



Standard Specification for Steel Forgings, General Requirements¹

This standard is issued under the fixed designation A 788; 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 reappraisal. A superscript epsilon (ε) indicates an editorial change since the last revision or reappraisal.

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

1. Scope*

1.1 This specification² covers a group of common requirements that, unless otherwise specified in the individual product specification, shall apply to steel forgings under any of the following specifications issued by ASTM:

ASTM Designation	Title		
A 266/A 266M	Carbon Steel Forgings for Pressure Vessel Components	A 592	High-Strength Quenched and Tempered Low-Alloy Steel Forged Fittings and Parts for Pressure Vessels
A 288	Carbon and Alloy Steel Forgings for Magnetic Retaining Rings for Turbine Generators	A 649/A 649M	Forged Steel Rolls Used for Corrugating Paper Machinery
A 289/A 289M	Alloy Steel Forgings for Nonmagnetic Retaining Rings for Generators	A 668/A 668M	Steel Forgings, Carbon and Alloy, for General Industrial Use
A 290	Carbon and Alloy Steel Forgings for Rings for Reduction Gears	A 723/A 723M	Alloy Steel Forgings for High-Strength Pressure Component Application
A 291	Steel Forgings, Carbon and Alloy, for Pinions, Gears, and Shafts for Reduction Gears	A 765/A 765M	Carbon Steel and Low-Alloy Steel Pressure-Vessel-Component Forgings with Mandatory Toughness Requirements
A 336/A 336M	Alloy Steel Forgings for Pressure and High-Temperature Parts	A 768	Vacuum-Treated 12 % Chromium Alloy Steel Forgings for Turbine Rotors and Shafts
A 372/A 372M	Carbon and Alloy Steel Forgings for Thin-Walled Pressure Vessels	A 837	Steel Forgings, Alloy, for Carburizing Applications
A 427	Wrought Alloy Steel Rolls for Cold and Hot Reduction	A 859/A 859M	Age-Hardening Alloy Steel Forgings for Pressure Vessel Components
A 469/A 469M	Vacuum-Treated Steel Forgings for Generator Rotors	A 891	Precipitation Hardening Iron Base Superalloy Forgings for Turbine Rotor Disks and Wheels
A 470	Vacuum-Treated Carbon and Alloy Steel Forgings for Turbine Rotors and Shafts	A 909	Steel Forgings, Microalloy, for General Industrial Use
A 471	Vacuum-Treated Alloy Steel Forgings for Turbine Rotor Disks and Wheels	A 940	Vacuum Treated Steel Forgings, Alloy, Differentially Heat Treated, for Turbine Rotors
A 508/A 508M	Quenched and Tempered Vacuum-Treated Carbon and Alloy Steel Forgings for Pressure Vessels	A 965/A 965M	Steel Forgings, Austenitic, for Pressure and High Temperature Parts
A 521	Steel, Closed-Impression Die Forgings for General Industrial Use	A 1021	Martensitic Stainless Steel Forgings and Forging Stock for High-Temperature Service
A 541/A 541M	Quenched and Tempered Carbon and Alloy Steel Forgings for Pressure Vessel Components		
A 579	Superstrength Alloy Steel Forgings		

1.2 In case of conflict in requirements, the requirements of the individual product specifications shall prevail over those of this specification.

1.3 The purchaser may specify additional requirements (see 4.2.3) that do not negate any of the provisions of either this specification or of the individual product specifications. The acceptance of any such additional requirements shall be dependent on negotiations with the supplier and must be included in the order.

1.4 If, by agreement, forgings are to be supplied in a partially completed condition, that is, all of the provisions of the product specification have not been filled, then the material marking (see Section 17) and certification (see Section 16) shall reflect the extent to which the product specification requirements have been met.

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 A1.06 on Steel Forgings and Billets.

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-788 in Section II of that code.

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

1.5 As noted in the Certification Section (16), the number and year date of this specification, as well as that of the product specification, are required to be included in the product certification.

1.6 *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 limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:³

- A 266/A 266M Specification for Carbon Steel Forgings for Pressure Vessel Components
- A 275/A 275M Test Method for Magnetic Particle Examination of Steel Forgings
- A 288 Specification for Carbon and Alloy Steel Forgings for Magnetic Retaining Rings for Turbine Generators
- A 289/A 289M Specification for Alloy Steel Forgings for Nonmagnetic Retaining Rings for Generators
- A 290 Specification for Carbon and Alloy Steel Forgings for Rings for Reduction Gears
- A 291 Specification for Steel Forgings, Carbon and Alloy, for Pinions, Gears, and Shafts for Reduction Gears
- A 336/A 336M Specification for Alloy Steel Forgings for Pressure and High-Temperature Parts
- A 370 Test Methods and Definitions for Mechanical Testing of Steel Products
- A 372/A 372M Specification for Carbon and Alloy Steel Forgings for Thin-Walled Pressure Vessels
- A 388/A 388M Practice for Ultrasonic Examination of Heavy Steel Forgings
- A 427 Specification for Wrought Alloy Steel Rolls for Cold and Hot Reduction
- A 469/A 469M Specification for Vacuum-Treated Steel Forgings for Generator Rotors
- A 470 Specification for Vacuum-Treated Carbon and Alloy Steel Forgings for Turbine Rotors and Shafts
- A 471 Specification for Vacuum-Treated Alloy Steel Forgings for Turbine Rotor Disks and Wheels
- A 508/A 508M Specification for Quenched and Tempered Vacuum-Treated Carbon and Alloy Steel Forgings for Pressure Vessels
- A 521 Specification for Steel, Closed-Impression Die Forgings for General Industrial Use
- A 541/A 541M Specification for Quenched and Tempered Carbon Alloy Steel Forgings for Pressure Vessel Components
- A 579 Specification for Superstrength Alloy Steel Forgings
- A 592 Specification for High-Strength Quenched and Tempered Low-Alloy Steel Forged Fittings and Parts for Pressure Vessels
- A 649/A 649M Specification for Forged Steel Rolls Used

- for Corrugating Paper Machinery
- A 668/A 668M Specification for Steel Forgings, Carbon and Alloy, for General Industrial Use
- A 723/A 723M Specification for Alloy Steel Forgings for High-Strength Pressure Component Application
- A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products
- A 765/A 765M Specification for Carbon Steel and Low-Alloy Steel Pressure-Vessel-Component Forgings with Mandatory Toughness Requirements
- A 768 Specification for Vacuum-Treated 12 % Chromium Alloy Steel Forgings for Turbine Rotors and Shafts
- A 833 Practice for Indentation Hardness of Metallic Materials by Comparison Hardness Testers
- A 837 Specification for Steel Forgings, Alloy, for Carburizing Applications
- A 859/A 859M Specification for Age-Hardening Alloy Steel Forgings for Pressure Vessel Components
- A 891 Specification for Precipitation Hardening Iron Base Superalloy Forgings for Turbine Rotor Disks and Wheels
- A 909 Specification for Steel Forgings, Microalloy, for General Industrial Use
- A 939 Test Method for Ultrasonic Examination from Bored Surfaces of Cylindrical Forgings
- A 940 Specification for Vacuum-Treated Steel Forgings, Alloy, Differentially Heat Treated, for Turbine Rotors
- A 941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys
- A 965/A 965M Specification for Steel Forgings, Austenitic, for Pressure and High Temperature Parts
- A 966/A 966M Test Method for Magnetic Particle Examination of Steel Forgings Using Alternating Current
- A 991/A 991M Test Method for Conducting Temperature Uniformity Surveys of Furnaces Used to Heat Treat Steel Products
- A 1021 Specification for Martensitic Stainless Steel Forgings and Forging Stock for High-Temperature Service
- E 23 Test Methods for Notched Bar Impact Testing of Metallic Materials
- E 112 Test Methods for Determining Average Grain Size
- E 165 Test Method for Liquid Penetrant Examination
- E 380 Practice for Use of the International System of Units (SI) (The Modernized Metric System)⁴
- E 399 Test Method for Plane-Strain Fracture Toughness of Metallic Materials
- E 428 Practice for Fabrication and Control of Steel Reference Blocks Used in Ultrasonic Examination
- E 1290 Test Method for Crack-Tip Opening Displacement (CTOD) Fracture Toughness Measurement
- E 1820 Test Method for Measurement of Fracture Toughness
- E 1916 Guide for Identification and/or Segregation of Mixed Lots of Metals

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.

⁴ Withdrawn.

3. Terminology

3.1 Terminology A 941 is applicable to this specification. Additional terms and wording more applicable to forgings are as noted in this section.

3.2 Definitions:

3.2.1 *steel forging*—the product of a substantially compressive plastic working operation that consolidates the material and produces the desired shape. The plastic working may be performed by a hammer, press, forging machine, or ring rolling machine, and must deform the material to produce an essentially wrought structure. Hot rolling operations may be used to produce blooms or billets for reforging. Forgings may be subdivided into the following three classes on the basis of their forging temperatures:

3.2.1.1 *cold-worked forgings*—forgings produced by plastic working well below the temperature range at which recrystallization of the material occurs. Cold-worked forgings must be made from material previously hot worked by forging or rolling.

3.2.1.2 *hot-cold-worked forgings*—forgings worked at elevated temperatures slightly below the recrystallization range to increase mechanical strength. Hot-cold-worked forgings must be made from material previously hot worked by forging or rolling. A hot-cold-worked forging may be produced in one continuous operation wherein the material is first hot worked and then cold-worked by control of the finishing temperature.

Discussion—Because of differences in manufacture, hot rolled, or hot rolled and cold finished bars (semi-finished or finished), billets or blooms are not considered to be forgings.

3.2.1.3 *hot-worked forgings*—forgings produced by working at temperatures above the recrystallization temperature for the material.

3.3 *Billets and Blooms*—Interchangeable terms representing hot worked semi-finished product intended as a starting stock for making forgings.

3.3.1 *Discussion*—No size limitations are assumed for either term. Cast shapes produced by a continuous casting process, without subsequent work, are considered to be ingots for the purposes of this specification, and if supplied as billets or blooms must carry the descriptor *Cast Billet* or *Cast Bloom*.

3.4 Definitions of Terms Specific to This Standard:

3.4.1 *bottom pouring*—steel from a single heat, or from a multiple heat tapped into a common ladle (see 8.1.1 and 8.1.2), introduced into ingot mold(s) such that they are filled from the bottom up. One or more molds can be set up on an individual plate, and more than one plate may be poured in sequence from a heat. The plate is generally constructed such that the molten steel can be ducted through refractory channels to the bottom of each mold on the plate. The steel is poured into a central sprue that is high enough to permit filling the ingot molds to the required level.

3.4.2 *ingot*—the product obtained when molten steel, upon being cast into a mold, is subsequently capable of being wrought in conformance with 3.1. Open-ended molds, that are usually cooled and used, for example, in the continuous casting of steel, are considered to be included in this definition.

3.4.3 *intercritical heat treatment*—use of a multi-stage heat treatment procedure in which the material is first austenitized at

a temperature above the upper critical temperature (Ac3) followed by cooling below the lower critical temperature (Ac1). The material is then reheated to a temperature in the intercritical range between the Ac1 and the Ac3 and again cooled below the Ac1, followed by subcritical tempering in the range specified in the material specification.

3.4.3.1 *Discussion*—This procedure is generally applicable to low hardenability carbon and low alloy steels that would usually have a microstructure of ferrite and pearlite in the heat treated section size of the component being heat treated.

3.4.4 *killed steel*—steel deoxidized, either by the addition of strong deoxidizing agents or by vacuum treatment, to reduce the oxygen content to such a level that essentially no reaction occurs between carbon and oxygen during solidification

3.4.4.1 *Discussion*—Vacuum carbon deoxidation (VCD) is a steelmaking process in which primary deoxidation occurs during vacuum treatment as a result of the carbon-oxygen reaction. In order for primary deoxidation to occur during vacuum treatment, deoxidizing agents such as aluminum or silicon are not to be added to the melt in any significant amount prior to the vacuum treatment operation.

3.4.4.2 *Discussion*—Precipitation deoxidation is a steelmaking process in which primary deoxidation is achieved by the addition of strong deoxidizing agents, such as aluminum, early in the process, and holding the steel in the molten state for sufficient time for the products of deoxidation to separate from the melt to the slag.

3.4.5 *sequential or continuous strand casting*—steel from several heats poured consecutively into a cooled open-ended mold to form a continuous cast product with a change from heat to heat along its length.

3.4.6 *strand casting*—steel from one heat poured into a cooled open-ended mold to form a continuous strand or strands.

4. Ordering Information

4.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for forgings under the applicable product specification. Such requirements to be considered include, but are not restricted to, the following:

4.1.1 Quantity,

4.1.2 Dimensions, including tolerances and surface finishes, and so forth.

4.1.3 Specification number with type, class, and grade as applicable (including year date), and should include:

4.1.4 Number of copies of the material test report.

4.2 Additional information including the following may be added by agreement with the supplier:

4.2.1 Type of heat treatment when alternative methods are allowed by the product specification,

4.2.2 Supplementary requirements, if any, and

4.2.3 Additional requirements (see 1.4, 16.1.5, and 16.1.6).

4.2.4 Repair welding NOT permitted.

5. Melting Process

5.1 Unless otherwise specified in the product specification, the steel shall be produced by any of the following primary processes: electric-furnace, basic oxygen, vacuum-induction (VIM) or open-hearth. The primary melting may incorporate

separate degassing or refining and may be followed by secondary melting, using electro slag remelting (ESR) or vacuum arc remelting (VAR).

5.1.1 The steel shall be fully killed.

5.2 The molten steel may be vacuum-treated prior to or during pouring of the ingot.

5.2.1 When vacuum treatment of the molten steel is required by the product specification the following conditions shall apply:

5.2.1.1 When the vacuum stream degassing process is used, the vacuum system must be of sufficient capacity to effect a blank-off pressure low enough (usually less than 1000 μm), to break up the normal tight, rope-like stream of molten metal into a wide-angled conical stream of relatively small droplets. The capacity of the system must also be sufficiently high to reduce the initial surge pressure at the start of the pour to a low level within 2 min.

5.2.1.2 When the vacuum-lift process is utilized, the molten metal shall be repeatedly drawn into the evacuated vessel to give a recirculation factor (see [Annex A1](#)) of at least 2.5 to ensure thorough degassing and mixing of the entire heat. The evacuation system shall be capable of reducing the pressure surges, which occur each time a new portion of steel is admitted to the vessel to increasingly lower levels, until a blank-off pressure (usually less than 1000 μm) is achieved signifying the end of the degassing treatment.

5.2.1.3 When the ladle degassing process is used, the evacuation system shall be capable of reducing the system vacuum pressure to a low level (usually less than 1000 μm). The molten metal shall be adequately stirred for a sufficient length of time to maximize exposure to the evacuated atmosphere.

5.2.1.4 Other methods of vacuum treatment may be used if the supplier can demonstrate adequate degassing and acceptable properties in the finished forging to the satisfaction of the purchaser.

6. Forging

6.1 Forgings shall be made in accordance with [3.2.1](#).

7. Cooling Prior to Heat Treatment

7.1 After forging and before reheating for heat treatment, the forgings shall be allowed to cool in such a manner as to prevent injury and, in the case of ferritic forgings, to permit substantially complete transformation of austenite.

8. Chemical Composition

8.1 Heat Analysis:

8.1.1 An analysis of each heat of steel shall be made by the steel producer to determine the percentages of those elements specified in the product specification. This analysis shall be made from a test sample preferably taken during the pouring of the heat and shall conform to the requirements of the product specification.

8.1.2 When multiple heats are tapped into a common ladle, the ladle chemistry shall apply. The chemical composition thus determined shall conform to the requirements of the product specification.

8.1.3 For multiple-heat ingots, either individual heat analyses or a weighted average (see [Annex A2](#)) may be taken. The results of the method used shall conform to the requirements of the product specification.

8.1.4 With the exception of the product from multiple heats sequentially cast in strand casting machines (see [8.1.5](#)), if the test sample taken for a heat analysis is lost or declared inadequate for chemical determinations, the steel producer may take alternative samples from appropriate locations near the surface of the ingot or forging as necessary to establish the analysis of the heat in question.

8.1.5 For multiple heats sequentially cast in strand casting machines, the heat analysis shall be determined for each individual heat in accordance with [8.1.1](#) or [8.1.2](#) if applicable.

8.1.5.1 If, for multiple heats sequentially strand cast, the test sample is lost or declared inadequate for chemical analysis determination, alternative samples, remote from the transition zones, may be taken by the steel producer from the cast material or product of that heat, as defined in [8.2](#) or [8.3](#) as appropriate.

8.1.6 Heat Analysis for Remelted Ingots:

8.1.6.1 When consumable remelting processes are used, a chemical analysis shall be taken from a remelted ingot (or the product of a remelted ingot) for the remelt heat analysis.

8.1.6.2 When more than one electrode is prepared from a master or parent heat for remelting in the same facility by the same process, then the heat analysis obtained from one remelted ingot, or the product from that ingot, shall be taken as the heat analysis for all of the remelted ingots from that master heat. For analysis from each remelted ingot, see [S27](#).

8.1.6.3 When electrodes from different master heats are remelted sequentially, an analysis shall be made in each zone of the remelted ingot corresponding to at least one electrode from each master heat. The resultant chemical analysis of each zone shall conform to the requirements of the product specification. The heat analysis of the remelted ingot shall be represented by a weighted average (see [Annex A2](#)) of the individual chemical analyses for each zone.

8.1.6.4 Limits on aluminum content in remelt ingots shall be set as required in the product specification.

8.2 *Heat Number Assignment for Sequentially Strand Cast Material*—When heats of the same chemical composition are sequentially strand cast, the heat number assigned to the cast product may remain unchanged until all of the steel in the product is from the following heat, except when Supplementary Requirement S3 is invoked.

8.3 *Identification of Material of Different Chemical Composition Ranges, Sequentially Strand Cast*—Because of intermixing in the tun dish, separation and identification of the resultant transition material is required when steels of different chemical composition ranges are sequentially strand cast. The steel producer shall remove the transition material by any established procedure that positively separates the grades.

8.4 Product Analysis:

8.4.1 An analysis may be made by the purchaser from a forging representing each heat or multiple heat (see [8.1](#)). Samples for analysis may be taken from the forging or from a full-size prolongation at any point from the midradius to the



outer surface of disk or other solid forgings or midway between the inner and outer surfaces of hollow or bored forgings. The analysis may also be taken from a mechanical test specimen or the mechanical test location as defined in the product specification.

8.4.2 The chemical composition thus determined shall conform to the requirements of the forging specification subject to the permissible variations specified in **Table 1**, for those elements listed in the product specification. Limitations on the

TABLE 1 Permissible Variations in Product Analysis for Killed Steel

NOTE 1—This table covers permissible variations in product analysis for most of the elements commonly found in killed steels under the jurisdiction of A01.06. This table is applicable only for those elements for which product analysis variations are permitted by the material specification.

NOTE 2—Product cross-sectional area (taken at right angles to the axis of the original ingot or billet) is defined as either: (a) maximum cross-sectional area of rough machined forging (excluding boring), (b) maximum cross-sectional area of the unmachined forging, or (c) maximum cross-sectional area of the billet bloom or slab.

Element	Permissible Variation Over the Specified Maximum Limit or Under the Specified Minimum Limit, %						
	Maximum or Specified Range—l	Up to and incl 100 in. ² (650 cm ²) ^A	Over 100 ^A to 200 in. ² (650 to 1300 cm ²)	Over 200 in. ² to 400 in. ² (1300 to 2600 cm ²)	Over 400 in. ² to 800 in. ² (2600 to 5200 cm ²)	Over 800 in. ² to 1600 in. ² (5200 to 10300 cm ²)	Over 1600 in. ² (over 10300 cm ²)
Carbon	Up to and incl 0.05	0.005	0.005	0.005	0.01	0.01	0.01
	0.06 to 0.10, incl	0.01	0.01	0.01	0.01	0.01	0.01
	0.11 to 0.25, incl	0.02	0.03	0.03	0.04	0.05	0.05
	0.26 to 0.55, incl	0.03	0.04	0.04	0.05	0.06	0.06
	0.56 and over	0.04	0.05	0.05	0.06	0.07	0.07
Manganese	Up to and incl 0.90	0.03	0.04	0.05	0.06	0.07	0.08
	0.91 and over	0.06	0.06	0.07	0.08	0.08	0.09
Phosphorus	Up to and incl 0.05	0.008	0.008	0.010	0.010	0.015	0.015
Sulfur	Up to and incl 0.030	0.005	0.005	0.005	0.005	0.006	0.006
	0.031 to 0.060 incl	0.008	0.010	0.010	0.010	0.015	0.015
Silicon	Up to and incl 0.35	0.02	0.03	0.04	0.04	0.05	0.06
	0.36 and over	0.05	0.06	0.06	0.07	0.07	0.08
Nickel	Up to and incl 1.00	0.03	0.03	0.03	0.03	0.03	0.03
	1.01 to 2.00, incl	0.05	0.05	0.05	0.05	0.05	0.05
	2.01 to 5.30, incl	0.07	0.07	0.07	0.07	0.07	0.07
	5.31 to 10.00, incl	0.10	0.10	0.10	0.10	0.10	0.10
Chromium	10.01 and over	0.15	0.15	0.15	0.15	0.15	0.15
	Up to and incl 0.90	0.03	0.04	0.04	0.05	0.05	0.06
	0.91 to 2.10, incl	0.05	0.06	0.06	0.07	0.07	0.08
	2.11 to 10.00, incl	0.10	0.10	0.12	0.14	0.15	0.16
	10.01 to 15.00, incl	0.15	0.15	0.15	0.17	0.17	0.19
Molybdenum	15.01 to 20.00, incl	0.20	0.20	0.20	0.22	0.24	0.24
	20.01 and over	0.25	0.25	0.25	0.27	0.27	0.29
	Up to and incl 0.20	0.01	0.02	0.02	0.02	0.03	0.03
	0.21 to 0.40, incl	0.02	0.03	0.03	0.03	0.04	0.04
	0.41 to 1.15, incl	0.03	0.04	0.05	0.06	0.07	0.08
Vanadium	1.16 to 5.50, incl	0.05	0.06	0.08	0.10	0.12	0.12
	Up to and incl 0.10	0.01	0.01	0.01	0.01	0.01	0.01
	0.11 to 0.25, incl	0.02	0.02	0.02	0.02	0.02	0.02
	0.26 to 0.50, incl	0.03	0.03	0.03	0.03	0.03	0.03
Columbium (Niobium)	0.51 to 1.25, incl	0.04	0.04	0.04	0.04	0.04	0.04
	Up to and incl 0.14	0.02	0.02	0.02	0.02	0.03	0.03
Titanium	0.15 to 0.50, incl	0.06	0.06	0.06	0.06	0.07	0.08
	Up to and incl 0.85	0.05	0.05	0.05	0.05	0.05	0.05
Cobalt	Up to and incl 0.25	0.01	0.01	0.01	0.01	0.01	0.01
	0.25 to 5.00, incl	0.07	0.07	0.07	0.08	0.08	0.09
	5.01 to 10.00, incl	0.14	0.14	0.14	0.16	0.16	0.18
Tungsten	Up to and incl 1.00	0.05	0.05	0.05	0.06	0.06	0.07
	1.01 to 4.00, incl	0.09	0.09	0.10	0.12	0.12	0.14
Copper	Up to and incl 1.0	0.03	0.03	0.03	0.03	0.03	0.03
	1.01 to 2.00, incl	0.05	0.05	0.05	0.05	0.05	0.05
	2.01 to 5.00, incl	0.07	0.07	0.07	0.07	0.07	0.07
Aluminum	Up to and incl 0.03	0.01	0.01	0.01	0.01	0.01	0.01
	Over 0.03 to 0.05, incl	0.01	0.01	0.02	0.02	0.03	0.03
	0.06 to 0.15, incl	0.02	0.02	0.02	0.03	0.03	0.03
	0.16 to 0.50, incl	0.05	0.05	0.06	0.07	0.07	0.08
	0.50 to 2.00, incl	0.10	0.10	0.10	0.12	0.12	0.14
Zirconium	Up to and incl 0.15	0.01	0.01	0.01	0.01	0.01	0.01
Nitrogen	Up to 0.02 incl	0.005	0.005	0.005	0.005	0.005	0.005
	Over 0.02 to 0.19, incl	0.01	0.01	0.01	0.01	0.01	0.01
	Over 0.19 to 0.25, incl	0.02	0.02	0.02	0.02	0.02	0.02
	Over 0.25 to 0.35, incl	0.03	0.03	0.03	0.03	0.03	0.03
	Over 0.35 to 0.45, incl	0.04	0.04	0.04	0.04	0.04	0.04

^A When the product size range up to 100 in.² is deleted, then the 100 to 200-in.² column shall be changed to read up to and including 200 in.²

application of the allowances in [Table 1](#) may be made in the product specification for specified elements.

8.5 *Residual and Unspecified Elements*—Provisions for the limitation of certain residual and unspecified elements have been made in Supplementary Requirements S1 and S2, respectively.

8.6 Grade substitution is not permitted.

8.7 *Method of Analysis*—Methods included in Test Methods, Practices, and Terminology [A 751](#) shall be used for referee purposes.

9. Heat Treatment

9.1 Heat treatment shall be performed as specified in the product specification. Supplementary Requirement S4 concerns a specialized heat treat process (see [3.4.3](#)) whose application will be controlled in the product specification. Unless otherwise specified during a heat treating hold cycle, the recorded furnace temperature shall be within $\pm 25^{\circ}\text{F}$ ($\pm 15^{\circ}\text{C}$) of the controlling set point temperature. Material shall be heat treated in the working zone of a furnace that has been surveyed in accordance with Test Method [A 991/A 991M](#) provided that the working zone was established using a variation of $\pm 25^{\circ}\text{F}$ ($\pm 15^{\circ}\text{C}$) or less from the furnace set point.

10. Mechanical Testing

10.1 *Test Methods*—All tests shall be conducted in accordance with Test Methods and Definitions [A 370](#).

10.1.1 In addition to the hardness testing provisions of Test Methods and Definitions [A 370](#), comparison hardness testing in accordance with Practice [A 833](#) may be used in determining the hardness of forgings.

10.2 *Retests*—If the results of the tension tests do not conform to the requirements specified, retests are permitted as outlined in Test Methods and Definitions [A 370](#) or as follows:

10.2.1 If the percentage of elongation or reduction of area of any tension test specimen is less than specified because a flaw becomes evident in the test specimen during testing, a retest shall be allowed provided that the defect was not attributable to ruptures, cracks, or flakes in the steel.

10.2.2 If the average impact energy value meets the specification requirements, but the energy value for one specimen is below the specified minimum value for individual specimens prescribed in the material specification, a retest is permitted. This shall consist of two impact specimens from a location adjacent to and on either side of the specimen that failed. Each of the retested specimens must exhibit an energy value equal to or greater than the minimum average value required by the product specification.

11. Reheat Treatment

11.1 If the results of the initial mechanical tests do not conform to the specified requirements, the forgings may be heat treated (if initially tested in the as-forged condition) or reheat treated (if heat treated prior to initial testing).

12. Repair Welding

12.1 Repair welding of forgings is not permitted unless specifically allowed by the product specification (see also [4.2.4](#)).

13. Dimensions and Finish

13.1 The forgings shall conform to the dimensions, tolerances, and finishes required by the ordering information ([4.1.2](#)). Supplementary Requirements S5 or S6, concerning straightening of forgings, may be used.

14. Inspection

14.1 All tests and inspections other than [8.4](#) shall be made at the place of manufacture, unless otherwise agreed upon.

14.2 The manufacturer shall afford the purchaser's inspector all reasonable facilities necessary to satisfy him that the material is being produced and furnished in accordance with the material specification.

14.3 Mill inspection by the purchaser shall not interfere unnecessarily with the manufacturer's operations.

15. Rejection

15.1 Any rejection based on the presence of an injurious defect found subsequent to acceptance at the manufacturer's works or based on the results of a product analysis made in accordance with [8.4](#) shall be reported to the manufacturer.

15.2 Disposition of forgings rejected by the purchaser under [15.1](#) shall be as agreed upon between manufacturer and the purchaser.

16. Certification

16.1 The manufacturer shall furnish to the purchaser the number of copies of the material test report specified in the ordering information ([4.1.4](#)). The following items shall be reported:

16.1.1 Purchase order number,

16.1.2 Forging identification number,

16.1.3 The product specification number, including the year date and revision letter if any, as well as the appropriate class, type, and grade,

16.1.3.1 Reference to Specification [A 788](#) including the year date together with the applicable revision letter, if any, of the revision used shall be a part of the certification.

16.1.4 Heat number and analysis,

16.1.5 Results of the required acceptance tests for mechanical properties,

16.1.6 Results of any required nondestructive examinations,

16.1.7 Final heat treatment cycle including austenitizing and tempering temperatures and holding times and cooling methods if required by the product specification or [4.2.3](#),

16.1.8 Extent to which the forging is incomplete with respect to the product specification (see [1.4](#) and [16.1.7](#)), and

16.1.9 Results of any supplementary and additional test requirements that were specified.

16.1.10 The material test report may be sent to the purchaser in electronic form from an electronic data interchange (EDI) transmission, and this shall be regarded as having the same validity as a counterpart printed in the certifier's facility. The content of the EDI transmitted document shall meet the requirements of the invoked ASTM standard(s) and conform to any existing EDI agreement between the purchaser and the supplier. Notwithstanding the absence of a signature, the organization submitting the EDI transmission is responsible for the content of the report.