



Standard Specification for Alloy-Steel and Stainless Steel Bolting Materials for High-Temperature Service¹

This standard is issued under the fixed designation A 193/A 193M; 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 Department of Defense.

Note—Corrections were made throughout editorially and the year date was changed on May 11, 2004.

1. Scope*

1.1 This specification² covers alloy and stainless steel bolting material for pressure vessels, valves, flanges, and fittings for high-temperature service. The term *bolting material* as used in this specification covers bars, bolts, screws, studs, stud bolts, and wire. Bars and wire shall be hot-wrought. The material may be further processed by centerless grinding or by cold drawing. Austenitic stainless steel may be carbide solution treated or carbide solution treated and strain-hardened. When strain hardened austenitic steel is ordered, the purchaser should take special care to ensure that Appendix X1 is thoroughly understood.

1.2 Several grades are covered, including ferritic steels and austenitic stainless steels designated B5, B8, and so forth. Selection will depend upon design, service conditions, mechanical properties, and high-temperature characteristics.

NOTE 1—The committee formulating this specification has included fifteen steel types that have been rather extensively used for the present purpose. Other compositions will be considered for inclusion by the committee from time to time as the need becomes apparent.

NOTE 2—For grades of alloy-steel bolting material suitable for use at the lower range of high-temperature applications, reference should be made to Specification A 354.

NOTE 3—For grades of alloy-steel bolting material suitable for use in low-temperature applications, reference should be made to Specification A 320/A 320M.

1.3 Nuts for use with this bolting material are covered in Section 13.

1.4 Supplementary Requirements S1 through S10 are provided for use when additional tests or inspection are desired. These shall apply only when specified in the purchase order.

1.5 This specification is expressed in both inch-pound units and in SI units. However, unless the order specifies the

applicable *M* specification designation (SI units), the material shall be furnished to inch-pound units.

1.6 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.

2. Referenced Documents

2.1 ASTM Standards:³

A 194/A 194M Specification for Carbon and Alloy Steel Nuts for Bolts for High-Pressure or High-Temperature Service, or Both

A 320/A 320M Specification for Alloy/Steel Bolting Materials for Low-Temperature Service

A 354 Specification for Quenched and Tempered Alloy Steel Bolts, Studs, and Other Externally Threaded Fasteners

A 962/A 962M Specification for Common Requirements for Steel Fasteners or Fastener Materials, or Both, Intended for Use at Any Temperature from Cryogenic to the Creep Range

E 18 Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials

E 21 Test Methods for Elevated Temperature Tension Tests of Metallic Materials

E 112 Test Methods for Determining Average Grain Size

E 139 Test Methods for Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials

E 150 Practice for Conducting Creep and Creep-Rupture Tension Tests of Metallic Materials Under Conditions of Rapid Heating and Short Times⁴

E 151 Practice for Tension Tests of Metallic Materials at

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 A01.22 on Steel Forgings and Wrought Fittings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications.

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-193 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.

⁴ Withdrawn.

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