



Designation: **A848 – 01 (Reapproved 2011) A848 – 17**

## Standard Specification for Low-Carbon Magnetic Iron<sup>1</sup>

This standard is issued under the fixed designation A848; 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.

### 1. Scope

1.1 This specification covers the requirements for wrought low-carbon iron typically having a carbon content of 0.015 % or less with the remainder of the analysis-chemical composition being substantially iron.

1.1.1 Two alloy types are covered: Type 1 is a low-phosphorous grade and Type 2 contains a phosphorous addition to improve machinability.

1.2 This specification also covers alloys supplied by a producer or converter in the form and condition suitable for fabrication into parts which will be subsequently heat treated to create the desired magnetic characteristics. It covers alloys supplied in the form of forging billets, hot-rolled products, and cold-finished bar, wire, and strip.

1.3 This specification does not cover iron powders capable of being processed into magnetic components. Please refer to the following ASTM Standards for information regarding powdered metal materials and magnetic components: Specifications [A811](#), [A839](#), and [A904](#).

1.4 This specification does not cover flat-rolled, low-carbon electrical steels. Please refer to Specification [A726](#) for information regarding these materials.

1.5 The values stated in customary (cgs-emu and inch-pound) SI units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI-customary (cgs-emu and inch-pound) units which 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.

1.7 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>

[A34/A34M Practice for Sampling and Procurement Testing of Magnetic Materials](#)

[A340 Terminology of Symbols and Definitions Relating to Magnetic Testing](#)

[A341/A341M Test Method for Direct Current Magnetic Properties of Soft Magnetic Materials Using D-C Permeameters and the Point by Point \(Ballistic\) Test Methods](#)

[A596/A596M Test Method for Direct-Current Magnetic Properties of Materials Using the Ballistic Method and Ring Specimens](#)

[A726 Specification for Cold-Rolled Magnetic Lamination Quality Steel, Semiprocessed Types](#)

[A773/A773M Test Method for Direct Current Magnetic Properties of Low Coercivity Magnetic Materials Using Hysteresis-graphs](#)

[A811 Specification for Soft Magnetic Iron Parts Fabricated by Powder Metallurgy Techniques](#)

[A839 Specification for Iron-Phosphorus Powder Metallurgy Parts for Soft Magnetic Applications](#)

[A904 Specification for 50 Nickel-50 Iron Powder Metallurgy Soft Magnetic Parts](#)

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee [A06](#) on Magnetic Properties and is the direct responsibility of Subcommittee [A06.02](#) on Material Specifications.

Current edition approved ~~May 1, 2011~~ April 1, 2017. Published ~~May 2011~~ May 2017. Originally approved in 1985. Last previous edition approved in ~~2006~~ 2011 as A848 – 01 (2011). (2006)–DOI: ~~10.1520/A0848-01RH-10.1520/A0848-17.~~

<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.

2.2 *Other:*

IEC Publication 60404-7 Ed. 1 [Magnetic Materials – Part 7: Method of Measurement of the Coercivity of Magnetic Materials in an Open Magnetic Circuit](#)<sup>3</sup>

### 3. Terminology

3.1 The terms and symbols used in this specification, unless otherwise noted, are defined in Terminology [A340](#).

### 4. Ordering Information

4.1 Orders to this specification shall include as much of the following information as is required to describe the desired material:

4.1.1 ASTM specification number and alloy type.

4.1.2 *Dimensions and Tolerances*—~~The~~Dimensional tolerances are to be mutually agreed upon between the user and the producer.

4.1.3 Quantity (weight or number of pieces).

4.1.4 Form and condition.

4.1.5 Magnetic property requirements if they are other than stated herein.

4.1.6 Certification of chemical analysis or magnetic property evaluation, or both.

4.1.7 Marking and packaging.

4.1.8 *End Use*—Whenever possible, the user should specify whether the product will be machined, blanked into flat pieces, blanked and formed, or deep drawn to shape. This information will help the producer provide the most suitable product for the user’s fabrication practice.

4.1.9 Exceptions to this specification or special requirements.

### 5. Chemical Composition

5.1 Alloys supplied to this specification shall conform to the alloy percentage requirements in [Table 1](#). ~~Three of the elements listed in Vanadium, Table 1, namely vanadium, titanium, and aluminum, aluminum~~ are not required but may be added to suppress magnetic aging. ~~If aging; if present, they must~~shall be analyzed and ~~reported~~reported and shall meet the requirements in [Table 1](#).

### 6. Form and Condition

6.1 ~~These~~The two alloys-alloy types are capable of being produced in a wide variety of forms and conditions for fabrication into magnetic components. The desired form and condition shall be discussed with the producer to assure receiving the correct product. Available forms and conditions are:

6.1.1 *Forging Billet*—Hot worked and surface conditioned by grinding.

6.1.2 *Hot-Rolled Product*—Hot rolled; hot rolled and acid cleaned; hot rolled and annealed; hot rolled, annealed, and acid cleaned; hot rolled and mechanically cleaned; mechanical properties as specified.

6.1.3 *Cold-Finished Bars*—Cold drawn, centerless ground, mechanical properties as specified; or relay condition.

6.1.3.1 ~~Relay condition~~ applies to 1 in. (25.4 mm) round and Relay condition applies to round bars of 25.4 mm (1.00 in.) or less in diameter and ~~certain other special~~ shapes supplied in the cold-worked condition having up to 25 % reduction in area and capable of meeting Class 2 magnetic property requirements as defined in [6:57.5](#).

6.1.4 *Strip*—Cold rolled, cold rolled and annealed, deep draw quality, mechanical properties as specified; or relay condition.

6.1.4.1 ~~Relay condition~~ Relay condition applies to cold-rolled strip 0.020 to 0.200 in. (0.51 to 5.1 mm) ~~0.51 to 5.1 mm (0.020 to 0.20 in.)~~ thick having up to 25 % reduction in thickness and capable of meeting Class 2 magnetic property requirements as defined in [6:57.5](#) and [Table 2](#).

<sup>3</sup> Available from American National Standards Institute, 25 W. 43rd St., 4th Floor, New York, NY 10036. International Electrotechnical Commission (IEC), 3, rue de Varembe, 1st Floor, P.O. Box 131, CH-1211, Geneva 20, Switzerland, <http://www.iec.ch>.

**TABLE 1 Chemical Composition Requirements (Weight Percent)**

	Alloy Type 1	Alloy Type 2
Carbon, max	0.020	0.020
Manganese, max	0.35	0.35
Silicon, max	0.15	0.15
Phosphorous	0.030 max	0.10/0.18
Phosphorous	0.030 max	0.10 to 0.18
Sulfur, max	0.025	0.025
Chromium, max	0.20	0.20
Nickel, max	0.15	0.15
Vanadium, max	0.10	0.10
Titanium, max	0.10	0.10
Aluminum, max	0.10	0.10
Iron	balance	balance

**TABLE 2 Direct Current Coercive Field Strength Requirements**

Class 1	0.75 Oe (60 A/m)
Class 2 (Relay Condition)	1.0 Oe (80 A/m)
Class 3	1.5 Oe (120 A/m)

**TABLE 2 Maximum Direct Current Coercive Field Strength,  $H_{cB}$**

Class 1	60 A/m (0.75 Oe)
Class 2 (Relay Condition)	80 A/m (1.0 Oe)
Class 3	120 A/m (1.5 Oe)

6.1.4.2 Ordering information for strip must include edge condition and mechanical property requirements.

6.1.5 Wire—Cold drawn, annealed, mechanical properties as specified or relay condition.

6.1.5.1 *Relay condition* applies to cold-drawn wire when capable of being supplied having up to 25 % reduction in area and capable of meeting Class 2 magnetic property requirements as defined in [6.57.5](#) and [Table 2](#).

## 7. Magnetic Property Requirements

7.1 *Density*—The density for test purposes is 7.86 g/cm<sup>3</sup> (7860 kg/m<sup>3</sup>).

7.2 *Test Specimen*—~~Whenever possible, The~~ test specimen size and shape shall conform to Practice [A34/A34M](#). Shapes such as ring laminations, solid rings, Epstein specimens, or straight lengths having a uniform cross section are preferred. If, however, it is impossible to prepare a preferred test specimen shape from the as-manufactured product, specimen shape and size shall be mutually agreed upon by the user and the producer.

7.3 *Heat Treatment*—It is recommended that the user specify the desired heat treatment method to be applied to the test specimens.

7.3.1 When ~~relay condition~~ “*relay condition*” is specified, the test specimen shall be heat treated in a dry forming gas atmosphere (5 to 15 % hydrogen in nitrogen with a dew point less than ~~−40°C~~ −40°C (−40°F)) at a temperature of 845°C (1550°F) for ~~1 hour~~ at temperature and cooled at a rate from 55 to 100°C/h to 500°C/100°C per hour (99 to 180°F per hour) to 500°C (930°F) and cooled at any rate thereafter.

7.3.2 If ~~relay condition~~ “*relay condition*” is not specified and no heat-treating procedure is specified by the user, the producer is free to choose a heat treatment procedure. Refer to [Appendix X3](#) for heat treatment recommendations.

7.4 *Test Method*—Magnetic testing shall be conducted in accordance with Test Methods [A341/A341M](#), [A596/A596M](#), or [A773/A773M](#), or by use of a ~~coercimeter~~ coercimeter as described in [7.5.1](#). Under this specification only the coercive field strength ( $H_{cB}$ ) must be measured.

7.5 *Requirements*—~~The coercive field strength (Coercive field strength,  $H_{cB}$ ) measured from a maximum shall be measured at a magnetic flux density of 15 kG (1.5 T) 1.5 T (15 kG) or higher and must meet not exceed the required maximum values listed in [Table 2](#) when the test specimen is heat treated in accordance with [6.3.1](#) and [7.3.1](#).~~

7.5.1 When a coercimeter is used, the supplier must be able to demonstrate that the flux density in the test specimen reaches at least ~~15 kG (1.5 T) 1.5 T (15 kG)~~ during the magnetization cycle. In addition, the test equipment and method ~~should~~ shall conform to those specified in IEC Publication 60404-7.

## 8. Packaging and Marking

8.1 Packaging shall be subject to agreement between the producer and the user.

8.2 Material furnished under this specification shall be identified by the name or symbol of the producer, by alloy type, melt number, and material size. Each lot ~~applied~~ supplied on a given order must be identified and packaged separately.

## ~~8. Investigation of Claim~~

~~8.1 Where any order fails to meet the requirements of this specification, disposition of the material so designated shall be subject to agreement between the user and the producer.~~

## 9. Rejection and Rehearing

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

9.2 The disposition of rejected parts shall be subject to agreement between the producer and user.

## 10. Keywords

10.1 coercive field strength; magnetic iron; relay steel

APPENDIXES

(Nonmandatory Information)

X1. TYPICAL MAGNETIC PROPERTIES

X1.1 Typical magnetic properties of these alloys are shown in Fig. X1.1, Fig. X1.2, and Fig. X1.3, and are listed in Table X1.1. There is no statistically significant difference in magnetic properties between Type 1 and Type 2 alloys for a given product size, condition, and heat treatment. The data provided are for information only and are not requirements in this specification. Fig. X1.1, Fig. X1.2, and Fig. X1.3 include supplemental x-axes showing magnetic field strength in oersteds, Oe, to maintain informational references to these charts in prior versions of this specification.

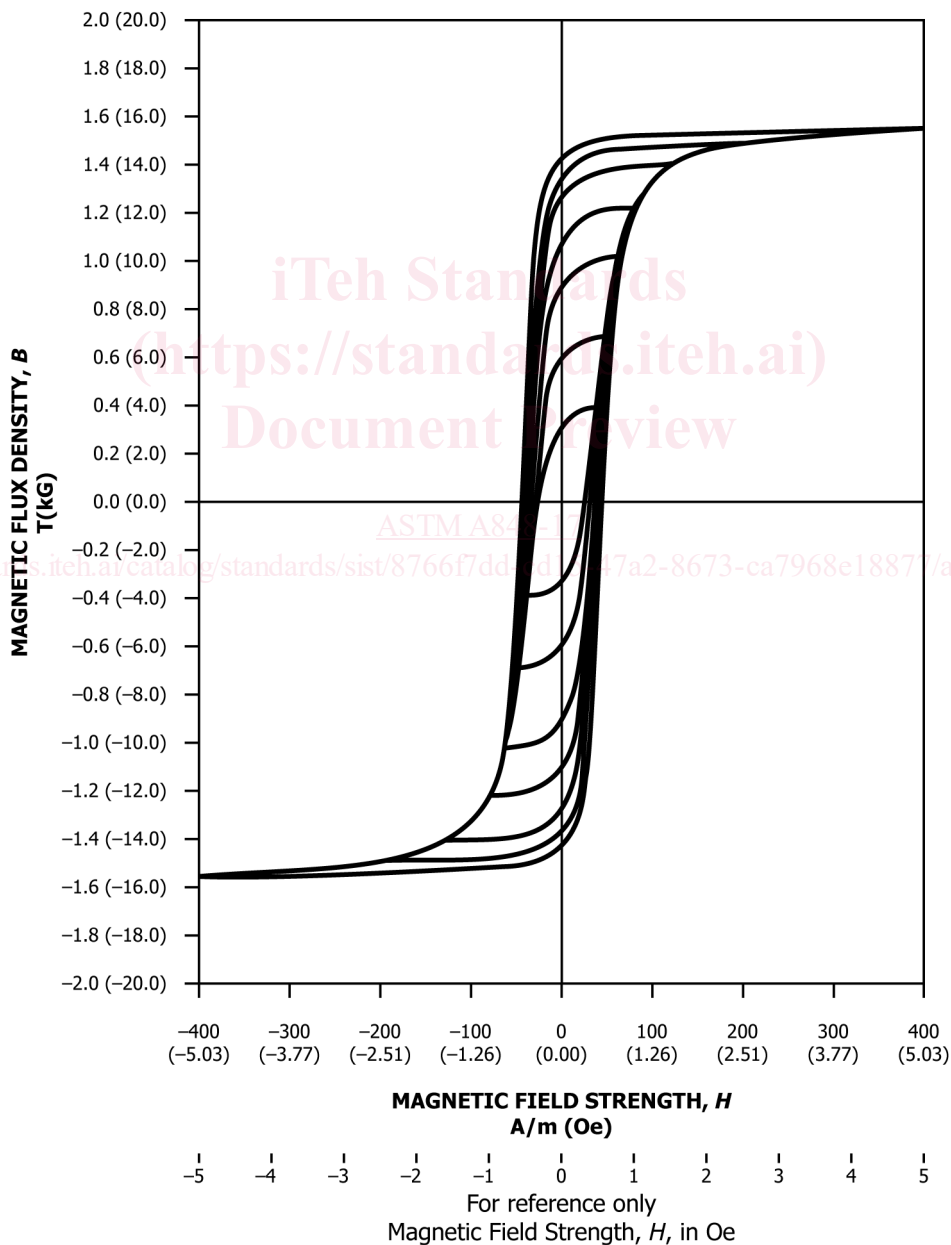


FIG. X1.1 Direct Current Hysteresis Loops for Specimen of Low-Carbon Magnetic Iron Exhibiting Class 1 Behavior. Coercive Field Strength,  $H_{CB}$  is 0.534 Oe (42.5 A/m) 42.5 A/m (0.534 Oe)