



Designation: A27/A27M – 08

Standard Specification for Steel Castings, Carbon, for General Application¹

This standard is issued under the fixed designation A27/A27M; 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 This specification covers carbon steel castings for general applications that require up to 70 ksi (485 MPa) minimum tensile strength.

NOTE 1—The grades covered by this specification represent materials that are suitable for assembly with other steel castings or wrought steel parts by fusion welding. It is not intended to imply that all these grades possess the same degree of weldability or that the same welding techniques can be used on all castings. It is the responsibility of the purchaser to establish for himself a suitable welding technique.

1.2 Several grades and two classes of steel castings are covered, as indicated below. The grade and class desired shall be specified by the purchaser.

1.2.1 *Grade N-1*—Chemical analysis only.

1.2.2 *Grade N-2*—Heat-treated but not mechanically tested.

1.2.3 *Grade U-60-30 [415-205]*—Mechanically tested but not heat-treated.

1.2.4 *Grades 60-30 [415-205], 65-35 [450-240], 70-36 [485-250], and 70-40 [485-275]*—Heat-treated and mechanically tested.

1.2.5 Class 1 and Class 2 steel castings shall be specified in accordance with 9.2.

1.3 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*:²

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.

Current edition approved Oct. 1, 2008. Published November 2008. Originally approved in 1901. Last previous edition approved in 2005 as A27/A27M – 05. DOI: 10.1520/A0027_A0027M-08.

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.

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A732/A732M Specification for Castings, Investment, Carbon and Low Alloy Steel for General Application, and Cobalt Alloy for High Strength at Elevated Temperatures

A781/A781M Specification for Castings, Steel and Alloy, Common Requirements, for General Industrial Use

A957/A957M Specification for Investment Castings, Steel and Alloy, Common Requirements, for General Industrial Use

3. General Conditions for Delivery

3.1 Except for steel investment castings, material furnished to this specification shall conform to the requirements of Specification A781/A781M, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A781/A781M constitutes nonconformance with the specification. In case of a conflict between the requirements of this specification and Specification A781/A781M, this specification shall prevail.

3.2 Steel investment castings furnished to this specification shall conform to the requirements of Specification A957/A957M, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the common requirements of Specification A957/A957M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A957/A957M, Specification A957/A957M shall prevail.

4. Ordering Information

4.1 Orders for material under this specification should include the following information in proper sequence.

4.1.1 Quantity,

4.1.2 Specification, grade (1.2), and class (9.2),

4.1.3 Description of the casting by pattern number or drawing,

4.1.4 Options in the specification, and

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

4.1.5 Supplementary requirements desired, including standards of acceptance.

5. Heat Treatment

5.1 All castings of Grades N-2, 60-30 [415-205], 65-35 [450-240], 70-36 [485-250], and 70-40 [485-275] shall be heat-treated by full annealing, normalizing, normalizing and tempering, or quenching and tempering. Unless otherwise specified in the inquiry, contract, or order, the castings may be heat-treated by any one or combination of these heat-treatments at the option of the manufacturer.

5.1.1 Heat-treatment shall be performed after castings have been allowed to cool from the pouring temperature to below the transformation range.

5.2 Furnace temperatures for heat-treating shall be regulated by the use of pyrometers.

6. Chemical Composition

6.1 The steel shall conform to the requirements as to chemical composition prescribed in **Table 1**. Product analysis tolerances shall conform to the Product Analysis Tolerances shown in Specification **A781/A781M**. When residual element chemical content is of interest to the purchaser, S54 may be considered.

7. Tensile Properties

7.1 Except for Grades N-1 and N-2, one tension test shall be performed on each heat and the mechanical properties thus determined shall conform to the requirements specified in **Table 2**. The tension test shall be performed in accordance with Test Methods and Definitions **A370**.

7.2 Test bars shall be poured in special blocks similar to those shown in Fig. 1 of Specification **A781/A781M** and from the same heat as the casting represented.

7.3 Test coupons may be cut from the heat-treated (if required) castings or cast integrally with the castings at the producer's option.

7.4 The test bars for heat-treated castings shall be heat-treated in production furnaces to the same procedure as the castings they represent. When specified by the purchaser, the test bars shall be heat-treated with the castings.

7.5 Test specimens shall be machined to the form and dimensions shown in Fig. 4 of Test Methods and Definitions **A370**, with the ends machined to fit the grips on the tensile testing machine to be used. Suggested types of ends for

TABLE 2 Tensile Requirements

Grade ^A	Tensile Strength, min, ksi (MPa)	Yield Point, min, ksi (MPa)	Elongation in 2 in. (50 mm), min, % ^B	Reduction of Area, min, %
Grade U-60-30 (415-205)	60 (415)	30 (205)	22	30
Grade 60-30 (415-205)	60 (415)	30 (205)	24	35
Grade 65-35 (450-240)	65 (450)	35 (240)	24	35
Grade 70-36 (485-250)	70 (485)	36 (250)	22	30
Grade 70-40 (485-275) ^C	70 (485)	40 (275)	22	30

^A Specify Class 1 or Class 2 in addition to grade designation (see 9.2).

^B When ICI test bars are used in tensile testing as provided for in this specification, the gage length to reduced section diameter ratio shall be 4 to 1.

^C Grade 70-40 [485-275] may be used to meet the requirement of Grade 70-36 [485-250], when agreed upon between the manufacturer and the purchaser.

standard round tension test specimens are shown in Fig. 5 of Test Methods and Definitions **A370**.

7.6 If any specimen is machined improperly or if flaws are revealed by machining or during testing, the specimen may be discarded and another substituted from the same heat.

7.7 When this specification is applied to investment castings, test coupons and tension test specimens shall be obtained and prepared as directed in S3.2 of Specification **A732/A732M**. Test coupons shall be heat treated as prescribed in 7.4.

8. Retests

8.1 If the results of the mechanical tests for any heat, lot, or casting do not conform to the requirements specified, retests are permitted as outlined in Test Methods and Definitions **A370**. At the manufacturer's option, castings may be reheat-treated and retested. When castings are reheat-treated, they may not be re-austenitized more than 3 times without the approval of the purchaser. Testing after reheat treatment shall consist of the full number of specimens taken from locations complying with the specification or order.

9. Rework and Retreatment

9.1 All welds shall be inspected to the same quality standards as were used to inspect the casting.

9.2 If postweld heat-treatment is required, Class 1 must be specified along with the grade, and the welds to be heat-treated must be defined. If postweld heat-treatment is not required, Class 2 must be specified along with the grade.

TABLE 1 Chemical Requirements

Grade (UNS No.) ^A	Composition, %				
	Carbon, ^B max	Manganese, ^B max	Silicon, max	Sulfur, max	Phosphorus, max
Grade N-1 (J02500)	0.25	0.75	0.80	0.06	0.05
Grade N-2 (J03500)	0.35	0.60	0.80	0.06	0.05
Grade U-60-30 [415-205] (J02500)	0.25	0.75	0.80	0.06	0.05
Grade 60-30 [415-205] (J03000)	0.30	0.60	0.80	0.06	0.05
Grade 65-35 [450-240] (J03001)	0.30	0.70	0.80	0.06	0.05
Grade 70-36 [485-250] (J03501)	0.35	0.70	0.80	0.06	0.05
Grade 70-40 [485-275] (J02501)	0.25	1.20	0.80	0.06	0.05

^A Specify Class 1 or Class 2 in addition to grade designation (see 9.2).

^B For each reduction of 0.01 % carbon below the maximum specified, an increase of 0.04 % manganese above the maximum specified will be permitted to a maximum of 1.40 % for Grade 70-40 [485-275] and 1.00 % for the other grades.