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Standard Specification for Steel, Sheet, Carbon, Structural, and High-Strength, Low- Alloy, Hot-Rolled and Cold-Rolled, General Requirements for¹

This standard is issued under the fixed designation A 568/A 568M; 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 specification covers the general requirements for steel sheet in coils and cut lengths. It applies to the following specifications that describe carbon steel, structural steel, and high-strength, low-alloy steel (HSLA) furnished as hot-rolled sheet and cold-rolled sheet: Specifications A 414/A 414M, A 424, A 606, A 659/A 659M, A 794, A 1008/A 1008M, A 1011/A 1011M, and A 1039/A 1039M.

1.2 This specification is not applicable to hot-rolled heavy-thickness carbon sheet coils (Specification ~~A635A~~ A 635/A 635M/ A635M).

1.3 In case of any conflict in requirements, the requirements of the individual material specification shall prevail over those of this general specification.

1.4 For the purposes of determining conformance with this and the appropriate product specification referenced in 1.1, values shall be rounded to the nearest unit in the right hand place of figures used in expressing the limiting values in accordance with the rounding method of Practice E 29.

1.5 Annex A1 lists permissible variations in dimensions and mass (see Note 1) in SI [metric] units. The values listed are not exact conversions of the values listed in the inch-pound tables, but instead are rounded or rationalized values. Conformance to Annex A1 is mandatory when the "M" specification is used.

NOTE 1—The term *weight* is used when inch-pound units are the standard. However, under SI the preferred term is *mass*.

1.6 The values stated in either inch-pound units or SI units are to be regarded 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.

1.7 This specification and the applicable material specifications are expressed in both inch-pound units and SI units. However, unless the order specifies the applicable "M" specification designation (SI units), the material shall be furnished to inch-pound units.

2. Referenced Documents

2.1 ASTM Standards:²

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

A 414/A 414M Specification for Steel, Sheet, Carbon, for Pressure Vessels

A 424 Specification for Steel, Sheet, for Porcelain Enameling

A 606 Specification for Steel, Sheet and Strip, High-Strength, Low-Alloy, Hot-Rolled and Cold-Rolled, with Improved Atmospheric Corrosion Resistance

A 635/A 635M Specification for Steel, Sheet and Strip, Heavy-Thickness Coils, Hot-Rolled, Carbon, Structural, High-Strength Low-Alloy, and High-Strength Low-Alloy with Improved Formability, General Requirements for

A 659/A 659M Specification for Commercial Steel (CS), Sheet and Strip, Carbon (0.16 Maximum to 0.25 Maximum Percent), Hot-Rolled

A 700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Domestic Shipment

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 A01.19 on Steel Sheet and Strip.

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² 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.

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

- A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products
- A 794 Specification for Commercial Steel (CS), Sheet, Carbon (0.16 % Maximum to 0.25 % Maximum), Cold-Rolled
- ~~A 1008/A 1008M Specification for Steel, Sheet, Cold-Rolled, Carbon, Structural, High-Strength Low-Alloy and High-Strength Low-Alloy with Improved Formability~~ Specification for Steel, Sheet, Cold-Rolled, Carbon, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, Solution Hardened, and Bake Hardenable
- ~~A 1011/A 1011M Specification for Steel, Sheet and Strip, Hot-Rolled, Carbon, Structural, High-Strength Low-Alloy and High-Strength Low-Alloy with Improved Formability~~ Specification for Steel, Sheet and Strip, Hot-Rolled, Carbon, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, and Ultra-High Strength
- A 1030/A 1030M Practice for Measuring Flatness Characteristics of Steel Sheet Products
- A 1039/A 1039M Specification for Steel, Sheet, Hot Rolled, Carbon, Commercial and Structural, Produced by the Twin-Roll Casting Process
- E 11 Specification for Wire Cloth and Sieves for Testing Purposes
- E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E 59 Practice for Sampling Steel and Iron for Determination of Chemical Composition³
- E 290 Test Methods for Bend Testing of Material for Ductility
- 2.2 *Military Standards:*⁴
 - MIL-STD-129 Marking for Shipment and Storage
 - MIL-STD-163 Steel Mill Products Preparation for Shipment and Storage
- 2.3 *Federal Standards:*⁴
 - Fed. Std. No. 123 Marking for Shipments (Civil Agencies)
 - Fed. Std. No. 183 Continuous Identification Marking of Iron and Steel Products

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 Steel Types:

3.1.2 *carbon steel*—designation for steel when no minimum content is specified or required for aluminum, chromium, cobalt, columbium, molybdenum, nickel, titanium, tungsten, vanadium, zirconium, or any element added to obtain a desired alloying effect; when the specified minimum for copper does not exceed 0.40 %; or when the maximum content specified for any of the following elements does not exceed the percentages noted: manganese 1.65, silicon 0.60, or copper 0.60.

3.1.2.1 *Discussion*—In all carbon steels small quantities of certain residual elements unavoidably retained from raw materials are sometimes found which are not specified or required, such as copper, nickel, molybdenum, chromium, etc. These elements are considered as incidental and are not normally determined or reported.

3.1.3 *high-strength, low-alloy steel*—specific group of steels in which higher strength, and in some cases additional resistance to atmospheric corrosion or improved formability, are obtained by moderate amounts of one or more alloying elements.

3.1.4 Product Types:

3.1.5 *hot-rolled sheet*—manufactured by hot rolling slabs in a continuous mill to the required thickness and can be supplied in coils or cut lengths as specified.

(1) Hot-rolled carbon and high-strength low-alloy (HSLA) steel sheet is commonly classified by size as follows:

| Width, in. | Coils and Cut Lengths | Thickness, in. |
|------------------------|-----------------------|----------------------|
| 12 to 48, incl | | 0.027 to 0.230, excl |
| Over 48 | | 0.027 to 0.180, excl |
| | | |
| Width, mm | Coils and Cut Lengths | Thickness, mm |
| Over 300 to 1200, incl | | 0.7 to 6.0, excl |
| Over 1200 | | 0.7 to 4.5, excl |

3.1.6 *cold-rolled sheet*—manufactured from hot-rolled descaled coils by cold reducing to the desired thickness, generally followed by annealing to recrystallize the grain structure. If the sheet is not annealed after cold reduction it is known as full hard with a hardness of 84 HRB minimum and can be used for certain applications where ductility and flatness are not required.

(1) Cold-rolled carbon sheet is commonly classified by size as follows:

| Width, in. | Thickness, in. |
|---------------------------------------|----------------|
| Through 12 ^A | Through 0.082 |
| Over 12 ^B through 23 15/16 | Through 0.142 |
| Over 23 15/16 | Through 0.142 |
| Width, mm | Thickness, mm |

³ Withdrawn.

⁴ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.



To 300, incl^A
Over 300^B

Through 2.0
Through 4.0

^A Cold-rolled sheet coils and cut lengths, slit from wider coils with cut edge (only) and in thicknesses through 0.082 in. [2.0 mm] carbon 0.25 % maximum by cast analysis.
^B When no special edge or finish (other than matte, commercial bright, or luster finish) or single strand rolling of widths, or both under 24 in. [600 mm] is not specified or required.

(2) Cold-rolled high-strength low-alloy sheet is commonly classified by size as follows:

| | |
|---|---|
| Width, in. Through 12 ^A Over 12 ^B | Thickness, in. 0.019 through 0.082 0.020 and over |
| Width, mm To 300, incl ^A Over 300 ^B | Thickness, mm 0.5 to 2.0, incl 0.5 and Over |

^A Cold-rolled sheet coils and cut lengths, slit from wider coils with cut edge (only) and in thicknesses 0.019 in. [0.5 mm] through 0.82 in. [2.0 mm] carbon 0.25 % maximum by cast analysis.

^B When no special edge or finish (other than matte, commercial bright, or luster finish) or single strand rolling of widths, or both under 24 in. [600 mm] is not specified or required.

3.1.6.1 *Discussion*—Steel products are available in various thickness, width, and length combinations depending upon equipment and processing capabilities of various manufacturers and processors. Historic limitations of a product based upon dimensions (thickness, width, and length) do not take into account current production and processing capabilities. To qualify any product for a particular product specification requires all appropriate and necessary tests be performed and that the results meet the limits prescribed in that product specification. If the necessary tests required by a product specification cannot be conducted, the product cannot be qualified to that specification. This general requirements specification contains permitted variations for the commonly available sizes. Permitted variations for other sizes are subject to agreement between the customer and the manufacturer or processor, whichever is applicable.

3.1.7 *retests, n*—additional test, or tests, made from the original material when the original test did not meet the appropriate acceptance criteria required by a product specification and the failure was mechanical in nature as described in Section 11.

3.1.8 *resample, n*—additional test, test or tests, tests made when the test on the original sample did not meet the appropriate acceptance criteria required by the product specification, but possibly possibly requiring that the material in question have an appropriate amount discarded prior to securing the new sample or samples.

4. Materials and Manufacture

4.1 Unless otherwise specified, hot-rolled material shall be furnished hot-rolled, not annealed, not pickled.

4.2 Coil breaks, stretcher strains, and fluting can occur during the user’s processing of hot-rolled or hot-rolled pickled sheet. When any of these features are detrimental to the application, the manufacturer shall be notified at time of ordering in order to properly process the sheet.

4.3 Cold-rolled carbon steel sheet is available as discussed in 10.2, 10.3, and in Table 1.

4.4 Unless specified as a full-hard product, cold-rolled sheet is annealed after being cold reduced to thickness. The annealed, cold-rolled sheet can be used as annealed last (dead soft) for unexposed end-use applications. When cold-rolled sheet is used for

TABLE 1 Cold-Rolled Sheet Steel Class Comparison

| | Exposed | Unexposed |
|--|---|---|
| Major imperfections: | | |
| Cut lengths | Mill rejects | Mill rejects |
| Coils | Purchaser accepts within the manufacturer’s published standards (policy) | Purchaser accepts within the manufacturer’s published standards (policy) |
| Minor imperfections: | | |
| Cut lengths | Mill rejections repetitive imperfections. May contain random imperfections which the purchaser accepts within the manufacturer’s published standards (policy) | Purchaser accepts all minor imperfections |
| Coils | Purchaser accepts within the manufacturer’s published standards (policy) | Purchaser accepts all minor imperfections |
| Finish | Matte unless otherwise specified | Purchaser accepts all finishes |
| Special oils | May be specified | May not be specified |
| Thickness, width and length tolerance: | | |
| Standard | Will be met | Will be met |
| Restricted | May be specified | May not be specified |
| Flatness tolerance: | | |
| Standard | Will be met | Will be met (temper rolled) Not guaranteed—normally within twice standard (annealed last) |
| Restricted Squareness | May be specified | May not be specified |
| Coil wraps | Purchaser accepts within the manufacturer’s published standards (policy) | Purchaser accepts all |
| Coil welds | Purchaser accepts within the manufacturer’s published standards (policy) | Purchaser accepts within the manufacturer’s published standards (policy) |
| Outside inspection | May be specified | May not be specified |
| Special testing | May be specified | May not be specified |

unexposed applications and coil breaks are a hazard in uncoiling, it may be necessary to further process the material. In this case the manufacturer should be consulted. After annealing, cold-rolled sheet is generally given a light skin pass to impart shape or may be given a heavier skin pass or temper pass to prevent the phenomenon known as stretcher straining or fluting, when formed. Temper passing also provides a required surface texture.

4.5 Temper Rolling:

4.5.1 Unless otherwise specified, cold-rolled sheet for exposed applications shall be temper rolled and is usually specified and furnished in the strain free condition as shipped. See Appendix X1, Effect of Aging of Cold-Rolled Carbon Steel Sheet on Drawing and Forming.

4.5.2 Cold-rolled sheet for unexposed applications may be specified and furnished “annealed last” or “temper rolled.” “Annealed last” is normally produced without temper rolling but may be lightly temper rolled during oiling or rewinding. Unexposed temper-rolled material may be specified strain-free or nonfluting. Where specific hardness range or limit or a specified surface texture is required, the application is considered as exposed.

NOTE 2—Skin-passed sheet is subject to an aging phenomenon (see Appendix X1). Unless special killed (nonaging) steel is specified, it is to the user’s interest to fabricate the sheet as soon as possible, for optimum performance.

5. Chemical Composition

5.1 Limits:

5.1.1 The chemical composition shall be in accordance with the applicable product specification. However, if other compositions are required for carbon steel, they shall be prepared in accordance with Appendix X2.

5.1.2 Where the material is used for fabrication by welding, care must be exercised in selection of chemical composition or mechanical properties to assure compatibility with the welding process and its effect on altering the properties.

5.2 Cast or Heat Analysis:

5.2.1 An analysis of each cast or heat of steel shall be made by the manufacturer to determine the percentage of elements specified or restricted by the applicable specification.

5.2.2 When requested, cast or heat analysis for elements listed or required shall be reported to the purchaser or to his representative.

5.3 Product, Check, or Verification Analysis:

5.3.1 Non-killed steels such as capped or rimmed steels are not technologically suited to product analysis due to the nonuniform character of their chemical composition and therefore, the tolerances in Table 2 do not apply. Product analysis is appropriate on these types of steel only when misapplication is apparent or for copper when copper steel is specified.

5.3.2 For steels other than non-killed (capped or rimmed), product analysis may be made by the purchaser. The chemical analysis shall not vary from the limits specified by more than the amounts in Table 2. The several determinations of any element

TABLE 2 Tolerances for Product Analysis

| Element | Limit, or Maximum of Specified Element, % | Tolerance | |
|------------------------|---|---------------------|--------------------|
| | | Under Minimum Limit | Over Maximum Limit |
| Carbon | to 0.15 incl | 0.02 | 0.03 |
| | over 0.15 to 0.40 incl | 0.03 | 0.04 |
| | over 0.40 to 0.80 incl | 0.03 | 0.05 |
| | over 0.80 | 0.03 | 0.06 |
| Manganese | to 0.60 incl | 0.03 | 0.03 |
| | over 0.60 to 1.15 incl | 0.04 | 0.04 |
| | over 1.15 to 1.65 incl | 0.05 | 0.05 |
| Phosphorus | ... ^A | ... ^A | 0.01 |
| Sulfur | ... ^A | ... ^A | 0.01 |
| Silicon | to 0.30 incl | 0.02 | 0.03 |
| | over 0.30 to 0.60 incl | 0.05 | 0.05 |
| Copper | ... ^A | 0.02 | ... ^A |
| Nickel | to 1.00 incl | ... ^A | 0.03 |
| Chromium | to 0.90 incl | ... ^A | 0.04 |
| Molybdenum | to 0.20 incl | ... ^A | 0.01 |
| Vanadium | to 0.10 incl | 0.01 ^B | 0.01 ^B |
| Columbium (Niobium) | to 0.10 incl | 0.01 ^B | 0.01 ^B |
| Titanium | to 0.15 incl | 0.01 ^A | 0.01 ^B |
| Aluminum | to 0.10 incl | 0.03 ^C | ... ^A |
| Nitrogen | to 0.030 incl | 0.005 | 0.005 |

^A Where an ellipsis (. . .) appears in the table, the requirements have not been defined.

^B If the minimum of the range is 0.01%, the under tolerance is 0.005%.

^C If the minimum of the range is 0.01%, the under tolerance is 0.005% and if the minimum of the range is 0.02%, the under tolerance is 0.01%.

in a cast shall not vary both above and below the specified range.

5.4 *Sampling for Product Analysis* :

5.4.1 To indicate adequately the representative composition of a cast by product analysis, it is general practice to select samples to represent the steel, as fairly as possible, from a minimum number of pieces as follows: 3 pieces for lots up to 15 tons incl, and 6 pieces for lots over 15 tons. (See tons (see Practice E 59-)).

5.4.2 When the steel is subject to tension test requirements, samples for product analysis may be taken either by drilling entirely through the used tension test specimens themselves, or as covered in 5.4.3.

5.4.3 When the steel is not subject to tension test requirements, the samples for analysis must be taken by milling or drilling entirely through the sheet in a sufficient number of places so that the samples are representative of the entire sheet or strip. The sampling may be facilitated by folding the sheet both ways, so that several samples may be taken at one drilling. Steel subjected to certain heating operations by the purchaser may not give chemical analysis results that properly represent its original composition. Therefore, users must analyze chips taken from the steel in the condition in which it is received from the steel manufacturer.

5.5 *Specimen Preparation*—Drillings or chips must be taken without the application of water, oil, or other lubricant, and must be free of scale, grease, dirt, or other foreign substances. They must not be overheated during cutting to the extent of causing decarburization. Chips must be well mixed and those too coarse to pass a No. 10 sieve or too fine to remain on a No. 30 sieve are not suitable for proper analysis. Sieve size numbers are in accordance with Specification E 11.

5.6 *Test Methods*—In case a referee analysis is required and agreed upon to resolve a dispute concerning the results of a chemical analysis, the procedure of performing the referee analysis must be in accordance with the latest issue of Test Methods, Practices, and Terminology A 751, unless otherwise agreed upon between the manufacturer and the purchaser.

6. Mechanical Properties

6.1 The mechanical property requirements, number of specimens, and test locations and specimen orientation shall be in accordance with the applicable product specification.

6.2 Unless otherwise specified in the applicable product specification, test specimens must be prepared in accordance with Test Methods and Definitions A 370.

6.3 Mechanical tests shall be conducted in accordance with Test Methods and Definitions A 370.

6.4 Bend tests where required shall be conducted in compliance with Test Method E 290.

6.5 To determine conformance with the product specification, a calculated value should be rounded to the nearest 1 ksi tensile strength and yield point or yield strength, and to the nearest unit in the right hand place of figures used in expressing the limiting value for other values in accordance with the rounding off method given in Practice E 29.

6.6 Structural sheet steels are commonly fabricated by cold bending. There are many interrelated factors that affect the ability of a given steel to cold form over a given radius under shop conditions. These factors include thickness, strength level, degree of restraint, relationship to rolling direction, chemistry and microstructure. Each of the appropriate product specifications lists in the appendix the suggested minimum inside radius for cold bending. These radii should be used as minima for 90° bends. They presuppose “hard way” bending (bend axis parallel to rolling direction) and reasonably good shop forming practices. Where possible, the use of larger radii or “easy way” bends are recommended for improved performance.

6.7 Fabricators should be aware that cracks may initiate upon bending a sheared or burned edge. This is not considered to be a fault of the steel but is rather a function of the induced cold-work or heat-affected zone.

7. General Requirements for Delivery

7.1 The products covered by this specification are produced to inch-pound or metric decimal thickness only and the appropriate thickness tolerances apply.

7.2 Steel may be produced as ingot-cast or strand-cast. When different grades of strand-cast steel are sequentially cast, identification and separation of the transition material is required.

8. Dimensions, Tolerances, and Allowances

8.1 Dimensions, tolerances, and allowances applicable to products covered by this specification are contained in Tables 3-25 [Annex A1, Tables A1.1-A1.20]. The appropriate tolerance tables shall be identified in each individual specification.

8.2 *Flatness Tolerances*:

8.2.1 Standard flatness tolerances are contained in Table 15 and Table 16 for hot-rolled sheet and Table 25 for cold-rolled sheet.

8.2.2 Measurement techniques for flatness characteristics are described in Practice A 1030/A 1030M.

8.2.3 Two alternative methods for flatness determination are the use of I-units and percent steepness. A description of these two alternative methods is contained in Practice A 1030/A 1030M, as well as Appendix X5.

8.2.3.1 The use of I-units or percent steepness as a flatness standard is subject to negotiation between the purchaser and the producer.

8.2.3.2 Measurement techniques for I-units and percent steepness and rejection limits are subject to negotiation between the purchaser and the producer.

TABLE 3 List of Tables for Dimensions, Tolerances, and Allowances

| Dimensions | Carbon ^A and High-Strength Low-Alloy Steel | | | |
|--|---|------------------------|-------------------|--------------|
| | Hot-Rolled Sheet | | Cold-Rolled Sheet | |
| | Inch-Pound Units | SI Units | Inch-Pound Units | SI Units |
| Camber tolerances | 12 | A1.9 | 12, 24 | A1.9, A1.19 |
| Diameter tolerances of sheared circles | 11 | A1.8 | 11 | A1.8 |
| Flatness tolerances | 15, 16 | A1.12, A1.13 | 25 | A1.20 |
| Length tolerances | 10 | A1.7 | 21, 22 | A1.16, A1.17 |
| Out-of-square tolerances | 13 | A1.10 | 13 | A1.10 |
| Restricted Squareness tolerances | 14 | A1.11 | 14 | A1.11 |
| Thickness tolerances | 4, 5, 6, 7 | A1.1, A1.2, A1.3, A1.4 | 17, 18, 19, 20 | A1.14, A1.15 |
| Width tolerances of cut edge | 9 | A1.6 | 9, 23 | A1.6, A1.18 |
| Width tolerances of mill edge | 8 | A1.5 | ... | ... |

^A Tolerances for hot-rolled carbon sheet steel with 0.25 % maximum carbon, cast or heat analysis.

TABLE 4 Standard Thickness Tolerances for Hot-Rolled Sheet (Carbon and Structural Steel Only)— $\frac{3}{8}$ -in. (Cut Edge) and $\frac{3}{4}$ -in. (Mill Edge) Minimum Edge Distance (Coils and Cut Lengths, Including Pickled)

NOTE 1—Thickness is measured at any point across the width not less than $\frac{3}{8}$ in. from a cut edge and not less than $\frac{3}{4}$ in. from a mill edge. This table does not apply to the uncropped ends of mill edge coils.

NOTE 2—The specified thickness range captions also apply when sheet is specified to a nominal thickness, and the tolerances are divided equally, over and under.

NOTE 3—Micrometers used for measurement of thickness shall be constructed with anvils and spindles having minimum diameters of 0.188 in. [4.80 mm]. The tip of the spindle shall be flat, and the tip of the anvil shall be flat or rounded with a minimum radius of curvature of 0.10 in. [2.55 mm]. Micrometers with pointed tips are not suitable for thickness measurements.

| Specified Width, in. | Thickness Tolerances ^A Over, in., No Tolerance Under Specified Minimum Thickness, in. ^A | | | | | |
|----------------------|---|---------------------------|---------------------------|---------------------------|---------------------------|----------------------|
| | 0.027 to 0.051, incl | Over 0.051 to 0.057, incl | Over 0.057 to 0.071, incl | Over 0.071 to 0.098, incl | Over 0.098 to 0.180, excl | 0.180 to 0.230, excl |
| | Thickness Tolerances Over, in., No Tolerance Under ^B | | | | | |
| 12 to 20 incl | 0.010 | 0.010 | 0.012 | 0.012 | 0.014 | 0.014 |
| Over 20 to 40 incl | 0.010 | 0.010 | 0.012 | 0.014 | 0.014 | 0.016 |
| Over 40 to 48 incl | 0.010 | 0.012 | 0.012 | 0.014 | 0.016 | 0.018 |
| Over 48 to 60 incl | ... ^A | 0.012 | 0.014 | 0.014 | 0.016 | ^B |
| Over 48 to 60 incl | ... ^C | 0.012 | 0.014 | 0.014 | 0.016 | ^D |
| Over 60 to 72 incl | ... ^A | 0.014 | 0.014 | 0.016 | 0.016 | ^B |
| Over 60 to 72 incl | ... ^C | 0.014 | 0.014 | 0.016 | 0.016 | ^D |
| Over 72 | ... ^A | ... ^A | ... ^A | 0.016 | 0.016 | ^B |
| Over 72 | ... ^C | ... ^C | ... ^C | 0.016 | 0.016 | ^D |

^A Where an ellipsis (. . .) appears in the table, the requirements have not been defined.

^B The tolerances provided in the table are based on minimum thickness (tolerance over, no tolerance under). For nominal thickness, the tolerance is divided equally over and under.

^C Where an ellipsis (. . .) appears in the table, the requirements have not been defined.

^D Product not available in this size range.

9. Finish and Condition

9.1 Hot-rolled sheet has a surface with an oxide or scale resulting from the hot-rolling operation. The oxide or scale can be removed by pickling or blast cleaning when required for press-work operations or welding. Hot-rolled and hot-rolled descaled sheet is not generally used for exposed parts where surface is of prime importance.

9.1.1 Hot-rolled sheet can be supplied with mill edges or cut edges as specified. Mill edges are the natural edges resulting from the hot-rolling operation. They do not conform to any particular contour. They may also contain some edge imperfections, the more common types of which are cracked edges, thin edges (feather), and damaged edges due to handling or processing and which should not extend in beyond the ordered width. These edge conditions are detrimental where joining of the mill edges by welding is practiced. When the purchaser intends to shear or to blank, a sufficient width allowance should be made when purchasing to ensure obtaining the desired contour and size of the pattern sheet. The manufacturer may be consulted for guidance. Cut edges are the normal edges which result from the shearing, slitting, or trimming of mill-edge sheet.

9.1.1.1 The ends of plain hot-rolled mill-edge coils are irregular in shape and are referred to as uncropped ends. Where such ends are not acceptable, the purchaser's order should so specify. Processed coils such as pickled or blast cleaned are supplied with square-cut ends.

9.2 Cold-rolled carbon sheet (exposed) is intended for those applications where surface appearance is of primary importance. This class will meet requirements for controlled surface texture, surface quality, and flatness. It is normally processed by the manufacturer to be free of stretcher strain and fluting. Subsequent user roller leveling immediately before fabrication will minimize strain resulting from aging.

9.2.1 Cold-rolled carbon sheet, when ordered for exposed applications, can be supplied in the following finishes:

TABLE 5 Restricted Thickness Tolerances for Hot-Rolled Sheet (Carbon and Structural Steel Only)— $\frac{5}{8}$ -in. (Cut Edge) and 1-in. (Mill Edge) Minimum Edge Distance (Coils and Cut Lengths, Including Pickled)

NOTE 1—Thickness is measured at any point across the width not less than $\frac{5}{8}$ in. from a cut edge and not less than 1 in. from a mill edge. This table does not apply to the uncropped ends of mill edge coils.

NOTE 2—The specified thickness range captions also apply when sheet is specified to a nominal thickness, and the tolerances are divided equally, over and under.

NOTE 3—Micrometers used for measurement of thickness shall be constructed with anvils and spindles having minimum diameters of 0.188 in. [4.80 mm]. The tip of the spindle shall be flat, and the tip of the anvil shall be flat or rounded with a minimum radius of curvature of 0.10 in. [2.55 mm]. Micrometers with pointed tips are not suitable for thickness measurements.

NOTE 4—This table was constructed by multiplying the values in the standard table by 0.75 and rounding to 3 decimal places using standard ASTM practice.

| Specified Width, in. | Thickness Tolerances, Over, in., No Tolerance Under ^B | | | | | |
|----------------------|--|---------------------------|---------------------------|---------------------------|---------------------------|----------------------|
| | 0.027 to 0.051, incl | Over 0.051 to 0.057, incl | Over 0.057 to 0.071, incl | Over 0.071 to 0.098, incl | Over 0.098 to 0.180, excl | 0.180 to 0.230, excl |
| 12 to 20 incl | 0.008 | 0.008 | 0.009 | 0.009 | 0.010 | 0.010 |
| Over 20 to 40, incl | 0.008 | 0.008 | 0.009 | 0.010 | 0.010 | 0.012 |
| Over 40 to 48, incl | 0.008 | 0.009 | 0.009 | 0.010 | 0.012 | 0.014 |
| Over 48 to 60, incl | ... ^A | 0.009 | 0.010 | 0.010 | 0.012 | ... ^B |
| Over 48 to 60, incl | ... ^C | 0.009 | 0.010 | 0.010 | 0.012 | ... ^D |
| Over 60 to 72, incl | ... ^A | 0.010 | 0.010 | 0.012 | 0.012 | ... ^B |
| Over 60 to 72, incl | ... ^C | 0.010 | 0.010 | 0.012 | 0.012 | ... ^D |
| Over 72 | ... ^A | ... ^A | ... ^A | 0.012 | 0.012 | ... ^B |
| Over 72 | ... ^C | ... ^C | ... ^C | 0.012 | 0.012 | ... ^D |

^A Where an ellipsis (. . .) appears in the table, the requirements have not been defined.

^B The tolerances provided in the table are based on minimum thickness (tolerance over, no tolerance under). For nominal thickness, the tolerance is divided equally over and under.

^C Where an ellipsis (. . .) appears in the table, the requirements have not been defined.

^D Product not available in this size range.

TABLE 6 Standard Thickness Tolerances for Hot-Rolled Sheet (High-Strength, Low-Alloy Steel)— $\frac{3}{8}$ -in. (Cut Edge) and $\frac{3}{4}$ -in. (Mill Edge) Minimum Edge Distance (Coils and Cut Lengths, Including Pickled)

NOTE 1—Thickness is measured at any point across the width not less than $\frac{3}{8}$ in. from a cut edge and not less than $\frac{3}{4}$ in. from a mill edge. This table does not apply to the uncropped ends of mill edge coils.

NOTE 2—The specified thickness range captions also apply when sheet is specified to a nominal thickness, and the tolerances are divided equally, over and under.

NOTE 3—Micrometers used for measurement of thickness shall be constructed with anvils and spindles having minimum diameters of 0.188 in. [4.80 mm]. The tip of the spindle shall be flat, and the tip of the anvil shall be flat or rounded with a minimum radius of curvature of 0.10 in. [2.55 mm]. Micrometers with pointed tips are not suitable for thickness measurements.

| Specified Width, in. | Thickness Tolerances, Over, in., No Tolerance Under ^B | | | | | | |
|----------------------|--|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|----------------------|
| | 0.031 to 0.051, incl | Over 0.051 to 0.059, incl | Over 0.059 to 0.070, incl | Over 0.070 to 0.082, incl | Over 0.082 to 0.098, incl | Over 0.098 to 0.180, excl | 0.180 to 0.230, excl |
| 12 to 15, incl | 0.010 | 0.012 | 0.012 | 0.012 | 0.012 | 0.014 | 0.014 |
| Over 15 to 20, incl | 0.010 | 0.012 | 0.014 | 0.014 | 0.014 | 0.016 | 0.016 |
| Over 20 to 32, incl | 0.012 | 0.012 | 0.014 | 0.014 | 0.014 | 0.016 | 0.018 |
| Over 32 to 40, incl | 0.012 | 0.012 | 0.014 | 0.014 | 0.016 | 0.016 | 0.018 |
| Over 40 to 48, incl | 0.012 | 0.014 | 0.014 | 0.014 | 0.016 | 0.020 | 0.020 |
| Over 48 to 60, incl | ... ^A | 0.014 | 0.014 | 0.014 | 0.016 | 0.020 | ... ^B |
| Over 48 to 60, incl | ... ^C | 0.014 | 0.014 | 0.014 | 0.016 | 0.020 | ... ^D |
| Over 60 to 72, incl | ... ^A | ... ^A | 0.016 | 0.016 | 0.018 | 0.022 | ... ^B |
| Over 60 to 72, incl | ... ^C | ... ^C | 0.016 | 0.016 | 0.018 | 0.022 | ... ^D |
| Over 72 to 80, incl | ... ^A | ... ^A | ... ^A | 0.016 | 0.018 | 0.024 | ... ^B |
| Over 72 to 80, incl | ... ^C | ... ^C | ... ^C | 0.016 | 0.018 | 0.024 | ... ^D |
| Over 80 | ... ^A | ... ^A | ... ^A | ... ^A | 0.020 | 0.024 | ... ^B |
| Over 80 | ... ^C | ... ^C | ... ^C | ... ^C | 0.020 | 0.024 | ... ^D |

^A Where an ellipsis (. . .) appears in the table, the requirements have not been defined.

^B The tolerances provided in the table are based on minimum thickness (tolerance over, no tolerance under). For nominal thickness, the tolerance is divided equally over and under.

^C Where an ellipsis (. . .) appears in the table, the requirements have not been defined.

^D Product not available in this size range.

9.2.1.1 Matte finish is a dull finish, without luster, produced by rolling on rolls that have been roughened by mechanical or chemical means to various degrees of surface texture depending upon application. With some surface preparation matte finish is suitable for decorative painting. It is not generally recommended for bright plating.

9.2.1.2 Commercial bright finish is a relatively bright finish having a surface texture intermediate between that of matte and luster finish. With some surface preparation commercial bright finish is suitable for decorative painting or certain plating

TABLE 7 Restricted Thickness Tolerances for Hot-Rolled Sheet (High-Strength, Low-Alloy Steel)— $\frac{5}{8}$ -in. (Cut Edge) and 1-in. (Mill Edge) Minimum Edge Distance (Coils and Cut Lengths, Including Pickled)

NOTE 1—Thickness is measured at any point across the width not less than $\frac{5}{8}$ in. from a cut edge and not less than 1 in. from a mill edge. This table does not apply to the uncropped ends of mill edge coils.

NOTE 2—The specified thickness tolerance range captions also apply when sheet is specified to a nominal thickness, and the tolerances are divided equally, over and under.

NOTE 3—Micrometers used for measurement of thickness shall be constructed with anvils and spindles having minimum diameters of 0.188 in. [4.80 mm]. The tip of the spindle shall be flat, and the tip of the anvil shall be flat or rounded with a minimum radius of curvature of 0.10 in. [2.55 mm]. Micrometers with pointed tips are not suitable for thickness measurements.

NOTE 4—This table was constructed by multiplying the values in the standard table by 0.75 and rounding to 3 places using standard ASTM practice.

| Specified Width, in. | Thickness Tolerances All Over, in., No Tolerance Under ^B | | | | | | |
|----------------------|---|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|----------------------|
| | 0.031 to 0.051, incl | Over 0.051 to 0.059, incl | Over 0.059 to 0.070, incl | Over 0.070 to 0.082, incl | Over 0.082 to 0.098, incl | Over 0.098 to 0.180, excl | 0.180 to 0.230, excl |
| 12 to 15, incl | 0.008 | 0.009 | 0.009 | 0.009 | 0.009 | 0.010 | 0.010 |
| Over 15 to 20, incl | 0.008 | 0.009 | 0.010 | 0.010 | 0.010 | 0.012 | 0.012 |
| Over 20 to 32, incl | 0.009 | 0.009 | 0.010 | 0.010 | 0.010 | 0.012 | 0.014 |
| Over 32 to 40, incl | 0.009 | 0.009 | 0.010 | 0.010 | 0.012 | 0.012 | 0.014 |
| Over 40 to 48, incl | 0.009 | 0.010 | 0.010 | 0.010 | 0.012 | 0.015 | 0.015 |
| Over 48 to 60, incl | ... ^A | 0.010 | 0.010 | 0.010 | 0.012 | 0.015 | ... ^B |
| Over 48 to 60, incl | ... ^C | 0.010 | 0.010 | 0.010 | 0.012 | 0.015 | ... ^D |
| Over 60 to 72, incl | ... ^A | ... ^A | 0.012 | 0.012 | 0.014 | 0.016 | ... ^B |
| Over 60 to 72, incl | ... ^C | ... ^C | 0.012 | 0.012 | 0.014 | 0.016 | ... ^D |
| Over 72 to 80, incl | ... ^A | ... ^A | ... ^A | 0.012 | 0.014 | 0.018 | ... ^B |
| Over 72 to 80, incl | ... ^C | ... ^C | ... ^C | 0.012 | 0.014 | 0.018 | ... ^D |
| Over 80 | ... ^A | ... ^A | ... ^A | ... ^A | 0.015 | 0.018 | ... ^B |
| Over 80 | ... ^C | ... ^C | ... ^C | ... ^C | 0.015 | 0.018 | ... ^D |

^A Where an ellipsis (...) appears in the table, the requirements have not been defined.

^B The tolerances provided in the table are based on minimum thickness (tolerance over, no tolerance under). For nominal thickness, the tolerance is divided equally over and under.

^C Where an ellipsis (...) appears in the table, the requirements have not been defined.

^D Product not available in this size range.

TABLE 8 Width Tolerances^A of Hot-Rolled Mill Edge Sheet (All Designations)
(Coils and Cut Lengths, Including Pickled)

| Carbon | |
|-------------------------|---|
| Specified Width, in. | Tolerances Over Specified Width, in. No Tolerance Under |
| 12 to 14 incl | $\frac{7}{16}$ |
| Over 14 to 17 incl | $\frac{1}{2}$ |
| Over 17 to 19 incl | $\frac{9}{16}$ |
| Over 19 to 21 incl | $\frac{5}{8}$ |
| Over 21 to 24 incl | $\frac{11}{16}$ |
| Over 24 to 26 incl | $\frac{13}{16}$ |
| Over 26 to 30 incl | $\frac{15}{16}$ |
| Over 30 to 50 incl | $1\frac{1}{8}$ |
| Over 50 to 78 incl | $1\frac{1}{2}$ |
| Over 78 | $1\frac{7}{8}$ |
| High-Strength Low-Alloy | |
| 12 to 14 incl | $\frac{7}{16}$ |
| Over 14 to 17 incl | $\frac{1}{2}$ |
| Over 17 to 19 incl | $\frac{9}{16}$ |
| Over 19 to 21 incl | $\frac{5}{8}$ |
| Over 21 to 24 incl | $\frac{11}{16}$ |
| Over 24 to 26 incl | $\frac{13}{16}$ |
| Over 26 to 28 incl | $\frac{15}{16}$ |
| Over 28 to 35 incl | $1\frac{1}{8}$ |
| Over 35 to 50 incl | $1\frac{1}{4}$ |
| Over 50 to 60 incl | $1\frac{1}{2}$ |
| Over 60 to 65 incl | $1\frac{5}{8}$ |
| Over 65 to 70 incl | $1\frac{3}{4}$ |
| Over 70 to 80 incl | $1\frac{7}{8}$ |
| Over 80 | 2 |

^A The above tolerances do not apply to the uncropped ends of mill edge coils (10.1.1.1).

TABLE 9 Width Tolerances of Hot-Rolled Cut Edge Sheet and Cold-Rolled Sheet (All Designations)
(Not Resquared, Coils and Cut Lengths, Including Pickled)

| Specified Width, in. | Tolerances Over Specified Width, in. No Tolerance Under |
|----------------------|---|
| Over 12 to 30 incl | 1/8 |
| Over 30 to 48 incl | 3/16 |
| Over 48 to 60 incl | 1/4 |
| Over 60 to 80 incl | 5/16 |
| Over 80 | 3/8 |

TABLE 10 Length Tolerances of Hot-Rolled Sheet (All Designations)
(Cut Lengths Not Resquared, Including Pickled)

| Specified Length, in. | Tolerances Over Specified Length, in. No Tolerance Under |
|-----------------------|--|
| To 15 incl | 1/8 |
| Over 15 to 30 incl | 1/4 |
| Over 30 to 60 incl | 1/2 |
| Over 60 to 120 incl | 3/4 |
| Over 120 to 156 incl | 1 |
| Over 156 to 192 incl | 1 1/4 |
| Over 192 to 240 incl | 1 1/2 |
| Over 240 | 1 3/4 |

TABLE 11 Diameter Tolerances of Circles Sheared from Hot-Rolled (Including Pickled) and Cold-Rolled Sheet (Over 12 in. Width) (All Designations)

| Specified Thickness, ^A in. | Tolerances Over Specified Diameter, in. (No Tolerances Under) | | |
|---------------------------------------|---|--------------------|---------|
| | Under 30 | Over 30 to 48 incl | Over 48 |
| 0.044 to 0.057 incl | 1/16 | 1/8 | 3/16 |
| Over 0.057 to 0.098 incl | 3/32 | 5/32 | 7/32 |
| Over 0.098 | 1/8 | 3/16 | 1/4 |

^A 0.071 in. minimum thickness for hot-rolled high-strength low-alloy steel sheet.

applications. If sheet is deformed in fabrication the surface may roughen to some degree and areas so affected will require surface preparation to restore surface texture to that of the undeformed areas.

9.2.1.3 Luster finish is a smooth bright finish produced by rolling on ground rolls and is suitable for decorative painting or plating with additional special surface preparation by the user. The luster may not be retained after fabrication; therefore, the formed parts will require surface preparation to make them suitable for bright plating.

9.3 Cold-rolled carbon sheet, when intended for unexposed applications, is not subject to limitations on degree and frequency of surface imperfections, and restrictions on texture and mechanical properties are not applicable. When ordered as “annealed last,” the product will have coil breaks and a tendency toward fluting and stretcher straining. Unexposed cold-rolled sheet may contain more surface imperfections than exposed cold-rolled sheet because steel applications, processing procedures, and inspection standards are less stringent.

9.4 Cold-rolled high-strength low-alloy sheet is supplied with a matte finish, unless otherwise specified.

9.5 The cold-rolled products covered by this specification are furnished with cut edges and square cut ends, unless otherwise specified.

9.6 *Oiling:*

9.6.1 Plain hot-rolled sheet is customarily furnished not oiled. Oiling must be specified, when required.

9.6.2 Hot-rolled pickled or descaled sheet is customarily furnished oiled. If the product is not to be oiled, it must be so specified since the cleaned surface is prone to rusting.

9.6.3 Cold-rolled products covered by this specification can be furnished oiled or not oiled as specified.

TABLE 12 Camber Tolerances^A for Hot-Rolled (Including Pickled) and Cold-Rolled Sheet (Over 12 in. Width) (All Designations)
(Cut Lengths, not Resquared)

NOTE 1—Camber is the greatest deviation of a side edge from a straight line, the measurement being taken on the concave side with a straightedge.

| Cut Length, ft | Camber Tolerances, in. |
|--------------------|------------------------|
| To 4 incl | 1/8 |
| Over 4 to 6 incl | 3/16 |
| Over 6 to 8 incl | 1/4 |
| Over 8 to 10 incl | 5/16 |
| Over 10 to 12 incl | 3/8 |
| Over 12 to 14 incl | 1/2 |
| Over 14 to 16 incl | 5/8 |
| Over 16 to 18 incl | 3/4 |
| Over 18 to 20 incl | 7/8 |
| Over 20 to 30 incl | 1 1/4 |
| Over 30 to 40 incl | 1 1/2 |

^A The camber tolerance for coils is 1 in. in any 20 ft.

TABLE 13 Out-of-Square Tolerances of Hot-Rolled Cut-Edge (Including Pickled) and Cold-Rolled Sheet (Over 12 in. Width) (All Designations)
(Cut Lengths Not Resquared)

Out-of-square is the greatest deviation of an end edge from a straight line at right angle to a side and touching one corner. It is also obtained by measuring the difference between the diagonals of the cut length. The out-of-square deviation is one half of that difference. The tolerance for all thicknesses and all sizes is 1/16 in./6 in. of width or fraction thereof.

TABLE 14 Restricted Squareness Tolerances of Hot-Rolled (Including Pickled) and Cold-Rolled Sheet (Over 12 in. Width) (All Designations)
(Cut Lengths)

When cut lengths are specified resquared, the width and the length are not less than the dimensions specified. The individual tolerance for over-width, over-length, camber, or out-of-square should not exceed 1/16 in. up to and including 48 in. in width and up to and including 120 in. in length. For cut lengths wider or longer, the applicable tolerance is 1/8 in.

9.7 Sheet steel in coils or cut lengths may contain surface imperfections that can be removed with a reasonable amount of metal finishing by the purchaser.

10. Workmanship

10.1 Cut lengths shall have a workmanlike appearance and shall not have imperfections of a nature or degree for the product, the grade, class, and the quality ordered that will be detrimental to the fabrication of the finished part.

10.2 Coils may contain some abnormal imperfections that render a portion of the coil unusable since the inspection of coils does not afford the producer the same opportunity to remove portions containing imperfections as in the case with cut lengths.

10.3 Surface Conditions:

10.3.1 Exposed cold-rolled sheet is intended for applications where surface appearance is of primary importance, that is, exposed applications. Unexposed or annealed cold-rolled sheet is intended for applications where surface appearance is not of primary importance, that is, unexposed applications.

10.3.2 Cut lengths for exposed applications shall not include individual sheets having major surface imperfections (holes, loose slivers, and pipe) and repetitive minor surface imperfections. Cut lengths may contain random minor surface imperfections that can be removed with a reasonable amount of metal finishing by the purchaser. These imperfections shall be acceptable to the purchaser within the manufacturer's published standards.

10.3.3 For coils for exposed applications, it is not possible to remove the surface imperfections listed in 10.3.2. Coils will contain such imperfections which shall be acceptable to the purchaser within the manufacturer's published standards. Coils contain more surface imperfections than cut lengths because the producer does not have the same opportunity to sort portions containing such imperfections as is possible with cut lengths.

TABLE 15 Flatness Tolerances^A of Temper Rolled or Pickled Hot-Rolled Sheet Cut Lengths^B (All Designations)

| Specified Minimum Thickness, in. | Specified Width, in. | Flatness Tolerances, ^C in. | |
|----------------------------------|----------------------|---------------------------------------|-------------------------|
| | | Specified Yield Strength, min, ksi | |
| | | Under 45 | 45 to 50 ^{D,E} |
| 0.027 to 0.057 incl | over 12 to 36 incl | 1/2 | 3/4 |
| | over 36 to 60 incl | 3/4 | 1 1/8 |
| | over 60 | 1 | ... |
| 0.057 to 0.180 excl | over 12 to 60 incl | 1/2 | 3/4 |
| | over 60 to 72 incl | 3/4 | 1 1/8 |
| | over 72 | 1 | 1 1/2 |
| 0.180 to 0.230 excl | over 12 to 48 incl | 1/2 | 3/4 |

^A The above table also applies to lengths cut from coils by the consumer when adequate flattening operations are performed.

^B Application of this table to product in coil form is not appropriate unless the coil has been rolled out and adequately flattened with all coil set removed.

^C Maximum deviation from a horizontal flat surface.

^D Tolerances for steels with specified minimum yield strength in excess of 50 ksi are subject to negotiation.

^E 0.071 minimum thickness of HSLA.

TABLE 16 Flatness Tolerances^A of Non-Processed Hot Rolled Sheet Cut Lengths^B (All Designations)

| Specified Minimum Thickness, in. | Specified Width, in. | Flatness Tolerances, ^C in. | |
|----------------------------------|----------------------|---------------------------------------|-------------------------|
| | | Specified Yield Strength, min, ksi | |
| | | Under 45 | 45 to 50 ^{D,E} |
| 0.027 to 0.057 incl | over 12 to 36 incl | 1 1/2 | 2 1/4 |
| | over 36 to 60 incl | 2 1/4 | 3 3/8 |
| | over 60 | 3 | ... |
| over 0.057 to 0.180 excl | over 12 to 60 incl | 1 1/2 | 2 1/4 |
| | over 60 to 72 incl | 2 1/4 | 3 3/8 |
| | over 72 | 3 | 4 1/2 |
| 0.180 to 0.230 excl | over 12 to 48 incl | 1 1/2 | 2 1/4 |

^A The above table also applies to lengths cut from coils by the consumer when adequate flattening operations are performed.

^B Application of this table to product in coil form is not appropriate unless the coil has been rolled out and adequately flattened with all coil set removed.

^C Maximum deviation from a horizontal flat surface.

^D Tolerances for steels with specified minimum yield strength in excess of 50 ksi are subject to negotiation.

^E 0.071 minimum thickness of HSLA.

10.3.4 Cut lengths for unexposed applications shall not include individual sheets having major surface imperfections such as holes, loose slivers, and pipe. In addition, unexposed cut lengths can be expected to contain more minor imperfections such as pits, scratches, sticker breaks, edge breaks, pinchers, cross breaks, roll marks, and other surface imperfections than exposed. These imperfections shall be acceptable to the purchaser without limitation.

10.3.5 For coils for unexposed applications, it is not possible to remove the surface imperfections listed in 10.3.4. Coils will contain surface imperfections that are normally not repairable. Minor imperfections shall be acceptable to the purchaser within the manufacturer's published standards. Unexposed coils contain more surface imperfections than exposed coils.

11. Retests and Disposition of Non-Conforming Material

11.1 Retests:

11.1.1 Unless otherwise prohibited by the product specification, retests are permitted under the following circumstances:

11.1.1.1 If any tension test specimen shows defective machining or develops flaws, it must be discarded and another specimen substituted.

11.1.1.2 If the percent elongation of any tension test specimen is less than that specified and any part of the fracture is more than 3/4 in. [20 mm] from the center of the gage length of a 2-in. [50 mm] specimen or is outside the middle half of the gage length of an 8-in. [200 mm] specimen, as indicated by scribe scratches marked on the specimen before testing, a retest is allowed.

11.1.1.3 If the test result of any tension test specimen fails to meet the specification requirements and the failure is the result of improper adherence to tension test procedures, a retest is permitted.