



Designation: A389/A389M – 08

Standard Specification for Steel Castings, Alloy, Specially Heat-Treated, for Pressure- Containing Parts, Suitable for High-Temperature Service¹

This standard is issued under the fixed designation A389/A389M; 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 specification covers alloy steel castings, which have been subjected to special heat treatment, for valves, flanges, fittings, and other pressure-containing parts (**Note 1**) intended primarily for high-temperature service.

1.2 The high-temperature properties of the materials covered in this specification are dependent upon special heat treatment that is required. Although the high-temperature properties are not specified, they are implied by control of chemistry, heat treatment, and room-temperature properties.

1.3 Two grades of ferritic alloy steel are covered (**Note 2**). Selection will depend on the design and service conditions, mechanical properties, and high-temperature characteristics.

NOTE 1—Carbon steel castings for pressure-containing parts are covered by Specification **A216/A216M**. Alloy steel castings are covered by Specification **A217/A217M**.

NOTE 2—The grades covered by this specification represent materials that are generally suitable for assembly with other castings or wrought steel parts by fusion welding. It is not intended to imply that these grades possess equal degrees of weldability; therefore, it is the responsibility of the purchaser to establish for himself a suitable welding technique. Since these grades possess varying degrees of suitability for resistance to oxidation and for high-temperature service, it is also the responsibility of the purchaser to determine which grade shall be furnished, due consideration being given to the requirements of the applicable construction codes.

1.4 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.

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. Referenced Documents

2.1 ASTM Standards:²

A216/A216M Specification for Steel Castings, Carbon, Suitable for Fusion Welding, for High-Temperature Service

A217/A217M Specification for Steel Castings, Martensitic Stainless and Alloy, for Pressure-Containing Parts, Suitable for High-Temperature Service

A488/A488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel

A703/A703M Specification for Steel Castings, General Requirements, for Pressure-Containing Parts

A985/A985M Specification for Steel Investment Castings General Requirements, for Pressure-Containing Parts

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

SP-55 Quality Standard for Steel Castings for Valves, Flanges, and Fittings and other Components (Visual Method)³

3. General Conditions for Delivery

3.1 Except for steel investment castings, material furnished to this specification shall conform to the requirements of Specification **A703/A703M**, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of **A703/A703M** constitutes nonconformance with the specification. In case of conflict between the requirements of this specification and **A703/A703M**, this specification shall prevail.

3.2 Steel investment castings furnished to this specification shall conform to the requirements of Specification **A985/**

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.