



Designation: **A485 – 14 A485 – 17**

Standard Specification for High Hardenability Antifriction Bearing Steel¹

This standard is issued under the fixed designation A485; 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 U.S. Department of Defense.

1. Scope*

1.1 This specification covers high hardenability modifications of high-carbon bearing quality steel to be used in the manufacture of antifriction bearings.

1.2 Supplementary requirements of an optional nature are provided and when desired shall be so stated in the order.

1.3 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.

1.4 *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:²

A29/A29M Specification for General Requirements for Steel Bars, Carbon and Alloy, Hot-Wrought

A255 Test Methods for Determining Hardenability of Steel

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

E45 Test Methods for Determining the Inclusion Content of Steel

E381 Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings

E1019 Test Methods for Determination of Carbon, Sulfur, Nitrogen, and Oxygen in Steel, Iron, Nickel, and Cobalt Alloys by Various Combustion and Fusion Techniques

E1077 Test Methods for Estimating the Depth of Decarburization of Steel Specimens

2.2 Other Standards:

SAE J148a Grain Size Determination of Steel³

ISO 683 Part 17: Ball and Roller Bearing Steels⁴

3. Ordering Information

3.1 Orders for material under this specification should include the following information:

3.1.1 Quantity (weight or number of pieces),

3.1.2 Grade identification,

3.1.3 ASTM designation and year of issue,

3.1.4 Dimensions,

3.1.5 Supplementary requirements, if included.

4. Process

4.1 The steel shall be made by a process that is capable of providing a high quality product meeting the requirements of this specification.

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 A01.28 on Bearing Steels.

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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.

³ Available from SAE International (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, 15096, <http://www.sae.org>.

⁴ Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, CP 56, CH-1211 Geneva 20, ISO Central Secretariat, BIBC II, Chemin de Blandonnet 8, CP 401, 1214 Vernier, Geneva, Switzerland, <http://www.iso.org>.

*A Summary of Changes section appears at the end of this standard

5. Chemical Composition and Analysis

5.1 Typical examples of chemical compositions are shown in Table 1. Other compositions may be specified.

5.2 An analysis of each heat of steel shall be made by the steel manufacturer in accordance with Test Methods, Practices, and Terminology A751. The chemical composition thus determined shall conform to the requirements specified in Table 1 for the ordered grade or to other requirements agreed upon between manufacturer and purchaser.

5.3 Product analysis may be made by the purchaser in accordance with Test Methods, Practices, and Terminology A751. Permissible variations in product analysis shall be in accordance with Specification A29/A29M.

6. Sizes, Shapes, and Dimensional Tolerances

6.1 The physical size and shape of the material shall be agreed upon between manufacturer and purchaser.

6.2 Dimensional tolerances for hot-rolled or hot-rolled and annealed bars, in straight lengths or coils, and cold-finished bars furnished under this specification shall conform to the requirements specified in the latest edition of Specification A29/A29M.

7. Quality Tests

7.1 The supplier shall be held responsible for the quality of the material furnished and shall make the necessary tests to ensure this quality. The supplier shall be required to report on the results of the micro-inclusion rating tests detailed below. Quality tests shown in 7.1 through 7.3 are based upon procedures established in Test Methods E45.

7.2 *Sampling*—Samples taken in accordance with the following paragraphs shall be obtained from 4 by 4 in. (102 by 102 mm) rolled billets or forged sections. Tests may be made on smaller or larger sections by agreement with the purchaser. A minimum of 3 to 1 reduction of rolled billets or forged sections is required for strand cast products.

7.2.1 For top poured products, a minimum of six samples representing the top and bottom of the first, middle and last usable ingots shall be examined.

7.2.2 For bottom poured products, a minimum of six samples shall be taken from semi-finished or finished product representing the top and bottom of three ingots. One ingot shall be taken at random from the first usable plate poured, one ingot at random from the usable plate poured nearest to the middle of the heat, and one ingot at random from the last usable plate poured. When a heat is constituted by two usable plates, two of the sample ingots shall be selected from the second usable plate poured. When a heat consists of a single usable plate, any three random ingots may be selected. Other methods of sampling shall be as agreed upon between manufacturer and purchaser.

TABLE 1 Chemical Composition^{A, B}

Number ^C	Name	C	Mn	P (max)	S (max)	Si	Cr	Ni (max)	Ti (max)	Cu (max)	Mo	O (max) ^D	Al (max)
1	Grade 1	0.90–1.05	0.90–1.20	0.025	0.015	0.45–0.75	0.90–1.20	0.25	0.0050	0.30	0.10 (max)	0.0015	0.050
2	Grade 2	0.85–1.00	1.40–1.70	0.025	0.015	0.50–0.80	1.40–1.80	0.25	0.0050	0.30	0.10 (max)	0.0015	0.050
3	Grade 3	0.95–1.10	0.65–0.90	0.025	0.015	0.15–0.35	1.10–1.50	0.25	0.0050	0.30	0.20–0.30	0.0015	0.050
4	Grade 4	0.95–1.10	1.05–1.35	0.025	0.015	0.15–0.35	1.10–1.50	0.25	0.0050	0.30	0.45–0.60	0.0015	0.050
B2	100CrMnSi4–4	0.93–1.05	0.90–1.20	0.025	0.015	0.45–0.75	0.90–1.20	...	E	0.30	0.10 (max)	0.0015	0.050
B3	100CrMnSi6–4	0.93–1.05	1.00–1.20	0.025	0.015	0.45–0.75	1.40–1.65	...	E	0.30	0.10 (max)	0.0015	0.050
B4	100CrMnSi6–6	0.93–1.05	1.40–1.70	0.025	0.015	0.45–0.75	1.40–1.65	...	E	0.30	0.10 (max)	0.0015	0.050
B5	100CrMo7	0.93–1.05	0.25–0.45	0.025	0.015	0.15–0.35	1.65–1.95	...	E	0.30	0.15–0.30	0.0015	0.050
B6	100CrMo7–3	0.93–1.05	0.60–0.80	0.025	0.015	0.15–0.35	1.65–1.95	...	E	0.30	0.20–0.35	0.0015	0.050
B7	100CrMo7–4	0.93–1.05	0.60–0.80	0.025	0.015	0.15–0.35	1.65–1.95	...	E	0.30	0.40–0.50	0.0015	0.050
B8	100CrMnMoSi8–4–6	0.93–1.05	0.80–1.10	0.025	0.015	0.40–0.60	1.80–2.05	...	E	0.30	0.50–0.60	0.0015	0.050

TABLE 1 Chemical Composition^{A, B}

ISO ^C	Name	C	Mn	P (max)	S (max)	Si	Cr	Ni (max)	Ti (max)	Cu (max)	Mo	O (max) ^D	Al (max)
...	Grade 1	0.90–1.05	0.90–1.20	0.025	0.015	0.45–0.75	0.90–1.20	0.25	0.0050	0.30	0.10 (max)	0.0015	0.050
...	Grade 2	0.85–1.00	1.40–1.70	0.025	0.015	0.50–0.80	1.40–1.80	0.25	0.0050	0.30	0.10 (max)	0.0015	0.050
...	Grade 3	0.95–1.10	0.65–0.90	0.025	0.015	0.15–0.35	1.10–1.50	0.25	0.0050	0.30	0.20–0.30	0.0015	0.050
...	Grade 4	0.95–1.10	1.05–1.35	0.025	0.015	0.15–0.35	1.10–1.50	0.25	0.0050	0.30	0.45–0.60	0.0015	0.050
ISO	100CrMnSi4–4	0.93–1.05	0.90–1.20	0.025	0.015	0.45–0.75	0.90–1.20	...	E	0.30	0.10 (max)	0.0015	0.050
ISO	100CrMnSi6–4	0.93–1.05	1.00–1.20	0.025	0.015	0.45–0.75	1.40–1.65	...	E	0.30	0.10 (max)	0.0015	0.050
ISO	100CrMnSi6–6	0.93–1.05	1.40–1.70	0.025	0.015	0.45–0.75	1.40–1.65	...	E	0.30	0.10 (max)	0.0015	0.050
ISO	100CrMo7	0.93–1.05	0.25–0.45	0.025	0.015	0.15–0.45	1.65–1.95	...	E	0.30	0.15–0.30	0.0015	0.050
ISO	100CrMo7–3	0.93–1.05	0.60–0.80	0.025	0.015	0.15–0.45	1.65–1.95	...	E	0.30	0.20–0.35	0.0015	0.050
ISO	100CrMo7–4	0.93–1.05	0.60–0.80	0.025	0.015	0.15–0.35	1.65–1.95	...	E	0.30	0.40–0.50	0.0015	0.050
ISO	100CrMnMoSi8–4–6	0.93–1.05	0.80–1.10	0.025	0.015	0.40–0.60	1.80–2.05	...	E	0.30	0.50–0.60	0.0015	0.050

^A Elements not quoted shall not be intentionally added to the steel without the agreement of the purchaser.

^B Intentional additions of calcium or calcium alloys for deoxidation or inclusion shape control are not permitted unless specifically approved by the purchaser.

^C Steels B2 through B8 listed as ISO meet the requirements of ISO 683, Part 17, Second/Third Edition, Table 3.

^D Oxygen content applies to product analysis and shall be determined in accordance with Test Methods E1019.

^E A maximum titanium content may be agreed upon at the time of inquiry and order.