INTERNATIONAL

Designation: ~~A841/A841M – 03a (Reapproved 2007)~~ A841/A841M – 13

Standard Specification for Steel Plates for Pressure Vessels, Produced by Thermo-Mechanical Control Process (TMCP)[1]

This standard is issued under the fixed designation A841/A841M; 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~~ Scope*

1.1 This specification[2] covers steel plates produced by the thermo-mechanical control process (TMCP). The plates are intended primarily for use in welded pressure vessels. A description of the TMCP method is given in Appendix X1.

~~1.2 The TMCP method consists of rolling-reduction and cooling rate controls that result in mechanical properties in the finished plate that are equivalent to those attained using conventional rolling and heat treating processes, which entail reheating after rolling. A description of the TMCP method is given in Appendix X1.~~

1.2 Due to the inherent characteristics of the TMCP method, the plates cannot be formed at elevated temperatures without sustaining significant losses in strength and toughness. ~~The~~ Except for Grade G, the plates may be formed and post-weld heat-treated at temperatures not exceeding 1200°F [650°C], providing the requirements of 6.1 are met. Grade G plates may be formed at temperatures not exceeding 985°F [530°C] provided the requirements of 6.1 are met.

1.3 The maximum permitted nominal thickness of plates furnished to this specification is 4 in. [100 mm] for Grades A, B, and C; ~~and~~ 1.5 in. [40 mm] for Grades D,[3] E, and ~~F.~~F; and 2 in. [50 mm] for Grade G.

1.4 Grade G is susceptible to magnetization. Use of magnets in handling after heat treatment should be avoided if residual magnetism would be detrimental to subsequent fabrication or service.

1.5 The values stated in either inch-pound units or SI units are to be regarded separately as 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 this specification.

2. Referenced Documents

2.1 *ASTM Standards:*[4]

A20/A20M Specification for General Requirements for Steel Plates for Pressure Vessels
A435/A435M Specification for Straight-Beam Ultrasonic Examination of Steel Plates
A577/A577M Specification for Ultrasonic Angle-Beam Examination of Steel Plates
A578/A578M Specification for Straight-Beam Ultrasonic Examination of Rolled Steel Plates for Special Applications

3. General Requirements and Ordering Information

3.1 Plates supplied to this product specification shall conform to Specification A20/A20M, which outlines the testing and retesting methods and procedures, permissible variations in dimensions, quality and repair of defects, marking, loading, etc.

3.2 Specification A20/A20M also establishes the rules for ordering information that should be complied with when purchasing plates to this specification.

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[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 A01.11 on Steel Plates for Boilers and Pressure Vessels.

Current edition approved ~~Nov. 1, 2007~~Oct. 1, 2013. Published ~~March 2008~~November 2013. Originally approved in 1985. Last previous edition approved in ~~2003~~2007 as ~~A841/A841M – 03a.~~A841/A841M – 03a (2007). DOI: ~~10.1520/A0841_A0841M-03AR07.~~10.1520/A0841_A0841M-13.

[2] For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-841/SA-841M in Section II of that Code.

[3] ExxonMobil Upstream Research Company has patents pending concerning the use of chemistry ranges in ASTM A841 Grade D, in combination with specific TMCP routes and/or specific microstructural features. Interested parties are invited to submit information regarding identification of alternatives to these patented items to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee,[1] which you may attend.

[4] 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**

3.2.1 If the plates are to be subjected to warm forming or post-weld heat treatment, the order must indicate the temperatures and times-at-temperature that will be utilized in such operations. (See 6.1 and Specification A20/A20M, Supplementary Requirement S3.)

3.3 In addition to the basic requirements of this specification, certain supplementary requirements are available when additional control, testing, or examination is required to meet end use requirements. These include:

3.3.1 Vacuum treatment,

3.3.2 Additional or special tension testing,

3.3.3 Additional or special impact testing, and

3.3.4 Nondestructive examination.

3.4 The purchaser is referred to the listed supplementary requirements in this specification and to the detailed requirements in Specification A20/A20M.

3.5 If the requirements of this specification are in conflict with the requirements of Specification A20/A20M, the requirements of this specification shall prevail.

4. Manufacture

4.1 *Steelmaking Practice*—The steel shall be killed and shall conform to the fine austenitic grain size requirement of Specification A20/A20M.

4.2 The plates shall be produced by the thermo-mechanical control process.

5. Chemical Composition

5.1 The chemical composition on heat analysis shall conform to the requirements given in Table 1, except as otherwise provided in Supplementary Requirement S17 of Specification A20/A20M when that requirement is involved.

5.2 If a product analysis is made on a sample taken from the standard location (see Specification A20/A20M), the results of the analysis shall not deviate from the limits for the heat analysis by more than the values given in Table 2.

6. Mechanical Requirements

6.1 If the plates are to be subjected to warm forming or post-weld heat treatment, the test coupons shall be subjected to heat treatment to simulate such fabrication operations. (See 3.2.1 and Specification A20/A20M, Supplementary Requirement S3.)

6.2 *Tension Test Requirements*—The plates as represented by the tension-test specimens shall conform to the requirements given in Table 3.

6.2.1 *Number and Location of Test Coupons*—Two tension tests shall be made from each plate-as-rolled. One test coupon shall be taken from a corner of the plate on each end.

6.3 *Notch Toughness Test Requirements:*

6.3.1 ~~Longitudinal~~ Except for Grade G, longitudinal Charpy V-notch tests shall be made in accordance with Specification A20/A20M.

6.3.2 For Grades A, B and C, unless the test temperature and absorbed energy requirements are specified in the purchase order, the tests shall be conducted at –40°F [–40°C] and the average absorbed energy for each set of three full size specimens shall be 15 ft·lb [20J] or more.

6.3.3 For Grade D, unless the test temperature and the lateral expansion requirements are specified in the purchase order, the tests shall be conducted at –40°F [–40°C] and the lateral expansion for each specimen shall be 0.015 in. [0.4 mm] or more.

6.3.4 For Grades E and F, unless the test temperature and absorbed energy requirements are specified in the purchase order, the tests shall be conducted at –40°F [–40°C] and the average absorbed energy for each set of three full size specimens shall be 20 ft·lb [27 J] or more.

6.3.5 For Grade G, transverse Charpy V-notch tests shall be made in accordance with Specification A20/A20M. Unless the test temperature is specified in the purchase order, the tests shall be conducted at –320°F [–195°C]. Each specimen shall have a lateral expansion opposite the notch of not less than 0.015 in. [0.38 mm], up to a plate thickness of 1.25 in. [31.75 mm] inclusive; and 0.019 in. [0.48 mm] at a plate thickness of 2.0 in. [50 mm]. Values of lateral expansion for plate thicknesses between 1.25 in. [31.75 mm] and 2.0 in. [50 mm] shall be determined by linear interpolation.

7. Marking

7.1 In addition to the marking required in Specification A20/A20M, each plate shall be legibly stamped with the letters "TMC" following the stamped specification designation.

8. Keywords

8.1 pressure containing parts; pressure vessel steel; steel plates; steel plates for pressure vessel applications

TABLE 1 Chemical Requirements

Element	Composition, %					
	Grade A	Grade B	Grade C	Grade D	Grade E	Grade F
~~Carbon, max~~	~~0.20~~	~~0.15~~	~~0.10~~	~~0.09~~	~~0.07~~	~~0.10~~[A]
Manganese						
~~t ≤ 1.5 in. [40 mm]~~	~~0.70–1.35~~[B]	~~0.70–1.35~~[B]	~~0.70–1.60~~	~~1.00–2.00~~	~~0.70–1.60~~	~~1.10–1.70~~[A]
~~t > 1.5 in. [40 mm]~~	~~1.00–1.60~~	~~1.00–1.60~~	~~1.00–1.60~~	[C]	[C]	[C]
~~Phosphorus, max~~	~~0.030~~	~~0.030~~	~~0.030~~	~~0.010~~	~~0.015~~	~~0.020~~
~~Sulfur, max~~	~~0.030~~	~~0.025~~	~~0.015~~	~~0.005~~	~~0.005~~	~~0.008~~
Silicon	0.15–0.50	0.15–0.50	0.15–0.50	0.05–0.25	0.05–0.30	0.10–0.45
~~Copper, max~~	~~0.35~~	~~0.35~~	~~0.35~~	~~0.50~~	~~0.35~~	~~0.40~~
~~Nickel~~	~~0.25 max~~	~~0.60 max~~	~~0.25 max~~	~~1.0–5.0~~	~~0.60 max~~	~~0.85 max~~
~~Chromium, max~~	~~0.25~~	~~0.25~~	~~0.25~~	~~0.30~~	~~0.30~~	~~0.30~~
~~Molybdenum, max~~	~~0.08~~	~~0.30~~	~~0.08~~	~~0.40~~	~~0.30~~	~~0.50~~
~~Columbium, max~~	~~0.03~~	~~0.03~~	~~0.06~~	~~0.05~~	~~0.08~~	~~0.10~~
~~Vanadium, max~~	~~0.06~~	~~0.06~~	~~0.06~~	~~0.02~~	~~0.06~~	~~0.09~~
~~Titanium~~	[D]	[D]	~~0.006–0.02~~	~~0.006–0.03~~	[D]	[E]
~~Boron~~	~~...~~	~~...~~	~~...~~	~~0.0005–0.002~~	~~0.0007 max~~	~~0.0007 max~~
Aluminum, min	0.020 total or ~~0.015 acid soluble~~[D]	0.020 total or ~~0.015 acid soluble~~[D]	...	...	0.020 total or ~~0.015 acid soluble~~[D]	0.020 total or ~~0.015 acid soluble~~[E]

TABLE 1 Chemical Requirements[A]

Element	Composition, %						
	Grade A	Grade B	Grade C	Grade D	Grade E	Grade F	Grade G
Carbon	0.20	0.15	0.10	0.09	0.07	0.10[B]	0.13
Manganese							
t ≤ 1.5 in. [40 mm]	0.70–1.35[C]	0.70–1.35[C]	0.70–1.60	1.00–2.00	0.70–1.60	1.10–1.70[B]	0.60–1.20
t > 1.5 in. [40 mm]	1.00–1.60	1.00–1.60	1.00–1.60	[D]	[D]	[D]	0.60–1.20
Phosphorus	0.030	0.030	0.030	0.010	0.015	0.020	0.015
Sulfur	0.030	0.025	0.015	0.005	0.005	0.008	0.015
Silicon	0.15–0.50	0.15–0.50	0.15–0.50	0.05–0.25	0.05–0.30	0.10–0.45	0.04–0.15[E]
Copper	0.35	0.35	0.35	0.50	0.35	0.40	...
Nickel	0.25	0.60	0.25	1.0–5.0	0.60	0.85	6.0–7.5
Chromium	0.25	0.25	0.25	0.30	0.30	0.30	0.30–1.00
Molybdenum	0.08	0.30	0.08	0.40	0.30	0.50	0.30
Columbium	0.03	0.03	0.06	0.05	0.08	0.10	...
Vanadium	0.06	0.06	0.06	0.02	0.06	0.09	...
Titanium	[F] –	[F] –	0.006–0.02	0.006–0.03	[F] –	[G] –	...
Boron	...	...	...	0.0005–0.002	0.0007	0.0007	...
Aluminum, min	0.020 total or 0.015 acid soluble[F]	0.020 total or 0.015 acid soluble[F]	...	...	0.020 total or 0.015 acid soluble[F]	0.020 total or 0.015 acid soluble[G]	[E] – 0.008 acid soluble

[A] Values are maximums unless a minimum or a range is indicated. Where ellipses appear in this table, there is no requirement.

[B] For each reduction of 0.01 percentage point below the specified maximum for carbon, an increase of 0.06 percentage points above the specified maximum for manganese is permitted, up to a maximum of 1.85 %.

[C] Manganese may exceed 1.35 % on heat analysis, up to a maximum of 1.60 %, provided that the carbon equivalent on heat analysis does not exceed 0.47 %, or the value specified in Supplementary Requirement S77 when that requirement is invoked, when based on the following formula:

$$CE = C + Mn/6 + (Cr + Mo + V)/5 + (Ni + Cu)/15\ \%$$

When this option is exercised, the manganese content on product analysis shall not exceed the heat analysis content by more than 0.12 percentage points.

[D] Not applicable.

[E] Silicon may be less than 0.04 %, provided that total aluminum is 0.030 % or over, or provided acid soluble aluminum is 0.025 % or over.

[F] By agreement, the steel may be produced with titanium, in which case the minimum aluminum content shall not apply. When this option is exercised, the titanium content, by heat analysis, shall be 0.006 % to 0.02 %, and the actual titanium content shall be reported on the test report.

[G] By agreement, the steel may be produced with titanium, in which case the minimum aluminum content shall not apply. When this option is exercised, the titanium content, by heat analysis, shall be 0.006 % to 0.03 %, and the actual titanium content shall be reported on the test report.

TABLE 2 Product Analysis Tolerances

Element	Specified Limit, %	Tolerances, %	
		Under Minimum Limit	Over Maximum Limit
Carbon	to 0.15, incl	0.02	0.03
	over 0.15	0.03	0.04
Manganese	to 0.60, incl	0.05	0.06
	over 0.60 to 0.90, incl	0.06	0.08
	over 0.90 to 1.20, incl	0.08	0.10
	over 1.20 to 1.35, incl	0.09	0.11
	over 1.35 to 1.65, incl	0.09	0.12
	over 1.65	0.11	0.14
Phosphorus	to 0.020, incl	...	0.005
	over 0.020	...	0.010
Sulfur	to 0.020, incl	...	0.005
	over 0.020	...	0.010
Silicon	to 0.30, incl	0.02	0.03
	over 0.30 to 0.40, incl	0.05	0.05
	over 0.40	0.06	0.06
Nickel	to 1.00, incl	0.03	0.03
	over 1.0 to 2.0, incl	0.05	0.05
	over 2.0 to 3.8, incl	0.07	0.07
	over 3.8	0.08	0.08
Chromium	to 0.90, incl	0.04	0.04
Molybdenum	to 0.20, incl	0.01	0.01
	over 0.20	0.03	0.03
Copper	to 1.00, incl	0.03	0.03
Vanadium	to 0.10, incl	0.01	0.01
Columbium	to 0.10, incl	0.01	0.01
Aluminum	to 0.15, incl	0.005	0.01
Titanium	to 0.010, incl	0.002	0.01
	over 0.010	0.01	0.01
Boron	any	[A]	[A]

[A] Product analysis is not applicable for this element.

TABLE 3 Tensile Requirements

	Grades A, B, and C		Grade D	Grade E		Grade F		
	Class 1	Class 2	Class 3	Class 4	Class 5	Class 6	Class 7	Class 8
Yield strength, min, ksi [MPa]								
to 1.5 in. [40 mm] incl	50 [345]	60 [415]	100 [690]	70 [485]	75 [515]	70 [485]	75 [515]	80 [550]
over 1.5 in. [40 mm] to 2.5 in. [to 65 mm]	50 [345]	60 [415]	A	A	A	A	A	A
over 2.5 in. [over 65 mm]	45 [310]	55 [380]	A	A	A	A	A	A
Tensile strength, ksi [MPa]								
to 1.5 in. [40 mm] incl	70–90 [485–620]	80–100 [550–690]	145–170 [1000–1170]	84–104 [580–715]	88–108 [605–745]	82–102 [565–705]	86–106 [590–730]	90–110 [620–760]
over 1.5 in. [40 mm] to 2.5 in. [to 65 mm]	70–90 [485–620]	80–100 [550–690]	A	A	A	A	A	A
over 2.5 in. [over 65 mm]	65–85 [450–585]	75–95 [515–655]	A	A	A	A	A	A
Elongation in 2 in. [50 mm], min, %[B]								
to 1.5 in. [40 mm] incl	22	22	13	20	19	20	19	18
over 1.5 in. [40 mm] to 2.5 in. [to 65 mm]	22	22	A	A	A	A	A	A
over 2.5 in. [over 65 mm]	22	22	A	A	A	A	A	A
Elongation in 8 in. [200 mm], min, %[B]								
to 1.5 in. [40 mm] incl	18	...	...	16	15	16	15	14
over 1.5 in. [40 mm] to 2.5 in. [to 65 mm]	18	....	A	A	A	A	A	A
over 2.5 in. [over 65 mm]	18	...	A	A	A	A	A	A

TABLE 3 Tensile Requirements

	Grades A, B, and C		Grade D	Grade E			Grade F		Grade G	
	Class 1	Class 2	Class 3	Class 4	Class 5	Class 6	Class 7	Class 8	Class 9	Class 10
Yield strength, min, ksi [MPa]										
to 1.5 in. [40 mm] incl	50 [345]	60 [415]	100 [690]	70 [485]	75 [515]	70 [485]	75 [515]	80 [550]	85 [585]	90 [620]
over 1.5 in. [40 mm] to 2.0 in. [50 mm]	A	A	A	A	A	A	A	A	85 [585]	90 [620]
over 1.5 in. [40 mm] to 2.5 in. [to 65 mm]	50 [345]	60 [415]	A	A	A	A	A	A	A	A
over 2.5 in. [over 65 mm]	45 [310]	55 [380]	A	A	A	A	A	A	A	A
Tensile strength, ksi [MPa]										
to 1.5 in. [40 mm] incl	70–90 [485–620]	80–100 [550–690]	145–170 [1000–1170]	84–104 [580–715]	88–108 [605–745]	82–102 [565–705]	86–106 [590–730]	90–110 [620–760]	100–120 [690–825]	109–129 [750–885]
over 1.5 in. [40 mm] to 2.0 in. [50 mm]	A	A	A	A	A	A	A	A	100–120 [690–825]	109–129 [750–885]
over 1.5 in. [40 mm] to 2.5 in. [to 65 mm]	70–90 [485–620]	80–100 [550–690]	A	A	A	A	A	A	A	A
over 2.5 in. [over 65 mm]	65–85 [450–585]	75–95 [515–655]	A	A	A	A	A	A	A	A

	Grades A, B, and C		Grade D	Grade E		Grade F			Grade G	
	Class 1	Class 2	Class 3	Class 4	Class 5	Class 6	Class 7	Class 8	Class 9	Class 10
Elongation in 2 in. [50 mm], min, %[B]										
to 1.5 in. [40 mm] incl	22	22	13	20	19	20	19	18	20	20
over 1.5 in. [40 mm] to 2.0 in. [50 mm]	[A] –	[A] –	[A] –	[A] –	[A] –	[A] –	[A] –	[A] –	20	20
over 1.5 in. [40 mm] to 2.5 in. [to 65 mm]	22	22	[A]	[A]	[A]	[A]	[A]	[A]	[A] –	[A] –
over 2.5 in. [over 65 mm]	22	22	[A]	[A]	[A]	[A]	[A]	[A]	[A] –	[A] –
Elongation in 8 in. [200 mm], min, %[B]										
to 1.5 in. [40 mm] incl	18	...	...	16	15	16	15	14	[A] –	[A] –
over 1.5 in. [40 mm] to 2.5 in. [to 65 mm]	18	....	[A]	[A]	[A]	[A]	[A]	[A]	[A] –	[A] –
over 2.5 in. [over 65 mm]	18	...	[A]	[A]	[A]	[A]	[A]	[A]	[A] –	[A] –

[A] Not applicable.
[B] See Specification A20/A20M for elongation requirement adjustments.