



Designation: A973/A973M – 07

Standard Specification for Grade 100 Alloy Steel Chain¹

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1. Scope*

1.1 This specification covers Grade 100 heat-treated alloy steel chain for such applications as slings, lifting assemblies, and load binding.

NOTE 1—This specification does not cover alloy steel chain for pocket wheel applications.

1.2 This specification is a performance standard for Grade 100 chain used between -20 and 400°F [-29 and 205°C]. The chain manufacturer should be contacted for use at temperatures outside this range.

1.3 The Grade designation is $1/10$ of the minimum breaking strength in newtons divided by two times the nominal cross-sectional area of the chain in square millimetres.

1.4 The values stated in either SI units or in other units shall be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system must be used independently of the other, without combining values in any way.

2. Referenced Documents

2.1 *ASTM Standards*:²

A29/A29M Specification for Steel Bars, Carbon and Alloy, Hot-Wrought, General Requirements for

A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products

A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys

2.2 *SAE Standard*:

SAE J422 Microscopic Determination of Inclusions in Steels³

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 A01.27 on Steel Chain.

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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 Society of Automotive Engineers, 400 Commonwealth Drive, Warrendale, PA 15096.

3. Terminology

3.1 *Definitions of Terms Specific to This Standard*:

3.1.1 *breaking force, minimum, n*—minimum force in pounds or newtons at which the chain, during manufacture, has been found by testing to break when a constantly increasing force is applied in direct tension.

3.1.1.1 *Discussion*—This test is a manufacturer's attribute acceptance test and shall not be used as criteria for service.

3.1.2 *date code, n*—series of letters, numbers, or both embossed on the chain which enables its manufacturing history to be traced.

3.1.3 *lot, n*—for the purpose of acceptance testing, a lot shall consist of 3000 ft [1000 m], or fraction thereof, of the same size chain. If a continuous length of chain exceeds 3000 ft [1000 m], it shall also be considered a lot.

3.1.4 *proof test, n*—quality control tensile test applied to chain for the purpose of verifying weld and material quality.

3.1.4.1 *Discussion*—It is the minimum force in pounds or newtons which the chain has withstood at the time it left the producer, under a test in which a constantly increasing force has been applied in direct tension to a straight length of chain. Proof test loads are a manufacturing integrity test and shall not be used as criteria for service or design purposes.

3.1.5 *traceability code, n*—series of letters, numbers, or both embossed on the chain which enables its manufacturing history, including the identity of the steel heat, to be traced.

3.1.6 *working load limit (WLL), n*—maximum combined static and dynamic load in pounds or kilograms that shall be applied in direct tension to an undamaged straight length of chain.

4. Ordering Information

4.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this specification. Such requirements include, but are not limited to, the following:

4.1.1 Product to conform to Specification A973/A973M and date of issue,

4.1.2 Nominal size of chain (in. or mm),

4.1.3 Quantity of chain (ft or m),

4.1.4 Length of each piece, if required,

4.1.5 Finish, if required,

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

TABLE 2 Mechanical Test Sample Length Requirements

| Size of Chain | Minimum Number of Links in Test Specimen |
|---|--|
| 7/32 in. [5.5 mm] | 9 |
| Larger than 7/32 in. [5.5 mm] but less than 3/4 in. [20.0 mm] | 7 |
| 3/4 in. [20.0 mm] and larger | 3 |

7.2.1 Fixtures for securing chain in a testing machine shall be properly designed to support securely the shoulder of the link (see **Note 2**). The opening in the fixture shall not be more than 125 % of the stock diameter being tested. Links engaged in the testing fixture shall not be considered part of the test specimen.

NOTE 2—“U” bolts of the same or larger diameter and the same or greater strength may be used to secure the chain to the jaws of the testing machine.

7.2.2 Test results shall meet or exceed the minimum breaking force values given in **Table 1** for the appropriate size chain.

7.3 Elongation:

7.3.1 All chain must be in the quenched and tempered condition before the elongation is measured.

7.3.2 The elongation test specimen shall consist of a length from the lot containing at least the number of links in **Table 2**.

7.3.3 A positive load not exceeding 10 % of the proof test shall be applied for determining the original gage length ($L\{0\}$).

7.3.4 The elongation shall be based on the total extension at fracture. This is expressed as a percentage of the change in length (ΔL) divided by the original gage length ($L\{0\}$). The elongation may be determined by the equation below or by autographic recorder or side scale.

$$\text{Elongation (\%)} = \{\Delta L/L\{0\}\} \times 100$$

where:

ΔL = test specimen final length at fracture – test specimen original gage length ($L\{0\}$), and

$L\{0\}$ = original gage length (sum or the inside lengths of the test chain links, not counting the fixture links, or as determined in **7.3.3**).

7.3.5 The elongation shall be a minimum of 20 %.

7.4 One test for breaking strength and elongation shall be made from each lot. The elongation and breaking force tests may be performed at the same time on the same test specimen.

- 4.1.6 Certification of test(s), if required,
- 4.1.7 Acceptance of inspection by purchaser, if required, and
- 4.1.8 Supplementary requirements, if required.

5. Manufacturing

5.1 *Melting Process*—The alloy steel shall be fully killed and have an austenitic grain size of five or finer.

5.2 *Welding Process*—Alloy steel chain may be made by the electric welding or gas welding process.

5.3 *Heat Treatment*—After welding, alloy steel chain shall be heat treated before applying the proof test. Heat treatment shall include quenching and tempering as defined by Terminology **A941**.

6. Material Requirements

6.1 *Heat Analysis*—The selection and amounts of the alloying elements in the steel are left to the judgment of the individual chain manufacturer provided the steel meets the following criteria: carbon = 0.35 % max; phosphorous = 0.025 % max; sulfur = 0.025 % max. The following elements must all be present in alloying amounts, nickel (0.40% min), chromium (0.40% min), and molybdenum (0.15% min). The steel shall have oxide and silicate inclusions of 4 or less as determined by SAE J422.

6.2 *Product Analysis*—The steel used may be analyzed by the purchaser and shall conform to the requirements of 6.1 subject to the product analysis tolerances specified in Specification **A29/A29M**. Test samples may be taken from rods, bars, or finished chain. Samples for analysis shall be so taken as to represent the full cross section of the specimen.

6.3 Test Methods, Practices, and Terminology **A751** shall be used for referee purposes.

7. Mechanical Requirements

7.1 *Proof Test*—All chain shall be tested to at least the proof load prescribed in **Table 1** for the appropriate size chain. When so tested it shall withstand these loads without loss of chain integrity. Links or chain segments not withstanding the proof test load shall be removed from the chain.

7.2 *Breaking Force*—The breaking force test specimen shall consist of a length from the lot containing at least the number of links in **Table 2**. All chain shall be in the quenched and tempered condition before the breaking force is measured.

TABLE 1 Grade 100 Alloy Chain Mechanical and Dimensional Requirements

| Nominal Chain Size | | Material Diameter | | Working Load Limit (max) | | Proof Test (min) | | Minimum Breaking Force | | Inside Length (max) | | Inside Width Range | |
|--------------------|-----|-------------------|------|--------------------------|--------|------------------|------|------------------------|------|---------------------|------|--------------------|----------------|
| in. | mm | in. | mm | lb | kg | lb | kN | lb | kN | in. | mm | in. | mm |
| 7/32 | 5.5 | 0.217 | 5.5 | 2700 | 1220 | 5400 | 23.8 | 10 800 | 47.6 | 0.69 | 17.6 | 0.281 to 0.325 | 7.14 to 8.25 |
| 9/32 | 7 | 0.276 | 7.0 | 4300 | 1950 | 8600 | 38.5 | 17 200 | 77 | 0.90 | 22.9 | 0.375 to 0.430 | 9.53 to 10.92 |
| 5/16 | 8 | 0.315 | 8.0 | 5700 | 2600 | 11 400 | 51 | 22 800 | 102 | 1.04 | 26.4 | 0.430 to 0.500 | 10.92 to 12.70 |
| 3/8 | 10 | 0.394 | 10.0 | 8800 | 4000 | 17 600 | 79 | 35 200 | 158 | 1.26 | 32.0 | 0.512 to 0.600 | 13.00 to 15.20 |
| 1/2 | 13 | 0.512 | 13.0 | 15 000 | 6800 | 30 000 | 134 | 60 000 | 268 | 1.64 | 41.6 | 0.688 to 0.768 | 17.48 to 19.50 |
| 5/8 | 16 | 0.630 | 16.0 | 22 600 | 10 300 | 45 200 | 201 | 90 400 | 402 | 2.02 | 51.2 | 0.812 to 0.945 | 20.63 to 24.00 |
| 3/4 | 20 | 0.787 | 20.0 | 35 300 | 16 000 | 70 600 | 315 | 141 200 | 630 | 2.52 | 64.0 | 0.984 to 1.18 | 25.0 to 30.0 |
| 7/8 | 22 | 0.866 | 22.0 | 42 700 | 19 400 | 85 400 | 381 | 170 800 | 762 | 2.77 | 70.4 | 1.08 to 1.30 | 27.5 to 33.0 |