



Designation: A515/A515M – 10 (Reapproved 2015) A515/A515M – 17

Standard Specification for Pressure Vessel Plates, Carbon Steel, for Intermediate- and Higher-Temperature Service¹

This standard is issued under the fixed designation A515/A515M; 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 specification² covers carbon-silicon steel plates primarily for intermediate- and higher-temperature service in welded boilers and other pressure vessels.

1.2 Plates under this specification are available in three grades having different strength levels as follows:

Grade U.S. [SI]	Tensile Strength, ksi [MPa]
60 [415]	60–80 [415–550]
65 [450]	65–85 [450–585]
70 [485]	70–90 [485–620]

1.3 The maximum thickness of plates is limited only by the capacity of the composition to meet the specified mechanical property requirements; however, current practice normally limits the maximum thickness of plates furnished under this specification as follows: requirements.

Grade U.S. [SI]	Maximum Thickness, in. [mm]
60 [415]	–8 [200]
65 [450]	–8 [200]
70 [485]	–8 [200]

1.4 For plates produced from coil and furnished without heat treatment or with stress relieving only, the additional requirements, including additional testing requirements and the reporting of additional test results, of Specification A20/A20M apply.

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 the specification.

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:³

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. These requirements outline the testing and retesting methods and procedures, permissible variations in dimensions and mass, quality and repair of defects, marking, loading, and ordering information.

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.

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-515/SA-515M in Section II of that Code.

³ 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 In addition to the basic requirements of this specification, certain supplementary requirements are available where additional control, testing, or examination is required to meet end use requirements. The purchaser is referred to the listed supplementary requirements in this specification and to the detailed requirements in Specification **A20/A20M**.

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

3.4 Coils are excluded from qualification to this specification until they are processed into finished plates. Plates produced from coil means plates that have been cut to individual lengths from coil. The processor directly controls, or is responsible for, the operations involved in the processing of coils into finished plates. Such operations include decoiling, leveling, cutting to length, testing, inspection, conditioning, heat treatment (if applicable), packaging, marking, loading for shipment, and certification.

NOTE 1—For plates produced from coil and furnished without heat treatment or with stress relieving only, three test results are reported for each qualifying coil. Additional requirements regarding plate produced from coil are described in Specification **A20/A20M**.

4. Materials and Manufacture

4.1 *Steelmaking Practice*—The steel shall be killed and made to a coarse austenitic grain size practice.

5. Heat Treatment

5.1 Plates 2 in. [50 mm] and under in thickness are normally supplied in the as-rolled condition. The plates may be ordered normalized or stress relieved, or both.

5.2 Plates over 2 in. [50 mm] in thickness shall be normalized.

6. Chemical Composition

6.1 The steel shall conform to the chemical requirements given in **Table 1** unless otherwise modified in accordance with Supplementary Requirement S17, Vacuum Carbon-Deoxidized Steel, in Specification **A20/A20M**.

7. Mechanical Properties

7.1 *Tension Test*—The plates, as represented by the tension test specimens, shall conform to the requirements given in **Table 2**.

8. Keywords

8.1 carbon steel; carbon steel plate; pressure containing parts; pressure vessel steels; steel plates for pressure vessels

TABLE 1 Chemical Requirements

Elements	Composition, %		
	Grade 60 [Grade 415]	Grade 65 [Grade 450]	Grade 70 [Grade 485]
Carbon, max: ^{A, B}			
1 in. [25 mm] and under	0.24	0.28	0.31
Over 1 to 2 in. [25 to 50 mm], incl	0.27	0.31	0.33
Over 2 to 4 in. [50 to 100 mm], incl	0.29	0.33	0.35
Over 4 to 8 in. [100 to 200 mm], incl	0.31	0.33	0.35
Over 8 in. [200 mm]	0.31	0.33	0.35
Manganese, ^B max:			
Heat analysis	0.90	0.90	1.20
Product analysis	0.98	0.98	1.30
Phosphorus, max ^A	0.025	0.025	0.025
Sulfur, max ^A	0.025	0.025	0.025
Silicon:			
Heat analysis	0.15–0.40	0.15–0.40	0.15–0.40
Product analysis	0.13–0.45	0.13–0.45	0.13–0.45

^A Applies to both heat and product analyses.

^B For each reduction of 0.01 percentage point below the specified maximum for carbon, an increase of 0.06 percentage point above the specified maximum for manganese is permitted, up to a maximum of 1.50 % by heat analysis and 1.60 % by product analysis.