



Designation: F593 – 02(Reapproved 2008)^{e1}

Standard Specification for Stainless Steel Bolts, Hex Cap Screws, and Studs¹

This standard is issued under the fixed designation F593; 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.

^{e1} NOTE—1.4 and 2.1 were editorially corrected in January 2012.

1. Scope

1.1 This specification covers the requirements for stainless steel bolts, hex cap screws, and studs 0.25 to 1.50 in., inclusive, in nominal diameter in a number of alloys in common use and intended for service applications requiring general corrosion resistance.

1.2 Seven groups of stainless steel alloys are covered, including twelve austenitic, two ferritic, four martensitic, and one precipitation hardening.

Group	Alloys ^A	Condition ^B
1	304, 305, 384, 304 L, 18-9LW, 302HQ ^D	(CW) cold worked ^C
2	316, 316 L	(CW) cold worked ^C
3	321, 347	(CW) cold worked ^C
4	430 ^E	(CW) cold worked ^C
5	410 ^F	(H) hardened and tempered
6	431	(H) hardened and tempered
7	630	(AH) age hardened

^A Unless otherwise specified on the inquiry and order, the choice of an alloy from within a group shall be at the discretion of the fastener manufacturer (see 6.1).

^B See 4.2 for options.

^C Sizes 0.75 in. and larger may be hot worked and solution annealed.

^D When approved by the purchaser, Alloys 303, 303Se, or XM1 may be furnished.

^E When approved by the purchaser, Alloy 430F may be furnished.

^F When approved by the purchaser, Alloys 416 or 416Se may be furnished.

1.3 Supplementary requirements of an optional nature are provided, applicable only when agreed upon between the manufacturer and the purchaser at the time of the inquiry and order.

1.4 Suitable nuts for use with bolts, hex cap screws, and studs included in this specification are covered by Specification F594. Unless otherwise specified, all nuts used on these fasteners shall conform to the requirements of Specification F594, shall be of the same alloy group, and shall have a

specified minimum proof stress equal to or greater than the specified minimum full-size tensile strength of the externally threaded fastener.

1.5 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.

1.6 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels

A276 Specification for Stainless Steel Bars and Shapes

A342/A342M Test Methods for Permeability of Feebly Magnetic Materials

A380 Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment, and Systems

A484/A484M Specification for General Requirements for Stainless Steel Bars, Billets, and Forgings

A493 Specification for Stainless Steel Wire and Wire Rods for Cold Heading and Cold Forging

A555/A555M Specification for General Requirements for Stainless Steel Wire and Wire Rods

A564/A564M Specification for Hot-Rolled and Cold-Finished Age-Hardening Stainless Steel Bars and Shapes

A582/A582M Specification for Free-Machining Stainless Steel Bars

A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products

¹ This specification is under the jurisdiction of ASTM Committee F16 on Fasteners and is the direct responsibility of Subcommittee F16.04 on Nonferrous Fasteners.

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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.

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Stainless Steel Parts

D3951 Practice for Commercial Packaging

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

F594 Specification for Stainless Steel Nuts

F606 Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, Direct Tension Indicators, and Rivets

F1470 Practice for Fastener Sampling for Specified Mechanical Properties and Performance Inspection

2.2 *ASME Standards*:³

B1.1 Unified Inch Screw Threads

B18.2.1 Square and Hex Bolts and Screws, Including Hex Cap Screws

3. Ordering Information

3.1 Orders for bolts, hex cap screws, and studs under this specification shall include the following:

3.1.1 Quantity (number of pieces of each item and size),

3.1.2 Name of item (bolt, hex cap screw, stud, etc.),

3.1.3 Size (nominal diameter, threads per inch, length; see Section 9),

3.1.4 Alloy group number (see 6.1), and

3.1.5 Condition (see 4.2).

3.2 Orders for bolts, hex cap screws, and studs under this specification may include the following optional requirements:

3.2.1 Forming (see 4.1.2),

3.2.2 Rolled or cut threads (see 4.1.3),

3.2.3 Composition (see 6.2),

3.2.4 Corrosion Resistance (see 8.1),

3.2.5 Finish (see 10.3),

3.2.6 Rejection (see 16.1), and

3.2.7 Test report (see 17.2).

3.2.8 Supplementary requirements, if any, to be specified on the order (see S1 through S8), and

3.2.9 ASTM specification and year of issue. When year of issue is not specified, fasteners shall be furnished to the latest issue.

NOTE 1—*Example* 10 000 pieces, Hex Cap Screw, 0.250 in. –20 × 3.00 in., Alloy Group 1, Condition CW, Furnish Test Report, Supplementary Requirement S3.

4. Manufacture

4.1 *Manufacture*:

4.1.1 Specifications **A276**, **A493**, **A564/A564M**, and **A582/A582M** are noted for information only as suitable sources of material for the manufacture of bolts, hex cap screws, and studs to this specification.

4.1.2 *Forming*—Unless otherwise specified, the fasteners shall be cold formed, hot formed, or machined from suitable material at the option of the manufacturer.

4.1.3 *Threads*—Unless otherwise specified, the threads shall be rolled or cut at the option of the manufacturer.

³ Available from Global Engineering Documents, 15 Inverness Way, East Englewood, CO 80112-5704, <http://www.global.ihs.com>.

4.2 *Condition*—The fasteners shall be furnished in the following conditions, unless specified to be furnished in one of the optional conditions:

Alloy Group	Condition Furnished Unless Otherwise Specified	Optional Conditions (must be specified)
1, 2, 3	CW	AF, A, SH
4	CW	A
5	H	HT
6	H	HT
7	AH	none

A—Machined from annealed or solution-annealed stock thus retaining the properties of the original material; or hot-formed and solution annealed.

AF—Headed and rolled from annealed stock and then reannealed.

AH—Solution-annealed and age-hardened after forming.

CW—Headed and rolled from annealed stock thus acquiring a degree of cold work. Sizes 0.75 in. and larger may be hot-worked and solution-annealed.

H—Hardened and tempered at 1050°F (565°C) minimum.

HT—Hardened and tempered at 525°F (274°C) minimum.

SH—Machined from strain-hardened stock or cold-worked to develop the specific properties.

5. Heat Treatment

5.1 *Alloy Groups 1, 2, and 3 (Austenitic Alloys 303, 303Se, 304, 304 L, 305, 316, 316 L, 321, 347, 384, XM1, 18-9LW, and 302HQ)*:

5.1.1 *Condition A*—When Condition A is specified, the austenitic alloys shall be heated to 1900 ± 50°F (1038 ± 28°C), at which time the chromium carbide will go into the solution, be held for a sufficient time, and then be cooled at a rate sufficient to prevent precipitation of the carbide and to provide the specified properties.

5.1.2 *Condition CW*—When Condition CW is specified, the austenitic alloys shall be annealed in accordance with 5.1.1, generally by the raw material manufacturer and then cold worked to develop the specified properties.

5.1.3 *Condition AF*—When Condition AF is specified, the austenitic alloys shall be annealed in accordance with 5.1.1 after all cold working (including heading and threading) has been completed.

5.2 *Alloy Group 4 (Ferritic Alloys 430 and 430F)*:

5.2.1 *Condition A*—The ferritic alloys shall be heated to a temperature of 1450 ± 50°F (788 ± 28°C), held for an appropriate time, and then air cooled to provide the specified properties.

5.2.2 *Condition CW*—When Condition CW is specified, the ferritic alloys shall be annealed in accordance with 5.2.1, generally by the raw material manufacturer and then cold worked to develop the specified properties.

5.2.3 *Condition AF*—When Condition AF is specified, the ferritic alloys shall be annealed in accordance with 5.2.1 after all cold working (including heading and threading) has been completed.

5.3 *Alloy Group 5 (Martensitic Alloys 410, 416, and 416Se)*:

5.3.1 *Condition H*—When Condition H is specified, the Martensitic Alloys 410, 416, and 416Se shall be hardened and tempered by heating to 1850 ± 50°F (1010 ± 28°C) sufficient for austenitization, held for at least ½ h and rapid air- or oil-quenched, and then reheating to 1050°F (565°C) minimum for at least 1 h and air cooled to provide the specified properties.

5.3.2 *Condition HT*—When Condition HT is specified, the Martensitic Alloys 410, 416, and 416Se shall be hardened and tempered by heating to 1850 ± 50°F (1010 ± 28°C) sufficient for austenitization, held for at least ½ h and rapid air- or oil-quenched, and then reheating to 525°F (274°C) minimum for at least 1 h and air cooled to provide the specified properties.

5.4 *Alloy Group 6 (Martensitic Alloy 431):*

5.4.1 *Conditions H and HT*—Martensitic Alloy 431 shall be hardened and tempered in accordance with 5.3.1 and 5.3.2 as applicable.

5.5 *Alloy Group 7 (Precipitation Hardening Alloy 630):*

5.5.1 *Condition AH*—Precipitation Hardening Alloy 630 shall be solution annealed and aged by heating to 1900 ± 25°F (1038 ± 14°C) for at least ½ h and rapid air- or oil-quenched to 80°F (27°C) maximum, then reheating to a temperature of 1150 ± 15°F (621 ± 8°C) for 4 h and air cooled to provide the specified properties.

6. Chemical Composition

6.1 *Alloy Groups*—It is the intent of this specification that fasteners shall be ordered by alloy group numbers, which include alloys considered to be chemically equivalent for general purpose use. The alloy groupings are shown as follows. The purchaser has the option of ordering a specific alloy, in stead of an alloy group number, as permitted in 6.2.2.

Alloy Group	Alloys
1	304, 304 L, 305, 384, 18-9LW, 302HQ ^A
2	316, 316 L
3	321, 347
4	430 ^B
5	410 ^C
6	431
7	630

^A When approved by the purchaser, Alloys 303, 303Se, or XM1 may be furnished.

^B When approved by the purchaser, Alloy 430F may be furnished.

^C When approved by the purchaser, Alloys 416 or 416Se may be furnished.

6.2 *Chemical Composition Limits:*

6.2.1 *Ordering by Alloy Group*—Unless otherwise specified on the inquiry and order (see Supplementary Requirement S4), the choice of an alloy from within a group shall be at the discretion of the fastener manufacturer as required by his method of fastener fabrication and material availability. The specific alloy used by the fastener manufacturer shall be clearly identified on any certification required by the order and shall have a chemical composition conforming to the requirements of Table 1 for the specific alloy.

6.2.2 *Ordering by Specific Alloy*—When ordered by a specific alloy number, the fasteners shall conform to the chemical composition limits of Table 1 for the specific alloy.

6.3 *Product Analysis:*

6.3.1 When performed, product analysis to determine chemical composition shall be performed on at least one fully manufactured finished fastener representing each lot. The chemical composition thus determined shall conform to the requirements of Table 1 for the specified alloy or alloy group as appropriate, subject to the Product Analysis Tolerance in Specifications A484/A484M and A555/A555M.

6.3.2 In the event of discrepancy, a referee chemical analysis of samples from each lot shall be made in accordance with 14.1.

7. Mechanical Properties

7.1 The finished fasteners shall meet the applicable mechanical property and test requirements of Table 2 and Table 3

TABLE 1 Chemical Requirements

Alloy Group	UNS Designation	Alloy	Composition, % maximum except as shown									
			Carbon	Manganese	Phosphorus	Sulfur	Silicon	Chromium	Nickel	Copper	Molybdenum	Others
Austenitic Alloys												
1	S30300	303	0.15	2.00	0.20	0.15 min	1.00	17.0 to 19.0	8.0 to 10.0	...	0.60 max ^A	...
1	S30323	303 Se	0.15	2.00	0.20	0.060	1.00	17.0 to 19.0	8.0 to 10.0	Se 0.15 min
1	S30400	304	0.08	2.00	0.045	0.030	1.00	18.0 to 20.0	8.0 to 10.5	1.00
1	S30403	304 L	0.03	2.00	0.045	0.030	1.00	18.0 to 20.0	8.0 to 12.0	1.00
1	S30500	305	0.12	2.00	0.045	0.030	1.00	17.0 to 19.0	10.5 to 13.0	1.00
1	S38400	384	0.08	2.00	0.045	0.030	1.00	15.0 to 17.0	17.0 to 19.0	...	0.50 max ^A	...
1	S20300	XM1	0.08	5.0 to 6.5	0.040	0.18 to 0.35	1.00	16.0 to 18.0	5.0 to 6.5	1.75 to 2.25
1	S30430	18-9LW	0.10	2.00	0.045	0.030	1.00	17.0 to 19.0	8.0 to 10.0	3.0 to 4.0
1	S30433	302HQ	0.03	2.00	0.045	0.030	1.00	17.0 to 19.0	8.0 to 10.0	3.0 to 4.0
2	S31600	316	0.08	2.00	0.045	0.030	1.00	16.0 to 18.0	10.0 to 14.0	...	2.00 to 3.00	...
2	S31603	316 L	0.03	2.00	0.045	0.030	1.00	16.0 to 18.0	10.0 to 14.0	...	2.00 to 3.00	...
3	S32100	321	0.08	2.00	0.045	0.030	1.00	17.0 to 19.0	9.0 to 12.0	Ti 5× C min
3	S34700	347	0.08	2.00	0.045	0.030	1.00	17.0 to 19.0	9.0 to 13.0	Cb+Ta 10 × C min
Ferritic Alloys												
4	S43000	430	0.12	1.00	0.040	0.030	1.00	16.0 to 18.0	0.60 max ^A	...
4	S43020	430F	0.12	1.25	0.060	0.15 min	1.00	16.0 to 18.0	0.60 max ^A	...
Martensitic Alloys												
5	S41000	410	0.15	1.00	0.040	0.030	1.00	11.5 to 13.5
5	S41600	416	0.15	1.25	0.060	0.15 min	1.00	12.0 to 14.0	0.60 max ^A	Se 0.15 min
5	S41623	416Se	0.15	1.25	0.060	0.060	1.00	12.0 to 14.0	0.60 max ^A	Se 0.15 min
6	S43100	431	0.20	1.00	0.040	0.030	1.00	15.0 to 17.0	1.25 to 2.50
Precipitation Hardening Alloy												
7	S17400	630	0.07	1.00	0.040	0.030	1.00	15.0 to 17.5	3.0 to 5.0	3.0 to 5.0	...	Cb+Ta 0.15–0.45

^A At manufacturer's option, determined only when intentionally added.