



~~Designation: E1019-03~~ Designation: E 1019 – 08

~~Standard Test Methods for Determination of Carbon, Sulfur, Nitrogen, and Oxygen in Steel and in Iron, Nickel, and Cobalt Alloys~~ Determination of Carbon, Sulfur, Nitrogen, and Oxygen in Steel, Iron, Nickel, and Cobalt Alloys by Various Combustion and Fusion Techniques¹

This standard is issued under the fixed designation E 1019; 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 reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 These test methods² cover the determination of carbon, sulfur, nitrogen, and oxygen, in steel and in iron, nickel, and cobalt alloys having chemical compositions within the following limits:

Element	Concentration Range, %
Aluminum	0.001 to 18.00
Antimony	0.002 to 0.03
Arsenic	0.0005 to 0.10
Beryllium	0.001 to 0.05
Bismuth	0.001 to 0.50
Boron	0.0005 to 1.00
Cadmium	0.001 to 0.005
Calcium	0.001 to 0.05
Carbon	0.001 to 4.50
Cerium	0.005 to 0.05
Chromium	0.005 to 35.00
Cobalt	0.01 to 75.0
Columbium	0.002 to 6.00
Copper	0.005 to 10.00
Hydrogen	0.0001 to 0.0030
Iron	0.01 to 100.0
Lead	0.001 to 0.50
Magnesium	0.001 to 0.05
Manganese	0.01 to 20.0
Molybdenum	0.002 to 30.00
Nickel	0.005 to 84.00
Nitrogen	0.0005 to 0.50
Oxygen	0.0005 to 0.03
Phosphorus	0.001 to 0.90
Selenium	0.001 to 0.50
Silicon	0.001 to 6.00
Sulfur (Metal Reference Materials)	0.002 to 0.35
Sulfur (Potassium Sulfate)	0.001 to 0.600
Tantalum	0.001 to 10.00
Tellurium	0.001 to 0.35
Tin	0.002 to 0.35
Titanium	0.002 to 5.00
Tungsten	0.005 to 21.00
Vanadium	0.005 to 5.50
Zinc	0.005 to 0.20
Zirconium	0.005 to 2.500

1.2 The test methods appear in the following order:

¹ These test methods are under the jurisdiction of ASTM Committee E01 on Analytical Chemistry for Metals, Ores, and Related Materials and are the direct responsibility of Subcommittee E01.01 on Iron, Steel, and Ferroalloys.

Current edition approved Oct. 1, 2003-2008. Published November 2003-2008. Originally approved in 1984. Last previous edition approved in 2002-2003 as E 1019 – 023.

² Some of these test methods represent revisions of test methods covered by ASTM Test Methods E 350, E 351, E 352, E 353, and E 354, which appear in the *Annual Book of ASTM Standards*, Vol 03.05.

	Sections
<u>Carbon, Total, by the Combustion-Instrumental Measurement Method</u>	— 40-20
<u>Carbon, Total, by the Combustion-Instrumental Measurement Test Method</u>	— 10-20
<u>Nitrogen by the Inert Gas Fusion-Thermal Conductivity Method</u>	32-42
<u>Nitrogen by the Inert Gas Fusion-Thermal Conductivity Test Method</u>	32-42
<u>Oxygen by the Inert Gas Fusion Method</u>	43-54
<u>Oxygen by the Inert Gas Fusion Test Method</u>	43-54
<u>Sulfur by the Combustion-Infrared Absorption Method (Calibration with Metal Reference Materials)</u>	— 55-65
<u>Sulfur by the Combustion-Infrared Absorption Test Method (Calibration with Metal Reference Materials)</u>	— 55-65
<u>Sulfur by the Combustion-Infrared Absorption Method (Potassium Sulfate Calibration)</u>	— 21-31
<u>Sulfur by the Combustion-Infrared Absorption Test Method (Potassium Sulfate Calibration)</u>	— 21-31

1.3

1.3 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

1.4 This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use. Specific hazards statements are given in Section 6.

2. Referenced Documents

2.1 ASTM Standards:³

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E 50 Practices for Apparatus, Reagents, and Safety Precautions for Chemical Analysis of Metals

Practices for Apparatus, Reagents, and Safety Considerations for Chemical Analysis of Metals, Ores, and Related Materials

E 135 Terminology Relating to Analytical Chemistry for Metals, Ores, and Related Materials

E 173 Practice for Conducting Interlaboratory Studies of Methods for Chemical Analysis of Metals⁴

E 1601 Practice for Conducting an Interlaboratory Study to Evaluate the Performance of an Analytical Method

E 1806 Practice for Sampling Steel and Iron for Determination of Chemical Composition

E 173 Practice for Conducting Interlaboratory Studies of Methods for Chemical Analysis of Metals Practice for Sampling Steel and Iron for Determination of Chemical Composition

3. Terminology

3.1 For definition of terms used in this test method, refer to Terminology E 135. [4aa-1e4522ed62c3/astm-e1019-08](https://www.astm.org/standards/E1019-08)

4. Significance and Use

4.1 These test methods for the chemical analysis of metals and alloys are primarily intended to test such materials for compliance with compositional specifications. It is assumed that all who use these test methods will be trained analysts, capable of performing common laboratory procedures skillfully and safely. It is expected that work will be performed in a properly equipped laboratory.

5. Apparatus and Reagents

5.1 Apparatus and reagents required for each determination are listed in separate sections preceding the procedure.

6. Hazards

6.1 For hazards to be observed in the use of certain reagents in this test method, refer to Practices E 50.

6.2 Use care when handling hot crucibles and operating furnaces to avoid personal injury by either burn or electrical shock.

7. Sampling

7.1 For procedures for sampling the materials, refer to those parts of Practice E 1806.

8. Rounding Calculated Values

8.1 Calculated values shall be rounded to the desired number of places as directed in Practice E 29.

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 Withdrawn. The last approved version of this historical standard is referenced on www.astm.org.

9. Interlaboratory Studies

9.1 These test methods have been evaluated in accordance with Practice E 173 (discontinued 1997). The Reproducibility R_2 of E173 of Practice E 173 corresponds to the Reproducibility Index R of E1601 of Practice E 1601. The Repeatability R_1 of E173 of Practice E 173 corresponds to the Repeatability Index r of E1601 of Practice E 1601.

TOTAL CARBON BY THE COMBUSTION INSTRUMENTAL MEASUREMENT TEST METHOD

10. Scope

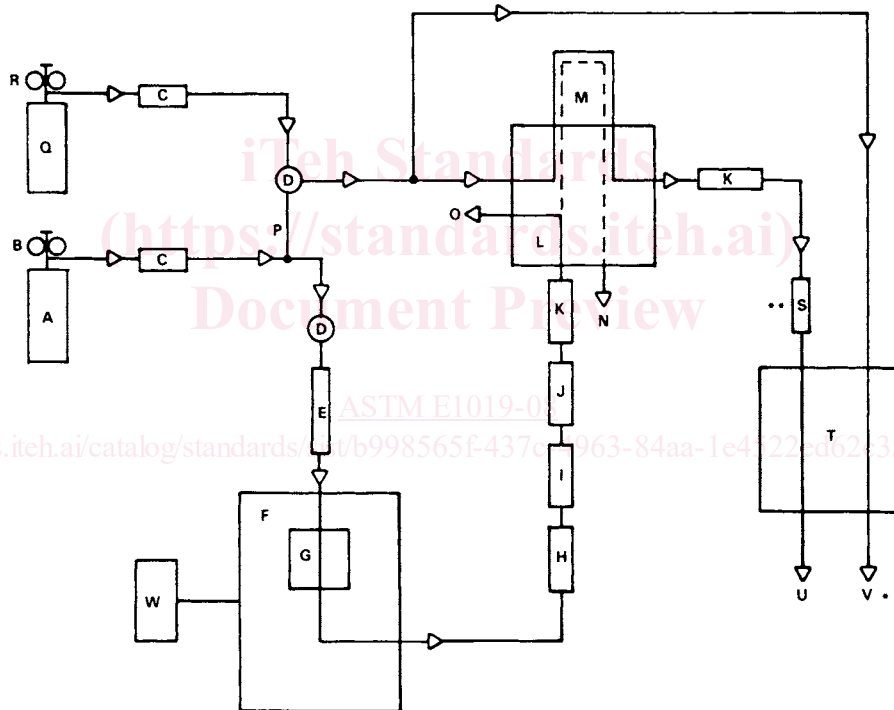
10.1 This test method covers the determination of carbon in concentrations from 0.005 % to 4.5 %.

11. Summary of Test Method

11.1 The carbon is converted to carbon dioxide by combustion in a stream of oxygen.

11.1.1 *Thermal Conductivity Test Method*—The carbon dioxide is absorbed on a suitable grade of zeolite, released by heating the zeolite, and swept by helium or oxygen into a chromatographic column. Upon elution, the amount of carbon dioxide is measured in a thermistor-type conductivity cell. Refer to Fig. 1.

11.1.2 *Infrared (IR) Absorption, Test Method A*—The amount of carbon dioxide is measured by infrared (IR) absorption. Carbon dioxide (CO₂) absorbs IR energy at a precise wavelength within the IR spectrum. Energy of this wavelength is absorbed as the gas passes through a cell body in which the IR energy is transmitted. All other IR energy is eliminated from reaching the detector



- | | |
|---|---|
| <p>A—High Purity Oxygen
 B—Oxygen Regulator (2 Stage)
 C—Sodium Hydroxide Impregnated Clay/Magnesium Perchlorate
 D—Secondary Pressure Regulator
 E—Flowmeter
 F—Induction Furnace
 G—Combustion Tube
 H—Dust Trap
 I—Manganese Dioxide
 J—Heated CO to CO₂ Converter
 K—Magnesium Perchlorate
 L—Valve Manifold</p> | <p>M—CO₂ Collection Trap
 N—Furnace Combustion Exhaust
 O—Furnace Purge Exhaust
 P—Metal Connector To Use Oxygen As Carrier Gas
 Q—High Purity Helium
 R—Helium Regulator (2 Stage)
 S—Chromagraphic Column
 T—TC Cell/Readout
 U—Measure Flowmeter
 V—Reference Flowmeter
 W—Furnace Power Stat</p> |
|---|---|

* May be sealed chamber if oxygen is carrier gas.

** Not required if oxygen is carrier gas.

FIG. 1 Apparatus for Determination of Carbon by the Combustion Thermal Conductivity Test Method

by a precise wavelength filter. Thus, the absorption of IR energy can be attributed to only CO₂ and its concentration is measured as changes in energy at the detector. One cell is used as both a reference and a measure chamber. Total carbon, as CO₂, is monitored and measured over a period of time. Refer to Fig. 2.

11.1.3 *Infrared (IR) Absorption, Test Method B*—The detector consists of an IR energy source, a separate measure chamber and reference chamber, and a diaphragm acting as one plate of a parallel plate capacitor. During specimen combustion, the flow of CO₂ with its oxygen gas carrier is routed through the measure chamber while oxygen alone passes through the reference chamber. Energy from the IR source passes through both chambers, simultaneously arriving at the diaphragm (capacitor plate). Part of the IR energy is absorbed by the CO₂ present in the measure chamber while none is absorbed passing through the reference chamber. This creates an IR energy imbalance reaching the diaphragm, thus distorting it. This distortion alters the fixed capacitance creating an electric signal change that is amplified for measurement as CO₂. Total carbon, as CO₂, is monitored and measured over a period of time. Refer to Fig. 3.

11.1.4 *Infrared (IR) Absorption, Test Method C, Closed Loop*—The combustion is performed in a closed loop, where CO and CO₂ are detected in the same infrared cell. Each gas is measured with a solid state energy detector. Filters are used to pass the appropriate IR wavelength to each detector. In the absence of CO and CO₂, the energy received by each detector is maximum. During combustion, the IR absorption properties of CO and CO₂ gases in the chamber cause a loss of energy; therefore a loss in signal results which is proportional to concentrations of each gas in the closed loop. Total carbon, as CO₂ plus CO, is monitored and measured over a period of time. Refer to Fig. 4.

11.2 This test method is written for use with commercial analyzers, equipped to ~~carry out~~ perform the above operations automatically and calibrated using steels of known carbon content.

12. Interferences

12.1 The elements ordinarily present do not interfere.

13. Apparatus

13.1 *Combustion and Measurement Apparatus*—See Figs. 1-4.

13.2 *Crucibles*—Use crucibles that meet or exceed the specifications of those recommended by the manufacturer of the instrument used and preheat in a suitable furnace for not less than 40 min at more than 1000°C. Remove from the furnace and cool in air for 90 ± 15 s before use. Crucibles may be placed in a desiccator for periods of 1 h prior to use.—Use crucibles that meet or exceed the specifications of the instrument manufacturer and preheat in a suitable furnace for not less than 40 min at

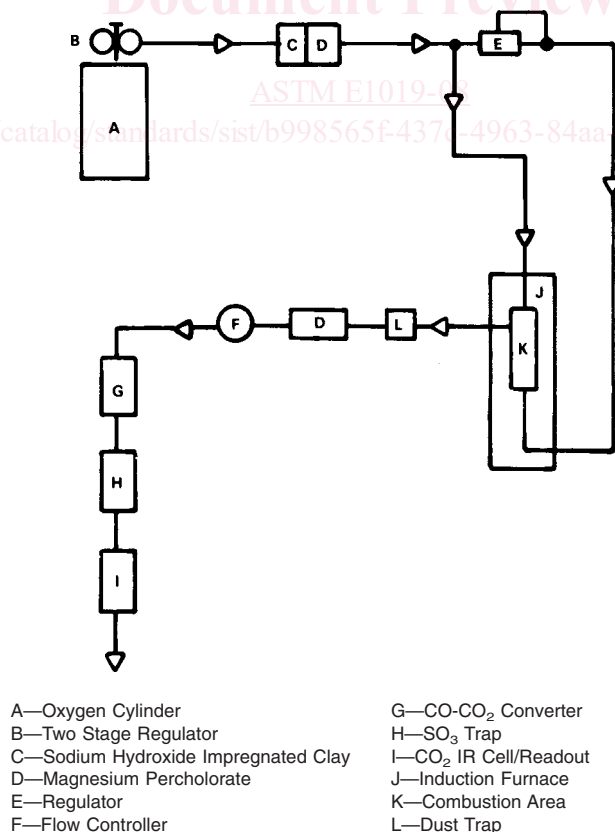
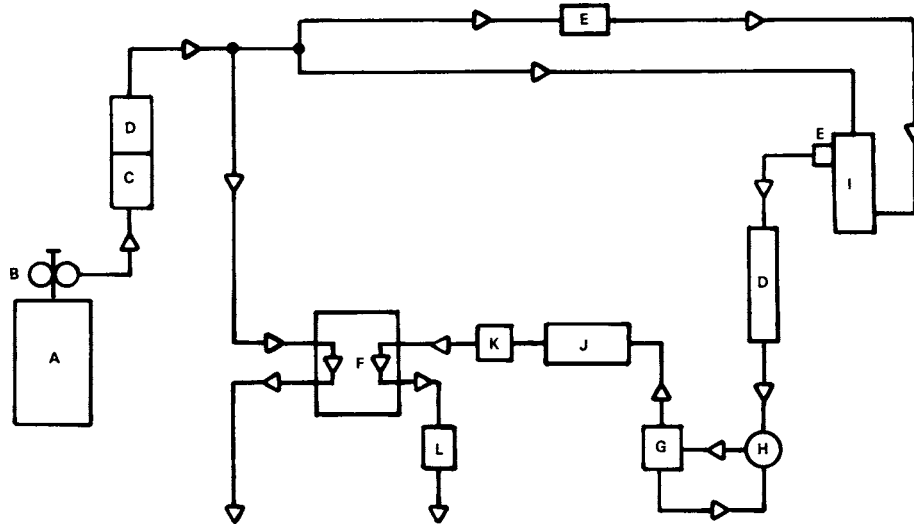
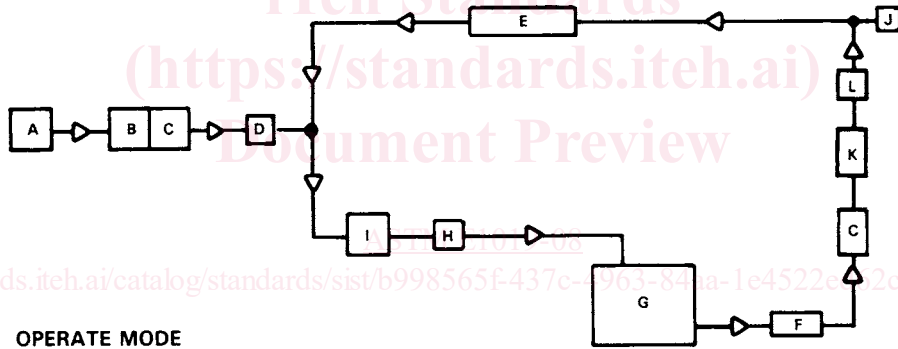


FIG. 2 Infrared Absorption Test Method A

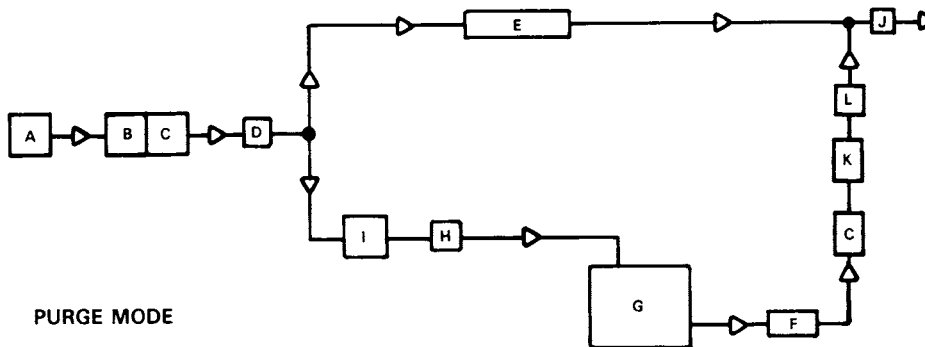


- | | |
|-------------------------------------|-----------------------------------|
| A—Oxygen Cylinder | G—Orifice |
| B—Two Stage Regulator | H—Pressure Regulator |
| C—Sodium Hydroxide Impregnated Clay | I—Combustion Chamber |
| D—Magnesium Perchlorate | J—CO to CO ₂ Converter |
| E—Dust Trap | K—SO ₃ Trap |
| F—IR Cell/Readout | L—Measure Flow Rotameter |

FIG. 3 Infrared Absorption Test Method B



OPERATE MODE



PURGE MODE

- | | |
|-------------------------------------|-----------------------------------|
| A—Oxygen Cylinder | G—Furnace |
| B—Sodium Hydroxide Impregnated Clay | H—Pump |
| C—Magnesium Perchlorate | I—Flow Meter |
| D—Press Regulator | J—Exhaust |
| E—IR Cell/Readout | K—CO to CO ₂ Converter |
| F—Dust Trap | L—SO ₃ Trap |

FIG. 4 Infrared Absorption Test Method C—Closed Loop

approximately 1000 °C. Remove from the furnace and cool before use. Crucibles may be stored in a desiccator prior to use. Preheating of crucibles is particularly important for low levels of carbon. It may not be required for the determination of higher levels of carbon such as those found in pig iron.

13.3 *Crucible Tongs*—Capable of handling recommended crucibles.

14. Reagents

14.1 *Purity of Reagents*—Reagent grade chemicals shall be used in all tests. Unless otherwise indicated, it is intended that all reagents shall conform to the specifications of the Committee on Analytical Reagents of the American Chemical Society, where such specifications are available.⁵ Other grades may be used, provided it is first ascertained that the reagent is of sufficiently high purity to permit its use without lessening the accuracy of the determination.

14.2 *Acetone*—The residue after evaporation must be < 0.0005 %.

14.3 *Copper (Low Carbon)*, granular (10 to 30 mesh) (Note 1).

14.4 *Magnesium Perchlorate*, (known commercially as *Anhydron*).

14.5 *Oxygen, Ultra High Purity (purity: 99.95 % minimum)*—Other grades of oxygen may be used if low and consistent blank readings are obtained, or the oxygen may be purified as described in Practices E 50.

14.6 *Platinum or Platinized Silica*, heated to 350 °C for the conversion of carbon monoxide to carbon dioxide.

14.7 *Sodium Hydroxide*, on clay (known commercially as *Ascarite II*).

14.8 *Tungsten (Low Carbon) Accelerator*, 12 to 20 mesh (Note 1).

14.9 *Tungsten-Tin (Low Carbon)*, 20 to 40 mesh. *Tungsten-Tin (Low Carbon) Accelerator*, 20 to 40 mesh or 12 to 20 mesh.

NOTE 1—The accelerator should contain no more than 0.001% carbon. If necessary, wash three times with acetone by decantation to remove organic contaminants and dry at room temperature. The mesh size is critical to the inductive coupling which heats the sample. 1—The accelerator should contain no more than 0.001 % carbon. If necessary, wash three times with acetone by decantation to remove organic contaminants and dry at room temperature. The mesh size is critical to the inductive coupling which heats the sample. Some manufacturers of accelerators may not certify the mesh size on a lot to lot basis. These accelerators may be considered acceptable for use without verifying the mesh size.

15. Preparation of Apparatus

15.1 Assemble the apparatus as recommended by the manufacturer.

15.2 Test the furnace and analyzer to ensure the absence of leaks and make the required electrical power connections. Prepare the analyzer for operation according to the manufacturer's instructions. Make a minimum of two determinations using the specimen and accelerator as directed in 18.1.2 and 18.1.3 before attempting to calibrate the system or determine the blank.

16. Sample Preparation

16.1 The sample should be uniform in size, but not finer than 40 mesh.

16.2 Wash in acetone and dry at 70 to 100°C.

16.2 If necessary, wash in acetone or another suitable solvent and dry.

17. Calibration

17.1 *Calibration Reference Materials* (Note 2):

17.1.1 For Range I, 0.005 % to 0.10 % carbon, select three certified reference materials containing approximately 0.005 %, 0.05 %, and 0.10 % carbon and designate them as Calibrants A, B, and C, respectively. Some labs may use accelerator with a certified carbon value as Calibrant A.

17.1.2 For Range II, 0.10 % to 1.25 % carbon, select two certified reference materials containing approximately 0.12 % and 1.00 % carbon and designate them as Calibrants BB and CC, respectively.

17.1.3 For Range III, 1.25 % to 4.50 % carbon, select two certified reference materials containing approximately 1.25 % and 4.00 % carbon and designate them as Calibrants BBB and CCC, respectively.

NOTE 2—The uncertainty of results obtained using this test method is dependent on the uncertainty of the values assigned to the calibration reference materials. The homogeneity of the reference materials must be considered as well, if it was not included in the derivation of the published uncertainty values.

17.2 *Adjustment of Response of Measurement System:*

17.2.1 Transfer 1.0 g of Calibrant B, weighed to the nearest 1 mg, and 1.5 g of accelerator, weighed to the nearest 5 mg, to a preburned crucible.

17.2.2 Proceed as directed in

17.2.1 Transfer 1.0 g of Calibrant B, weighed to the nearest 1 mg, and approximately 1.5 g of accelerator to a preheated crucible. Some manufacturers provide scoops that dispense approximately 1.5 g of accelerator. Once it is verified that the scoop delivers

⁴ Supporting data are available from ASTM International Headquarters. Request RR:E01-1093.

⁵ *Reagent Chemicals, American Chemical Society Specifications*, American Chemical Society, Washington, DC. For suggestions on the testing of reagents not listed by the American Chemical Society, see *Analar Standards for Laboratory Chemicals*, BDH Ltd., Poole, Dorset, U.K. (<http://uk.vwr.com>), and the *United States Pharmacopeia—National Formulary*, U.S. Pharmacopeial Convention, Inc. (USPC), Rockville, MD (<http://www.usp.org/USPNF>).

this approximate weight, it is acceptable to use this device for routine dispensing of accelerator.

17.2.2 Proceed as directed in 18.1.2 and 18.1.3.

17.2.3 Repeat 17.2.1 and 17.2.2 until the absence of drift is indicated. Adjust the signal to provide a reading within ± 0.003 of the certified percent carbon value for the certified reference material.

17.3 *Determination of Blank Reading—Range I:*

~~17.3.1 Transfer 1.0 g of Calibrant A, weighed to the nearest 1 mg, and 1.5 g of accelerator, weighed to the nearest 5 mg, into a preburned crucible.~~

~~17.3.2 Proceed as directed in~~

17.3.1 Add approximately 1.5 g of accelerator into a preheated crucible. If required, 1.0 g of Calibrant A, weighed to the nearest 1 mg, may be added to the crucible.

17.3.2 Proceed as directed in 18.1.2 and 18.1.3.

17.3.3 Repeat 17.3.1 and 17.3.2 a sufficient number of times to establish that low (less than 0.002% of carbon) and consistent ($\pm 0.0002\%$ of carbon) readings are obtained. Blank values are equal to the total result of the accelerator and Calibrant A minus the certified value for the certified reference material. a sufficient number of times to establish that low (less than 0.002 % of carbon) and consistent (± 0.0002 % of carbon) readings are obtained. Blank values are equal to the total result of the accelerator. If Calibrant A was used, blank values are equal to the total result of the accelerator and Calibrant A minus the certified value of Calibrant A.

17.3.4 Record the average value of at least three blank determinations.

17.3.5 If the blank readings are too high or inconsistent, determine the cause, correct it, and repeat the steps as directed in 17.3.1-17.3.4.

17.3.6 Enter the average blank value in the analyzer (Note 3); refer to manufacturer's instructions. This mechanism will electronically compensate for the blank value.

NOTE 3—If the unit does not have this function, the blank value must be subtracted from the total result prior to any calculation.

17.4 *Determination of Blank Reading—Range II*—Proceed as directed in 17.3.

17.5 *Determination of Blank Reading—Range III:*

~~17.5.1 Transfer 0.5 g of Calibrant A, weighed to the nearest 1 mg, and approximately 1.5 g of accelerator, weighed accelerator to the nearest 5 mg, to a preburnedpreheated crucible.~~

~~17.5.2 Proceed as directed in 17.3.2-17.3.6.~~

17.6 *Calibration—Range I (0.005 % to 0.10 % carbon):*

~~17.6.1 Weigh four 1.0 g specimens of Calibrant C, to the nearest 1 mg, then place in preburnedpreheated crucibles. To each, add approximately 1.5 g of accelerator, weighed to the nearest 5 mg, accelerator.~~

17.6.2 Follow the calibration procedure recommended by the manufacturer. Use Calibrant C as the primary calibrant and analyze at least three specimens to determine the calibration slope. Treat each specimen, as directed in 18.1.2 and 18.1.3, before proceeding to the next one.

~~17.6.3 Confirm the calibration by analyzing Calibrant C following the calibration procedure. The value should be within the allowableuncertainty limits of the certified value for the certified reference material. Calibrant C. If not, repeat 17.6.1 and 17.6.2.~~

17.6.4 Weigh at least two 1.0 g specimens of Calibrant B, weighed to the nearest 1 mg, and transfer them to preburnedpreheated crucibles. To each, add approximately 1.5 g of accelerator, weighed to the nearest 5 mg, accelerator.

17.6.5 Treat each specimen as directed in 18.1.2 and 18.1.3 before proceeding to the next one.

17.6.6 Record the results of 17.6.4 and 17.6.5 and compare them to the certified carbon value of Calibrant B. The results should be within the allowableuncertainty limits of the certified reference material. Calibrant B. If not, refer to the manufacturer's instructions for checking the linearity of the system.

NOTE 4—Repeat the calibration when: (1) a different lot of crucibles is used, (2) a different lot of accelerator is used, (3) the system has not been in use for 1 h, and (4) the oxygen supply has been changed. 4—The use of 1.5 g of accelerator may not be sufficient for all determinators. The required amount is determined by the analyzer used, induction coil spacing, position of the crucible in the induction coil, age and strength of the oscillator tube, and type of crucible being used. Use the amount required to produce proper sample combustion using the same amount throughout the entire test method.

17.7 *Calibration—Range II (0.10 % to 1.25 % carbon):*

17.7.1 Proceed as directed in 17.6.1-17.6.3, using Calibrant CC.

17.7.2 Proceed as directed in 17.6.4-17.6.6, using Calibrant BB.

17.8 *Calibration—Range III (1.25 % to 4.50 % carbon):*

~~17.8.1 Weigh four 0.5 g specimens of Calibrant CCC, to the nearest 1 mg, and place in preburnedpreheated crucibles. To each, add approximately 1.5 g of accelerator, weighed to the nearest 5 mg, accelerator.~~

17.8.2 Follow the calibration procedure recommended by the manufacturer. Use Calibrant CCC as the certified reference material primary calibrant and analyze at least three specimens to determine the calibration slope. Treat each specimen, as directed in 18.1.2 and 18.1.3, before proceeding to the next one.

~~17.8.3 Confirm the calibration by analyzing Calibrant CCC following the calibration procedure. The value should be within the allowableuncertainty limits of the certified value for the certified reference material. Calibrant CCC. If not, repeat 17.8.1 and 17.8.2.~~

17.8.4 Weigh at least two 0.5 g specimens of Calibrant BBB, weighed to the nearest 1 mg, and transfer to ~~preburned~~preheated crucibles. To each, add approximately 1.5 g of accelerator, weighed to the nearest 5 mg, accelerator.

17.8.5 Treat each specimen as described in 18.1.2 and 18.1.3 before proceeding to the next one.

17.8.6 Record the results of 17.8.4 and 17.8.5 ~~and compare to the certified carbon value of the Calibrant BBB. The results should be within the allowable limits of the certified reference material. If not, refer to manufacturer’s instructions for checking the linearity of the analyzer (Note 4).~~ and compare to the certified carbon value of Calibrant BBB. The results should be within the uncertainty limits of Calibrant BBB. If not, refer to manufacturer’s instructions for checking the linearity of the analyzer (Note 5).

NOTE 5—Verify the calibration when: (1) a different lot of crucibles is used, (2) a different lot of accelerator is used, (3) the system has not been in use for 4 h, and (4) the oxygen supply has been changed. Verification should consist of analyzing at least one run of each calibrant. Recalibrate as necessary.

18. Procedure

18.1 *Procedure—Range I:*

18.1.1 Stabilize the furnace and analyzer as directed in Section 15. ~~Transfer 1.0 g of specimen, weighed to the nearest 1 mg, and 1.5 g of accelerator, weighed to the nearest 5 mg, to a preburned crucible. (See .~~ Transfer approximately 1.0 g of specimen and approximately 1.5 g of accelerator to a preheated crucible. (See 13.2.)

18.1.2 Place the crucible on the furnace pedestal and raise the pedestal into position. Use crucible tongs to handle the ~~preburned~~preheated crucibles.

~~18.1.3 Start the analysis cycle; refer 18.1.3~~ Refer to the manufacturer’s recommended procedure regarding entry of specimen weight and blank value. Start the analysis cycle.

18.2 *Procedure—Range II*—Proceed as directed in 18.1.

18.3 *Procedure—Range III*—Proceed as directed in 18.1, using a 0.5 g specimen.

19. Calculation

19.1 Since most commercially available instruments calculate percent concentrations directly, including corrections for blank and sample weight, calculations by the analyst are not required.

~~NOTE 5—If 6—~~If the analyzer does not compensate for blank and sample weight values, then use the following formula:

$$\text{Carbon, \%} = [(A - B) \times CID] \tag{1}$$

where:

- A = DVM reading for specimen,
- B = DVM reading for blank,
- C = weight compensator setting, and
- D = specimen weight, g.

20. Precision and Bias ⁶

20.1 *Precision*—Nine laboratories cooperated in testing this test method and obtained the data summarized in Tables 1-3. Testing was performed in compliance with Practice E 173.

⁶ Supporting data are available from ASTM International Headquarters. Request RR: E01-1041-E01-1093.

TABLE 1 Statistical Information—Carbon, Range I

Test Specimen	Carbon Found, %	Repeatability (<i>R</i> ₁ , Practice E 173)	Reproducibility (<i>R</i> ₂ , Practice E 173)
1. Electrolytic iron (NBS 365, 0.0068 C)	0.007	0.002	0.003
1. Electrolytic iron (NIST 365, 0.0068 C)	0.007	0.002	0.003
2. Bessemer carbon steel (NBS 8j, 0.081 C)	0.080	0.003	0.006
2. Bessemer carbon steel (NIST 8j, 0.081 C)	0.080	0.003	0.006
3. Type 304L stainless steel 18Cr-8Ni (NBS 101f, 0.014 C)	0.014	0.002	0.004
3. Type 304L stainless steel 18Cr-8Ni (NIST 101f, 0.014 C)	0.014	0.002	0.004
4. Type 446 stainless steel 26Cr (SRM 367, 0.093 C)	0.094	0.003	0.004
4. Type 446 stainless steel 26Cr (NIST 367, 0.093 C)	0.094	0.003	0.004
5. Nickel steel 36Ni (NBS 126b, 0.090 C)	0.092	0.003	0.004
5. Nickel steel 36Ni (NIST 126b, 0.090 C)	0.092	0.003	0.004
6. Waspaloy 57Ni-20Cr-14Co-4Mo (NBS 349, 0.080 C)	0.078	0.003	0.004
6. Waspaloy 57Ni-20Cr-14Co-4Mo (NIST 349, 0.080 C)	0.078	0.003	0.004
7. Silicon steel (NBS 131a, 0.004 C)	0.004	0.002	0.002
7. Silicon steel (NIST 131a, 0.004 C)	0.004	0.002	0.002
8. High temperature alloy A286 26Ni-15Cr (NBS 348, 0.044 C)	0.046	0.003	0.004
8. High temperature alloy A286 26Ni-15Cr (NIST 348, 0.044 C)	0.046	0.003	0.004

TABLE 2 Statistical Information—Carbon, Range II

Test Specimen	Carbon Found, %	Repeatability (R_1 , Practice E 173)	Reproducibility (R_2 , Practice E 173)
1. Basic open hearth steel (SRM 11h, 0.200 C)	0.201	0.006	0.010
1. Basic open hearth steel (NIST 11h, 0.200 C)	0.201	0.006	0.010
2. Basic open hearth carbon steel (NBS 337, 1.07 C)	1.087	0.039	0.053
2. Basic open hearth carbon steel (NIST 337, 1.07 C)	1.087	0.039	0.053
3. Low alloy electric furnace steel (NBS 51b, 1.21 C)	1.224	0.039	0.048
3. Low alloy electric furnace steel (NIST 51b, 1.21 C)	1.224	0.039	0.048
4. High temperature nickel alloy (LE 105, 0.130 C)	0.130	0.005	0.008
5. Tool steel 8Co-9Mo-2W-4Cr-2V (NBS 153a, 0.902 C)	0.905	0.023	0.027
5. Tool steel 8Co-9Mo-2W-4Cr-2V (NIST 153a, 0.902 C)	0.905	0.023	0.027
6. Type 416 stainless steel (SRM 133b, 0.128 C)	0.126	0.005	0.013
6. Type 416 stainless steel (NIST 133b, 0.128 C)	0.126	0.005	0.013
7. Low alloy steel 1Cr (SRM 163, 0.933 C)	0.934	0.016	0.020
7. Low alloy steel 1Cr (NIST 163, 0.933 C)	0.934	0.016	0.020

TABLE 3 Statistical Information—Carbon, Range III

Test Specimen	Carbon Found, %	Repeatability (R_1 , Practice E 173)	Reproducibility (R_2 , Practice E 173)
1. Tool steel (CISRI 150, 1.56 C)	1.550	0.027	0.049
2. Low alloy electric furnace steel (NBS 51b, 1.21 C)	1.228	0.039	0.050
2. Low alloy electric furnace steel (NIST 51b, 1.21 C)	1.228	0.039	0.050
3. Cast iron (LECO 501-105, 2.20 C)	2.202	0.044	0.056
4. Ductile iron (LECO 501-083, 4.24 C)	4.244	0.083	0.091
5. White iron (LECO 501-024, 3.25 C)	3.274	0.064	0.074
6. Iron (BAM 035-1, 1.31 C)	1.314	0.034	0.048
7. Ferritic stainless steel (BAM 228-1, 2.05 C)	2.040	0.027	0.055

20.2 *Bias*—Information on the accuracy of this test method is incomplete at this time. The user is cautioned to verify by the use of certified reference materials, if available, that the accuracy of this test method is adequate for the contemplated use.

SULFUR BY THE COMBUSTION-INFRARED ABSORPTION TEST METHOD (POTASSIUM SULFATE CALIBRATION)

21. Scope

21.1 This test method covers the determination of sulfur in the range of 0.001 % to 0.01 %. As written, this test method is not applicable to cast iron samples.

22. Summary of Test Method

22.1 The sample is combusted in a stream of oxygen that converts the sulfur in the sample to sulfur dioxide. The sulfur is then determined by infrared absorption.

22.1.1 *Infrared Absorption Test Method A*—Sulfur dioxide (SO₂) absorbs infrared (IR) energy at a precise wavelength within the IR spectrum. Energy of this wavelength is absorbed as the gas passes through a cell body in which the IR energy is transmitted. All other IR energy is eliminated from reaching the detector by a precise wavelength filter. Therefore, the absorption of IR energy can be attributed to only SO₂ and its concentration is measured as changes in energy at the detector. One cell is used as both a reference and a measure chamber. Total sulfur, as SO₂, is monitored and measured over a period of time. Refer to Fig. 5.

22.1.2 *Infrared Absorption Test Method B*—The combustion is performed in a closed loop where SO₂ is detected in an infrared cell. The SO₂ is measured with a solid state energy detector, and filters are used to pass the appropriate IR wavelength to the detector. During combustion, the IR absorption properties of the SO₂ gas in the chamber causes a loss of energy, therefore a loss in signal results which is proportional to the concentration of the gas in the closed loop. Total sulfur, as SO₂, is monitored and measured over a period of time. Refer to Fig. 6.

22.1.3 *Infrared Absorption Test Method C*—The detector consists of an IR energy source, a separate measure chamber and reference chamber, and a diaphragm acting as one plate of a parallel plate capacitor. During specimen combustion, the flow of SO₂ with its oxygen gas carrier is routed through the measure chamber while oxygen alone passes through the reference chamber. Energy from the IR source passes through both chambers, simultaneously arriving at the diaphragm (capacitor plate). Part of the IR energy is absorbed by the SO₂ present in the measure chamber while none is absorbed passing through the reference chamber. This creates an IR energy imbalance reaching the diaphragm, thus distorting it. This distortion alters the fixed capacitance creating an electric signal change that is amplified for measurement as SO₂. Total SO₂ is monitored and measured over a period of time. Refer to Fig. 7.

23. Interferences

23.1 The elements ordinarily present do not interfere.

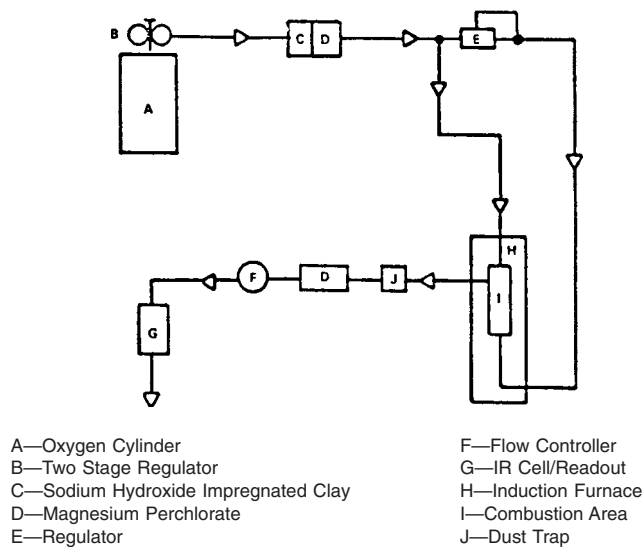
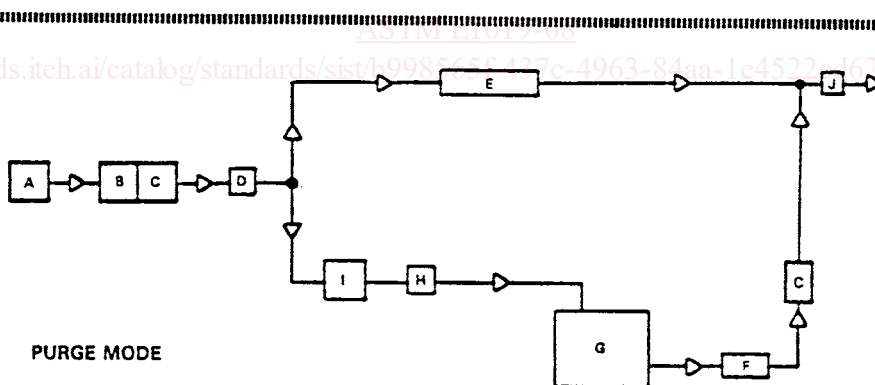
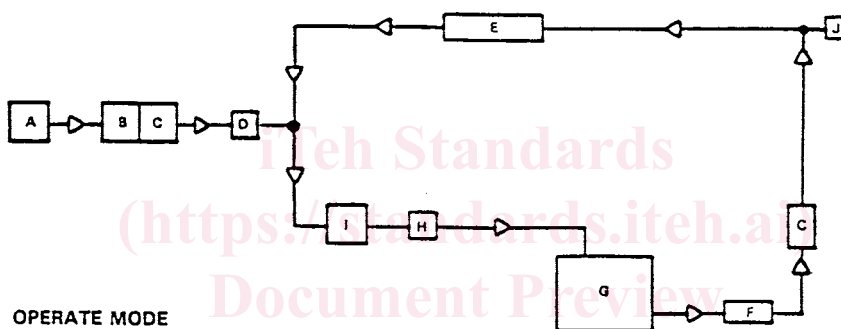


FIG. 5 Infrared Absorption Test Method A



- A—Oxygen Cylinder
 B—Sodium Hydroxide Impregnated Clay
 C—Magnesium Perchlorate
 D—Press Regulator
 E—IR Cell/Readout
 F—Dust Trap
 G—Furnace
 H—Pump
 I—Flow Meter
 J—Exhaust

FIG. 6 Infrared Absorption Test Method B

24. Apparatus

24.1 *Combustion and Measurement Apparatus*—See Figs. 5-7.

24.2 *Crucibles*—Use crucibles recommended by the manufacturer of the instrument, or equivalent, and preheat in a suitable furnace for not less than 1 h at ~~more than~~ approximately 1000 °C. Remove from furnace and cool ~~in air~~ for 90 ± 15 s before use. Preheated crucibles may also be stored in a desiccator prior to use.

24.3 *Micropipet*, (50 μ L).