



**Designation: ~~A 473-01~~ Designation: A 473 – 01 (Reapproved 2009)**

## Standard Specification for Stainless Steel Forgings<sup>1</sup>

This standard is issued under the fixed designation A 473; 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 ( $\epsilon$ ) 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 austenitic, austenitic-ferritic, ferritic, and martensitic stainless steel forgings for general use, and for low- or high-temperature service.

~~1.2 The values stated in inch-pound units are to be regarded as the standard.~~

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

### 2. Referenced Documents

#### 2.1 ASTM Standards:<sup>2</sup>

A 314 Specification for Stainless Steel Billets and Bars for Forging

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

A 484/A 484M Specification for General Requirements for Stainless Steel Bars, Billets, and Forgings

A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products

E 527 ~~Practice for Numbering Metals and Alloys (UNS)~~ Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

### 3. Ordering Information

3.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this specification. Such requirements may include, but are not limited to, the following:

3.1.1 Quantity (weight or number of pieces),

3.1.2 Dimensions, including prints or sketches,

3.1.3 Name of material (stainless steel forgings),

3.1.4 Type or UNS designation (Table 1),

3.1.5 Condition (Table 2), and

3.1.6 ASTM designation and date of issue.

3.1.7 Test for magnetic permeability if specified by customer purchase order when ordering Types 207 and 205.

3.1.8 Special requirements.

3.2 If possible the intended end use of the item should be given on the purchase order especially when the item is ordered for a specific end use or uses.

NOTE 1—A typical ordering description is as follows: 5 stainless steel forgings, Type 410, Designation A, ASTM Specification A 473 dated ———. End use: pump blocks for oil well equipment.

### 4. General Requirements

4.1 In addition to the requirements of this specification, all requirements of the current edition of Specification A 484/A 484M/A 484M shall apply. Failure to comply with the general requirements of Specification A 484/A 484M constitutes nonconformance with this specification.

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.17 on Flat Stainless Steel Products.

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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards*, Vol 01.05, volume information, refer to the standard's Document Summary page on the ASTM website.

TABLE 1 Chemical Requirements<sup>A</sup>

UNS Designation <sup>B</sup>	Type Number	Carbon, %	Manganese, %	Phosphorus, %	Sulfur, %	Silicon, %	Chromium, %	Nickel, %	Molybdenum, %	Nitrogen, %	Other Elements, %
Austenitic Grades											
S20100	201	0.15	5.5–7.5	0.060	0.030	1.00	16.0–18.0	3.5–5.5	...	0.25	
S20200	202	0.15	7.5–10.0	0.060	0.030	1.00	17.0–19.0	4.0–6.0	...	0.25	
S20500	205	0.12–0.25	14.0–15.5	0.060	0.030	1.00	16.5–18.0	1.00–1.75	...	0.32–0.40	
S21900	XM-10	0.08	8.0–10.0	0.060	0.030	1.00	19.0–21.5	5.5–7.5	...	0.15–0.40	
S21904	XM-11	0.04	8.0–10.0	0.060	0.030	1.00	19.0–21.5	5.5–7.5	...	0.15–0.40	
S28200	...	0.15	17.0–19.0	0.045	0.030	1.00	17.0–19.0	...	0.75–1.25	0.40–0.60	Cu 0.75–1.25
S30200	302	0.15	2.00	0.045	0.030	1.00	17.0–19.0	8.0–10.0	...	0.10	
S30215	302B	0.15	2.00	0.045	0.030	2.00–3.00	17.0–19.0	8.0–10.0	...	...	
S30300	303	0.15	2.00	0.20	0.15 min	1.00	17.0–19.0	8.0–10.0	0.60 <sup>C</sup>	...	
S30323	303 Se	0.15	2.00	0.20	0.06	1.00	17.0–19.0	8.0–10.0	...	...	Se 0.15 min
S30400	304	0.08	2.00	0.045	0.030	1.00	18.0–20.0	8.0–10.5	...	0.10	
S30403	304L	0.030	2.00	0.045	0.030	1.00	18.0–20.0	8.0–12.0	...	0.10	
S30500	305	0.12	2.00	0.045	0.030	1.00	17.0–19.0	10.5–13.0	...	...	
S30800	308	0.08	2.00	0.045	0.030	1.00	19.0–21.0	10.0–12.0	...	...	
S30815	...	0.10	0.80	0.040	0.030	1.40–2.00	20.0–22.0	10.0–12.0	...	0.14–0.20	Ce 0.03–0.08
S30900	309	0.20	2.00	0.045	0.030	1.00	22.0–24.0	12.0–15.0	...	...	
S30908	309S	0.08	2.00	0.045	0.030	1.00	22.0–24.0	12.0–15.0	...	...	
S31000	310	0.25	2.00	0.045	0.030	1.50	24.0–26.0	19.0–22.0	...	...	
S31008	310S	0.08	2.00	0.045	0.030	1.50	24.0–26.0	19.0–22.0	...	...	
S31254	...	0.020	1.00	0.030	0.010	0.80	19.5–20.5	17.5–18.5	6.0–6.5	0.18–0.22	Cu 0.50–1.00
S31400	314	0.25	2.00	0.045	0.030	1.50–3.00	23.0–26.0	19.0–22.0	...	...	
S31600	316	0.08	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0	2.00–3.00	0.10	
S31603	316L	0.030	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0	2.00–3.00	0.10	
S31700	317	0.08	2.00	0.045	0.030	1.00	18.0–20.0	11.0–15.0	3.0–4.0	0.10	
S32100	321	0.08	2.00	0.045	0.030	1.00	17.0–19.0	9.0–12.0	...	...	Ti 5×C min
S34700	347	0.08	2.00	0.045	0.030	1.00	17.0–19.0	9.0–13.0	...	...	Cb+Ta 10×C, min
S34800	348	0.08	2.00	0.045	0.030	1.00	17.0–19.0	9.0–13.0	...	...	Cb+Ta 10×C, min Ta 0.10 Co 0.20
Austenitic-Ferritic Grades											
S32550 <sup>D</sup>	...	0.04	1.50	0.040	0.030	1.00	24.0–27.0	4.5–6.5	2.9–3.9	0.10–0.25	Cu 1.50–2.50
S32760 <sup>D</sup>	...	0.030	1.00	0.030	0.010	1.00	24.0–26.0	6.0–8.0	3.0–4.0	0.20–0.30	Cu 0.50–1.00 W 0.50–1.00
S32950	...	0.03	2.00	0.035	0.010	0.60	26.0–29.0	3.5–5.2	1.00–2.50	0.15–0.35	
Ferritic Grades											
S40500	405	0.08	1.00	0.040	0.030	1.00	11.5–14.5	0.60	...	...	A1 0.10–0.30
S42900	429	0.12	1.00	0.040	0.030	1.00	14.0–16.0	0.75	...	...	
S43000	430	0.12	1.00	0.040	0.030	1.00	16.0–18.0	0.75	...	...	
S43020	430F	0.12	1.25	0.06	0.15 min	1.00	16.0–18.0	0.75	0.60 <sup>C</sup>	...	
S43023	430F Se	0.12	1.25	0.06	0.06	1.00	16.0–18.0	0.75	...	...	Se 0.15 min
S44600	446	0.20	1.50	0.040	0.030	1.00	23.0–27.0	0.75	...	0.25	
Martensitic Grades											
S40300	403	0.15	1.00	0.040	0.030	0.50	11.5–13.0	...	...	...	
S41000	410	0.15	1.00	0.040	0.030	1.00	11.5–13.5	0.75	...	...	
S41008	410S	0.08	1.00	0.040	0.030	1.00	11.5–13.5	0.75	...	...	
S41400	414	0.15	1.00	0.040	0.030	1.00	11.5–13.5	1.25–2.50	...	...	
S41425	...	0.05	0.50–1.00	0.020	0.005	0.50	12.0–15.0	4.0–7.0	1.50–2.00	0.06–0.12	Cu 0.30
S41500	<sup>E</sup>	0.05	0.5–1.0	0.030	0.030	0.60	11.5–14.0	3.5–5.5	0.40–0.80	...	
S41600	416	0.15	1.25	0.06	0.15 min	1.00	12.0–14.0	...	0.60 <sup>C</sup>	...	
S41623	416 Se	0.15	1.25	0.06	0.06	1.00	12.0–14.0	...	...	...	Se 0.15 min
S42000	420	Over 0.15	1.00	0.040	0.030	1.00	12.0–14.0	...	...	...	
S43100	431	0.20	1.00	0.040	0.030	1.00	15.0–17.0	1.25–2.50	...	...	
S44002	440A	0.60–0.75	1.00	0.040	0.030	1.00	16.0–18.0	...	0.75	...	
S44003	440B	0.75–0.95	1.00	0.040	0.030	1.00	16.0–18.0	...	0.75	...	
S44004	440C	0.95–1.20	1.00	0.040	0.030	1.00	16.0–18.0	...	0.75	...	

<sup>A</sup> Maximum, unless range or minimum is indicated.

<sup>B</sup> New designation established in accordance with Practice E 527 and SAE J 1086.

<sup>C</sup> At manufacturer's option; reported only when intentionally added.

<sup>D</sup> % Cr + 3.3 × % Mo + 16 × % N ≥ 40.

<sup>E</sup> Wrought version of CA6NM.

## 5. Manufacture

5.1 Material for forgings shall consist of ingots or blooms, billets, slabs, or bars, either forged or rolled from an ingot, and cut to the required length by a suitable process. This material, except for ingots, may be specified to Specification A 314.