



Designation: A502 – 24

Standard Specification for Rivets, Steel, Structural¹

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1. Scope*

1.1 This specification covers three grades of steel rivets in diameters from $\frac{1}{2}$ to $1\frac{1}{2}$ in. inclusive, for structural fabricating purposes. The grades are as follows:

Grade	Description
1	Carbon steel rivets for general purpose use
2	Carbon manganese steel rivets for use with high strength carbon and high strength low alloy structural steels
3	Weathering steel rivets

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.

2. Referenced Documents

2.1 ASTM Standards:²

A751 Test Methods and Practices for Chemical Analysis of Steel Products

F606/F606M Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, Direct Tension Indicators, and Rivets

F1470 Practice for Fastener Sampling for Specified Mechanical Properties and Performance Inspection

G101 Guide for Estimating the Atmospheric Corrosion Resistance of Low-Alloy Steels

2.2 ASME Standard:

B 18.1.2 Large Rivets ($\frac{1}{2}$ Inch Nominal Diameter and Larger)³

3. Ordering Information

3.1 Orders for rivets under this specification shall include:

3.1.1 Quantity (number of pieces of rivets),

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² 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.

³ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

3.1.2 Name of product, including head type,
3.1.3 Dimensions including nominal diameter and length,
3.1.4 Supplementary Requirement S1, if required (see 8.1.2),
3.1.5 Test report, if required (see 13.1),
3.1.6 Additional package marking, if required (see 16.2),
3.1.7 ASTM designation, including grade and date of issue, and

3.1.8 Any special requirements.

Example—10 000 pieces, Steel Button Head Rivets, $\frac{1}{2}$ × 1 in., Test Report Required, ASTM A502, Grade 1, dated_____.

4. Materials and Manufacture

4.1 *Process*—The steel for rivets shall be made by the open-hearth, basic-oxygen, or electric-furnace process.

4.2 *Heading*—Rivets shall be made by the hot or cold heading process.

5. Chemical Composition

5.1 Grade 1 and Grade 2 rivets shall conform to the heat analysis requirements given in Table 1.

5.2 Grade 3 rivets shall be weathering steel and shall conform to Class A or Class B chemical composition specified in Table 1. The selection of the composition, A or B, shall be at the option of the rivet manufacturer. See Guide G101 for methods of estimating the atmospheric corrosion resistance of low alloy steels.

5.3 Application of heats of steel to which bismuth, selenium, tellurium, or lead has been intentionally added shall not be permitted. Compliance with this requirement shall be based on a statement on the steel certificate indicating that these elements were not intentionally added.

5.4 Product analysis made on finished rivets representing each lot shall conform to the product analysis requirements specified in Table 1, as applicable. Product Analysis is not applicable to Grade 1 rivets made from rimmed steel or merchant quality bars.

6. Mechanical Properties

6.1 The rivets shall conform to the hardness requirements shown in Table 2.

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

TABLE 1 Chemical Requirements

	Grade 1		Grade 2		Grade 3 ^{A,B}			
					Class A		Class B	
	Heat Analysis, %	Product Analysis, ^C %	Heat Analysis, %	Product Analysis, %	Heat Analysis, %	Product Analysis, %	Heat Analysis, %	Product Analysis, %
Carbon	0.13–0.25	0.11–0.27	0.19–0.30	0.16–0.33	0.10–0.19	0.09–0.20	0.20 max	0.21 max
Manganese	0.30–0.90	0.27–0.93	1.20–1.65	1.14–1.71	0.90–1.25	0.86–1.29	0.75–1.25	0.71–1.29
Phosphorus, max								
acid	0.06	0.070	0.06	0.070	...	...	...	...
basic	0.04	0.048	0.04	0.048	0.04	0.045	0.04	0.045
Sulfur, max	0.05	0.058	0.05	0.058	0.05	0.055	0.05	0.055
Silicon	...	...	0.10–0.35	0.08–0.37	0.15–0.35	0.13–0.37	0.15–0.35	0.13–0.37
Nickel	...	...	...	...	...	...	0.25–0.50	0.22–0.53
Chromium	...	...	...	...	0.40–0.65	0.37–0.68	0.40–0.70	0.37–0.73
Copper	...	...	...	...	0.25–0.40	0.22–0.43	0.20–0.40	0.17–0.43
Copper, when copper bearing steel is specified, min	0.20	0.18	0.20	0.18	...	...	...	...
Vanadium	...	...	...	...	0.02–0.10	0.01–0.11	0.01–0.10	0.11 max

^A A and B are classes of material used for Grade 3 rivets. Selection of a class shall be at the option of the rivet manufacturer.

^B See 5.2.

^C Product analysis is not applicable to rivets made from rimmed steel or merchant quality bars.

TABLE 2 Hardness Requirements

	Grade 1		Grade 2		Grade 3	
	Min	Max	Min	Max	Min	Max
Rockwell, B	55	72	76	85	76	93
Brinell, 500-kgf (4900-N), 10-mm ball	103	126	137	163	137	197

6.2 Brinell hardness shall be measured at one point. Rockwell hardness shall be measured at three points, equally spaced about the axis of the rivet, and the hardness shall be taken as the arithmetic average of the three measurements.

7. Dimensions

7.1 Dimensions of rivets, unless otherwise specified, shall conform to those of one of the head types provided in ASME B 18.1.2.

8. Number of Tests and Retests

8.1 Hardness:

8.1.1 The requirements of this specification shall be met in continuous mass production for stock, and the manufacturer shall make sample inspections to ensure that the product conforms to the specified hardness requirements. Additional tests of individual shipments of material are not ordinarily contemplated. Individual heats of steel are not necessarily identified in the finished product.

8.1.2 When additional hardness tests are required, Supplementary Requirement S1 shall be specified.

8.2 Head Bursts and Duds:

8.2.1 From each lot, the number of tests and the acceptance/rejection criteria for cracks (bursts) and duds shall be in accordance with Practice F1470 using the sampling level characteristic specified for Surface Discontinuities.

9. Specimen Preparation

9.1 Rivets used for testing shall be heat treated in the following manner prior to testing:

9.1.1 *Grade 1*—Normalize by air cooling from above the transformation range.

9.1.2 *Grade 2*—Anneal by heating to 1450°F (790°C), holding for 30 min at temperature and cooling in the furnace.

9.1.3 *Grade 3*—Normalizing test samples shall be at the option of the manufacturer.

9.2 If any test specimen shows defective preparation, it shall be discarded and another specimen substituted.

10. Visual Inspection for Head Bursts and Duds

10.1 The rivets shall be inspected for cracks (bursts) and duds. Sampling and inspection shall be in accordance with 8.2. Rivets having an opening at the periphery of the head wider than 0.020 inch plus 0.05 times the rivet diameter shall be considered nonconforming (see Note 1).

NOTE 1—Crack and burst are two names for the same thing. Each designates an abrupt interruption of the periphery of a rivet head by separation of the metal. Such interruptions do not adversely affect structural strength, corrosion resistance, or other functional requirements of the rivet, but are unsightly if they are large.

11. Test Methods

11.1 Hardness tests shall be conducted in accordance with Test Methods F606/F606M.

11.2 Chemical analyses shall be conducted in accordance with Test Methods A751.

12. Rejection and Rehearing

12.1 Disposition of nonconforming rivets shall be in accordance with the Practice F1470 section entitled “Disposition of Nonconforming Lots.”

13. Certification

13.1 Upon request of the purchaser in the contract or order, a manufacturer’s certification that the rivets were manufactured and tested in accordance with this specification, together with a report of the latest hardness tests of each stock size in each shipment, shall be furnished at the time of shipment.