



# Standard Specification for Alloy-Steel Bolting for Special Applications<sup>1</sup>

This standard is issued under the fixed designation A540/A540M; 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 reappraisal. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reappraisal.

## 1. Scope\*

1.1 This specification<sup>2</sup> covers regular and special-quality alloy steel bolting materials and bolting components that may be used for nuclear and other special applications. See Specification [A962/A962M](#) for the definition of bolting.

1.2 The following referenced common requirements are indispensable for application of this specification: Specification [A962/A962M](#).

1.3 Supplementary requirements of an optional nature are provided for use at the option of the purchaser. These supplementary requirements only apply when specified individually by the purchaser in the purchase order or contract.

1.4 This specification is expressed in both inch-pound units and in SI units; however, unless the purchase order or contract specifies the applicable “M” specification designation (SI units), inch-pound units shall apply.

1.5 The values stated in either SI units or inch-pound units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

## 2. Referenced Documents

### 2.1 *ASTM Standards*:<sup>3</sup>

[A962/A962M Specification for Common Requirements for Bolting Intended for Use at Any Temperature from Cryogenic to the Creep Range](#)

[E45 Test Methods for Determining the Inclusion Content of Steel](#)

<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.

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<sup>2</sup> For ASME Boiler and Pressure Vessel Code Applications see related Specification SA-540 in Section II of that Code.

<sup>3</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard’s Document Summary page on the ASTM website.

## 3. Ordering Information

3.1 The inquiry and orders for bolting material and bolting components under this specification shall include the following, as required, to describe the desired items adequately:

3.1.1 Grade and Class

3.1.2 Condition (Section 5),

3.1.3 Heat treatment (Section 6),

3.1.4 Supplementary Requirements (S1 to S9),

3.1.5 Reports required (Section 16),

3.1.6 End use, and

3.1.7 Any special requirements.

3.2 The purchaser is referred to the listed supplementary requirements.

## 4. Common Requirements

4.1 Bolting materials and bolting components supplied to this specification shall conform to the requirements of Specification [A962/A962M](#). These requirements include test methods, finish, thread dimensions, macro etch, marking, certification, optional supplementary requirements, and others. Failure to comply with the requirements of Specification [A962/A962M](#) constitutes nonconformance with this specification. In case of conflict between this specification and Specification [A962/A962M](#), this specification shall prevail.

## 5. Manufacture

5.1 Bolting material shall be supplied hot-rolled or hot-forged or cold-finished at the option of the producer. However, if desired by the purchaser, cold finishing may be specified.

## 6. Heat Treatment

6.1 Bolting material ordered in the annealed condition shall have a structure suitable for machining. Such annealed material is not intended to be used without subsequent quenching and tempering as specified in [6.2](#).

6.2 Bolting material ordered in the liquid-quenched and tempered condition shall be uniformly reheated from a temperature below the cooling transformation range to the proper austenitizing temperature, quenched in a liquid medium under substantially uniform conditions, and then uniformly reheated for tempering. The minimum tempering temperature shall be 850 °F [455 °C].

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

6.3 Bolting material that has been straightened after quenching and tempering shall be stress relieved by reheating to a temperature not lower than 100 °F [55 °C] under the tempering temperature.

**7. Chemical Composition**

7.1 Steels used for bolting materials shall conform to the chemical requirements prescribed in **Table 1**.

**8. Tensile Requirements**

8.1 Bolting material furnished in the annealed condition shall be capable of meeting the specified tensile properties for the class as specified in **Table 2** when heat treated in accordance with **6.2** and **6.3** (see Supplementary Requirement S4).

8.2 Bolting material in the quenched and tempered or quenched, tempered and stress-relieved condition shall conform to properties shown in **Table 2** for the specified class.

**9. Hardness Requirements**

9.1 The hardness shall be determined on the surface of the material after removal of decarburization.

9.2 The hardness of bolting material in the annealed condition shall not be greater than 235 HBW.

9.3 The hardness of bolting material in the quenched and tempered or quenched, tempered and stress-relieved condition shall be within the limits in **Table 2** for the specified class.

**10. Impact Requirements**

10.1 Annealed bolting material after proper heat treatment shall be capable of meeting the impact requirements in **Table 2** or of Supplementary Requirement S8, if so specified (see Supplementary Requirement S4).

10.2 Bolting material in the quenched and tempered or quenched, tempered, and stress-relieved condition shall con-

form to the impact requirements in **Table 2**, or of Supplementary Requirement S8 if so specified.

10.3 The percent of shear (ductility or fibrous) fracture shall be computed. The computed value shall be recorded for all impact specimens.

10.4 The amount of lateral expansion shall be measured. The measured value shall be recorded for all impact specimens.

10.5 The percent shear and the amount of lateral expansion shall be reported for information purposes (see **16.1**).

**11. Workmanship, Finish, and Appearance**

11.1 Bolting material shall be uniform in quality and free of defects that would be detrimental to the intended service. If magnetic particle inspection for such defects is desired, Supplementary Requirement S6 should be specified.

11.2 *Surface Quality*—Bolting material shall be free of seams, laps, cracks, or other defects that are not removable within the machining cleanup allowance specified in **Table 3**.

**12. Surface Condition**

12.1 Bolting material shall be cleaned and furnished in the scale-free condition.

**13. Number of Tests**

13.1 *Mechanical Tests on Quenched and Tempered Bolting Material:*

13.1.1 One test coupon shall be removed from each end of one bar, one seamless tube, or one bored bar or from each of two forged hollows from each size of each heat in each tempering charge, or each 10 000 lb [4540 kg], whichever is less. One tension test and one impact test consisting of three Charpy V-notch specimens shall be taken from each test coupon. For testing in accordance with **15.1.1**, two tests shall be obtained from two representative production pieces from

**TABLE 1 Chemical Requirements<sup>A</sup>**

Grade Symbol	B21		B22		B23		B24		B24V	
	(Cr-Mo-V)		(4142-H)		(E-4340-H)		(4340 Mod.)		(4340V Mod.)	
	Chromium-Molybdenum-Vanadium		Chromium-Molybdenum		Chromium-Nickel-Molybdenum		Chromium-Nickel-Molybdenum		Chromium-Nickel-Molybdenum-Vanadium	
	Range, %	Product Variation, Over or Under, <sup>B</sup> %	Range, %	Product Variation, Over or Under, <sup>B</sup> %	Range, %	Product Variation, Over or Under, <sup>B</sup> %	Range, %	Product Variation, Over or Under, <sup>B</sup> %	Range, %	Product Variation, Over or Under, <sup>B</sup> %
Carbon	0.36–0.44	0.02	0.39–0.46	0.02	0.37–0.44	0.02	0.37–0.44	0.02	0.37–0.44	0.02
Manganese	0.45–0.70	0.03	0.65–1.10	0.04	0.60–0.95	0.04	0.70–0.90	0.04	0.60–0.95	0.04
Phosphorus, max	0.025 <sup>C</sup>	0.005	0.025 <sup>C</sup>	0.005	0.025 <sup>C</sup>	0.005	0.025 <sup>C</sup>	0.005	0.025 <sup>C</sup>	0.005
Sulfur, max	0.025 <sup>C</sup>	0.005	0.025 <sup>C</sup>	0.005	0.025 <sup>C</sup>	0.005	0.025 <sup>C</sup>	0.005	0.025 <sup>C</sup>	0.005
Silicon	0.15–0.35	0.02	0.15–0.35	0.02	0.15–0.35	0.02	0.15–0.35	0.02	0.15–0.35 <sup>D</sup>	0.02
Chromium	0.80–1.15	0.05	0.75–1.20	0.05	0.65–0.95	0.05	0.70–0.95	0.05	0.60–0.95	0.05
Nickel	...	...	...	...	1.55–2.00	0.05	1.65–2.00	0.05	1.55–2.00	0.05
Molybdenum	0.50–0.65	0.03	0.15–0.25	0.02	0.20–0.30	0.02	0.30–0.40	0.02	0.40–0.60	0.03
Vanadium	0.25–0.35	0.03	...	...	...	...	...	...	0.04–0.10	0.01

<sup>A</sup> The intentional addition of Bi, Se, Te, and Pb is not permitted.

<sup>B</sup> Unless otherwise specified, separate determinations may vary from the specified ranges, except that elements in any heat must not vary both above and below the specified range.

<sup>C</sup> Phosphorus and sulfur content is 0.04 % max when open-hearth steel is specified.

<sup>D</sup> Silicon content is 0.35 % max if vacuum-carbon deoxidized.

**TABLE 2 Mechanical Property Requirements**

NOTE 1—The minimum average of 3 specimens shall not be less than 35 ft-lbf [47 J]. One specimen from a set of 3 may be less than 35 ft-lbf [47 J] but not less than 30 ft-lbf [41 J].

NOTE 2— The minimum average of 3 specimens shall not be less than 30 ft-lbf [41 J]. One specimen from a set of 3 may be less than 30 ft-lbf [41 J] but not less than 25 ft-lbf [34 J].

NOTE 3—The minimum average of 3 specimens shall not be less than 25 ft-lbf [34 J]. One specimen from a set of 3 may be less than 25 ft-lbf [34 J] but not less than 20 ft-lbf [27 J].

NOTE 4—No minimum values established. Tests shall be run for information only.

Grade	Class	Diameter	Tensile Strength, min	Yield Strength, 0.2 % offset, min	Elongation, min, %	Reduction of Area, min, %	Surface Brinell Hardness		Charpy V-Notch +10 °F [−12.2 °C]
							min	max	
Inch-Pound Units									
		in.	ksi	ksi	In 2 in.				
B21 (Cr-Mo-V)	5	to 2, incl	120	105	15	50	241	285	Note 4
		over 2 to 6, incl	115	100	15	50	248	302	Note 4
		over 6 to 8, incl	115	100	15	50	255	311	Note 4
	4	to 3, incl	135	120	13	45	269	331	Note 4
		over 3 to 6, incl	135	120	13	45	277	352	Note 4
	3	to 3, incl	145	130	12	40	293	352	Note 4
		over 3 to 6, incl	145	130	12	40	302	375	Note 4
	2	to 4, incl	155	140	11	40	311	401	Note 4
	1	to 4, incl	165	150	10	35	321	429	Note 4
	B22 (4142-H)	5	to 2, incl	120	105	15	50	248	293
over 2 to 4, incl			115	100	15	50	255	302	Note 4
4		to 1, incl	135	120	13	45	269	341	Note 1
		over 1 to 4, incl	135	120	13	45	277	363	Note 4
3		to 2, incl	145	130	12	40	293	363	Note 4
		over 2 to 4, incl	145	130	12	40	302	375	Note 4
2		to 3, incl	155	140	11	40	311	401	Note 4
1		to 1½, incl	165	150	10	35	321	401	Note 4
B23 (E-4340-H)	5	to 6, incl	120	105	15	50	248	311	Note 1
		over 6 to 8, incl	115	100	15	50	255	321	Note 1
		over 8 to 9½, incl	115	100	15	50	262	321	Note 4
	4	to 3, incl	135	120	13	45	269	341	Note 1
		over 3 to 6, incl	135	120	13	45	277	352	Note 1
		over 6 to 9½, incl	135	120	13	45	285	363	Note 4
	3	to 3, incl	145	130	12	40	293	363	Note 2
		over 3 to 6, incl	145	130	12	40	302	375	Note 2
	2	over 6 to 9½, incl	145	130	12	40	311	388	Note 4
		to 3, incl	155	140	11	40	311	388	Note 4
	1	over 3 to 6, incl	155	140	11	40	311	401	Note 4
		over 6 to 9½, incl	155	140	11	40	321	415	Note 4
	2	to 3, incl	165	150	10	35	321	415	Note 4
		over 3 to 6, incl	165	150	10	35	331	429	Note 4
		over 6 to 8, incl	165	150	10	35	341	444	Note 4
		over 8 to 9½, incl	165	150	10	35	341	444	Note 4
B24 (4340 Mod.)	5	to 6, incl	120	105	15	50	248	311	Note 1
		over 6 to 8, incl	115	100	15	50	255	321	Note 1
		over 8 to 9½, incl	115	100	15	50	262	321	Note 1
	4	to 3, incl	135	120	13	45	269	341	Note 1
		over 3 to 6, incl	135	120	13	45	277	352	Note 1
		over 6 to 8, incl	135	120	13	45	285	363	Note 1
	3	over 8 to 9½, incl	135	120	13	45	293	363	Note 4
		to 3, incl	145	130	12	40	293	363	Note 2
	2	over 3 to 8, incl	145	130	12	40	302	388	Note 2
		over 8 to 9½, incl	145	130	12	40	311	388	Note 4
	1	to 7, incl	155	140	11	40	311	401	Note 2
		over 7 to 9½, incl	155	140	11	40	321	415	Note 4
	3	to 4, incl	145	130	12	40	293	363	Note 1
		over 4 to 8, incl	145	130	12	40	302	375	Note 2
	2	over 8 to 11, incl	145	130	12	40	311	388	Note 3
		to 4, incl	155	140	11	40	311	388	Note 2
1	over 4 to 8, incl	155	140	11	40	311	401	Note 3	
	over 8 to 11, incl	155	140	11	40	321	415	Note 4	
B24V (4340V Mod.)	3	to 4, incl	145	130	12	40	293	363	Note 1
		over 4 to 8, incl	145	130	12	40	302	375	Note 2
	2	over 8 to 11, incl	145	130	12	40	311	388	Note 3
		to 4, incl	155	140	11	40	311	388	Note 2
1	over 4 to 8, incl	155	140	11	40	311	401	Note 3	
	over 8 to 11, incl	155	140	11	40	321	415	Note 4	
B24V (4340V Mod.)	2	to 4, incl	165	150	10	35	321	415	Note 3
		over 4 to 8, incl	165	150	10	35	331	429	Note 4
	1	over 8 to 11, incl	165	150	10	35	331	444	Note 4
		to 4, incl	165	150	10	35	331	444	Note 4