



Designation: A 336/A 336M – 08

Standard Specification for Alloy Steel Forgings for Pressure and High-Temperature Parts¹

This standard is issued under the fixed designation A 336/A 336M; 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 ferritic steel forgings for boilers, pressure vessels, high-temperature parts, and associated equipment.

1.2 Forgings made of steel grades listed in Specification A 335/A 335M, may also be ordered under this specification. The chemical, tensile, heat treatment, and marking requirements of Specification A 335/A 335M shall apply, except the forging shall conform to the chemical requirements of Tables 1 and 2 of Specification A 335/A 335M only with respect to heat analysis. On check analysis they may deviate from these limits to the extent permitted in Table 1 of this specification.

Current	Formerly
Grade F1	Class F1
Grade F11, Class 2	Class F11
Grade F11, Class 3	Class F11A
Grade F11, Class 1	Class F11B
Grade F12	Class F12
Grade F5	Class F5
Grade F5A	Class F5A
Grade F9	Class F9
Grade F6	Class F6
Grade F21 Class 1	Class F21A
Grade F21, Class 3	Class F21
Grade F22, Class 1	Class F22A
Grade F22, Class 3	Class F22
Grade F91	Class F91
Grade F3V	Class F3V
Grade F22V	Class F22V

1.3 Supplementary Requirements S1 to S9 are provided for use when additional testing or inspection is desired. These shall apply only when specified individually by the purchaser in the order.

1.4 Unless the order specifies the applicable “M” specification designation, the material shall be furnished to the inch-pound units.

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 A01.06 on Steel Forgings and Billets.

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-336/SA-336M in Section II of that Code.

1.5 Specification A 336/A 336M formerly included austenitic steel forgings, which are now found in Specification A 965/A 965M.

1.6 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

2. Referenced Documents

2.1 ASTM Standards:³

A 275/A 275M Practice for Magnetic Particle Examination of Steel Forgings

A 335/A 335M Specification for Seamless Ferritic Alloy-Steel Pipe for High-Temperature Service

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

A 788/A 788M Specification for Steel Forgings, General Requirements

A 965/A 965M Specification for Steel Forgings, Austenitic, for Pressure and High Temperature Parts

E 165 Test Method for Liquid Penetrant Examination

2.2 Other Standard:

ASME Boiler and Pressure Vessel Code Section III, Nuclear Facility Components and Section IX, Welding Qualifications⁴

3. Ordering Information and General Requirements

3.1 In addition to the ordering information required by Specification A 788/A 788M, the purchaser should include with the inquiry and order the following information:

3.1.1 A drawing or sketch that shows test locations when the testing is in accordance with 8.1.1.3.

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.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990.

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

TABLE 1 Tensile Requirements

	Ferritic Steels																		
	Grade																		
	F1	F11, Class 2	F11, Class 3	F11, Class 1	F12	F5	F5A	F9	F6	F21, Class 3	F21, Class 1	F22, Class 3	F22, Class 1	F91	F911	F3V	F3VCb	F22V	
Tensile strength, psi [MPa]	70 000-95 000 [485-660]	70 000-95 000 [485-660]	75 000-100 000 [515-690]	60 000-85 000 [415-585]	70 000-95 000 [485-660]	60 000-85 000 [415-585]	80 000-105 000 [550-725]	85 000-110 000 [585-760]	85 000-110 000 [585-760]	75 000-100 000 [515-690]	60 000-85 000 [415-585]	75 000-100 000 [515-690]	60 000-85 000 [415-585]	85 000-110 000 [585-760]	90 000-120 000 [620-830]	85 000-110 000 [585-760]	85 000-110 000 [585-760]	85 000-110 000 [585-760]	85 000-110 000 [585-760]
Yield strength, min, psi [MPa]	40 000 [275]	40 000 [275]	45 000 [310]	30 000 [205]	40 000 [275]	36 000 [250]	50 000 [345]	55 000 [380]	55 000 [380]	45 000 [310]	30 000 [205]	45 000 [310]	30 000 [205]	60 000 [415]	64 000 [440]	60 000 [415]	60 000 [415]	60 000 [415]	60 000 [415]
Elongation in 2 in. or 50 mm, min, %	20	20	18	20	20	20	19	20	18	19	20	19	20	20	20	18	18	18	18
Reduction of area, min, %	40	40	40	45	40	40	35	40	35	40	45	40	45	40	40	45	45	45	45



3.1.2 The intended use of forgings if 5.1 is applicable.

3.2 Material supplied to this specification shall conform to the requirements of Specification **A 788/A 788M**, which outlines additional ordering information, manufacturing requirements, testing and retesting methods and procedures, marking, certification, product analysis variations, and additional supplementary requirements.

3.3 If the requirements of this specification are in conflict with the requirements of Specification **A 788/A 788M**, the requirements of this specification shall prevail.

3.4 For hubbed flanges and tube sheets ordered for **ASME Boiler and Pressure Vessel Code** application, Supplementary Requirement S12 of Specification **A 788/A 788M** shall be specified.

3.5 For Section III, Part NB of the **ASME Boiler and Pressure Vessel Code** application, Supplementary Requirement S3 shall be specified.

4. Melting and Forging

4.1 In addition to the melting and forging requirements of Specification **A 788/A 788M**, which may be supplemented by Supplementary Requirement S8, the following conditions apply:

4.1.1 A sufficient discard shall be made to secure freedom from injurious pipe and undue segregation.

5. Machining

5.1 Forged pressure vessels for steam power service shall have the inner surface machined or ground. Unfired pressure vessels shall have the inner surfaces sufficiently free of scale to permit inspection.

5.2 When rough machining is performed, it may be done either before or after heat treatment.

6. Heat Treatment

6.1 Except as permitted in 6.1.1 for Grade F22V, the steel forgings shall be annealed or normalized and tempered but alternatively may be liquid quenched and tempered when mutually agreed upon between the manufacturer and the purchaser. For all grades, normalizing or liquid quenching shall be followed by tempering at a subcritical temperature.

6.1.1 Grade F22V forgings shall be normalized and tempered or liquid quenched and tempered at the manufacturer’s option.

6.1.1.1 For Grade F22V forgings the minimum austenizing temperature shall be 1650°F [900°C].

6.1.2 For Grade F91 and F911 forgings the austenitizing temperature shall be in the range of 1900 to 1975°F [1040 to 1080°C].

6.1.3 Except for the following grades, the minimum tempering temperature shall be 1100°F [595°C]:

Grade	Tempering Temperature Minimum or Range, °F [°C]
F6	1150 [620]
F11, Class 2	1150 [620]
F11, Class 3	1150 [620]
F11, Class 1	1150 [620]
F5	1250 [675]
F9	1250 [675]

F21, Class 1	1250 [675]
F3V, F3VCb	1250 [675]
F22, Class 1	1250 [675]
F22V	1250 [675]
F91	1350-1470 [730-800]
F911	1365-1435 [740-780]
F22, Class 3	1250 [675]

7. Chemical Composition

7.1 *Heat Analysis*—The heat analysis obtained from sampling in accordance with Specification **A 788/A 788M** and shall comply with **Table 2**.

7.2 *Product Analysis*—The manufacturer shall use the product analysis provision of Specification **A 788/A 788M** to obtain a product analysis from a forging representing each heat or multiple heat. The product analysis for columbium and calcium for Grade F22V shall conform to the requirements of **Table 2** of this specification. Boron is not subject to product analysis. The purchaser may also make this determination in accordance with Specification **A 788/A 788M**.

8. Mechanical Properties

8.1 *General Requirements*—The material shall conform to the requirements for mechanical properties prescribed in **Table 1**. The largest obtainable tension test specimen as specified in Test Methods and Definitions **A 370** shall be used.

8.1.1 Except as required in 3.4, for annealed, normalized, and tempered or quenched and tempered forgings, the longitudinal axis of the tension test specimens, and, when required, Charpy impact test specimens, shall be parallel to the direction of major working of the forging, except when Supplementary Requirement S2 is specified. For upset disk forgings, the longitudinal axis of the test specimen shall be in the tangential direction.

8.1.1.1 Except as provided for liquid quenched and tempered forgings in 8.1.1.3, the longitudinal axis of the specimen shall be located midway between the parallel surfaces of the test extension if added to the periphery of disks or midway between the center and surface of solid forgings. For hollow forgings, the longitudinal axis of the specimens shall be located midway between the center and outer surfaces of the wall. When separately forged test blocks are employed, as defined in 8.1.3, the tension test specimens shall be taken from a location that represents the midwall of the heaviest section of the production forgings. When specimens are required from opposite ends, they shall be taken from the diagonal corners of an axial plane. Alternatively, and when specified by the purchaser, the specimens shall be taken in accordance with Supplementary Requirement S3.

8.1.1.2 For liquid quenched and tempered forgings, the test specimens shall have their longitudinal axis at least ¼ *T* of the maximum heat-treated thickness from any surface and with the mid-length of the specimens at least one *T* from any second surface. This is normally referred to as ¼ *T* × *T*, where *T* is the maximum heat-treated thickness. A thermal buffer may be used to adhere to the above condition.

8.1.1.3 For liquid quenched and tempered forgings with prior purchaser approval, test specimens may be taken at a depth (*t*) corresponding to the distance from the area of significant stress to the nearest heat-treated surface and at least

TABLE 2 Chemical Requirements

Composition, %								
Grade								
Element	F1	F11, Classes 2 and 3	F11, Class 1	F12	F5 ^A	F5A ^A	F9	F6
Carbon	0.20–0.30	0.10–0.20	0.05–0.15	0.10–0.20	0.15 max	0.25 max	0.15 max	0.12 max
Manganese	0.60–0.80	0.30–0.80	0.30–0.60	0.30–0.80	0.30–0.60	0.60 max	0.30–0.60	1.00 max
Phosphorus, max	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025
Sulfur, max	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025
Silicon	0.20–0.35	0.50–1.00	0.50–1.00	0.10–0.60	0.50 max	0.50 max	0.50–1.00	1.00 max
Nickel	0.50 max	0.50 max	...	0.50 max
Chromium	...	1.00–1.50	1.00–1.50	0.80–1.10	4.0–6.0	4.0–6.0	8.0–10.0	11.5–13.5
Molybdenum	0.40–0.60	0.45–0.65	0.44–0.65	0.45–0.65	0.45–0.65	0.45–0.65	0.90–1.10	...

Grade		
Element	F21, Classes 1 and 3	F22, Classes 1 and 3
Carbon	0.05–0.15	0.05–0.15
Manganese	0.30–0.60	0.30–0.60
Phosphorus, max	0.025	0.025
Sulfur, max	0.025	0.025
Silicon	0.50 max	0.50 max
Nickel
Chromium	2.7–3.3	2.00–2.50
Molybdenum	0.80–1.06	0.90–1.10
Vanadium
Copper
Nitrogen
Columbium

Element	Grade F 91	Grade F911	F3V	F3VCb	F22V
Carbon	0.08–0.12	0.09–0.13	0.10–0.15	0.10–0.15	0.11–0.15
Manganese	0.30–0.60	0.30–0.60	0.30–0.60	0.30–0.60	0.30–0.60
Phosphorus, max	0.025	0.020	0.020	0.020	0.015
Sulfur, max	0.025	0.010	0.020	0.010	0.010
Silicon	0.20–0.50	0.10–0.50	0.10 max	0.10 max	0.10 max
Nickel	0.40 max	0.40 max	...	0.25 max	0.25 max
Chromium	8.0–9.5	8.5–9.5	2.7–3.3	2.7–3.3	2.00–2.50
Molybdenum	0.85–1.05	0.90–1.10	0.90–1.10	0.90–1.10	0.90–1.10
Vanadium	0.18–0.25	0.18–0.25	0.20–0.30	0.20–0.30	0.25–0.35
Columbium	0.06–0.10	0.06–0.10	...	0.015–0.070	0.07 max
Nitrogen	0.03–0.07	0.04–0.09
Aluminum	0.02 max ^B	0.02 max ^B
Boron	...	0.0003–0.006	0.001–0.003	...	0.0020 max
Tungsten	...	0.90–1.10
Titanium	0.01 max ^B	0.01 max ^B	0.015–0.035	0.015 max	0.030 max
Copper	0.25 max	0.20 max
Calcium	0.0005–0.0150	0.015 max ^C
Zirconium	0.01 max ^B	0.01 max ^B

^A The present Grade F 5A (0.25 %, maximum carbon) previous to 1955 was assigned the identification symbol F 5. Identification symbol F 5 has been assigned to the 0.15 %, maximum, carbon grade to be consistent with ASTM specifications for other products such as pipe, tubing, bolting, welding, fittings, etc.

^B Applies to both heat and product analyses.

^C For Grade F 22V, rare earth metals (REM) may be added in place of calcium subject to agreement between the producer and the purchaser. In that case the total amount of REM shall be determined and reported.

twice this distance ($2t$) from any second surface. However, the test depth shall not be nearer to one heat-treated surface than $\frac{3}{4}$ in. [19 mm] and to the second treated surface than $1\frac{1}{2}$ in. [38 mm]. This method of test specimen location normally (known as $tx2t$ testing) applies to thick and complex pressure vessel components where the testing in accordance with 8.1.1.2 is not practical. Sketches showing the proposed exact test locations shall be approved by the purchaser when this method is used.

8.1.2 Except as specified in this specification, tests for acceptance shall be made after heat treatment has been

completed in accordance with Section 6. When the ends of the cylindrical forgings are closed in by reforging, the cylindrical forgings may be normalized and tempered or annealed and tested before reforging. After reforging, the entire forging shall be re-heat treated in the same manner and at the same temperature range as employed when the forging was heat treated before certification testing.

8.1.3 When mutually agreed upon between the manufacturer and the purchaser, test specimens may be machined from a specially forged block suitably worked and heat treated with