



Designation: A 356/A 356M – 07

Standard Specification for Steel Castings, Carbon, Low Alloy, and Stainless Steel, Heavy-Walled for Steam Turbines¹

This standard is issued under the fixed designation A 356/A 356M; 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.

1. Scope*

1.1 This specification covers one grade of martensitic stainless steel and several grades of ferritic steel castings for cylinders (shells), valve chests, throttle valves, and other heavy-walled castings for steam turbine applications.

1.2 Optional supplementary requirements (S1 through S5) shall apply as selected by and specified by the purchaser.

1.3 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 must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification.

2. Referenced Documents

2.1 ASTM Standards:²

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

A 488/A 488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel

E 94 Guide for Radiographic Examination

E 125 Reference Photographs for Magnetic Particle Indications on Ferrous Castings

E 165 Test Method for Liquid Penetrant Examination

E 186 Reference Radiographs for Heavy-Walled (2 to 412-in. [51 to 114-mm]) Steel Castings

E 280 Reference Radiographs for Heavy-Walled (412 to 12-in. [114 to 305-mm]) Steel Castings

E 446 Reference Radiographs for Steel Castings Up to 2 in. [51 mm] in Thickness

E 709 Guide for Magnetic Particle Examination

2.2 Manufacturers' Standardization Society of the Valve and Fitting Industry Standard:³

SP-55 Quality Standard for Steel Castings for Valves, Flanges, and Fittings and Other Piping Components (Visual Method)

3. Classification

3.1 The castings are furnished in the grades shown in Table 1.

4. Ordering Information

4.1 Orders for material to this specification should include the following information:

4.1.1 A description of the casting by pattern number or drawing (dimensional tolerances shall be included on the casting drawing),

4.1.2 Grade of steel,

4.1.3 Options in the specification, and

4.1.4 The supplementary requirements desired, including the standards of acceptance.

5. Melting Process

5.1 The steel shall be made by the open-hearth or electric-furnace process.

5.2 Deoxidation Practice:

5.2.1 Deoxidation of the carbon and low-alloy steel grades shall be by manganese and silicon. Furnace or ladle deoxidation with other agents is permissible with the approval of the purchaser.

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 A01.18 on Castings.

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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.

³ Available from Manufacturers Standardization Society of the Valve and Fittings Industry (MSS), 127 Park St., NE, Vienna, VA 22180-4602, <http://www.mss-hq.com>.

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



TABLE 1 Chemical Requirements^A

Grade/ UNS Number	Material	Composition, %											
		Carbon	Manganese	Silicon	Phosphorus, max	Sulfur, max	Molybdenum	Chromium	Nickel	Vanadium	Columbium	Nitrogen	Aluminum
1	carbon steel	0.35 ^B max	0.70 ^B max	0.60 max	0.035	0.030
J03502													
2	½ % molybdenum	0.25 ^B max	0.70 ^B max	0.60 max	0.035	0.030	0.45-0.65
J12523													
5	½ % chromium, ½ % molybdenum	0.25 ^B max	0.70 ^B max	0.60 max	0.035	0.030	0.40-0.60	0.40-0.70
J12540													
6	1¼ % chromium, ½ % molybdenum	0.20 max	0.50-0.80	0.60 max	0.035	0.030	0.45-0.65	1.00-1.50
J12073													
8	1 % chromium, 1 % molybdenum, vanadium	0.20 max	0.50-0.90	0.20-0.60	0.035	0.030	0.90-1.20	1.00-1.50	0.05-0.15
J11697													
9	1 % chromium, 1 % molybdenum, vanadium	0.20 max	0.50-0.90	0.20-0.60	0.035	0.030	0.90-1.20	1.00-1.50	0.20-0.35
J21610													
10	2¼ % chromium, 1 % molybdenum, vanadium	0.20 max	0.50-0.80	0.60 max	0.035	0.030	0.90-1.20	2.00-2.75
J22090													
12A ^C	9 % chromium, 1 % molybdenum, vanadium	0.08-0.12	0.30-0.60	0.20-0.50	0.030	0.010	0.85-1.05	8.0-9.5	0.40 max	0.18-0.25	0.060-0.10	0.030-0.070	0.02 max
J84090													titanium, 0.01 max; zirconium, 0.01 max ...
CA6NM	martensitic chromium	0.06 max	1.00 max	1.00 max	0.040	0.030	0.4-1.0	11.5-14.0	3.5-4.5
J91540	nickel												...

^AWhere ellipses appear in this table, there is no requirement.

^BFor each 0.01 % reduction in carbon below the maximum specified, an increase of 0.04 percentage points of manganese over the maximum specified for that element will be permitted up to 1.00.

^CThe designation of Grade 12, formerly covered by this specification, has been changed to Grade 12A.

5.2.2 The purchaser may specify that no aluminum be added.

5.2.3 Vacuum deoxidation is acceptable. The specific method shall be subject to approval by the purchaser.

6. Heat Treatment

6.1 *Preliminary Heat Treatment*—The castings may receive such preliminary heat treatment as the founder may elect to employ.

6.2 *Heat Treatment for Final Properties* :

6.2.1 *Normalizing*—The castings shall be heated to and held at the proper temperature for a sufficient time to affect the desired transformation and withdrawn from the furnace and allowed to cool to affect complete transformation. Grade 12A castings shall be normalized at 1900-1975°F [1040-1080°C] and withdrawn from the furnace and allowed to cool to affect complete transformation.

6.2.2 *Tempering*—The casting shall be heated to and held at the proper temperature, which shall be below the transformation range, and then cooled under suitable conditions. The tempering temperature shall not be less than 1100°F [595°C]. Grade 12A castings shall be tempered at 1350-1470°F [730-800°C].

6.2.3 *Stress Relieving*—The stress relieving operation shall be carried out in the same manner as tempering. The temperature shall be within 50°F [28°C], but not exceeding the final tempering temperature.

6.3 *Stainless Steel Casting*:

6.3.1 *Normalizing*—The castings shall be heated to 1850°F [1010°C] minimum, held sufficiently at that temperature to uniformly heat the castings, and air cooled to below 200°F [93°C].

6.3.2 *Tempering*—The castings shall be final tempered from 1050 to 1150°F [565 to 620°C].

6.3.3 *Stress Relieving*—The stress relieving operation shall be performed in the same manner as tempering. Temperature shall be between 1050°F [565°C] and 1150°F [620°C].

7. Chemical Composition

7.1 The steel shall conform to the requirements given in Table 1 (Note 1).

NOTE 1—The role of alloying elements in the development of Grade 12A has been extensively investigated. V and Cb contribute to precipitation strengthening by forming fine and coherent precipitates of M(C,N)X carbo-nitrides in the ferritic matrix. V also precipitates as VN during tempering or creep. The two elements are more effective in combination. Therefore, the addition of strong nitride-forming elements, those with a stronger affinity for nitrogen than Cb and V, as deoxidation agents during melting of this grade, interferes with these high-temperature strengthening mechanisms.⁴

8. Tensile Requirements

8.1 Tensile properties shall conform to the requirements listed in Table 2 as determined by the test specimen set forth in Section 9.

8.2 Tension tests shall be performed in accordance with Test Methods and Definitions A 370.

9. Number of Tests and Retests

9.1 One tension test shall be made from each heat in each heat-treatment charge and from each casting on which attached coupons are specified. The bar from which the test specimen is taken shall be heat treated with the casting represented.

9.2 If any test specimen shows defective machining or develops flaws, it shall be discarded and another specimen substituted from the same heat.

9.3 If the results of the mechanical tests for any lot or casting do not conform to the requirements specified, the founder may reheat treat and retest such lot or casting.

10. Test Specimen

10.1 Tension test specimens and samples for microexamination may be taken from coupons conforming substantially to the

⁴ Viswanathan, R. and Bakker, W. T., *Materials for Ultra Supercritical Fossil Power Plants*, EPRI, Palo Alto, CA, 2000. TR-114750.

TABLE 2 Tensile Requirements

Grade	Material	Tensile Strength, min, ksi [MPa]	Yield Strength, min, ksi [MPa]	Elongation in 2 in. [50 mm] min, %	Reduction of Area, min, %
1	carbon steel	70 [485]	36 [250]	20.0	35.0
2	½ % molybdenum	65 [450]	35 [240]	22.0	35.0
5	½ % chromium, ½ % molybdenum	70 [485]	40 [275]	22.0	35.0
6	1¼ % chromium, ½ % molybdenum	70 [485]	45 [310]	22.0	35.0
8	1 % chromium, 1 % molybdenum, vanadium	80 [550]	50 [345]	18.0	45.0
9	1 % chromium, 1 % molybdenum, vanadium	85 [585]	60 [415]	15.0	45.0
10	2¼ % chromium, 1 % molybdenum	85 [585]	55 [380]	20.0	35.0
12A	9 % chromium, 1 % molybdenum, vanadium	85 [585]	60 [415]	20.0	...
CA6NM	martensitic chromium nickel	110 [760]	80 [550]	15.0	35.0