



Designation: A517/A517M – 06

Standard Specification for Pressure Vessel Plates, Alloy Steel, High-Strength, Quenched and Tempered¹

This standard is issued under the fixed designation A517/A517M; 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 high-strength quenched and tempered alloy steel plates intended for use in fusion welded boilers and other pressure vessels.

1.2 This specification includes a number of grades as manufactured by different producers, but all having the same mechanical properties and general characteristics.

1.3 The maximum thickness of plates furnished under this specification shall be as follows:

Grade	Thickness
A, B	1.25 in. [32 mm]
H, S	2 in. [50 mm]
P	4 in. [100 mm]
F	2.50 in. [65 mm]
E, Q	6 in. [150 mm]

1.4 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 is to be used independently of the other without combining values in any way.

2. Referenced Documents

2.1 ASTM Standards:³

[A20/A20M Specification for General Requirements for Steel Plates for Pressure Vessels](#)

[A435/A435M Specification for Straight-Beam Ultrasonic Examination of Steel Plates](#)

[A577/A577M Specification for Ultrasonic Angle-Beam Examination of Steel Plates](#)

[A578/A578M Specification for Straight-Beam Ultrasonic Examination of Rolled Steel Plates for Special Applications](#)

3. General Requirements and Ordering Information

3.1 Plates furnished to this material specification shall conform to Specification [A20/A20M](#). These requirements outline the testing and retesting methods and procedures, permissible variations in dimensions, and mass, quality and repair of defects, marking, loading, etc.

3.2 Specification [A20/A20M](#) also establishes the rules for the ordering information which should be complied with when purchasing material to this specification.

3.3 In addition to the basic requirements of this specification, certain supplementary requirements are available when additional control, testing, or examination is required to meet end use requirements. These include:

- 3.3.1 Vacuum treatment,
- 3.3.2 Additional or special tension testing,
- 3.3.3 Impact testing, and
- 3.3.4 Nondestructive examination.

3.4 The purchaser is referred to the listed supplementary requirements in this specification and to the detailed requirements in Specification [A20/A20M](#).

3.5 If the requirements of this specification are in conflict with the requirements of Specification [A20/A20M](#), the requirements of this specification shall prevail.

4. Manufacture

4.1 *Steelmaking Practice*—The steel shall be killed and shall conform to the fine austenitic grain size requirement of Specification [A20/A20M](#).

5. Heat Treatment

5.1 Except as allowed by section [5.2](#), the plates shall be heat treated by heating to not less than 1650°F [900°C], quenching in water or oil and tempering at not less than 1150°F [620°C].

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 A01.11 on Steel Plates for Boilers and Pressure Vessels.

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-517/SA-517M in Section II of that Code.

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

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



TABLE 1 Chemical Requirements

Elements	Composition, %							
	Grade A	Grade B	Grade E	Grade F	Grade H	Grade P	Grade Q	Grade S
Carbon:								
Heat analysis	0.15	0.15	0.12	0.10	0.12	0.12	0.14	0.10
	-0.21	-0.21	-0.20	-0.20	-0.21	-0.21	-0.21	-0.20
Product analysis	0.13	0.13	0.10	0.08	0.10	0.10	0.12	0.10
	-0.23	-0.23	-0.22	-0.22	-0.23	-0.23	-0.23	-0.22
Manganese:								
Heat analysis	0.80	0.70	0.40	0.60	0.95	0.45	0.95	1.10
	-1.10	-1.00	-0.70	-1.00	-1.30	-0.70	-1.30	-1.50
Product analysis	0.74	0.64	0.35	0.55	0.87	0.40	0.87	1.02
	-1.20	-1.10	-0.78	-1.10	-1.41	-0.78	-1.41	-1.62
Phosphorus, max ^A	0.035	0.035	0.035	0.035	0.035	0.035	0.035	0.035
Sulfur, max ^A	0.035	0.035	0.035	0.035	0.035	0.035	0.035	0.035
Silicon:								
Heat analysis	0.40	0.15	0.10	0.15	0.15	0.20	0.15	0.15
	-0.80	-0.35	-0.40	-0.35	-0.35	-0.35	-0.35	-0.40
Product analysis	0.34	0.13	0.08	0.13	0.13	0.18	0.13	0.13
	-0.86	-0.37	-0.45	-0.37	-0.37	-0.37	-0.37	-0.45
Nickel:								
Heat analysis	0.70	0.30	1.20	1.20	...
				-1.00	-0.70	-1.50	-1.50	
Product analysis	0.67	0.27	1.15	1.15	...
				-1.03	-0.73	-1.55	-1.55	
Chromium:								
Heat analysis	0.50	0.40	1.40	0.40	0.40	0.85	1.00	...
	-0.80	-0.65	-2.00	-0.65	-0.65	-1.20	-1.50	
Product analysis	0.46	0.36	1.34	0.36	0.36	0.79	0.94	...
	-0.84	-0.69	-2.06	-0.69	-0.69	-1.26	-1.56	
Molybdenum:								
Heat analysis	0.18	0.15	0.40	0.40	0.20	0.45	0.40	0.10
	-0.28	-0.25	-0.60	-0.60	-0.30	-0.60	-0.60	-0.35
Product analysis	0.15	0.12	0.36	0.36	0.17	0.41	0.36	0.10
	-0.31	-0.28	-0.64	-0.64	-0.33	-0.64	-0.64	-0.38
Boron	0.0025	0.0005	0.001	0.0005	0.0005	0.001
	max	-0.005	-0.005	-0.006	min	-0.005		
Vanadium:								
Heat analysis	...	0.03	^B	0.03	0.03	...	0.03	...
		-0.08		-0.08	-0.08		-0.08	
Product analysis	...	0.02	...	0.02	0.02	...	0.02	...
		-0.09		-0.09	-0.09		-0.09	
Titanium:								
Heat analysis	...	0.01	0.01	0.06
		-0.04	-0.10					
Product analysis	...	0.01	0.005	0.07
		-0.05	-0.11					
Zirconium:								
Heat analysis	0.05 ^C
	-0.15							
Product analysis	0.04
	-0.16							
Copper:								
Heat analysis	0.15
				-0.50				
Product analysis	0.12
				-0.53				
Columbium, max								
Heat analysis	0.06
Product analysis	0.07

^A Applied to both heat and product analyses.

^B May be substituted for part or all of titanium content on a one for one basis.

^C Zirconium may be replaced by cerium. When cerium is added, the cerium/sulfur ratio should be approximately 1.5 to 1, based on heat analysis.

5.2 Plates ordered without the heat treatment specified in section 5.1 shall be stress relieved by the manufacturer, and subsequent heat treatment of the plates to conform to section 5.1 shall be the responsibility of the purchaser.

6. Chemical Requirements

6.1 The steel shall conform to the chemical requirements shown in Table 1 unless otherwise modified in accordance with