



Designation: A311/A311M-04 Designation: A311/A311M – 04 (Reapproved 2010)

Standard Specification for Cold-Drawn, Stress-Relieved Carbon Steel Bars Subject to Mechanical Property Requirements¹

This standard is issued under the fixed designation A311/A311M; 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.

1. Scope *

1.1 This specification covers two classes, nine grades, and four conditions of stress-relieved cold-drawn carbon steel bars produced to mechanical property requirements. One class, B, is cold drawn with higher than normal (heavy) drafts to provide higher strength levels, and four grades provide improved machinability.

1.2 Supplementary Requirements, S1 through S6, of an optional nature are provided.

1.3 The values stated in inch-pound units or SI units are to be regarded as the standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents, therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification.

2. Referenced Documents

2.1 ASTM Standards:²

A29/A29M Specification for Steel Bars, Carbon and Alloy, Hot-Wrought, General Requirements for

A108 Specification for Steel Bar, Carbon and Alloy, Cold-Finished

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

3. Terminology

3.1 Definitions:

3.1.1 *stress relieving*—heating to a suitable temperature, holding long enough to reduce residual stresses, and then cooling slowly enough to minimize the development of new residual stresses.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *heavy draft*—Using higher than normal drafts (approximately 10 % through 35 % reduction), followed by stress relieving, produces higher tensile and yield strengths provided an appropriate composition is used; for example, medium carbon with normal or higher manganese content.

4. Classification

4.1 The bars are furnished in the following classes and grades, and in the conditions shown in 6.4.

4.1.1 *Class A*—Normal-draft cold-drawn and stress-relieved rounds, squares, hexagons, and flats in the following grades:³

Grades	UNS Designations ³
1018	G10180
1035	G10350
1045	G10450
1050	G10500
1541	G15410
1117	G11170
1137	G11370
1141	G11410
1144	G11440

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 A01.15 on Bars.

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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.

³ New designation established in accordance with Practice E527 and SAE J 1086.

4.1.2 *Class B*—Heavy-draft cold-drawn and stress-relieved rounds and hexagons in the following grades:

Grade	UNS Designations ³
1045	G10450
1050	G10500
1541	G15410
1141	G11410
1144	G11440

5. Ordering Information

5.1 Orders for material under this specification should include the following information as required to adequately describe the desired material:

- 5.1.1 Quantity (weight [mass] or number of pieces),
- 5.1.2 Name of material (carbon steel bars, cold drawn, stress relieved),
- 5.1.3 Condition 8.3,
- 5.1.4 Cross-sectional shape,
- 5.1.5 Size,
- 5.1.6 Length,
- 5.1.7 Class and grade,
- 5.1.8 Report of heat analysis, tensile properties Section 11,
- 5.1.9 ASTM designation A311 or A311M,
- 5.1.10 Application,
- 5.1.11 Leaded steel, when required (see Table 1, footnote A),
- 5.1.12 Supplementary requirements, if any, and
- 5.1.13 Additional requirements, if any.

NOTE 1—A typical ordering description is as follows: 10 000 lb carbon steel bars, cold drawn, stress relieved turned and polished, round 2.0 in. (50.8 mm) Diameter, 10 to 12 ft (3048 to 3658 mm) long, Class B, Grade 1050, (UNS G 10500), fine grain, test reports required, ASTM A311/A311M dated _____, hydraulic cylinder piston rods. [5000

kg carbon steel bars, cold drawn, stress relieved turned and polished round 50 mm diameter, 3050 to 3650 mm long, Class B, Grade 1050 (UNS G 10500), fine grain, test reports required, ASTM A311M dated _____, hydraulic cylinder piston rods.]

6. Materials and Manufacture

6.1 *Melting Practice*—The steel shall be made by one or more of the following primary processes: open-hearth, basic-oxygen, or electric-furnace. The primary melting may incorporate separate degassing or refining and may be followed by secondary melting using electroslag remelting or vacuum arc remelting. Where secondary melting is employed, the heat shall be defined as all of the ingots remelted from a single primary heat.

6.2 *Cold Working*:

- 6.2.1 Class A bars shall be cold drawn using normal drafting practices.
- 6.2.2 Class B bars shall be cold drawn using heavy (higher than normal) drafting practices.

6.3 *Thermal Treatment*—After cold drawing, the bars shall be stress relieved at a temperature of not less than 550°F [288°C] to meet the mechanical requirements specified in Table 2.

6.4 *Condition*—The bars shall be furnished in the following cold finish conditions, as specified:

- 6.4.1 Cold drawn, stress relieved;
- 6.4.2 Cold drawn, stress relieved, turned, and polished;

TABLE 1 Chemical Requirements (Cast or Heat Analysis)^A

UNS Designation	Grade	Carbon, %	Manganese, %	Phosphorus, max %	Sulfur, %
G10180	1018	0.15-0.20	0.60-0.90	0.040	0.050 max
G10350	1035	0.32-0.38	0.60-0.90	0.040	0.050 max
G10450	1045	0.43-0.50	0.60-0.90	0.040	0.050 max
G10500	1050	0.48-0.55	0.60-0.90	0.040	0.050 max
G15410	1541	0.36-0.44	1.35-1.65	0.040	0.050 max
G11170	1117	0.14-0.20	1.00-1.30	0.040	0.08-0.13
G11370	1137	0.32-0.39	1.35-1.65	0.040	0.08-0.13
G11410	1141	0.37-0.45	1.35-1.65	0.040	0.08-0.13
G11440	1144	0.40-0.48	1.35-1.65	0.040	0.24-0.33

^A When lead is required as an added element to a standard steel, a range from 0.15 to 0.35 % inclusive, is specified. Such a steel is identified by inserting the letter "L" between the second and third numerals of the grade designation, for example, 10L45. A cast or heat analysis is not determinable when lead is added to the ladle stream.