S 5 has been specified will not be necessary when an applicable surface inspection method was used to locate the discontinuity except for the following:

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TABLE 2 Chemical Requirements (Maximum Percent Unless Range is Given)

Grade	1.	2.	4.	6.	7.	8.	9.	10.	11.	12.
Class Type	ABC Vanadium	ABC Manganese-Molybdenum	ABCDE Nickel-Chromium-Molybdenum	AB Manganese Nickel-Chromium-Molybdenum	A Nickel-Chromium-Molybdenum-Vanadium ^A	ABC Chromium-Molybdenum	ABCDE Chromium-Molybdenum	AB Nickel-Chromium-Molybdenum	AB Nickel-Chromium-Molybdenum	AB Nickel-Chromium-Molybdenum
Carbon	0.30	0.30	0.30	0.05–0.38	0.05–0.20	0.05–0.20	0.05–0.33	0.30	0.05–0.20	0.05–0.20
Manganese	1.00	1.00–1.40	1.00	1.30–1.70	0.60–1.00	0.50–0.90	0.60–1.00	0.60 to 1.00	0.50–0.80	0.40–0.70
Phosphorus	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04
Sulfur	0.045	0.045	0.045	0.045	0.045	0.045	0.045	0.045	0.045	0.045
Silicon	0.80	0.80	0.80	0.80	0.80	0.80	0.80	0.80	0.60	0.60
Nickel	0.40–0.80	0.40–0.80	0.70–1.00	1.40–2.00	0.70–1.10	0.60–1.00
Chromium	0.40–0.80	0.40–0.80	0.40–0.80	2.00–2.75	0.75–1.10	0.55–0.90	0.50–0.80	0.50–0.90
Molybdenum	...	0.10–0.30	0.15–0.30	0.30–0.40	0.40–0.60	0.90–1.10	0.15–0.30	0.20–0.40	0.45–0.65	0.90–1.20
Vanadium	0.04–0.12	0.03–0.10
Boron	0.002–0.006
Copper	0.15–0.50
Residual Elements:										
Copper	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50
Nickel	0.50	0.50	0.50
Chromium	0.35	0.35
Mo + W	0.25
Tungsten	...	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10
Vanadium	...	0.03	0.03	0.03	...	0.03	0.03	0.03	0.03	0.03
Total content of residual elements	1.00	1.00	0.60	0.60	0.60	0.60	1.00	0.60	0.50	0.50

Grade	13.	14.	16	CA15	CA15M	CA6NM
Class Type	AB Nickel-Molybdenum	A Nickel-Molybdenum	A Low Carbon Manganese-Nickel (J31200)	ABCD Martensitic Chromium	A Martensitic Chromium	AB Martensitic Chromium Nickel
Carbon	0.30	0.55	0.12 ^B	0.15	0.15	0.06
Manganese	0.80–1.10	0.80–1.10	2.10 ^B	1.00	1.00	1.00
Phosphorus	0.04	0.04	0.02	0.040	0.040	0.04
Sulfur	0.045	0.045	0.02	0.040	0.040	0.03
Silicon	0.60	0.60	0.50	1.50	0.65	1.00
Nickel	1.40–1.75	1.40–1.75	1.00–1.40	1.00	1.0	3.5–4.5
Chromium	11.5–14.0	11.5–14.0	11.5–14.0
Molybdenum	0.20–0.30	0.20–0.30	...	0.50	0.15–1.0	0.4–1.0
Boron
Copper
Residual Elements						
Copper	0.50	0.50	0.20	0.50	0.50	0.50
Nickel
Chromium	0.40	0.40	0.20
Molybdenum	0.10
Tungsten	0.10	0.10	0.10	0.10	0.10	0.10
Vanadium	0.03	0.03	0.02	0.05	0.05	0.05
Total content of residual elements	0.75	0.75	0.50	0.50	0.50	0.50

^AProprietary steel composition.

^BFor each reduction of 0.01 % below the specified maximum carbon content, an increase of 0.04 % manganese above the specified maximum will be permitted up to a maximum of 2.30 %.

9.4.1 Weld repairs on castings which have leaked on hydrostatic test.

9.4.2 Weld repairs on castings in which the depth of any cavity prepared for repair welding is more than 20 % of the wall thickness or 1 in. [25 mm], whichever is smaller.

9.4.3 Weld repairs on castings in which any cavity prepared for welding is greater than approximately 10 in.²[65 cm²].

10. Product Marking

10.1 Castings shall be marked for material identification with the grade and class symbols (1-A, 4-C, CA15-A).

11. Keywords

11.1 steel castings; alloy steel; stainless steel; martensitic stainless steel; pressure containing parts