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American Association of State  
Highway and Transportation  
Officials Standard  
AASHTO No.: M 253

# Standard Specification for Structural Bolts, Alloy Steel, Heat Treated, 150 ksi Minimum Tensile Strength<sup>1</sup>

This standard is issued under the fixed designation A 490; 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.

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

## 1. Scope\*

1.1 This specification covers two types of quenched and tempered, alloy steel, heavy hex structural bolts having a tensile strength of 150 to 173 ksi.

1.2 These bolts are intended for use in structural connections. These connections are covered under the requirements of the Specification for Structural Joints Using Specification A 325 or A 490 bolts, approved by the Research Council on Structural Connections; endorsed by the American Institute of Steel Construction and by the Industrial Fastener Institute.<sup>2</sup>

1.3 The bolts are furnished in sizes ½ to 1½ in., inclusive. They are designated by type denoting chemical composition as follows:

Type	Description
Type 1	Medium carbon alloy steel
Type 2	Withdrawn in 2002
Type 3	Weathering steel

1.4 This specification provides that heavy hex structural bolts shall be furnished unless other dimensional requirements are specified on the purchase order.

1.5 Terms used in this specification are defined in Terminology F 1789 unless otherwise defined herein.

1.6 For metric bolts, see Specification A 490M Classes 10.9 and 10.9.3

1.7 The following safety hazards caveat pertains only to the Test Methods portion, Section 12 of this specification: *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.*

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee F16 on Fasteners and is the direct responsibility of Subcommittee F16.02 on Steel Bolts, Nuts, Rivets, and Washers.

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<sup>2</sup> Available from American Institute of Steel Construction (AISC), One E. Wacker Dr., Suite 700, Chicago, IL 60601-2001, <http://www.aisc.org>.

## 2. Referenced Documents

2.1 *ASTM Standards:*<sup>3</sup>

A 194/A 194M Specification for Carbon and Alloy Steel Nuts for Bolts for High Pressure or High Temperature Service, or Both

A 325 Specification for Structural Bolts, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength

A 354 Specification for Quenched and Tempered Alloy Steel Bolts, Studs, and Other Externally Threaded Fasteners

A 490M Specification for High-Strength Steel Bolts, Classes 10.9 and 10.9.3, for Structural Steel Joints [Metric]

A 563 Specification for Carbon and Alloy Steel Nuts

A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products

D 3951 Practice for Commercial Packaging

E 384 Test Method for Microindentation Hardness of Materials

E 709 Guide for Magnetic Particle Examination

E 1444 Practice for Magnetic Particle Testing

F 436 Specification for Hardened Steel Washers

F 606 Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, and Rivets

F 788/F 788M Specification for Surface Discontinuities of Bolts, Screws, and Studs, Inch and Metric Series

F 959 Specification for Compressible-Washer-Type Direct Tension Indicators for Use with Structural Fasteners

F 1470 Guide for Fastener Sampling for Specified Mechanical Properties and Performance Inspection

F 1789 Terminology for F16 Mechanical Fasteners

G 101 Guide for Estimating the Atmospheric Corrosion Resistance of Low-Alloy Steels

<sup>3</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto: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.

2.2 ASME Standards:<sup>4</sup>

B1.1 Unified Screw Threads

B18.2.6 Fasteners for Use in Structural Applications

B18.24 Part Identification Number (PIN) Code System Standard for B18 Fastener Products

2.3 SAE Standard:<sup>5</sup>

SAE J121 Decarburization in Hardened and Tempered Threaded Fasteners

3. Ordering Information

3.1 Orders for heavy hex structural bolts under this specification shall include the following:

3.1.1 Quantity (number of pieces of bolts and accessories);

3.1.2 Size, including nominal bolt diameter, thread pitch, and bolt length. The thread length shall not be changed;

3.1.3 Name of product: heavy hex structural bolts, or other such bolts as specified;

3.1.4 Type of bolt (Type 1 or 3). When type is not specified, either Type 1 or Type 3 shall be furnished at the supplier's option;

3.1.5 ASTM designation and year of issue,

3.1.6 Other components such as nuts, washers, and washer-type direct tension indicators, if required;

3.1.7 Test Reports, if required (see Section 15); and

3.1.8 Special requirements.

3.1.9 For establishment of a part identifying system, see ASME B18.24.

NOTE 1—A typical ordering description follows: 1000 pieces 1–8 in. dia × 4 in. long heavy hex structural bolt, Type 1, ASTM A 490 – 02; each with two hardened washers, ASTM F 436 Type 1; and one heavy hex nut, ASTM A 563 Grade DH.

3.2 Recommended Nuts:

3.2.1 Nuts conforming to the requirements of Specification A 563 are the recommended nuts for use with Specification A 490 heavy hex structural bolts. The nuts shall be of the class and have a surface finish for each type of bolt as follows:

Bolt Type and Finish	Nut Class and Finish
1, plain (uncoated)	A 563—DH, DH3 plain (uncoated)
3, weathering steel	A 563—DH3, weathering steel

3.2.2 Alternatively, nuts conforming to Specification A 194/ A 194M Gr. 2H plain (uncoated) are considered a suitable substitute for use with Specification A 490 Type 1 heavy hex structural bolts.

3.3 Recommended Washers—Washers conforming to Specification F 436 are the recommended washers for use with Specification A 490 heavy hex structural bolts. The washers shall have a surface finish for each type of bolt as follows:

Bolt Type and Finish	Washer Finish
1, plain (uncoated)	plain (uncoated)
3, weathering steel	weathering steel

<sup>4</sup> Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, http://www.asme.org.

<sup>5</sup> Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, http://www.sae.org.

3.4 Other Accessories—When compressible washer type direct tension indicators are specified to be used with these bolts, they shall conform to Specification F 959 Type 490.

4. Materials and Manufacture

4.1 Heat Treatment—Type 1 and Type 3 bolts shall be heat treated by quenching in oil from the austenitic temperature and then tempered by reheating to a temperature of not less than 800°F.

4.2 Threading—The threads shall be cut or rolled.

4.3 Protective Coatings—The bolts shall not be coated by hot-dip zinc coating, mechanical deposition, or electroplating with zinc or other metallic coatings (Note 2).

NOTE 2—For more detail see the H. E. Townsend Report “Effects of Zinc Coatings on Stress Corrosion Cracking and Hydrogen Embrittlement of Low Alloy Steel,” published in Metallurgical Transactions, Vol. 6, April 1975.

5. Chemical Composition

5.1 Type 1 bolts shall be alloy steel conforming to the chemical composition specified in Table 1. The steel shall contain sufficient alloying elements to qualify it as an alloy steel (see Note 3).

NOTE 3—Steel is considered to be alloy by the American Iron and Steel Institute when the maximum of the range given for the content of alloying elements exceeds one or more of the following limits: manganese, 1.65 %; silicon, 0.60 %; copper, 0.60 %; or in which a definite range or a definite minimum quantity of any of the following elements is specified or required within the limits of the recognized field of constructional alloy steels: aluminum, chromium up to 3.99 %, cobalt, columbium, molybdenum, nickel, titanium, tungsten, vanadium, zirconium, or any other alloying elements added to obtain a desired alloying effect.

5.2 Type 3 bolts shall be weathering steel conforming to the chemical composition requirements in Table 2. See Guide G 101 for methods of estimating the atmospheric corrosion resistance of low alloy steel.

5.3 Product analyses made on finished bolts representing each lot shall conform to the product analysis requirements specified in Tables 1 and 2, as applicable.

5.4 Heats of steel to which bismuth, selenium, tellurium, or lead has been intentionally added shall not be used for bolts furnished to this specification. Compliance with this requirement shall be based on certification that steels having these elements intentionally added were not used.

5.5 Chemical analyses shall be performed in accordance with Test Methods, Practices, and Terminology A 751.

6. Mechanical Properties

6.1 Hardness—The bolts shall conform to the hardness specified in Table 3.

TABLE 1 Chemical Requirements for Type 1 Bolts

Element	Heat Analysis, %	Product Analysis, %
Carbon		
For sizes through 1½ in.	0.30–0.48	0.28–0.50
For size 1½ in.	0.35–0.53	0.33–0.55
Phosphorus, max	0.040	0.045
Sulfur, max	0.040	0.045
Alloying Elements	→ See 5.1 ←	

**TABLE 2 Chemical Requirements for Type 3 Bolts**

Element	Heat Analysis, %	Product Analysis, %
Carbon		
Sizes 0.75 in. and smaller	0.20–0.53	0.19–0.55
Sizes larger than 0.75 in.	0.30–0.53	0.28–0.55
Manganese, min	0.40	0.37
Phosphorus, max	0.035	0.040
Sulfur, max	0.040	0.045
Copper	0.20–0.60	0.17–0.63
Chromium, min	0.45	0.42
Nickel, min	0.20	0.17
or		
Molybdenum, min	0.15	0.14

### 6.2 Tensile Properties:

6.2.1 Except as permitted in 6.2.2 for long bolts and 6.2.3 for short bolts, sizes 1.00 in. and smaller having a length of  $2\frac{1}{4}D$  and longer and sizes larger than 1.00 in. having a length of  $3D$  and longer shall be wedge tested full size and shall conform to the minimum and maximum wedge tensile load, and proof load or alternative proof load specified in Table 4. The load achieved during proof load testing shall be equal to or greater than the specified proof load.

6.2.2 When the length of the bolt makes full-size testing impractical, machined specimens shall be tested and shall conform to the requirements specified in Table 5. When bolts are tested by both full-size and machined specimen methods, the full-size test shall take precedence.

6.2.3 Sizes 1.00 in. and smaller having a length shorter than  $2\frac{1}{4}D$  down to  $2D$ , inclusive, that cannot be wedge tensile tested shall be axially tension tested full size and shall conform to the minimum tensile load and proof load or alternate proof load specified in Table 4. Sizes 1.00 in. and smaller having a length shorter than  $2D$  that cannot be axially tensile tested shall be qualified on the basis of hardness.

6.2.4 For bolts on which hardness and tension tests are performed, acceptance based on tensile requirements shall take precedence in the event of low hardness readings.

### 7. Carburization/Decarburization

7.1 This test is intended to evaluate the presence or absence of carburization and decarburization as determined by the difference in microhardness near the surface and core.

#### 7.2 Requirements:

7.2.1 *Carburization*—The bolts shall show no evidence of a carburized surface when evaluated in accordance with 12.2.

7.2.2 *Decarburization*—Hardness value differences shall not exceed the requirements set forth for decarburization in SAE J121 for Class 2/3H materials when evaluated in accordance with 12.2.

### 8. Dimensions

#### 8.1 Head and Body:

8.1.1 Unless otherwise specified, bolts shall conform to the dimensions for heavy hex structural bolts specified in ASME B18.2.6.

8.1.2 The thread length shall not be changed from that specified in ASME B18.2.6 for heavy hex structural bolts.

Bolts requiring thread lengths other than those required by this specification shall be ordered under Specification A 354 Gr. BD.

8.2 *Threads*—Threads shall be the Unified Coarse Thread Series as specified in ASME B1.1 and shall have Class 2A tolerances.

### 9. Workmanship

9.1 The allowable limits, inspection, and evaluation of the surface discontinuities, quench cracks, forging cracks, head bursts, shear bursts, seams, folds, thread laps, voids, tool marks, nicks, and gouges shall be in accordance with Specification F 788/F 788M (see Note 4).

NOTE 4—Specification F 788/F 788M nor Guide F 1470 do not guarantee 100 % freedom from head bursts. Sampling is designed to provide a 95 % confidence level of freedom from head bursts in any test lot. Head bursts, within the limits in Specification F 788/F 788M, are unsightly but do not affect mechanical properties or functional requirements of the bolt.

### 10. Magnetic Particle Inspection for Longitudinal Discontinuities and Transverse Cracks

#### 10.1 Requirements:

10.1.1 Each sample representative of the lot shall be magnetic particle inspected for longitudinal discontinuities and transverse cracks.

10.1.2 The lot, as represented by the sample, shall be free from nonconforming bolts, as defined in 10.3, when inspected in accordance with 10.2.1–10.2.4.

#### 10.2 Inspection Procedure:

10.2.1 The inspection sample shall be selected at random from each lot in accordance with Table 6 and examined for longitudinal discontinuities and transverse cracks.

10.2.2 Magnetic particle inspection shall be conducted in accordance with Guide E 709 or Practice E 1444. Guide E 709 shall be used for referee purposes. If any nonconforming bolt is found during the manufacturer's examination of the lot selected in 10.2.1, the lot shall be 100 % magnetic particle inspected, and all nonconforming bolts shall be removed and scrapped or destroyed.

10.2.3 Eddy current or liquid penetrant inspection shall be an acceptable substitute for the 100 % magnetic particle inspection when nonconforming bolts are found and 100 % inspection is required. On completion of the eddy current or liquid penetrant inspection, a random sample selected from each lot in accordance with Table 5 shall be re-examined by the magnetic particle method. In case of controversy, the magnetic particle test shall take precedence.

10.2.4 Magnetic particle indications of themselves shall not be cause for rejection. If in the opinion of the quality assurance representative the indications may be cause for rejection, a sample taken in accordance with Table 5 shall be examined by microscopic examination or removal by surface grinding to determine if the indicated discontinuities are within the specified limits.

#### 10.3 Definitions:

10.3.1 *Nonconforming Bolts*—Any bolt with a longitudinal discontinuity (located parallel to the axis of the bolt in the threads, body, fillet, or underside of head), with a depth normal to the surface greater than  $0.03D$ , where  $D$  is the nominal