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AMERICAN SOCIETY FOR TESTING AND MATERIALS
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Standard Specification for Ductile Iron Castings for Paper Mill Dryer Rolls^{1,2}

This standard is issued under the fixed designation A 476; 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.

1. Scope

1.1 This specification covers ductile iron castings for use in pressure containing paper mill dryer rolls at temperatures up to 450°F.

1.2 No precise quantitative relationship can be stated between the properties of the iron in various locations of the same casting or between the properties of a casting and those of a test specimen cast from the same iron (see Appendix X1).

1.3 A complete metric companion to Specification A 476 has been developed—A 476M; therefore, no metric equivalents are presented in this specification.

2. Referenced Documents

ASTM Standards:

A 644 Terminology Relating to Iron Castings³

E 8 Test Methods for Tension Testing of Metallic Materials⁴

E 10 Test Method for Brinell Hardness of Metallic Materials⁴

E 94 Guide for Radiographic Testing⁵

E 446 Reference Radiographs for Steel Castings Up to 2 in. (51 mm) in Thickness⁵

3. Terminology

3.1 Definitions for many terms common to iron castings are found in Terminology A 644.

4. Ordering Information

4.1 Orders for material purchased to the requirements of this specification should include the following information:

- 4.1.1 Quantity,
- 4.1.2 Specification number and date of issue,
- 4.1.3 Description of casting by pattern number or drawing,
- 4.1.4 Heat treatment, if required (see 5.1),
- 4.1.5 Type of test coupon (see 8.2),
- 4.1.6 Certification, if required (see 12.1),
- 4.1.7 Marking location (see 13.1), and

¹ This specification is under the jurisdiction of ASTM Committee A-4 on Iron Castings and is the direct responsibility of Subcommittee A04.02 on Malleable and Ductile Iron Castings.

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² For ASME Boiler and Pressure Vessel Code Applications see related Specifications SA-467 in Section II of that Code.

³ *Annual Book of ASTM Standards*, Vol 01.02.

⁴ *Annual Book of ASTM Standards*, Vol 03.01.

⁵ *Annual Book of ASTM Standards*, Vol 03.03.

4.1.8 Additional requirements.

5. Heat Treatment

5.1 The castings may be stress relieved at a temperature not to exceed 1200°F.

6. Mechanical Properties

6.1 The iron represented by test coupons shall conform to tensile requirements prescribed in Table 1.

6.2 The yield strength prescribed in Table 1 may be determined by any of the approved procedures described in 7.3 of Test Methods E 8.

6.3 The Brinell hardness of the material shall be a minimum of 201 HB. Hardness tests shall be conducted in accordance with Test Method E 10, using a 3000-kgf load. The test may be made on either the casting or on a test coupon representing the casting.

7. Workmanship, Finish, and Appearance

7.1 The castings shall conform to the dimensions on the drawings furnished by the purchaser, or if no drawing has been provided, to the dimensions predicated by the pattern supplied by the purchaser. Surfaces of the castings shall be free of adhering sand. Runners, risers, fins, and other extraneous metal shall be removed.

8. Sampling

8.1 Test coupons shall be poured from the same iron as the castings represented.

8.2 Test coupons shall be cast either to the “Y” block size and shape shown in Fig. 1 or to the dimensions of the 1-in. keel block shown in Fig. 2. The type of test coupon and, when selected, the size of the “Y” block shall be specified by the purchaser.

8.3 The test coupons shall be cast in open molds made of suitable core sand with a minimum 1½ in. of sand for the 1-in. size and 3 in. of sand for the 3-in. size. The coupons shall be left in the mold until black.

8.4 Table 2 shows the equivalent geometrical shapes with various dimensions and the equivalent “Y” block, based on cooling rates, and may be used as a guide for selection of the proper “Y” block to be specified to represent the casting.

8.5 When the castings are heat treated, the test coupons shall be heat treated with the castings they represent.

9. Tension Test

9.1 Tension test specimens shall be obtained from test