



Designation: A473 – 26

Standard Specification for Stainless Steel Forgings¹

This standard is issued under the fixed designation A473; 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 austenitic, austenitic-ferritic, ferritic, and martensitic stainless steel forgings for general use, and for low- or high-temperature service.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 Supplementary requirements from Specification A788/A788M may be specified when additional testing, inspection, or processing is required.

1.4 *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.*

2. Referenced Documents

2.1 ASTM Standards:²

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A751 Test Methods and Practices for Chemical Analysis of Steel Products

A788/A788M Specification for Steel Forgings, General Requirements

A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys

A1058 Test Methods for Mechanical Testing of Steel Products—Metric

E8/E8M Test Methods for Tension Testing of Metallic Materials

E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

2.2 SAE Standard:³

SAE J1086 Numbering Metals and Alloys

3. Terminology

3.1 Definitions:

3.1.1 *Condition A, n*—annealed, which may include full annealing, sub-critical annealing, solution annealing, or solution heat treatment.

3.1.2 *Condition T, n*—hardened and tempered.

3.1.3 *Condition H, n*—hardened and tempered.

3.1.4 *Condition 1, 2, or 3, n*—hardened and tempered.

NOTE 1—Hardened and tempered can result in different mechanical properties subject to the selection of temperatures. Table 2 and Section 7 provide information for the different application requirements.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 For definitions of terms used in this standard that are not included in 3.1, refer to Specification A788/A788M and Terminology A941.

4. Ordering Information

4.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this specification. Such requirements may include, but are not limited to, the following:

4.1.1 Quantity (weight or number of pieces);

4.1.2 Dimensions, including prints or sketches;

4.1.3 Name of material (stainless steel forgings);

4.1.4 Type or UNS designation (Table 1);

4.1.5 Condition (Table 2);

4.1.6 ASTM designation and date of issue;

4.1.7 Test for magnetic permeability, if specified by customer purchase order when ordering Types 207 and 205; and

4.1.8 Special requirements.

4.2 If possible, the intended end use of the item should be given on the purchase order, especially when the item is ordered for a specific end use or uses.

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 A01.06 on Steel Forgings and Billets.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at www.astm.org/contact. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from SAE International (SAE), 400 Commonwealth Dr., Warrendale, PA 15096, <http://www.sae.org>.

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

TABLE 1 Chemical Requirements^A

UNS Designation ^B	Type Number	Carbon, %	Manganese, %	Phosphorus, %	Sulfur, %	Silicon, %	Chromium, %	Nickel, %	Molybdenum, %	Nitrogen, %	Other Elements, %
Austenitic Grades											
S20100	201	0.15	5.5–7.5	0.060	0.030	1.00	16.0–18.0	3.5–5.5	...	0.25	
S20200	202	0.15	7.5–10.0	0.060	0.030	1.00	17.0–19.0	4.0–6.0	...	0.25	
S20500	205	0.12–0.25	14.0–15.5	0.060	0.030	1.00	16.5–18.0	1.00–1.75	...	0.32–0.40	
S21900	XM-10	0.08	8.0–10.0	0.060	0.030	1.00	19.0–21.5	5.5–7.5	...	0.15–0.40	
S21904	XM-11	0.04	8.0–10.0	0.060	0.030	1.00	19.0–21.5	5.5–7.5	...	0.15–0.40	
S28200	...	0.15	17.0–19.0	0.045	0.030	1.00	17.0–19.0	...	0.75–1.25	0.40–0.60	Cu 0.75–1.25
S30200	302	0.15	2.00	0.045	0.030	1.00	17.0–19.0	8.0–10.0	...	0.10	
S30215	302B	0.15	2.00	0.045	0.030	2.00–3.00	17.0–19.0	8.0–10.0	...	...	
S30300	303	0.15	2.00	0.20	0.15 min	1.00	17.0–19.0	8.0–10.0	0.60 ^C	...	
S30323	303 Se	0.15	2.00	0.20	0.06	1.00	17.0–19.0	8.0–10.0	...	...	Se 0.15 min
S30400	304	0.08	2.00	0.045	0.030	1.00	18.0–20.0	8.0–11.0	...	0.10	
S30403	304L	0.030	2.00	0.045	0.030	1.00	18.0–20.0	8.0–12.0	...	0.10	
S30500	305	0.12	2.00	0.045	0.030	1.00	17.0–19.0	10.5–13.0	...	...	
S30800	308	0.08	2.00	0.045	0.030	1.00	19.0–21.0	10.0–12.0	...	...	
S30815	...	0.10	0.80	0.040	0.030	1.40–2.00	20.0–22.0	10.0–12.0	...	0.14–0.20	Ce 0.03–0.08
S30900	309	0.20	2.00	0.045	0.030	1.00	22.0–24.0	12.0–15.0	...	...	
S30908	309S	0.08	2.00	0.045	0.030	1.00	22.0–24.0	12.0–15.0	...	...	
S31000	310	0.25	2.00	0.045	0.030	1.50	24.0–26.0	19.0–22.0	...	...	
S31008	310S	0.08	2.00	0.045	0.030	1.50	24.0–26.0	19.0–22.0	...	...	
S31254	...	0.020	1.00	0.030	0.010	0.80	19.5–20.5	17.5–18.5	6.0–6.5	0.18–0.25	Cu 0.50–1.00
S31400	314	0.25	2.00	0.045	0.030	1.50–3.00	23.0–26.0	19.0–22.0	...	...	
S31600	316	0.08	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0	2.00–3.00	0.10	
S31603	316L	0.030	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0	2.00–3.00	0.10	
S31700	317	0.08	2.00	0.045	0.030	1.00	18.0–20.0	11.0–15.0	3.0–4.0	0.10	
S32100	321	0.08	2.00	0.045	0.030	1.00	17.0–19.0	9.0–12.0	...	...	Ti 5xC min
S34700	347	0.08	2.00	0.045	0.030	1.00	17.0–19.0	9.0–13.0	...	...	Cb+Ta 10xC, min ^D
S34800	348	0.08	2.00	0.045	0.030	1.00	17.0–19.0	9.0–13.0	...	...	Cb+Ta 10xC, min ^D Ta 0.10 Co 0.20
Austenitic-Ferritic Grades											
S32550 ^E	...	0.04	1.50	0.040	0.030	1.00	24.0–27.0	4.5–6.5	2.9–3.9	0.10–0.25	Cu 1.50–2.50
S32760 ^E	...	0.030	1.00	0.030	0.010	1.00	24.0–26.0	6.0–8.0	3.0–4.0	0.20–0.30	Cu 0.50–1.00 W 0.50–1.00
S32950	...	0.03	2.00	0.035	0.010	0.60	26.0–29.0	3.5–5.2	1.00–2.50	0.15–0.35	
Ferritic Grades											
S40500	405	0.08	1.00	0.040	0.030	1.00	11.5–14.5	0.60	...	...	A1 0.10–0.30
S42900	429	0.12	1.00	0.040	0.030	1.00	14.0–16.0	0.75	...	...	
S43000	430	0.12	1.00	0.040	0.030	1.00	16.0–18.0	0.75	...	...	
S43020	430F	0.12	1.25	0.06	0.15 min	1.00	16.0–18.0	0.75	0.60 ^C	...	
S43023	430F Se	0.12	1.25	0.06	0.06	1.00	16.0–18.0	0.75	...	...	Se 0.15 min
S44600	446	0.20	1.50	0.040	0.030	1.00	23.0–27.0	0.75	...	0.25	
Martensitic Grades											
S40300	403	0.15	1.00	0.040	0.030	0.50	11.5–13.0	...	...	...	
S41000	410	0.15	1.00	0.040	0.030	1.00	11.5–13.5	0.75	...	...	
S41008	410S	0.08	1.00	0.040	0.030	1.00	11.5–13.5	0.75	...	...	
S41400	414	0.15	1.00	0.040	0.030	1.00	11.5–13.5	1.25–2.50	...	...	
S41425	...	0.05	0.50–1.00	0.020	0.005	0.50	12.0–15.0	4.0–7.0	1.50–2.00	0.06–0.12	Cu 0.30
S41500	F	0.05	0.5–1.0	0.030	0.030	0.60	11.5–14.0	3.5–5.5	0.40–0.80	...	
S41600	416	0.15	1.25	0.06	0.15 min	1.00	12.0–14.0	...	0.60 ^C	...	
S41623	416 Se	0.15	1.25	0.06	0.06	1.00	12.0–14.0	...	...	...	Se 0.15 min
S42000	420	Over 0.15	1.00	0.040	0.030	1.00	12.0–14.0	...	...	...	
S43100	431	0.20	1.00	0.040	0.030	1.00	15.0–17.0	1.25–2.50	...	...	
S44002	440A	0.60–0.75	1.00	0.040	0.030	1.00	16.0–18.0	...	0.75	...	
S44003	440B	0.75–0.95	1.00	0.040	0.030	1.00	16.0–18.0	...	0.75	...	
S44004	440C	0.95–1.20	1.00	0.040	0.030	1.00	16.0–18.0	...	0.75	...	

^A Maximum, unless range or minimum is indicated.

^B New designation established in accordance with Practice E527 and SAE J1086.

^C At manufacturer's option; reported only when intentionally added.

^D Columbium (Cb) and Niobium (Nb) are alternate names for element 41 in the Periodic Table of the Elements.

^E % Cr + 3.3 × % Mo + 16 × % N ≥ 40.

^F Wrought version of CA6NM.