



Designation: A995/A995M – 09

# Standard Specification for Castings, Austenitic-Ferritic (Duplex) Stainless Steel, for Pressure-Containing Parts<sup>1</sup>

This standard is issued under the fixed designation A995/A995M; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reappraisal.

## 1. Scope\*

1.1 This specification covers austenitic-ferritic (duplex) stainless steel castings for valves, flanges, fittings, and other pressure-containing parts.

1.2 The duplex stainless steels offer a combination of enhanced mechanical properties and corrosion resistance when properly balanced in composition and properly heat treated. Ferrite levels are not specified, but these grades will develop a range of approximately 30 to 60 % ferrite with the balance austenite. It is the responsibility of the purchaser to determine which grade shall be furnished depending on design and service conditions, mechanical properties, and corrosion-resistant characteristics.

NOTE 1—Because of the possibility of precipitation of embrittling phases, the grades included in this specification are not recommended for service at temperatures above 600°F [315°C].

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*:<sup>2</sup>

[A488/A488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel](#)

[A703/A703M Specification for Steel Castings, General Requirements, for Pressure-Containing Parts](#)

[E125 Reference Photographs for Magnetic Particle Indications on Ferrous Castings](#)

[E165 Practice for Liquid Penetrant Examination for General Industry](#)

<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 A01.18 on Castings.

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<sup>2</sup> 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.

TABLE 1 Heat Treatment Requirements

| Grade | Heat Treatment  |
|-------|---|
| 1B    | Heat to 1900°F [1040°C] minimum, hold for sufficient time to heat casting uniformly to temperature, quench in water or rapid cool by other means.   |
| 2A    | Heat to 2050°F [1120°C] minimum, hold for sufficient time to heat casting uniformly to temperature, quench in water or rapid cool by other means.   |
| 3A    | Heat to 1950°F [1070°C] minimum, hold for sufficient time to heat casting uniformly to temperature, quench in water or rapid cool by other means.   |
| 4A    | Heat to 2050°F [1120°C] minimum for sufficient time to heat casting uniformly to temperature and water quench, or the casting may be furnace cooled to 1850°F [1010°C] minimum, hold for 15 min minimum and then water quench. A rapid cool by other means may be employed in lieu of water quench. |
| 5A    | Heat to 2050°F [1120°C] minimum, hold for sufficient time to heat casting to temperature, furnace cool to 1910°F [1045°C] minimum, quench in water or rapid cool by other means.  |
| 6A    | Heat to 2010°F [1100°C] minimum, hold for sufficient time to heat casting uniformly to temperature, quench in water or cool rapidly by other means.   |

[E562 Test Method for Determining Volume Fraction by Systematic Manual Point Count](#)

## 3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *duplex stainless steel*—an iron-chromium-nickel-molybdenum alloy which when properly heat treated consists of approximately 30 to 60 % ferrite with the balance austenite.

## 4. General Conditions for Delivery

4.1 Material furnished to this specification shall conform to the applicable requirements of Specification [A703/A703M](#), including the supplementary requirements that are indicated on the purchaser order. Failure to comply with the general requirements of Specification [A703/A703M](#) constitutes non-conformance with this specification. In case of conflict between the requirements of the specification and Specification [A703/A703M](#), this specification shall prevail.

## 5. Ordering Information

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

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