

MATERIAL SPECIFICATION

PRESSURE VESSEL CARBON STEEL PLATES MODERATE & LOWER TEMPERATURE SERVICE

ASTM A516/A516M-17

Carbon steel plate grades for welded pressure-vessel service

GRADES 55, 60, 65 & 70

CHEMICAL COMPOSITION

TENSILE REQUIREMENTS

HEAT TREATMENT

SUPPLEMENTARY TESTS

PRESSURE VESSEL PLATE

ASTM A516/A516M-17

Technical data navigation

Use the index below to open the corresponding technical section.

SECTION	CONTENTS	PAGE
Scope, grades and ordering	Plate application, Grades 55/60/65/70 and referenced requirements	3
Chemical composition	Table 1 limits by grade, thickness and heat or product analysis	4
Tensile requirements	Table 2 tensile, yield and elongation requirements for all grades	4
Manufacture and heat treatment	Steelmaking, normalizing, cooling and mechanical properties	4
Supplementary requirements	Optional examinations, impact tests and hydrofluoric-acid service	5
Summary of changes	2017 revision note affecting thickness guidance	5
Project support	RFQ information and direct contact details	6
REFERENCE NOTE		
Source dimensional values and footnotes are retained. Confirm the applicable material, grade, schedule and project specification before ordering.		

This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.



Designation: A516/A516M – 17

Used in USDOE-NE Standards

Standard Specification for Pressure Vessel Plates, Carbon Steel, for Moderate- and Lower-Temperature Service¹

This standard is issued under the fixed designation A516/A516M; 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 specification² covers carbon steel plates intended primarily for service in welded pressure vessels where improved notch toughness is important.

1.2 Plates under this specification are available in four grades having different strength levels as follows:

Grade U.S. [SI]	Tensile Strength, ksi [MPa]
55 [380]	55–75 [380–515]
60 [415]	60–80 [415–550]
65 [450]	65–85 [450–585]
70 [485]	70–90 [485–620]

1.3 The maximum thickness of plates is limited only by the capacity of the composition to meet the specified mechanical property requirements.

1.4 For plates produced from coil and furnished without heat treatment or with stress relieving only, the additional requirements, including additional testing requirements and the reporting of additional test results of Specification A20/A20M apply.

1.5 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.

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

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 A01.11 on Steel Plates for Boilers and Pressure Vessels.

Current edition approved Nov. 1, 2017. Published November 2017. Originally approved in 1964. Last previous edition approved in 2015 as A516/A516M – 10 (2015). DOI: 10.1520/A0516_A0516M-17.

² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-516/SA-516M in Section II of that Code.

2. Referenced Documents

2.1 *ASTM Standards:*³

- A20/A20M Specification for General Requirements for Steel Plates for Pressure Vessels
- A435/A435M Specification for Straight-Beam Ultrasonic Examination of Steel Plates
- A577/A577M Specification for Ultrasonic Angle-Beam Examination of Steel Plates
- A578/A578M Specification for Straight-Beam Ultrasonic Examination of Rolled Steel Plates for Special Applications

3. General Requirements and Ordering Information

3.1 Material supplied to this product specification shall conform to Specification A20/A20M, which outlines the testing and retesting methods and procedures, permissible variations in dimensions and mass, quality and repair of defects, marking, loading, and ordering information.

3.2 In addition to the basic requirements of this specification, certain supplementary requirements are available where additional control, testing, or examination is required to meet end use requirements. The purchaser is referred to the listed supplementary requirements in this specification and to the detailed requirements in Specification A20/A20M.

3.3 If the requirements of this specification are in conflict with the requirements of Specification A20/A20M, the requirements of this specification shall prevail.

3.4 Coils are excluded from qualification to this specification until they are processed into finished plates. Plates produced from coil means plates that have been cut to individual lengths from coil. The processor directly controls, or is responsible for, the operations involved in the processing of coils into finished plates. Such operations include decoiling, leveling, cutting to length, testing, inspection, conditioning, heat treatment (if applicable), packaging, marking, loading for shipment, and certification.

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.

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

Copyright 2017 by ASTM International, 100 Barr Harbor Drive, West Conshohocken, PA 19380



A516/A516M – 17

TABLE 1 Chemical Requirements

Elements	Composition, %			
	Grade 55 [Grade 380]	Grade 60 [Grade 415]	Grade 65 [Grade 450]	Grade 70 [Grade 485]
Carbon, max: ^{A,B}				
½ in. [12.5 mm] and under	0.18	0.21	0.24	0.27
Over ½ in. to 2 in. [12.5 to 50 mm], incl	0.20	0.23	0.26	0.28
Over 2 in. to 4 in. [50 to 100 mm], incl	0.22	0.25	0.28	0.30
Over 4 to 8 in. [100 to 200 mm], incl	0.24	0.27	0.29	0.31
Over 8 in. [200 mm]	0.26	0.27	0.29	0.31
Manganese: ^B				
½ in. [12.5 mm] and under:				
Heat analysis	0.60–0.90	0.60–0.90 ^C	0.85–1.20	0.85–1.20
Product analysis	0.55–0.98	0.55–0.98 ^C	0.79–1.30	0.79–1.30
Over ½ in. [12.5 mm]:				
Heat analysis	0.60–1.20	0.85–1.20	0.85–1.20	0.85–1.20
Product analysis	0.55–1.30	0.79–1.30	0.79–1.30	0.79–1.30
Phosphorus, max ^A	0.025	0.025	0.025	0.025
Sulfur, max ^A	0.025	0.025	0.025	0.025
Silicon:				
Heat analysis	0.15–0.40	0.15–0.40	0.15–0.40	0.15–0.40
Product analysis	0.13–0.45	0.13–0.45	0.13–0.45	0.13–0.45

^A Applies to both heat and product analyses.

^B For each reduction of 0.01 percentage point below the specified maximum for carbon, an increase of 0.06 percentage point above the specified maximum for manganese is permitted, up to a maximum of 1.50 % by heat analysis and 1.60 % by product analysis.

^C Grade 60 plates ½ in. [12.5 mm] and under in thickness may have 0.85–1.20 % manganese on heat analysis, and 0.79–1.30 % manganese on product analysis.

TABLE 2 Tensile Requirements

	Grade			
	55 [380]	60 [415]	65 [450]	70 [485]
Tensile strength, ksi [MPa]	55–75 [380–515]	60–80 [415–550]	65–85 [450–585]	70–90 [485–620]
Yield strength, min, ^A ksi [MPa]	30 [205]	32 [220]	35 [240]	38 [260]
Elongation in 8 in. [200 mm], min, % ^B	23	21	19	17
Elongation in 2 in. [50 mm], min, % ^B	27	25	23	21

^A Determined by either the 0.2 % offset method or the 0.5 % extension-under-load method.

^B See Specification A20/A20M for elongation adjustment.

NOTE 1—For plates produced from coil and furnished without heat treatment or with stress relieving only, three test results are reported for each qualifying coil. Additional requirements regarding plate produced from coil are described in Specification A20/A20M.

3.5 If the requirements of this specification are in conflict with the requirements of Specification A20/A20M, the requirements of this specification shall prevail.

4. Materials and Manufacture

4.1 *Steelmaking Practice*—The steel shall be killed and shall conform to the fine austenitic grain size requirement of Specification A20/A20M.

5. Heat Treatment

5.1 Plates 1.50 in. [40 mm] and under in thickness are normally supplied in the as-rolled condition. The plates may be ordered normalized or stress relieved, or both.

5.2 Plates over 1.50 in. [40 mm] in thickness shall be normalized.

5.3 When notch-toughness tests are required on plates 1½ in. [40 mm] and under in thickness, the plates shall be normalized unless otherwise specified by the purchaser.

5.4 If approved by the purchaser, cooling rates faster than those obtained by cooling in air are permissible for improvement of the toughness, provided the plates are subsequently tempered in the temperature range 1100 to 1300°F [595 to 705°C].

6. Chemical Composition

6.1 The steel shall conform to the chemical requirements given in Table 1 unless otherwise modified in accordance with Supplementary Requirement S17, Vacuum Carbon-Deoxidized Steel, in Specification A20/A20M.

7. Mechanical Properties

7.1 *Tension Test*—The plates, as represented by the tension test specimens, shall conform to the requirements given in Table 2.

8. Keywords

8.1 carbon steel; carbon steel plate; pressure containing parts; pressure vessel steels; steel plates for pressure vessels



A516/A516M – 17

SUPPLEMENTARY REQUIREMENTS

Supplementary requirements shall not apply unless specified in the purchase order.

A list of standardized supplementary requirements for use at the option of the purchaser is included in ASTM Specification **A20/A20M**. Those that are considered suitable for use with this specification are listed below by title.

- S1. Vacuum Treatment,
- S2. Product Analysis,
- S3. Simulated Post-Weld Heat Treatment of Mechanical Test Coupons,
- S4.1 Additional Tension Test,
- S5. Charpy V-Notch Impact Test,
- S6. Drop Weight Test (for Material 0.625 in. [16 mm] and over in Thickness),
- S7. High-Temperature Tension Test,

- S8. Ultrasonic Examination in accordance with Specification **A435/A435M**,
- S9. Magnetic Particle Examination,
- S11. Ultrasonic Examination in accordance with Specification **A577/A577M**,
- S12. Ultrasonic Examination in accordance with Specification **A578/A578M**, and
- S17. Vacuum Carbon-Deoxidized Steel.

ADDITIONAL SUPPLEMENTARY REQUIREMENTS

In addition, the following supplementary requirement is suitable for this application.

S54. Requirements for Carbon Steel Plate for Hydrofluoric Acid Alkylation Service

S54.1 Plates shall be provided in the normalized heat-treated condition.

S54.2 The maximum carbon equivalent (CE) shall be as follows:

Plate thickness less than or equal to 1 in. [25 mm]:

$$CE_{\text{maximum}} = 0.43$$

Plate thickness greater than 1 in. [25 mm]:

$$CE_{\text{maximum}} = 0.45$$

S54.3 Determine the CE as follows:

$$CE = C + Mn/6 + (Cr + Mo + V)/5 + (Ni + Cu)/15$$

S54.4 Vanadium (V) and niobium (Nb) maximum content based on heat analysis shall be:

$$\text{Maximum vanadium} = 0.02 \%$$

$$\text{Maximum niobium} = 0.02 \%$$

$$\text{Maximum vanadium plus niobium} = 0.03 \%$$

(Note: niobium = columbium.)

S54.5 The maximum composition based on heat analysis of nickel (Ni) plus copper (Cu) shall be 0.15 %.

S54.6 The minimum carbon (C) content based on heat analysis shall be 0.18 %. The maximum C content shall be as specified for the ordered grade.

S54.7 Welding consumables for repair welds shall be of the low-hydrogen type. E60XX electrodes shall not be used and the resulting weld chemistry shall meet the same chemistry requirements as the base metal.

S54.8 In addition to the requirements for product marking in the specification, an “HF-N” stamp or marking shall be provided on each plate to identify that the plate complies with this supplementary requirement.

SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this standard since the last issue (A516/A516M – 10 (2015)) that may impact the use of this standard. (Approved Nov. 1, 2017.)

(1) Revised **1.3** to remove thickness guidelines.

Send your requirement

Send a drawing, product list, size, material grade, standard, schedule or wall thickness, testing and project document requirements.

EMAILinfo@lkiping.com**WHATSAPP**[+86 139 0327 9556](https://wa.me/8613903279556)**TECHNICAL RESOURCES**www.lkiping.com/technical/

RESPONSE AND DOCUMENT COORDINATION

Initial enquiries are answered within 24 hours, including weekends, by email or WhatsApp. Drawing review, material/standard matching and project document requirements can be discussed and organized with the buyer. Third-party inspection can be buyer-nominated or coordinated on request.

ADDRESS

Longtan Industrial Zone, Yanta Road, Yanshan County, Cangzhou City,
Hebei Province, China