



Standard Specification for Steel, Strip, Carbon and High-Strength, Low-Alloy, Hot-Rolled, General Requirements for¹

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This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This specification covers the general requirements for hot-rolled steel strip in coils and cut lengths. It applies to carbon steel and high-strength, low-alloy steel furnished as hot-rolled.

1.2 This specification is not applicable to hot-rolled heavy-thickness carbon sheet and strip coils (Specification [A1018/A1018M](#)), cold-rolled carbon steel strip (Specification [A109/A109M](#)), high-strength, low-alloy cold-rolled steel (Specifications [A606/A606M](#) and [A1008/A1008M](#)) or cold-rolled high carbon steel (Specification [A684/A684M](#)).

1.3 In case of any conflict in requirements, the requirements of the individual material specification shall prevail over those of this general specification.

1.4 For the purposes of determining conformance with this and the appropriate product specification referenced under [2.1](#), values shall be rounded to the nearest unit in the right hand place of figures used in expressing the limiting values in accordance with the rounding method of Practice [E29](#).

1.5 [Annex A1](#) lists permissible variations in dimensions and mass ([Note 1](#)) in SI [metric] units. The values listed are not exact conversions of the values listed in the inch-pound tables, but instead are rounded or rationalized values. Conformance to [Annex A1](#) is mandatory when the “M” specification is used.

NOTE 1—The term “weight” is used when inch-pound units are the standard; however, under SI, the preferred term is “mass.”

1.6 The values stated in either SI units or inch-pound units are to be regarded separately as standard. 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.

1.7 This specification and the applicable material specifications are expressed in both inch-pound units and SI units. However, unless the order specifies the applicable “M” specification designation (SI units), the material shall be furnished to inch-pound units.

2. Referenced Documents

2.1 ASTM Standards:²

- [A109/A109M Specification for Steel, Strip, Carbon \(0.25 Maximum Percent\), Cold-Rolled](#)
- [A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)
- [A568/A568M Specification for Steel, Sheet, Carbon, Structural, and High-Strength, Low-Alloy, Hot-Rolled and Cold-Rolled, General Requirements for](#)
- [A606/A606M Specification for Steel, Sheet and Strip, High-Strength, Low-Alloy, Hot-Rolled and Cold-Rolled, with Improved Atmospheric Corrosion Resistance](#)
- [A684/A684M Specification for Steel, Strip, High-Carbon, Cold-Rolled](#)
- [A700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Shipment \(Withdrawn 2014\)³](#)
- [A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products](#)
- [A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys](#)
- [A1008/A1008M Specification for Steel, Sheet, Cold-Rolled, Carbon, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, Solution Hardened, and Bake Hardenable](#)
- [A1018/A1018M Specification for Steel, Sheet and Strip, Heavy-Thickness Coils, Hot-Rolled, Carbon, Commercial, Drawing, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, and Ultra-High Strength](#)

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 [A01.19](#) on Steel Sheet and Strip.

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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 The last approved version of this historical standard is referenced on www.astm.org.

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

[E11 Specification for Woven Wire Test Sieve Cloth and Test Sieves](#)

[E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)

[E290 Test Methods for Bend Testing of Material for Ductility](#)

2.2 *Military Standards*:⁴

[MIL-STD-129 Marking for Shipment and Storage](#)

2.3 *Federal Standards*:⁴

[Fed. Std. No. 123 Marking for Shipments \(Civil Agencies\)](#)

[Fed. Std. No. 183 Continuous Identification Marking of Iron and Steel Products](#)

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *Product Types:*

3.1.2 *hot-rolled strip*—manufactured by hot rolling billets or slabs to the required thickness. It may be produced single width or by rolling multiple width and slitting to the desired width. It can be supplied in coils or cut lengths as specified.

Width, in.		Thickness, in.	
Over	Through	Over	Through
...	3½	0.044	0.203
3½	6	0.044	0.203
6	12	0.044	0.230 excl

Width, mm		Thickness, mm	
Over	Through	Over	Through
...	100	1.2	5.0
100	200	1.2	5.0
200	300	1.2	6.0, excl

Hot-rolled, high-strength, low-alloy strip is commonly available by size as follows:

Width, in.		Thickness, in.		
Over	Through	From	Through	
			Coils & Cut Lengths	Coils Only
...	6	0.054	0.203	0.230 excl
6	12	0.054	0.230	0.230 excl

Width, mm		Thickness, mm	
Over	Through	Over	Through
...	200	1.8	5.0
200	300	1.8	6.0, excl

4. Materials and Manufacture

4.1 Unless otherwise specified, hot-rolled material shall be furnished hot-rolled, not annealed or pickled.

5. Chemical Composition

5.1 *Limits:*

5.1.1 The chemical composition shall be in accordance with the applicable product specification. However, if other compositions are required for carbon steel, they shall be prepared in accordance with Specification [A568/A568M](#), Appendix X2.

⁴ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.

5.1.2 Where the material is used for fabrication by welding, care must be exercised in the selection of chemical composition or mechanical properties to ensure compatibility with the welding process and its effect on altering the properties.

5.2 *Cast or Heat (Formerly Ladle) Analysis:*

5.2.1 An analysis of each cast or heat of steel shall be made by the manufacturer to determine the percentage of elements specified or restricted by the applicable specification.

5.2.2 When requested, cast or heat analysis for elements listed or required shall be reported to the purchaser or to its representative.

5.3 *Product, Check, or Verification Analysis:*

5.3.1 Nonkilled steels (such as capped or rimmed) are not technologically suited to product analysis due to the nonuniform character of their chemical composition and therefore, the tolerances referenced in [5.3.2](#) do not apply. Product analysis is appropriate on these types of steel only when misapplication is apparent or for copper when copper steel is specified.

5.3.2 For steels other than nonkilled (capped or rimmed), product analysis may be made by the purchaser. The chemical analysis shall not vary from the limits specified by more than the amounts in Specification [A568/A568M](#), section 5.3 (Table 2 in [A568/A568M](#)). The several determinations of any element in a cast shall not vary both above and below the specified range.

5.4 *Sampling for Product Analysis:*

5.4.1 To indicate adequately the representative composition of a cast by product analysis, it is general practice to select samples to represent the steel, as fairly as possible, from a minimum number of pieces as follows: 3 pieces for lots up to 15 tons inclusive, and 6 pieces for lots over 15 tons [15 Mg].

5.4.2 When the steel is subject to tension test requirements, samples for product analysis may be taken either by drilling entirely through the used tension test specimens themselves or in accordance with [5.4.3](#).

5.4.3 When the steel is not subject to tension test requirements, the samples for analysis must be taken by milling or drilling entirely through the strip in a sufficient number of places so that the samples are representative of the entire strip. The sampling may be facilitated by folding the strip both ways, so that several samples may be taken at one drilling. Steel subjected to certain heating operations by the purchaser may not give chemical analysis results that properly represent its original composition. Therefore, users must analyze chips taken from the steel in the condition in which it is received from the steel manufacturer.

5.5 *Specimen Preparation*—Drillings or chips must be taken without the application of water, oil, or other lubricant, and must be free of scale, grease, dirt, or other foreign substances. They must not be overheated during cutting to the extent of causing decarburization. Chips must be well mixed, and those too coarse to pass a No. 10 (2.00-mm) sieve or too fine to remain on a No. 30 (600- μ m) sieve are not suitable for proper analysis. Sieve size numbers are in accordance with Specification [E11](#).

5.6 *Test Methods*—In case a referee analysis is required and agreed upon to resolve a dispute concerning the results of a

chemical analysis, the procedure for performing the referee analysis must be in accordance with the latest issue of Test Methods, Practices, and Terminology **A751**, unless otherwise agreed upon between the manufacturer and the purchaser.

6. Mechanical Properties

6.1 The mechanical property requirements, number of specimens, test locations, and specimen orientation shall be in accordance with the applicable product specification.

6.2 Unless otherwise specified in the applicable product specification, test specimens must be prepared in accordance with Test Methods and Definitions **A370**.

6.3 Mechanical tests shall be conducted in accordance with Test Methods and Definitions **A370**.

6.4 Bend tests, where required, shall be conducted in compliance with Test Methods **E290**.

6.5 To determine conformance with the product specification, a calculated value should be rounded to the nearest 1 ksi [7 MPa] tensile strength and yield point or yield strength, and to the nearest unit in the right hand place of figures used in expressing the limiting value for other values in accordance with the rounding off method given in Practice **E29**.

6.6 Structural steels are commonly fabricated by cold bending. There are many interrelated factors that affect the ability of a given steel to cold form over a given radius under shop conditions. These factors include thickness, strength level, degree of restraint, relationship to rolling direction, chemistry, and microstructure. Each of the appropriate product specifications lists in the appendix the suggested minimum inside radius for cold bending. These radii should be used as minima for 90° bends. They presuppose “hard way” bending (bend axis parallel to rolling direction) and reasonably good shop forming practices. Where possible, the use of larger radii or “easy way” bends are recommended for improved performance.

6.7 Fabricators should be aware that cracks may initiate upon bending a sheared or burned edge. This is not considered to be a fault of the steel but is rather a function of the induced cold-work or heat-affected zone.

7. Dimensions, Tolerances, and Allowances

7.1 Dimensions, tolerances, and allowances applicable to products covered by this specification are contained in **Tables 1-8 [Annex A1, Tables A1.1-A1.7]**. The appropriate tolerance tables shall be identified in each individual specification.

TABLE 1 Index of Tables for Dimensions, Tolerances, and Allowances

Dimensions	Table No.	SI Units
	Inch-Pound Units	
Camber tolerances	7	A1.6
Crown tolerances	4	A1.3
Flatness tolerances	8	A1.7
Length tolerances	6	A1.5
Thickness tolerances	2, 3	A1.1, A1.2
Width tolerances	5	A1.4

8. Workmanship

8.1 Cut lengths shall have a workmanlike appearance and shall not have imperfections of a nature or degree for the product, the grade, and the quality ordered that will be detrimental to the fabrication of the finished part.

8.2 Coils may contain some abnormal imperfections that render a portion of the coil unusable since the inspection of coils does not afford the producer the same opportunity to remove portions containing imperfections as in the case with cut lengths.

9. Finish and Condition

9.1 Hot-rolled strip has a surface with an oxide or scale resulting from the hot-rolling operation. The oxide or scale can be removed by pickling or blast cleaning when required for press-work operations or welding. Hot-rolled and hot-rolled descaled strip are not generally used for exposed parts where surface is of prime importance. However, hot-rolled surface might be of importance, as in the case of weathering steels for exposed parts.

9.1.1 Hot-rolled strip can be supplied with mill edges, square edges, or cut (slit) edges as specified.

9.1.1.1 Mill edges are the natural edges resulting from the hot-rolling operation and are generally round and smooth without any definite contour.

9.1.1.2 Square edges are the edges resulting from rolling through vertical edging rolls during the hot-rolling operations. These edges are square and smooth, with the corners slightly rounded.

9.1.1.3 Cut (slit) edges are the normal edges that result from the shearing, slitting, or trimming of mill edges.

9.1.2 The ends of plain hot-rolled mill-edge coils are irregular in shape and are referred to as uncropped ends. Where such ends are not acceptable, the purchaser’s order should so specify. Processed coils such as pickled or blast cleaned are supplied with square-cut ends.

9.2 Oiling:

9.2.1 Plain hot-rolled strip is customarily furnished not oiled. Oiling must be specified when required for hot-rolled strip.

9.2.2 Hot-rolled pickled or descaled strip is customarily furnished oiled. If the pickled/descaled product is not to be oiled, it must be so specified since the cleaned surface is prone to rusting.

10. General Requirements for Delivery

10.1 Products covered by this specification are produced to inch-pound or metric decimal thickness only.

10.2 Steel may be produced as ingot-cast or strand-cast. When different grades of strand-cast steel are sequentially cast, identification and separation of the transition material is required.

11. Retests

11.1 If any test specimen shows defective machining or develops flaws, it must be discarded and another specimen substituted.