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Standard Specification for Steel, Sheet, for Porcelain Enameling¹

This standard is issued under the fixed designation A 424/A 424M; 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 sheet steel in coils and cut lengths for porcelain enameling. The compositions and processing of these steels are such that articles for porcelain enameling may be fabricated from them and, under proper conditions, enameled. The steels are furnished as Type I, Type II, and Type III. Type I and Type II are supplied in two designations, Commercial Steel and Drawing Steel. Type III steel is interstitial-free and does not require a designation.

1.2 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.

1.3 Tolerances are found in General Requirements Specifications A 568/A 568M and A 635/A 635M. The appropriate General Requirements specification is applied based on the thickness and width of the product ordered.

2. Referenced Documents

2.1 ASTM Standards:²

A 568/A 568M [Specification for Steel, Sheet, Carbon, Structural, and High-Strength, Low-Alloy, Hot-Rolled and Cold-Rolled, General Requirements for](#)

[A 635/A 635M Specification for Steel, Sheet and Strip, Heavy-Thickness Coils, Hot-Rolled, Alloy, Carbon, Structural, High-Strength Low-Alloy, and High-Strength Low-Alloy with Improved Formability, General Requirements for](#)

A 941 [Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys](#)

3. Terminology

3.1 *Definitions*— For definitions of other terms used in this specification, refer to Terminology A 941.

3.2 *Definitions of Terms Specific to This Standard:*

3.3 *base coat*—also known as ground coat. This coating layer is applied directly to the steel and promotes adhesion of the coating system to the steel.

3.4 *cover coat*—This coating layer is usually applied over the base or ground coat to improve the appearance and provide the proper color.

3.5 *direct cover coat*—This refers to a single coating application that provides both adequate adhesion and appearance.

4. Classification

4.1 Types:

4.1.1 *Type I* steel has an extremely low carbon level achieved through sheet decarburization. This material is suitable for direct cover coat enameling practice, but this requirement must be indicated by the purchaser in accordance with 5.1.6. This material is also suitable for ground and cover coat enameling practice. It has good sag resistance and good formability.

4.1.2 *Type II* steel is suitable for applications where ground and cover coat enameling operations are employed. The composition of the Type II steel is obtained in melting operations.

4.1.3 *Type III* is an interstitial-free steel and is suitable for applications where ground and cover coat enameling operations are employed. The composition of the Type III steel is obtained in melting operations. It has good sag resistance and excellent formability.

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 A01.19 on Steel Sheet and Strip.

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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.

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