



Designation: A488/A488M – 17

# Standard Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel<sup>1</sup>

This standard is issued under the fixed designation A488/A488M; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

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

## 1. Scope\*

1.1 This practice covers the qualification of procedures, welders, and operators for the fabrication and repair of steel castings by electric arc welding.

1.1.1 Qualifications of a procedure and either or both the operator or welder under Section IX of the ASME Boiler and Pressure Vessel Code shall automatically qualify the procedure and either or both the operator or welder under this practice. P-number designations in the ASME grouping of base metals for qualification may be different than the category numbers listed in [Table 1](#). Refer to [Appendix X1](#) for a comparison of ASTM category numbers with the corresponding ASME P-Number designations.

1.2 Each manufacturer or contractor is responsible for the welding done by his organization and shall conduct the tests required to qualify his welding procedures, welders, and operators.

1.3 Each manufacturer or contractor shall maintain a record of welding procedure qualification tests ([Fig. 1](#)), welder or operator performance qualification tests ([Fig. 2](#)), and welding procedure specification ([Fig. 3](#)), which shall be made available to the purchaser's representative on request.

1.4 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 nonconformance with the standard.

1.4.1 *SI Units*—Within the text, the SI units are shown in brackets.

1.5 *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 appro-*

*priate safety and health practices and determine the applicability of regulatory limitations prior to use.*

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>2</sup>

- [A27/A27M Specification for Steel Castings, Carbon, for General Application](#)
- [A128/A128M Specification for Steel Castings, Austenitic Manganese](#)
- [A148/A148M Specification for Steel Castings, High Strength, for Structural Purposes](#)
- [A216/A216M Specification for Steel Castings, Carbon, Suitable for Fusion Welding, for High-Temperature Service](#)
- [A217/A217M Specification for Steel Castings, Martensitic Stainless and Alloy, for Pressure-Containing Parts, Suitable for High-Temperature Service](#)
- [A297/A297M Specification for Steel Castings, Iron-Chromium and Iron-Chromium-Nickel, Heat Resistant, for General Application](#)
- [A351/A351M Specification for Castings, Austenitic, for Pressure-Containing Parts](#)
- [A352/A352M Specification for Steel Castings, Ferritic and Martensitic, for Pressure-Containing Parts, Suitable for Low-Temperature Service](#)
- [A356/A356M Specification for Steel Castings, Carbon, Low Alloy, and Stainless Steel, Heavy-Walled for Steam Turbines](#)
- [A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)

<sup>1</sup> This practice 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 May 1, 2017. Published May 2017. Originally approved in 1963. Last previous edition approved in 2016 as A488/A488M – 16. DOI: 10.1520/A0488\_A0488M-17.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto: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 Categories of Base Materials**

Category Number	Material Description	ASTM Specification	Grades
1	Carbon steel (carbon less than 0.35 %, tensile strength less than or equal to 70 ksi [485 MPa])	A27/A27M	all grades
		A216/A216M	WCA, WCB
		A352/A352M	LCB, LCA
		A356/A356M	1
		A732/A732M	1A, 2A
		A757/A757M	A1Q
2	Carbon steel (tensile strength greater than 70 ksi [485 MPa]). Carbon-manganese steel (tensile strength equal to or greater than 70 ksi [485 MPa]) but less than 90 ksi [620 MPa]).	A958/A958M	SC 1020, SC 1025, SC 1030, CLASSES 65/35, 70/36
		A148/A148M	80-40
		A216/A216M	WCC
		A352/A352M	LCC
		A732/A732M	2Q, 3A
		A757/A757M	A2Q
3	Carbon and carbon-manganese steel (tensile strength equal to or greater than 90 ksi [620 MPa]).	A958/A958M	SC 1030, SC 1040, SC 1045, CLASSES 80/40, 80/50
		A732/A732M	3Q, 4A, 4Q, 5N
4	Low-alloy steel (annealed, normalized, or normalized and tempered. Tensile strength less than 85 ksi [585 MPa]).	A958/A958M	SC 1045, CLASSES 90/60, 105/85, 115/95
		A148/A148M	80-50
		A217/A217M	WC1, WC4, WC5, WC6, WC9
		A352/A352M	LC1, LC2, LC3, LC4
		A356/A356M	2, 5, 6, 8
		A389/A389M	C23, C24
5	Low-alloy steel (annealed, normalized, or normalized and tempered. Tensile strength equal to or greater than 85 ksi [585 MPa]).	A487/A487M	11A, 12A, 16A
		A757/A757M	B2N, B3N, B4N
		A958/A958M	SC 4130, SC 4140, SC 8620, SC 8625, SC 8630, CLASSES 65/35, 70/36, 80/40, 80/50
		A148/A148M	90-60, 105-85
		A217/A217M	C5, C12, C12A, WC11
		A356/A356M	9, 10, 12
6	Low-alloy steel (quenched and tempered)	A487/A487M	1A, 1C, 2A, 2C, 4A, 4C, 6A, 8A, 9A, 9C, 10A, 13A
		A732/A732M	6N, 15A
		A757/A757M	D1N1, D1N2, D1N3, E2N1, E2N2, E2N3
		A958/A958M	SC 4340, CLASSES 90/60, 105/85
		A148/A148M	90-60, 105-85, 115-95, 130-115, 135-125, 150-135, 160-145, 165-150, 165-150L, 210-180, 210-180L, 260-210, 260-210L
		A352/A352M	LC2-1, LC1, LC2, LC3, LC4, LC9
7	Ferritic stainless steel	A487/A487M	1B, 1C, 2B, 2C, 4B, 4C, 4D, 4E, 6B, 7A, 8B, 8C, 9A, 9B, 9C, 9D, 9E, 10B, 11B, 12B, 13B, 14A
		A732/A732M	7Q, 8Q, 9Q, 10Q, 11Q, 12Q, 13Q, 14Q
		A757/A757M	B2Q, B3Q, B4Q, C1Q, D1Q1, D1Q2, D1Q3, E1Q, E2Q1, E2Q2, E2Q3
		A958/A958M	SC 4140, SC 4130, SC 4340, SC 8620, SC 8625, SC 8630, CLASSES 115/95, 130/115, 135/125, 150/135, 160/145, 165/150, 210/180
		A743/A743M	CB-30, CC-50
		A217/A217M	CA-15
8	Martensitic stainless steel	A352/A352M	CA6NM
		A356/A356M	CA6NM
		A487/A487M	CA15-A, CA15-B, CA15-C, CA15-D, CA15M-A, CA6NM-A, CA6NM-B
		A487/A487M	CA6NM-A, CA6NM-B

**TABLE 1** *Continued*

Category Number	Material Description	ASTM Specification	Grades
9	Low-carbon austenitic stainless steel (carbon equal to or less than 0.03 %)	A743/A743M A757/A757M	CA-15, CA-15M, CA6NM, CA-40, CA6N, CB6 E3N
		A351/A351M	CF-3, CF-3A, CF-3M, CF-3MA, CF-3MN, CK-3MCUN, CG3M, CN3MN
		A743/A743M	CF-3, CF-3M, CF-3MN, CK-3MCUN, CN-3M, CG3M, CN3MN
		A744/A744M	CF-3, CF-3M, CK-3MCUN, CG3M, CN3MN
10	Unstabilized austenitic stainless steel (carbon greater than 0.03 %)	A351/A351M	CF-8, CF-8A, CF-8M, CF-10, CF-10M, CG-8M, CH-8, CH-10, CH-20, CG6MMN, CF10SMNN, CE20N
		A447/A447M A743/A743M	Type I CF-8, CG-12, CF-20, CF-8M, CF-16F, CF10SMNN, CH-20, CG-8M, CE-30, CG6MMN, CH10, CF16Fa
		A744/A744M	CF-8, CF-8M, CG-8M
		A297/A297M A351/A351M	HG10MNM CF-8C, CF-10MC, CK-20, HK-30, HK-40, HT-30, CN-7M, CT-15C
11	Stabilized austenitic stainless steel	A447/A447M A743/A743M A744/A744M	Type II CF-8C, CN-7M, CN-7MS, CK-20 CF-8C, CN-7M, CN-7MS
		A872/A872M	J93183, J93550
		A890/A890M A995/A995M	1A, 1B, 2A, 3A, 4A, 5A, 6A 1B, 2A, 3A, 4A, 5A, 6A
12	Duplex (austenitic-ferritic) stainless steel	A872/A872M	J93183, J93550
13	Precipitation-hardened austenitic stainless steel	A747/A747M	CB7CU-1, CB7CU-2
14	Nickel-base alloys	A494/A494M	CW-12MW, CY-40 Class 1, CY-40 Class 2, CZ-100, M-35-1, M-35-2, M-30C, N-12MV, N-7M, CW-6M, CW-2M, CW-6MC, CX-2MW, CU5MCUC CW2M
15	Steel Castings, Austenitic Manganese	A990/A990M A128/A128M	A, B-1, B-2, B-3, B-4, C, D, E-1, E-2, F

**A389/A389M** Specification for Steel Castings, Alloy, Specially Heat-Treated, for Pressure-Containing Parts, Suitable for High-Temperature Service

**A447/A447M** Specification for Steel Castings, Chromium-Nickel-Iron Alloy (25-12 Class), for High-Temperature Service

**A487/A487M** Specification for Steel Castings Suitable for Pressure Service

**A494/A494M** Specification for Castings, Nickel and Nickel Alloy

**A732/A732M** Specification for Castings, Investment, Carbon and Low Alloy Steel for General Application, and Cobalt Alloy for High Strength at Elevated Temperatures

**A743/A743M** Specification for Castings, Iron-Chromium, Iron-Chromium-Nickel, Corrosion Resistant, for General Application

**A744/A744M** Specification for Castings, Iron-Chromium-Nickel, Corrosion Resistant, for Severe Service

**A747/A747M** Specification for Steel Castings, Stainless, Precipitation Hardening

**A757/A757M** Specification for Steel Castings, Ferritic and Martensitic, for Pressure-Containing and Other Applications, for Low-Temperature Service

**A872/A872M** Specification for Centrifugally Cast Ferritic/Austenitic Stainless Steel Pipe for Corrosive Environments

**A890/A890M** Specification for Castings, Iron-Chromium-Nickel-Molybdenum Corrosion-Resistant, Duplex (Austenitic/Ferritic) for General Application

**A958/A958M** Specification for Steel Castings, Carbon and Alloy, with Tensile Requirements, Chemical Requirements Similar to Standard Wrought Grades

**A990/A990M** Specification for Castings, Iron-Nickel-Chromium and Nickel Alloys, Specially Controlled for Pressure Retaining Parts for Corrosive Service

**A995/A995M** Specification for Castings, Austenitic-Ferritic



RECOMMENDED FORM FOR MANUFACTURER'S RECORD OF WELDING PROCEDURE QUALIFICATION TESTS

Procedure No. \_\_\_\_\_ Date: \_\_\_\_\_ Welding Process: \_\_\_\_\_  
 Material Specification: \_\_\_\_\_ to \_\_\_\_\_ of category No. \_\_\_\_\_ to category No. \_\_\_\_\_  
 Plate Thickness: \_\_\_\_\_ Thickness Range Qualified \_\_\_\_\_  
 Filler Metal F Group No. \_\_\_\_\_ Weld Deposit A-Group No.: \_\_\_\_\_  
 Flux Designation: \_\_\_\_\_ Gas Composition: \_\_\_\_\_  
 Gas Flow Rate: \_\_\_\_\_ Backing Strip, if any: \_\_\_\_\_  
 Preheat Temperature Range: \_\_\_\_\_ Single or Multiple Pass: \_\_\_\_\_  
 Position of Groove: \_\_\_\_\_ Filler Wire Diameter: \_\_\_\_\_  
 Trade Name: \_\_\_\_\_ Type of Backing: \_\_\_\_\_  
 Forehand or Backhand: \_\_\_\_\_ Amps: \_\_\_\_\_ Volts \_\_\_\_\_ Inches/min: \_\_\_\_\_  
 Postheat Temperature \_\_\_\_\_ Time at Temperature \_\_\_\_\_

TENSION TEST RESULTS

Specimen No.	Width	Dimensions Thickness	Area	Ultimate Total Load, lb	Ultimate Unit Stress, psi	Nature of Failure and Location

GUIDED BEND TEST RESULTS

Specimen No.	Results	Specimen No.	Results

Welder's Name: \_\_\_\_\_ Clock No. \_\_\_\_\_ Stamp. No. \_\_\_\_\_

Who by virtue of these tests meets the welder performance qualification.

Test Conducted By: \_\_\_\_\_ Test No. \_\_\_\_\_

per \_\_\_\_\_

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of ASTM Standard \_\_\_\_\_

Signed: \_\_\_\_\_

Manufacturer or Contractor

Date: \_\_\_\_\_

FIG. 1 Report Form 1

ASTM A488/A488M-17

<https://standards.iteh.ai/catalog/standards/sist/aa9e36b0-aa31-48e7-8313-72f8d2700e3a/astm-a488-a488m-17>



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## RECOMMENDED FORM FOR MANUFACTURER'S OR CONTRACTOR'S RECORD OF WELDER OR OPERATOR PERFORMANCE QUALIFICATION TESTS

Welder or Opeator's Name: Stamp No. \_\_\_\_\_  
 Clock No. \_\_\_\_\_ Welding Process: \_\_\_\_\_  
 Position: \_\_\_\_\_  
 In accordance with Procedure No. \_\_\_\_\_  
 Material Specification: \_\_\_\_\_ to \_\_\_\_\_ of category No. \_\_\_\_\_ to category No. \_\_\_\_\_  
 Plate Thickness: \_\_\_\_\_ Range of Thickness Qualified: \_\_\_\_\_  
 Filler Metal Specification No. \_\_\_\_\_ Group No. F. \_\_\_\_\_  
 Filler Metal A-Group No. \_\_\_\_\_ Filler Metal Diameter \_\_\_\_\_  
 Trade Name: \_\_\_\_\_ Flux Designation or Gas Analysis: \_\_\_\_\_  
 Was Backing Strip Used? \_\_\_\_\_

### GUIDED BEND TEST RESULTS

Specimen No.	Results	Specimen No.	Results

Test Conducted By: \_\_\_\_\_ . Laboratory Test No. \_\_\_\_\_  
 per \_\_\_\_\_

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with ASTM Standard \_\_\_\_\_

Signed: \_\_\_\_\_

Manufacturer or Contractor

Date: \_\_\_\_\_

FIG. 2 Report Form 2

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REPORT FORM 3

RECOMMENDED FORM FOR WELDING PROCEDURE SPECIFICATION

1. Title

Welding of <sup>A</sup> steel castings.

<sup>A</sup> Indicate general material description, such as carbon, Cr-Mo, 12 Cr, etc.

2. Specification No. \_\_\_\_\_ Rev. \_\_\_\_\_  
Date \_\_\_\_\_

3. Scope

3.1 Procedure Specification No. \_\_\_\_\_ covers the welding of <sup>A</sup> steel castings using the <sup>B</sup> welding process.

<sup>A</sup> Indicate general material description in the Title.

<sup>B</sup> Indicate specific welding process, such as shielded metal arc, etc.

4. Base Material

4.1 The base material shall conform to the specification for <sup>A</sup> which is found in materials category number <sup>B</sup>.

<sup>A</sup> Insert reference to ASTM designation or indicate chemical analysis and physical properties.

<sup>B</sup> Indicate category number from Table 1.

4.2 Base material shall be in the <sup>A</sup> heat treated condition before welding.

<sup>A</sup> Indicate heat treatment before welding.

5. Filler Metal

5.1 The filler metal shall conform to ANSI/AWS Specification <sup>A</sup> which is found in weld metal analysis group A <sup>B</sup>.

<sup>A</sup> Indicate appropriate American Welding Society specification number and filler metal classification (e.g., A5.1 E7018).

<sup>B</sup> Indicate A Number from Table 4.

5.2 Flux for submerged arc welding shall conform to the following nominal composition: <sup>A</sup>.

<sup>A</sup> Indicate chemical composition or trade designation.

5.3 Shielding gas for gas shielded arc welding shall conform to the following nominal composition: <sup>A</sup>.

<sup>A</sup> Indicate the single gas or proportional parts of mixed gases and flow rates.

6. Preparation of Base Material

6.1 Metal removal shall be performed by <sup>A</sup>.

<sup>A</sup> Indicate method of metal removal, such as chipping, grinding, carbon arc cutting, frame cutting, etc. Also indicate whether preheat is required during metal removal.

6.2 Configuration of the weld preparation for partial penetration welds shall conform to the following geometry: <sup>A</sup>.

<sup>A</sup> Indicate minimum root radius and minimum side wall angle.

6.3 Configuration of the weld preparation for full penetration welds shall conform to the following geometry: <sup>A</sup>.

<sup>A</sup> Indicate minimum side wall angle.

6.4 Backing plates shall be used for welding full penetration welds. Backing plates shall be made from <sup>A</sup> steel and shall fit the back of the cavity with a minimum gap of <sup>B</sup>.

<sup>A</sup> Indicate material of backing plate.

<sup>B</sup> Indicate dimension of maximum gap.

6.5 Surfaces of the weld preparation shall be cleaned of all oil, grease, dirt, scale, slag, shot blasting grit, or any foreign material which may be harmful to the quality of the weld. Surfaces of backing plates when used shall also meet the same cleanliness requirements.

6.6 All surfaces of the weld preparation shall be inspected as follows: <sup>A</sup>.

<sup>A</sup> Indicate type of inspection.

7. Preheat

7.1 Preheat and interpass temperature shall be maintained in the range from <sup>A</sup> to <sup>B</sup> during <sup>C</sup>.

<sup>A</sup> Indicate minimum temperature.

<sup>B</sup> Indicate maximum temperature.

<sup>C</sup> Indicate if preheat maintenance is during welding or until postweld heat treatment is performed.

7.2 Preheat for tack welding of backing plates is the same as required for welding.

7.3 Minimum temperature before applying heat shall be <sup>A</sup>.

<sup>A</sup> Indicate temperature.

7.4 Local preheating to the temperatures indicated may be performed so that the heated area completely surrounds the weld preparation for a minimum distance of <sup>A</sup> in any direction.

<sup>A</sup> Indicate minimum distance for local preheating.

8. Welding Position

8.1 Welds shall be made in the <sup>A</sup> position.

<sup>A</sup> Indicate position or positions in which the welding will be performed. See Fig. 4.

9. Electrical Characteristics

9.1 The current used shall be <sup>A</sup>. The base material shall be attached to the <sup>B</sup> welding electrode lead.

<sup>A</sup> Indicate whether direct or alternating current. If direct, state whether non-pulsed or pulsed. If pulsed, state frequency.

<sup>B</sup> Indicate whether electrode positive (EP) or electrode negative (EN) output terminal of power supply is used.

Electrode

Wire

Diameter<sup>A</sup>

Amperage<sup>A</sup>

Range<sup>A</sup>

Voltage<sup>A</sup>

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

<sup>A</sup> Indicate for each diameter of electrode, the amperage, the range of amperage permitted, and the voltage requirements. For welding processes using wire, indicate wire diameter, wire feed speed, and current requirements.

9.2 Electrodes subject to moisture absorption must be stored and handled to maintain dryness according to the following: <sup>A</sup>.

<sup>A</sup> Where applicable, indicate electrode care instructions.

10. Welding Details

10.1 The width of any pass of welding shall not exceed <sup>A</sup> times the size of the filler metal used.

<sup>A</sup> Indicate the number for controlling the maximum width.

10.2 Craters shall be properly filled before each interruption of the arc.

10.3 Slag or flux shall be removed on any bead before depositing the next successive bead.

10.4 Interpass inspection shall be performed according to the following: <sup>A</sup>.

\_\_\_\_\_

<sup>A</sup> Indicate degree of interpass inspection required.

10.5 Peening shall be performed according to the following: <sup>A</sup>.

<sup>A</sup> Indicate the degree of peening required. Indicate any limits on peening first and last layers.

11. Post-Weld Heat Treatment

11.1 Post-weld heat treatment shall consist of the following: <sup>A</sup>.

<sup>A</sup> Indicate the heating and cooking rates, holding temperatures and times.

12. Inspection

12.1 Inspection of the completed weld shall be performed according to the following: <sup>A</sup>.

<sup>A</sup> Indicate degree of inspection.

FIG. 3 Report Form 3