



Standard Specification for Steel, Sheet and Strip, Heavy-Thickness Coils, Hot-Rolled, Carbon, Commercial, Drawing, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, and Ultra-High Strength¹

This standard is issued under the fixed designation A1018/A1018M; 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 hot-rolled, heavy-thickness coils beyond the size limits of Specification [A1011/A1011M](#).

1.2 The product is available in six designations: Commercial Steel, Drawing Steel, Structural Steel, High-Strength Low-Alloy Steel, High-Strength Low-Alloy Steel with Improved Formability, and Ultra-High Strength Steel.

1.3 This material is available only in coils described as follows:

Product	Size Limits, Coils Only	
	Width, in. [mm]	Thickness, in. [mm]
Strip	Over 8 to 12, incl [Over 200 to 300]	0.230 to 1.000, incl [From 6.0 through 25]
Sheet	Over 12 [Over 300]	0.230 to 1.000, incl [From 6.0 through 25]

NOTE 1—The changes in width limits with the publication of [A635/A635M](#) – 06a result in a change in tensile testing direction for material from 0.180 in. [4.5 mm] to 0.230 in. exclusive [6.0 mm exclusive] over 48 in. [1200 mm] wide as that material is now covered by Specification [A568/A568M](#) – 06a. The purchaser is advised to discuss this change with

the supplier.

1.4 Sheet and strip in coils of sizes noted in 1.3 are covered by this specification only with the following provisions:

1.4.1 The material is to be fed directly from coils into a blanking press, drawing or forming operation, tube mill, rolling mill, or sheared or slit into blanks for subsequent drawing or forming.

1.4.2 The material is not to be converted into steel plates for structural or pressure vessel use unless tested in complete accordance with the appropriate sections of Specifications [A6/A6M](#) (plates provided from coils) or [A20/A20M](#) (plates produced from coils). Plate converted from coils is no longer

governed by this sheet steel specification and since this material is now a plate, the requirements of the appropriate plate specification shall apply, except in cases where there is a conflict between the requirements of the plate specification and this specification. In these cases, the more restrictive limits of either specification shall apply.

1.4.3 The dimensional tolerances of Specification [A635/A635M](#) are applicable to material produced to this specification.

1.4.4 Not all strength levels are available in all thicknesses. The user should consult the producer for appropriate size limitations.

1.5 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 non-conformance with the standard.

2. Referenced Documents

2.1 ASTM Standards:²

- [A6/A6M](#) Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling
- [A20/A20M](#) Specification for General Requirements for Steel Plates for Pressure Vessels
- [A370](#) Test Methods and Definitions for Mechanical Testing of Steel Products
- [A568/A568M](#) Specification for Steel, Sheet, Carbon, Structural, and High-Strength, Low-Alloy, Hot-Rolled and Cold-Rolled, General Requirements for
- [A572/A572M](#) Specification for High-Strength Low-Alloy Columbium-Vanadium Structural Steel
- [A635/A635M](#) Specification for Steel, Sheet and Strip,

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 [A01.19](#) on Steel Sheet and Strip.

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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.

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