



Designation: **A27/A27M—10 A27/A27M – 13**

Standard Specification for Steel Castings, Carbon, for General Application¹

This standard is issued under the fixed designation A27/A27M; 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 (ϵ) indicates an editorial change since the last revision or reappraisal.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This specification covers carbon steel castings for general applications that require up to 70 ksi (485 MPa) minimum tensile strength.

NOTE 1—The grades covered by this specification represent materials that are suitable for assembly with other steel castings or wrought steel parts by fusion welding. It is not intended to imply that all these grades possess the same degree of weldability or that the same welding techniques can be used on all castings. It is the responsibility of the purchaser to establish for himself a suitable welding technique.

1.2 Several grades and two classes of steel castings are covered, as indicated below. The grade and class desired shall be specified by the purchaser.

1.2.1 *Grade N-1*—Chemical analysis only.

1.2.2 *Grade N-2*—Heat-treated but not mechanically tested.

1.2.3 *Grade U-60-30* [415-205]—Mechanically tested but not heat-treated.

1.2.4 *Grades 60-30* [415-205], *65-35* [450-240], *70-36* [485-250], and *70-40* [485-275]—Heat-treated and mechanically tested.

1.2.5 Class 1 and Class 2 steel castings shall be specified in accordance with 9.2.

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.

1.4 *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

[A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)

~~[A732/A732M Specification for Castings, Investment, Carbon and Low Alloy Steel for General Application, and Cobalt Alloy for High-Strength at Elevated Temperatures](#)~~

[A781/A781M Specification for Castings, Steel and Alloy, Common Requirements, for General Industrial Use](#)

[A957/A957M Specification for Investment Castings, Steel and Alloy, Common Requirements, for General Industrial Use](#)

[A1067/A1067M Specification for Test Coupons for Steel Castings](#)

3. General Conditions for Delivery

3.1 Except for steel investment castings, material furnished to this specification shall conform to the requirements of Specification [A781/A781M](#), including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification [A781/A781M](#) constitutes nonconformance with the specification. In case of a conflict between the requirements of this specification and Specification [A781/A781M](#), this specification shall prevail.

3.2 Steel investment castings furnished to this specification shall conform to the requirements of Specification [A957/A957M](#), including any supplementary requirements that are indicated in the purchase order. Failure to comply with the common

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 A01.18 on Castings.

Current edition approved Oct. 1, 2010; Nov. 1, 2013. Published November 2010; November 2013. Originally approved in 1901. Last previous edition approved in 2008; 2010 as ~~A27/A27M—08~~; A27/A27M – 10. DOI: ~~10.1520/A0027_A0027M-10~~; 10.1520/A0027_A0027M-13.

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

requirements of Specification **A957/A957M** constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification **A957/A957M**, Specification **A957/A957M** shall prevail.

4. Ordering Information

- 4.1 Orders for material under this specification should include the following information in proper sequence.
- 4.1.1 Quantity,
 - 4.1.2 Specification, grade (1.2), and class (9.2),
 - 4.1.3 Description of the casting by pattern number or drawing,
 - 4.1.4 Options in the specification, and
 - 4.1.5 Supplementary requirements desired, including standards of acceptance.

5. Heat Treatment

5.1 All castings of Grades N-2, 60-30 [415-205], 65-35 [450-240], 70-36 [485-250], and 70-40 [485-275] shall be heat-treated by full annealing, normalizing, normalizing and tempering, or quenching and tempering. Unless otherwise specified in the inquiry, contract, or order, the castings may be heat-treated by any one or combination of these heat-treatments at the option of the manufacturer.

5.1.1 Heat-treatment shall be performed after castings have been allowed to cool from the pouring temperature to below the transformation range.

5.2 Furnace temperatures for heat-treating shall be regulated by the use of pyrometers.

6. Chemical Composition

6.1 The steel shall conform to the requirements as to chemical composition prescribed in **Table 1**. Product analysis tolerances shall conform to the Product Analysis Tolerances shown in Specification **A781/A781M** or Specification **A957/A957M**. When residual element chemical content is of interest to the purchaser, S54 may be considered.

7. Tensile Properties

7.1 Except for Grades N-1 and N-2, one tension test shall be performed on each heat and the mechanical properties thus determined shall conform to the requirements specified in **Table 2**. The tension test shall be performed in accordance with Test Methods and Definitions **A370**.

7.2 Test bars shall be poured in special blocks similar to those shown in Fig. 1 of Specification **A781/A781M/A1067/A1067M** and from the same heat as the casting represented.

7.3 Test coupons may be cut from the heat-treated (if required) castings or cast integrally with the castings at the producer's option.

7.4 The test bars for heat-treated castings shall be heat-treated in production furnaces to the same procedure as the castings they represent. When specified by the purchaser, the test bars shall be heat-treated with the castings.

7.5 Test specimens shall be machined to the form and dimensions shown in Fig. 4 of Test Methods and Definitions **A370**, with the ends machined to fit the grips on the tensile testing machine to be used. Suggested types of ends for standard round tension test specimens are shown in Fig. 5 of Test Methods and Definitions **A370**.

7.6 If any specimen is machined improperly or if flaws are revealed by machining or during testing, the specimen may be discarded and another substituted from the same heat.

7.7 When this specification is applied to investment castings, test coupons and tension test specimens shall be obtained and prepared as directed in S3.2 of Specification **A732/A732M**. Test coupons shall be heat treated as prescribed in 7.4.

TABLE 1 Chemical Requirements

Grade (UNS No.) ^A	Composition, %				
	Carbon, ^B max	Manganese, ^B max	Silicon, max	Sulfur, max	Phosphorus, max
Grade N-1 (J02500)	0.25	0.75	0.80	0.035	0.035
Grade N-2 (J03500)	0.35	0.60	0.80	0.035	0.035
Grade U-60-30 [415-205] (J02500)	0.25	0.75	0.80	0.035	0.035
Grade 60-30 [415-205] (J03000)	0.30	0.60	0.80	0.035	0.035
Grade 65-35 [450-240] (J03001)	0.30	0.70	0.80	0.035	0.035
Grade 70-36 [485-250] (J03501)	0.35	0.70	0.80	0.035	0.035
Grade 70-40 [485-275] (J02501)	0.25	1.20	0.80	0.035	0.035

^A Specify Class 1 or Class 2 in addition to grade designation (see 9.2).

^B For each reduction of 0.01 % carbon below the maximum specified, an increase of 0.04 % manganese above the maximum specified will be permitted to a maximum of 1.40 % for Grade 70-40 [485-275] and 1.00 % for the other grades.