



Designation: ~~B848-05~~ Designation: **B848 – 10**

Standard Specification for Powder Forged (P/F)(PF) Ferrous Materials¹

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1. Scope*

1.1 This specification covers powder forged ferrous materials fabricated by hot densification of atomized prealloyed or iron powders and intended for use as structural parts.

1.2 This specification covers powder forged parts made from the following materials:

1.2.1 Compositions:

1.2.1.1 P/F-10XX Carbon Steel (produced from atomized iron powder and graphite powder),

1.2.1.2 P/F-10CXX Copper-Carbon Steel (produced from atomized iron powder, copper and graphite powders),

1.2.1.3 P/F-11XX Carbon Steel with manganese sulfide for enhanced machinability (produced from atomized iron powder, manganese sulfide, and graphite powders),

1.2.1.4 P/F-11CXX Copper-Carbon Steel with manganese sulfide for enhanced machinability (produced from atomized iron powder, copper, manganese sulfide, and graphite powders),

1.2.1.5 P/F-42XX Nickel-Molybdenum Steel (produced from prealloyed atomized iron-nickel-molybdenum powder and graphite powder),

1.2.1.6 P/F-46XX Nickel-Molybdenum Steel (produced from prealloyed atomized iron-nickel-molybdenum powder and graphite powder),

1.2.1.7 P/F-44XX Molybdenum Steel (produced from prealloyed atomized iron-molybdenum powder and graphite powder), and

1.2.1.8 P/F-49XX Molybdenum Steel (produced from prealloyed atomized iron-molybdenum powder and graphite powder).

NOTE 1—Alloy composition designations are modifications of the AISI-SAE nomenclature. For example: 10CXX designates a plain carbon steel containing copper and XX amount of carbon. Compositional limits of alloy and impurity elements may be different from the AISI-SAE limits. Chemical composition limits are specified in Section 6.

NOTE 2—XX designates the forged carbon content, in hundredths of a percent, that is specified by the purchaser for the application. For a given specified carbon content, the permissible limits shall be as specified in 6.2.

NOTE 3—The old acronym for powder forging P/F has been replaced by PF throughout the document. The change in the prefix for the material designations is just to match the currently approved acronym for powder forging. No change has been made to the material specification and performance characteristics for the various powder forged materials.

1.2.2 Grades:

1.2.2.1 *Grade A*—Density equivalent to a maximum of 0.5 % porosity. The minimum density of those sections of the powder forged part so designated by the applicable part drawing shall not be less than the value specified in Table 1.

1.2.2.2 *Grade B*—Density equivalent to a maximum of 1.5 % porosity. The minimum density of those sections of the powder forged part so designated by the applicable part drawing shall not be less than the value specified in Table 1.

~~1.3 Property values stated in inch-pound units are the standard. Conversion factors to SI units may be approximate.~~

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

A255 [Test Methods for Determining Hardenability of Steel](#)

B243 [Terminology of Powder Metallurgy](#)

¹ This specification is under the jurisdiction of ASTM Committee B09 on Metal Powders and Metal Powder Products and is the direct responsibility of Subcommittee B09.11 on Near Full Density Powder Metallurgy Materials.

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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.

TABLE 1 Minimum Density for Selected Powder Forged Steel Compositions (Fully Annealed Heat Treatment Condition—Ferrite/Pearlite Microstructure)^{A,B}

Chemical Composition	Density (g/cm ³)	
	Grade A (0.5 % porosity) ^C	Grade B (1.5 % porosity) ^C
P/F-1040	7.81	7.74
PF-1040	7.81	7.74
P/F-1060	7.81	7.73
PF-1060	7.81	7.73
P/F-10C40	7.81^D	7.74^D
PF-10C40	7.81 ^D	7.74 ^D
P/F-10C60	7.81^D	7.73^D
PF-10C60	7.81 ^D	7.73 ^D
P/F-1140	7.79	7.71
PF-1140	7.79	7.71
P/F-1160	7.78	7.70
PF-1160	7.78	7.70
P/F-11C40	7.79^D	7.71^D
PF-11C40	7.79 ^D	7.71 ^D
P/F-11C60	7.79^D	7.71^D
PF-11C60	7.79 ^D	7.71 ^D
P/F-4220	7.82	7.74
PF-4220	7.82	7.74
P/F-4240	7.81	7.73
PF-4240	7.81	7.73
P/F-4260	7.80	7.72
PF-4260	7.80	7.72
P/F-4420	7.82	7.74
PF-4420	7.82	7.74
P/F-4440	7.81	7.73
PF-4440	7.81	7.73
P/F-4460	7.81	7.73
PF-4460	7.81	7.73
P/F-4620	7.82	7.74
PF-4620	7.82	7.74
P/F-4640	7.81	7.73
PF-4640	7.81	7.73
P/F-4660	7.81	7.73
PF-4660	7.81	7.73
P/F-4680	7.80	7.72
PF-4680	7.80	7.72
P/F-4920	7.83	7.75
PF-4920	7.83	7.75
P/F-4940	7.82	7.74
PF-4940	7.82	7.74
P/F-4960	7.81	7.74
PF-4960	7.81	7.74

^A Quench-hardening and tempering will reduce the density values. Normalized samples may have lower density values than fully annealed materials.

^B For the purpose of determining conformance with this specification, measured values shall be rounded "to the nearest unit" in the last right-hand digit used in expressing the specification limit, in accordance with the rounding-off method of Practice E29.

^C Based on the method described in Smith, D. W., "Calculation of the Pore-Free Density of P/M Steels: Role of Microstructure and Composition," *The International Journal of Powder Metallurgy*, Vol 28, No. 3, 1992, p. 259. Calculations based on 350 ppm max oxygen content and all oxygen combined as 3MnO · Al₂O₃ · 3SiO₂.

^D The method described by Smith is not considered applicable to steels with admixed copper additions. Pore-free densities for these materials were determined by experiment.

- B311 Test Method for Density of Powder Metallurgy (PM) Materials Containing Less Than Two Percent Porosity
- B795 Test Method for Determining the Percentage of Alloyed or Unalloyed Iron Contamination Present in Powder Forged (PF) Steel Materials
- B796 Test Method for Nonmetallic Inclusion Content of Powders Intended for Powder Forging (PF) Applications
- B797 Test Method for Surface Finger Oxide Penetration Depth and Presence of Interparticle Oxide Networks in Powder Forged (P/F) Steel Parts
- B934 Test Method for Effective Case Depth of Ferrous Powder Metallurgy (PM) Parts Using Microindentation Hardness Measurements
- E3 Guide for Preparation of Metallographic Specimens
- E8 Test Methods for Tension Testing of Metallic Materials

- E18 Test Methods for Rockwell Hardness of Metallic Materials
- E23 Test Methods for Notched Bar Impact Testing of Metallic Materials
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E350 Test Methods for Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron
- E415 Test Method for Atomic Emission Vacuum Spectrometric Analysis of Carbon and Low-Alloy Steel
- E562 Test Method for Determining Volume Fraction by Systematic Manual Point Count
- E1019 Test Methods for Determination of Carbon, Sulfur, Nitrogen, and Oxygen in Steel, Iron, Nickel, and Cobalt Alloys by Various Combustion and Fusion Techniques
- E1077 Test Methods for Estimating the Depth of Decarburization of Steel Specimens
- 2.2 MPIF Standard.³
- MPIF 35 Materials Standards for ~~P/FPF~~ Steel Parts

3. Terminology

3.1 Definitions—Definitions of powder metallurgy terms can be found in Terminology B243. Additional descriptive information is available in the Related Material Section of Vol. 02.05 of the *Annual Book of ASTM Standards*.

3.2 Descriptions of Terms Specific to This Standard:

3.2.1 *core region*—a core region is one where there is either no decarburization as determined by the procedure in 9.3.4 or there is no hardened surface as determined by the procedure in S2.2.

3.2.2 *critical region*—a critical region of a part is one that requires a density level or a microstructural characteristic to be separately specified.

4. Ordering Information

4.1 Orders for parts conforming to this specification shall include the following:

- 4.1.1 Alloy composition, including carbon content (see 1.2.1, Section 6, and Table 2),
- 4.1.2 Grade (minimum density requirement—see 1.2.2 and Section 7),
- 4.1.3 Heat treatment condition and hardness (see 8.1.3, 8.1.4, and 8.2.3),
- 4.1.4 Location of critical regions (see 3.2.2),
- 4.1.5 Whether functional or mechanical property testing is required, what type of testing is required, and what performance level is required (see 8.1.1, 8.1.2, 8.2.1, and 8.2.2),
- 4.1.6 Whether the purchaser desires that his representative inspect or witness the inspection and testing of the material prior to shipment (see 11.1 and 11.2),
- 4.1.7 Whether there are special microstructural requirements (see Section 9 and S4),
- 4.1.8 Whether certification of the material is required (see Section 13),
- 4.1.9 Whether there is a maximum forged-oxygen content (see S1),
- 4.1.10 Whether case hardening is required (see S2),
- 4.1.11 Whether there is a maximum area percent porosity requirement for critical regions (see 3.2.2 and S3), and
- 4.1.12 ASTM designation and year of issue.

5. Materials and Manufacture

5.1 Make the structural parts by hot forging of powder metallurgy (~~P/M~~(PM) preforms in confined dies with or without subsequent heat treatment. Prepare ~~P/M~~PM preforms by pressing or by pressing and sintering material conforming to the designations in 1.2.1 and meeting the chemical compositions specified in Section 6 and Table 2.

6. Chemical Composition

6.1 The hot forged material shall conform to the requirements prescribed in Table 2.

6.2 Unless otherwise specified, the hot forged carbon content shall not deviate from that specified by the purchaser by more than ± 0.05 weight percent.

6.3 ~~Determine~~ Determine the concentration of the elements copper, chromium, manganese, molybdenum, nickel, phosphorus, and silicon in accordance with Test Method E415 or Test Method E350; X-ray fluorescence (XRF) or inductively coupled plasma, atomic emission spectrometry (ICP-AES) techniques may also be used for these analyses. Determine the concentration of the elements carbon and sulfur in accordance with Test Methods E1019.

7. Density Requirement

7.1 The minimum density of those sections of powder forged parts so designated by the applicable part drawing shall not be less than the values specified in Table 1.

³ Available from Metal Powder Industries Federation, 105 College Road East, Princeton, NJ 08540-6692.

TABLE 2 Chemical Composition Requirements for Powder Forged Parts (Weight %)^A

Element	P/F-10XX	P/F-10CXX	P/F-11XX	P/F-11CXX
Nickel, max	0.10	0.10	0.10	0.10
Molybdenum, max	0.05	0.05	0.05	0.05
Manganese	0.10–0.25	0.10–0.25	0.30–0.60 ^B	0.30–0.60 ^B
Copper	0.30 max	1.8–2.2	0.30 max	1.8–2.2
Chromium, max	0.10	0.10	0.10	0.10
Sulfur, max	0.025	0.025	0.23 ^B	0.23 ^B
Silicon, max	0.03	0.03	0.03	0.03
Phosphorus, max	0.03	0.03	0.03	0.03
Carbon	<i>C</i>	<i>C</i>	<i>C</i>	<i>C</i>
Oxygen	<i>D</i>	<i>D</i>	<i>D</i>	<i>D</i>
Total Iron	Balance ^E	Balance ^E	Balance ^E	Balance ^E
Element	P/F-42XX	P/F-46XX	P/F-44XX	P/F-49XX
Nickel	0.40–0.50	1.75–2.00	0.10 max	0.10 max
Molybdenum	0.55–0.65	0.50–0.60	0.80–0.95	1.4–1.6
Manganese	0.20–0.35	0.10–0.25	0.08–0.18	0.08–0.18
Copper, max	0.15	0.15	0.15	0.15
Chromium, max	0.10	0.10	0.10	0.10
Sulfur, max	0.03	0.03	0.03	0.03
Silicon, max	0.03	0.03	0.03	0.03
Phosphorus, max	0.03	0.03	0.03	0.03
Carbon	<i>C</i>	<i>C</i>	<i>C</i>	<i>C</i>
Oxygen	<i>D</i>	<i>D</i>	<i>D</i>	<i>D</i>
Total Iron	Balance ^E	Balance ^E	Balance ^E	Balance ^E

^A For the purpose of determining conformance with this specification, measured values shall be rounded “to the nearest unit” in the last right-hand digit used in expressing the specification limit, in accordance with the rounding-off method of Practice E29.

^B Covers manganese sulfide (MnS) additions of from 0.3 to 0.5 %. The manganese content in solution is similar to P/F-10XX or P/F-10CXX, that is, 0.10 to 0.25 %.

^C Carbon content shall be as specified by the purchaser.

^D When required, maximum oxygen content shall conform to the amount specified by purchaser. See S1.

^E For information only. Quantitative determination of this element is not required.

7.2 Determine the density of complete parts or sections of parts in accordance with Test Method B311. [/astm-b848-10](#)

8. Mechanical Property Requirements

8.1 Mechanical Properties:

8.1.1 The preferred method for verifying the acceptable performance of a finished part is for the manufacturer and the purchaser to agree upon a qualification test to be performed on an actual part. The specific test should be determined following consideration of the function of the part. An example would be measuring the force needed to break teeth off a gear, using a prescribed test fixture.

8.1.2 Where the part configuration permits, standard mechanical property test specimens may be machined from the part in the condition in which it is to be used. (Remove test specimens from parts to be used in the quenched and tempered condition after heat treatment of the part to ensure the microstructure is representative of the actual part.) The applicable part drawing or purchase order shall designate the location from which the mechanical property test specimens are to be removed and the type of specimen to be tested.

8.1.3 The core hardness range of parts shall be in accordance with the applicable part drawing or purchase order.

8.1.4 The surface hardness range of parts shall be in accordance with the applicable part drawing or purchase order.

8.1.5 Typical mechanical properties of Grade A materials covered by this specification are shown in Appendix X1.

8.2 Mechanical Property Test Methods:

8.2.1 *Tensile Test Method*—When requested, take tensile test specimens from parts in accordance with the applicable part drawing or purchase order. Test tensile specimens in accordance with Test Methods E8. Determine yield strength by the 0.2 % offset method.

8.2.2 *Impact Energy Test Method*—When requested, take Charpy V-notch impact test bars from parts in accordance with the applicable part drawing or purchase order. Test impact bars in accordance with Test Methods E23; at room temperature, or, at a temperature agreed between the manufacturer and purchaser.

8.2.3 *Hardness Test Method*—Determine hardness measurements in accordance with Test Methods E18. Make core hardness measurements on sectioned parts within the core region of the part. Determine surface hardness measurements in accordance with

the applicable part drawing on the original forged surface, or, if machined, on the machined part surface.

9. Microstructure Requirements

9.1 Surface Finger Oxide Penetration:

9.1.1 The maximum depth of penetration of surface finger oxides from the finished part surface, for each designated critical region of a powder forged part, shall not exceed that agreed upon between the manufacturer and purchaser. Designate critical regions by the applicable part drawing or purchase order.

9.1.2 Determine the surface finger oxide penetration in accordance with Test Method B797.

9.2 Interparticle Oxide Networks:

9.2.1 The extent of any interparticle oxide networks in each designated critical region of a powder forged part shall not exceed that agreed upon between the manufacturer and purchaser. Designate critical regions on the applicable part drawing or purchase order.

9.2.2 Determine the interparticle oxide networks in accordance with Test Method B797.

9.3 Decarburization Depth:

9.3.1 The maximum depth of complete decarburization (only ferrite present) of surfaces of powder forged parts shall not exceed that agreed between the manufacturer and purchaser.

9.3.2 The depth of total decarburization (total decarburization = complete decarburization + partial decarburization), the depth at which core carbon content is reached, shall not exceed that agreed between the manufacturer and purchaser. Alternatively, for quenched and tempered parts, an effective decarburization depth (depth to a specified hardness) may be specified.

9.3.3 Determine the depth of complete decarburization by the microscopical method in accordance with Test Methods E1077.

9.3.4 Depth of total or effective decarburization.

9.3.4.1 *Slow-Cooled or Normalized Parts*—Estimate the depth of total decarburization of slow-cooled or normalized parts microscopically from the sum of the depths of complete and partial decarburization in accordance with Test Methods E1077.

9.3.4.2 *Quenched and Tempered Parts*—Determine the depth of effective decarburization by the microindentation hardness method in accordance with Test Methods E1077.

9.4 Nonmetallic Inclusion Level:

9.4.1 The nonmetallic inclusion level of Grade A powder forged parts shall not exceed that specified by the applicable part drawing or purchase order.

9.4.2 Determine the nonmetallic inclusion level in accordance with Test Method B796. For materials that contain manganese sulfide additions, modify the inclusion assessment to count either only those discrete inclusions greater than or equal to 100 μm maximum caliper (Feret's) diameter, or change the near neighbor separation distance from 30 μm to 15 μm in accordance with Test Method B796.

NOTE 34—Porosity dominates the mechanical properties of Grade B parts. Inclusion assessment of Grade B parts is therefore not necessary.

9.5 Cross Product Contamination :

9.5.1 The amount of unalloyed iron contamination of P/F – 42XX, P/F – 46XX, P/F – 44XX, or P/F – 49XX, or alloyed iron contamination of P/F – 10XX, P/F – 10CXX, P/F – 11XX, or P/F – 11CXX parts shall not exceed that agreed between the manufacturer and purchaser.

9.5.2 Determine alloyed or unalloyed iron contamination in accordance with Test Method B795.

10. Sampling

10.1 *Lot*—Unless otherwise specified, a lot shall consist of a specified quantity of product manufactured under traceable conditions as agreed upon between producer and user.

10.2 *Chemical Analysis*—When a full chemical analysis is requested on the purchase order, either the chemical analysis provided by the powder supplier for the specific lot of powder used to make the parts, or, testing of the forged parts, may be used to meet this requirement. However, the forged carbon content, and oxygen content when specified, shall be measured on the forged parts. Take samples from the core area of the part. For spectrometric analysis, the sample shall consist of a single solid piece carefully cut using a cutting fluid to prevent overheating. After cutting, wash the piece with low residue acetone to remove the cutting fluid and dry with compressed air. For carbon and wet chemical analysis, remove drillings, chips, or solid pieces without the use of water, oil, or other lubricant, and with care to prevent overheating. Take care to keep dirt and foreign substances out of the sample.

10.3 *Mechanical Tests*— The manufacturer and purchaser shall mutually agree on a representative number of specimens for qualification testing or mechanical property testing.

11. Inspection

11.1 Inspection of the parts supplied under this specification shall be the responsibility of the manufacturer or a mutually agreed upon third party.

11.2 If the purchaser desires that his representative inspect or witness the inspection and testing of the material prior to shipment, such a requirement shall be part of the purchase order.

12. Rejection and Rehearing

12.1 Parts that fail to conform to the requirements of this specification may be rejected. Rejection should be reported to the manufacturer or supplier promptly and in writing. In case of dissatisfaction with the results of the test, the manufacturer or supplier may make claim for a rehearing.

13. Certification

13.1 When specified in the purchase order, furnish a manufacturer's certification to the purchaser that the parts were manufactured, sampled, tested, and inspected in accordance with this specification and have been found to meet the requirements. When specified in the purchase order, furnish a report of the test results.

14. Keywords

14.1 powder forged (P/F)(PF) parts; powder forged (P/F)(PF) steels; powder forging (P/F)-(PF)

SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall apply only when specified by the purchaser in the purchase order.

S1. Forged Oxygen Content

S1.1 The maximum permissible oxygen content of forged parts shall be as specified by the applicable part drawing or the purchase order.

S1.2 Take at least one sample for analysis from each lot. Take samples from the core region of the part. The sample shall consist of a single solid piece carefully cut with a low speed precision cut-off wheel using cutting fluid to prevent overheating. After cutting, wash the sample with low residue acetone to remove the cutting fluid and dry with compressed air.

S1.3 Determine the oxygen concentration in accordance with Test Methods Method E1019. (Calibration standards should be selected with an oxygen level appropriate to the level of oxygen in the forged sample.)

S2. Case Hardening

S2.1 The effective case depth of surface hardened (for example, carburized or carbonitrided) powder forged steel parts shall meet the range specified by the applicable part drawing or as agreed upon by the manufacturer and purchaser.

S2.2 Determine the effective case depth of surface hardened parts in accordance with Test Method B934.

S3. Critical Region Porosity

S3.1 The maximum area percent porosity plus oxide inclusions of each designated critical region of a powder forged part shall not exceed that agreed upon between the manufacturer and purchaser. Designate critical regions on the applicable part drawing or purchase order.

S3.2 Determine the critical region percentage porosity plus oxide inclusions in accordance with Test Method E562 or by an agreed upon automated image analysis method.

S4. Microstructural Uniformity

S4.1 Microstructural uniformity requirements for powder forged parts shall be agreed upon between the manufacturer and purchaser.

S4.2 Remove a metallographic specimen representing the specified region or regions of the part for examination. Prepare the specimen following the procedures described in Practice E3.

APPENDIX

(Nonmandatory Information)

X1. MECHANICAL PROPERTIES OF POWDER FORGED (P/F)(PF) FERROUS STRUCTURAL PARTS

X1.1 Data for typical mechanical properties of Grade A powder forged ferrous structural parts are given in Table X1.1. The data do not constitute a part of the specification. They are merely intended to indicate to the purchaser the typical mechanical properties that may be expected from specimens machined from sample blanks of the chemical composition and heat treatment condition specified.