



Designation: A 677/A 677M – 99

Standard Specification for Nonoriented Electrical Steel Fully Processed Types¹

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1. Scope

1.1 This specification covers the detailed requirements to which flat-rolled nonoriented fully processed electrical steel shall conform.

1.2 This steel is produced to specified maximum core-loss values and is intended primarily for commercial power frequency (50- and 60-Hz) applications in magnetic devices. Desirable core-loss and permeability characteristics are developed during mill processing, so additional heat treatment by the purchaser is usually not necessary.

1.3 These nonoriented fully processed electrical steels are low-carbon, silicon-iron, or silicon-aluminum-iron alloys containing up to about 3.5 % silicon and a small amount of aluminum.

1.4 The values stated in either customary (cgs-emu and inch-pound) units or SI units are to be regarded separately as standard. The SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in nonconformance to this specification.

2. Referenced Documents

2.1 ASTM Standards:

- A 34/A 34M Practice for Sampling and Procurement Testing of Magnetic Materials²
- A 340 Terminology of Symbols and Definitions Relating to Magnetic Testing²
- A 343 Test Method for Alternating-Current Magnetic Properties of Materials at Power Frequencies Using Wattmeter-Ammeter-Voltmeter Method and 25-cm Epstein Test Frame²
- A 664 Practice for Identification of Standard Electrical Steel Grades in ASTM Specifications²
- A 700 Practices for Packaging, Marking, and Loading

Methods for Steel Products for Domestic Shipment³

- A 717/A 717M Test Method for Surface Insulation Resistivity of Single-Strip Specimens²
- A 719 Test Method for Lamination Factor of Magnetic Materials²
- A 720 Test Method for Ductility of Nonoriented Electrical Steel²
- A 937 Test Method for Determining Interlaminar Resistance of Insulating Coatings Using Two Adjacent Test Surfaces²
- A 976 Classification of Insulating Coatings by Composition, Relative Insulating Ability and Application²
- E 18 Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials⁴

3. Terminology

3.1 *Definitions:* The terms and symbols used in this specification are defined in Terminology A 340.

4. Classification

4.1 The nonoriented electrical steel types described by this specification are as shown in Table 1.

5. Ordering Information

5.1 Orders for material under this specification shall include as much of the following information as necessary to describe the desired material adequately:

- 5.1.1 ASTM specification number.
- 5.1.2 Core-loss type number.
- 5.1.3 Surface coating type.
- 5.1.4 Thickness, width, and length (if in cut lengths instead of coils).
- 5.1.5 Total weight of ordered item.
- 5.1.6 Limitations in coil size or lift weights.
- 5.1.7 *End Use*—The purchaser shall disclose as much pertinent information as possible about the intended application to enable the producer to provide material characteristics most suitable for specific fabricating practices.

¹ This specification is under the jurisdiction of ASTM Committee A06 on Magnetic Properties and is the direct responsibility of Subcommittee A06.02 on Material Specifications.

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² *Annual Book of ASTM Standards*, Vol 03.04.

³ *Annual Book of ASTM Standards*, Vol 01.05.

⁴ *Annual Book of ASTM Standards*, Vol 03.01.

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TABLE 1 Core-Loss Types^A and Maximum Core Losses^B at 15 kG [1.5 T] and 60 Hz^C for As-Sheared Epstein Specimens^D

0.0140-in. [0.36-mm] Thickness			0.0185-in. [0.47-mm] Thickness			0.0250-in. [0.64-mm] Thickness		
Core-Loss Type	Maximum Core Loss, W/lb [W/kg]		Core-Loss Type	Maximum Core Loss, W/lb [W/kg]		Core-Loss Type	Maximum Core Loss, W/lb [W/kg]	
36F145	1.45	[3.20]
36F155	1.55	[3.42]	47F165	1.65	[3.64]	64F200	2.00	[4.41]
36F165	1.65	[3.64]	47F180	1.80	[3.97]	64F210	2.10	[4.63]
36F175	1.75	[3.86]	47F190	1.90	[4.19]	64F225	2.25	[4.96]
36F185	1.85	[4.08]	47F200	2.00	[4.41]	64F235	2.35	[5.18]
36F195	1.95	[4.30]	47F210	2.10	[4.63]	64F250	2.50	[5.51]
36F205	2.05	[4.52]	47F240	2.40	[5.29]	64F275	2.75	[6.06]
...	47F280	2.80	[6.17]	64F320	3.20	[7.05]
...	47F400	4.00	[8.82]	64F500	5.00	[11.02]
...	47F450	4.50	[9.92]	64F550	5.50	[12.13]

^A See Practice A 664.

^B The test density shall be the correct ASTM assumed density (in accordance with 14.2) for the chemistry used by the producer to meet the property requirements of the specification.

^C Maximum core losses at 15 kG [1.5 T] and 50 Hz are 0.79 times maximum core losses at 60 Hz.

^D One half of strips cut parallel to the steel rolling direction, one half of strips cut perpendicular to the steel rolling direction.

5.1.8 Special requirements or exceptions to the provisions of this specification.

6. Manufacture

6.1 Typical Melting and Casting:

6.1.1 These fully processed electrical steels may be made by basic-oxygen, electric-furnace, or other steelmaking practice.

6.1.2 These electrical steels are characterized by low carbon, usually less than 0.020 %. The principal alloying element is commonly silicon, but aluminum up to about 0.8 % is sometimes used instead of or in addition to silicon, depending on mill-processing practice for the desired magnetic grade. Individual producers will often have different silicon or aluminum contents for a particular grade because of intrinsic mill-processing procedures.

6.1.3 Sulfur content is typically less than 0.025 % and is usually lowest in the numbered types representing lowest core loss. Manganese is typically present in amounts between 0.10 and 0.40 %. Phosphorus, copper, nickel, chromium, molybdenum, antimony, and tin are usually present only in residual amounts except in the higher numbered core-loss types in which phosphorus up to 0.15 % and tin or antimony up to 0.10 % may be present.

6.1.4 The producer is not required to report chemical composition of each lot except when a clear need for such information has been shown. In such cases, the analyses to be reported shall be negotiated between the producer and the purchaser.

6.2 *Typical Rolling and Annealing*—The processing sequence for fully processed, nonoriented electrical steel comprises hot-rolling, annealing, pickling, cold-rolling, and decarburizing annealing.

6.3 When changes in the manufacture of the material are believed to exert possible significant effects upon the purchaser's fabricating practices and upon the magnetic performance to be obtained in the specified end use, the producer shall notify the purchaser before shipment is made so the purchaser has an opportunity to evaluate the effects.

7. Magnetic Properties

7.1 *Specific Core Loss*—Each core-loss type of electrical steel is identified by a maximum core-loss limit as shown in Table 1.

7.2 *Permeability*—The permeability at all inductions shall be as high as possible, consistent with the required core-loss limits that govern the grade. Typical relative peak permeability (μ_p) values are given in Appendix X1.

7.3 *Specific Exciting Power*—The rms exciting power required for the excitation of a particular type of electrical steel is frequently useful to the purchaser. Typical values of specific exciting power are given in Appendix X1.

7.4 *Magnetic Aging*—Although steel sold to this specification is considered non-aging, the maximum core-loss values of Table 1 are based on tests of freshly sheared specimens. The guarantee of magnetic properties after an aging treatment is subject to negotiation between the purchaser and the producer. The definition of aging coefficient and the aging treatments usually specified are given in Terminology A 340.

8. Surface Insulation Characteristics

8.1 Unless otherwise specified, fully processed nonoriented electrical steels are supplied with a smooth surface finish and a thin, tightly adherent surface oxide (Coating Type C-0 in Classification A 976) which has sufficient insulating ability for most small cores.

8.2 Applied Coatings:

8.2.1 Several types of thin, tightly adherent applied coatings (Coating Types C-3, C-4, C-5, and C-6 in Classification A 976) with higher levels of insulating ability are available on fully processed nonoriented electrical steels. If an applied coating is needed, the purchaser shall specify the coating type.

8.2.2 If the insulating ability of the applied coating is unusually critical to the application, the purchaser shall specify not only the coating type, but also the test method (either Test Method A 717/A 717M or A 937) and test conditions to be used to evaluate the insulating ability of the coating, as well as the corresponding minimum value of insulating ability.

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8.2.3 A thinner-than-usual applied coating may be preferred when the core-fabricating practice involves welding or die casting. In such cases, the coating type shall be suffixed by the letter “A.”

9. Mechanical Requirements Mechanical Requirements

9.1 *Lamination Factor*—The lamination factor shall be as high as practicable. It is greatest for thicker gages and when the surface is smooth, uncoated, and without significant amounts of oxide. Lamination factors can be determined using Test Method A 719. Typical values of lamination factor are given in Appendix X1.

9.2 *Ductility*—The material shall be as ductile as possible. When required, the ductility can be determined by the bend test for ductility as described in Test Method A 720. Ductility is a function of microstructure and may differ between producers. The purchaser’s anneal may also affect ductility. Typical values for ductility are given in Appendix X1.

9.3 *Hardness*—The hardness of these materials can be determined using Test Methods E 18. Hardness is affected by chemistry and by the grain size and microstructure of the final product. Typical values for the hardness of “as-produced” materials are given in Appendix X1.

10. Dimensions and Permissible Variations

10.1 *Thickness*—Specified thickness should be one of the common thicknesses as follows:

Thickness, in. [mm]
0.0140 [0.36]
0.0185 [0.47]
0.0250 [0.64]

10.2 *Thickness Variations*—The average thickness of the material supplied shall be as close as possible to the ordered thickness. Measurements made with a contacting micrometer at points no closer than 3/8 in. [10 mm] from the edge of a sheet or coil of specified width shall not differ from the specified thickness by more than the values (which include taper) shown in Table 2.

10.3 *Taper*—The rolling of flat-rolled sheets inherently produces an edge which is thinner than the rest of the sheet. This characteristic is termed “tapered edge,” “feather,” or gamma and occurs primarily within 1 to 2 in. [25 to 51 mm] from the as-rolled edge of the material. The thickness variation involved in edge taper sometimes is the major portion of the total overall thickness variation permitted by 10.2. It may be expected that the following limits on the differences in thickness measured along a straight line perpendicular to the mill edge within the first 3 in. [76 mm] or less from either edge of the ordered width will apply:

Ordered Thickness, in. [mm]	Maximum Taper, in. [mm]
0.0140 [0.36]	0.0010 [0.025]
0.0185 [0.47]	0.0012 [0.030]
0.0250 [0.64]	0.0014 [0.036]

10.4 *Width Tolerances*—Maximum deviations from the ordered width shall be as shown in Table 3.

10.5 *Length Tolerances*—The maximum deviations from the ordered length shall be as shown in Table 4.

10.6 *Camber*—Camber is the greatest deviation of a side edge from a straight line, the measurement being taken on the concave side with a straightedge. It is limited to 1/4 in. [6.4 mm] per 96 in. [2.4 m] of length.

10.7 *Out of Square*—This tolerance applies to cut lengths only and represents the deviation of an edge from a straight line placed at a right angle to the side, touching one corner and extending to the other side. It shall not exceed 1/16 in. [1.6 mm] per 6 in. [152 mm] of width or fraction thereof.

11. Workmanship, Finish and Appearance

11.1 *Flatness*—Adequately defining the degree of flatness necessary for the general application of fully processed electrical steel sheets is extremely difficult; therefore, no specific limits for flatness have been established.

11.1.1 It is intended that flatness shall be suitable for the intended application, and consequently, the purchaser should inform the producer of any requirements for a degree of flatness more critical than that obtained from usual commercial practices. Processes used to improve flatness may affect magnetic and mechanical properties.

11.1.2 Commercial practices recognize that sharp, short waves and buckles are objectionable.

11.1.3 Procedures for judging the degree of critical flatness necessary shall be subject to negotiation between purchaser and producer.

11.2 *Surface Imperfections*—The surface shall be reasonably clean and essentially free of manufacturing defects such as holes, blisters, slivers, indentations, and so forth, which would interfere with its effective use in the intended application.

12. Sampling

12.1 The producer shall assign a number to each test lot for identification. The test lot shall not exceed 20 000 lbs [9100 kg] in weight.

12.2 Test samples shall be obtained after final mill heat treatment or other operation which is the final operation to have significant influence on the magnetic properties of fully processed electrical steel.

12.3 The full width coil identified as a test lot shall be sampled in accordance with Practice A 34/A 34M.

TABLE 2 Thickness Tolerances

Specified Thickness, in. [mm]	Thickness Tolerances, Over or Under, in. [mm] for Specified Width, in. [mm]			
	6 [0.15] and Under	Over 6 [0.15] to 12 [0.30], incl.	Over 12 [0.30] to 36 [0.91], incl.	Over 36 [0.91] to 48 [1.22], incl.
0.014 [0.36] to 0.020 [0.51], incl	0.0015 [0.038]	0.002 [0.051]	0.002 [0.051]	0.003 [0.076]
0.021 [0.53] to 0.031 [0.79], incl	0.002 [0.051]	0.002 [0.051]	0.003 [0.076]	0.003 [0.076]