



Standard Specification for Steel Castings Suitable for Pressure Service¹

This standard is issued under the fixed designation A 487/A 487M; 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 specification² covers low-alloy steels and martensitic stainless steels in the normalized and tempered, or quenched and tempered, condition suitable for pressure-containing parts. The weldability of the classes in this specification varies from readily weldable to weldable only with adequate precautions, and the weldability of each class should be considered prior to assembly by fusion welding.

1.2 Selection will depend on design, mechanical, and service conditions. Users should note that hardenability of some of the grades mentioned may restrict the maximum size at which the required mechanical properties are obtained.

1.3 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. Inch-pound units are applicable for material ordered to Specification A 487 and SI units for material ordered to Specification A 487M.

2. Referenced Documents

2.1 ASTM Standards:

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products³

A 488/A 488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel⁴

A 703/A 703M Specification for Steel Castings, General Requirements, for Pressure-Containing Parts⁴

E 165 Test Method for Liquid Penetrant Examination⁵

E 709 Guide for Magnetic Particle Examination⁵

2.2 American Society of Mechanical Engineers:

ASME Boiler and Pressure Vessel Code, Section IX⁶

2.3 *Manufacturers Standardization Society of the Valve and Fittings Industry Standards:*⁷

SP-55 Quality Standard for Steel Castings-Visual Method

3. General Conditions for Delivery

3.1 Material furnished to this specification shall conform to the requirements of Specification A 703/A 703M including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A 703/A 703M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A 703/A 703M, this specification shall prevail.

4. Ordering Information

4.1 The inquiry and order should include or indicate the following:

4.1.1 A description of the casting by pattern number or drawing (dimensional tolerances shall be included on the casting drawing),

4.1.2 ASTM designation and year of issue,

4.1.3 Grade and class of steel,

4.1.4 Options in the specification, and

4.1.5 The supplementary requirements desired including the standard of acceptance.

5. Heat Treatment

5.1 All castings shall receive a heat treatment indicated in Table 1. Preliminary heat treatment prior to final heat treatment as well as multiple tempering is permitted.

5.2 Heat treatment shall be performed after the castings have been allowed to cool below the transformation range.

5.3 The furnace temperature for heat treating shall be effectively controlled by use of recording-type pyrometers.

6. Chemical Composition

6.1 The steel shall conform to the requirements as to chemical composition prescribed in Table 2. Product analysis tolerance shall conform to the product analysis tolerance shown in Specification A 703/A 703M. Product analysis tolerances for stainless grades are not presently applicable pending development of these limits.

⁷ Available from Manufacturer's Standardization Society of the Valve and Fittings Industry, 127 Park St., N.E. Vienna, VA 22180.

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.18 on Castings.

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² For ASME Boiler and Pressure Vessel Code applications see related Specifications SA-487 in Section II of that code.

³ *Annual Book of ASTM Standards*, Vol 01.03.

⁴ *Annual Book of ASTM Standards*, Vol 01.02.

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

⁶ Available from American Society of Mechanical Engineers, 345 E. 47th St., New York, NY 10017.