



## Standard Specification for Titanium-Stabilized Carbon Steel Forgings for Glass-Lined Piping and Pressure Vessel Service<sup>1</sup>

This standard is issued under the fixed designation A 836/A 836M; 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 nonstandard as-forged fittings, valve components, and parts for glass-lined piping and pressure vessel service. Mechanical properties are certified on the basis of test material subjected to heat treatments to simulate glass-coating operations.

1.2 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. The inch-pound units shall apply unless the “M” designation of this specification is specified in the order.

### 2. Referenced Documents

#### 2.1 ASTM Standards:

A 788 Specification for Steel Forgings, General Requirements<sup>2</sup>

A 961 Specification for Common Requirements for Steel Flanges, Forged Fittings, Valves, and Parts for Piping Applications<sup>3</sup>

### 3. Ordering Information

3.1 Product furnished to this specification shall conform to the requirements of Specification A 961, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the requirements of Specification A 961 constitutes non-conformance with this specification.

3.2 It is the purchaser's responsibility to specify in the purchase order all ordering information necessary to purchase the needed material. Examples of such information include but are not limited to the ordering information in Specification A 961 and the following:

3.2.1 Supplementary requirements, and

3.2.2 Additional requirements (see 10.1, 12.1, 12.2, and 12.3).

3.3 If the requirements of this specification are in conflict with the requirements of Specification A 961, the requirements of this specification shall prevail.

### 4. Materials and Manufacture

4.1 The material shall be forged by hammering, pressing, rolling, extruding, or upsetting, such that the finished product will be a forging as defined in the Terminology Section of Specification A 788.

4.2 When specified in the order, the manufacturer shall submit for approval by the purchaser a sketch showing the shape of the rough forging before machining.

4.3 Forgings shall be protected against sudden or too rapid cooling from the rolling or forging while passing through the critical range.

4.4 Heat treatment of forgings is neither required nor prohibited. However, the test material for qualifying the forging or the welding procedure shall be heat treated to simulate glass-coating operations.

### 5. Chemical Composition

5.1 An analysis of each heat shall be made by the manufacturer to determine the percentages of the elements specified in Table 1. The chemical composition thus determined shall conform to the requirements in Table 1.

### 6. Mechanical Properties

6.1 The test material shall conform to the requirements as to tensile properties prescribed in Table 2.

### 7. Number of Tests and Retests

7.1 One tension test shall be made from each heat.

7.2 If any test specimen is defectively machined, it may be discarded and another specimen substituted.

### 8. Retests

8.1 When one or more representative test specimens do not conform to specification requirements for the tested characteristic, only a single retest for each nonconforming characteristic may be performed to establish product acceptability. Retests

<sup>1</sup> 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.

Current edition approved May 10, 2002. Published June 2002. Originally published as A 836 – 84. Last previous edition A 836/A 836M – 95b (2001).

<sup>2</sup> Annual Book of ASTM Standards, Vol 01.05.

<sup>3</sup> Annual Book of ASTM Standards, Vol 01.01.

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

