



Designation: A958/A958M – 17

Standard Specification for Steel Castings, Carbon and Alloy, with Tensile Requirements, Chemical Requirements Similar to Standard Wrought Grades¹

This standard is issued under the fixed designation A958/A958M; 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 (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope*

1.1 This specification covers carbon and low-alloy steel castings having chemical analyses similar to that of the standard wrought grades.

1.2 Several classes are covered and are designated by chemical composition as shown in [Table 1](#).

1.3 Options for tensile properties are shown in [Tables 2 and 3](#).

1.4 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 nonconformance with the standard.

1.4.1 Within the text, the SI units are shown in brackets.

1.5 *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

[A488/A488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel](#)

[A781/A781M Specification for Castings, Steel and Alloy, Common Requirements, for General Industrial Use](#)

[A957/A957M Specification for Investment Castings, Steel](#)

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 A01.18 on Castings.

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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.

[and Alloy, Common Requirements, for General Industrial Use](#)

3. General Conditions for Delivery

3.1 Material furnished to this specification shall conform to the requirements of Specification [A781/A781M](#), including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification [A781/A781M](#) constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification [A781/A781M](#), this specification shall prevail.

3.2 Steel investment castings furnished to this specification shall conform to the requirements of Specification [A957/A957M](#), including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification [A957/A957M](#) constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification [A957/A957M](#), Specification [A957/A957M](#) shall prevail.

4. Ordering Information

4.1 Orders for material under this specification should include the following information:

4.1.1 Quantity,

4.1.2 Specification, including year and date of issue,

4.1.3 Grade and class of steel,

4.1.4 Description of the casting by pattern number or drawing (Dimensional tolerances should be included on the casting drawing.),

4.1.5 Options in the specification, and

4.1.6 Supplementary requirements desired, including standards of acceptance.

5. Heat Treatment

5.1 All castings shall receive a heat treatment indicated in [Table 4](#). Preliminary heat treatment prior to final heat treatment as well as multiple tempering is permitted.

5.2 Heat treatment shall be performed after the castings have been allowed to cool below the transformation range.

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

TABLE 1 Chemical Composition, Weight Percent

NOTE 1—Values are maximum unless a range is given.

| Grade | C | Mn | P | S | Si | Ni | Cr | Mo |
|---------|-----------|-----------|-------|-------|-----------|-----------|-----------|-----------|
| SC 1020 | 0.18/0.23 | 0.40/0.80 | 0.040 | 0.040 | 0.30/0.60 | - | - | - |
| SC 1025 | 0.22/0.28 | 0.40/0.80 | 0.040 | 0.040 | 0.30/0.60 | - | - | - |
| SC 1030 | 0.28/0.34 | 0.50/0.90 | 0.040 | 0.040 | 0.30/0.60 | - | - | - |
| SC 1040 | 0.37/0.44 | 0.50/0.90 | 0.040 | 0.040 | 0.30/0.60 | - | - | - |
| SC 1045 | 0.43/0.50 | 0.50/0.90 | 0.040 | 0.040 | 0.30/0.60 | - | - | - |
| SC 4130 | 0.28/0.33 | 0.40/0.80 | 0.035 | 0.040 | 0.30/0.60 | - | 0.80/1.10 | 0.15/0.25 |
| SC 4140 | 0.38/0.43 | 0.70/1.10 | 0.035 | 0.040 | 0.30/0.60 | - | 0.80/1.10 | 0.15/0.25 |
| SC 4330 | 0.28/0.33 | 0.60/0.90 | 0.035 | 0.040 | 0.30/0.60 | 1.65/2.00 | 0.70/0.90 | 0.20/0.30 |
| SC 4340 | 0.38/0.43 | 0.60/0.90 | 0.035 | 0.040 | 0.30/0.60 | 1.65/2.00 | 0.70/0.90 | 0.20/0.30 |
| SC 8620 | 0.18/0.23 | 0.60/1.00 | 0.035 | 0.040 | 0.30/0.60 | 0.40/0.70 | 0.40/0.60 | 0.15/0.25 |
| SC 8625 | 0.23/0.28 | 0.60/1.00 | 0.035 | 0.040 | 0.30/0.60 | 0.40/0.70 | 0.40/0.60 | 0.15/0.25 |
| SC 8630 | 0.28/0.33 | 0.60/1.00 | 0.035 | 0.040 | 0.30/0.60 | 0.40/0.70 | 0.40/0.60 | 0.15/0.25 |

TABLE 2 Tensile Requirements

| Class | 65/35 | 70/36 | 80/40 | 80/50 | 90/60 | 105/85 | 115/95 | 130/115 | 135/125 | 150/135 | 160/145 | 165/150 | 210/180 |
|--------------------------------------|-------|-------|-------|-------|-------|--------|--------|---------|---------|---------|---------|---------|---------|
| Tensile, ksi | 65 | 70 | 80 | 80 | 90 | 105 | 115 | 130 | 135 | 150 | 160 | 165 | 210 |
| Tensile, min. (MPa) | [450] | [485] | [550] | [550] | [620] | [725] | [795] | [895] | [930] | [1035] | [1105] | [1140] | [1450] |
| Yield, ksi | 35 | 36 | 40 | 50 | 60 | 85 | 95 | 115 | 125 | 135 | 145 | 150 | 180 |
| Yield, min. (MPa) | [240] | [250] | [275] | [345] | [415] | [585] | [655] | [795] | [860] | [930] | [1000] | [1035] | [1240] |
| Elongation in 2 in. or 50 mm, min. % | 24 | 22 | 18 | 22 | 18 | 17 | 14 | 11 | 9 | 7 | 6 | 5 | 4 |
| Reduction of Area, min. % | 35 | 30 | 30 | 35 | 35 | 35 | 30 | 25 | 22 | 18 | 12 | 10 | 8 |

TABLE 3 Tensile Requirements/Grade Suitability

| Class | 65/35 | 70/36 | 80/40 | 80/50 | 90/60 | 105/85 | 115/95 | 130/115 | 135/125 | 150/135 | 160/145 | 165/150 | 210/180 |
|---------|----------------|----------------|----------------|----------------|----------------|--------|--------|---------|---------|---------|---------|---------|---------|
| Grade | | | | | | | | | | | | | |
| SC 1020 | X ^A | X | | | | | | | | | | | |
| SC 1025 | X | X | | | | | | | | | | | |
| SC 1030 | X | X | X | X | | | | | | | | | |
| SC 1040 | X ^B | X | X | X | X | | | | | | | | |
| SC 1045 | X ^B | X ^B | X | X | X | X | X | | | | | | |
| SC 4130 | X ^B | X ^B | X | X | X | X | X | X | X | X | | | |
| SC 4140 | X ^B | X ^B | X ^B | X ^B | X | X | X | X | X | X | X | X | |
| SC 4330 | X ^B | X ^B | X ^B | X ^B | X | X | X | X | X | X | X | X | X |
| SC 4340 | X ^B | X ^B | X ^B | X ^B | X ^B | X | X | X | X | X | X | X | X |
| SC 8620 | X ^B | X ^B | X | X | X | X | X | | | | | | |
| SC 8625 | X ^B | X ^B | X | X | X | X | X | X | X | | | | |
| SC 8630 | X ^B | X ^B | X | X | X | X | X | X | X | X | | | |

^A "X" denotes that the properties may be achieved by at least one of the heat treatments referenced in 5. The effect of section thickness should be considered in making grade selections. The heat treatment requirements do not imply that all section thicknesses will be through hardened.

^B These grades significantly exceed the minimum strength levels; therefore, they may be unsuitable for use due to weldability, and machinability issues.

5.3 The furnace temperature for heat treating shall be effectively controlled by the use of recording-type pyrometers.

6. Chemical Composition

6.1 The steel shall conform to the requirements of chemical composition as prescribed in **Table 1**.

6.2 The product analysis tolerances given in Specification **A781/A781M**, or for investment castings, Specification **A957/A957M**, shall apply to all product analyses performed on castings supplied to this specification.

7. Tensile Requirements

7.1 One tension test shall be made from each heat, for investment castings, each master heat, and shall conform to the tensile requirements specified for the grade selected in **Tables 2 and 3**.

8. Repair by Welding

8.1 Repairs shall be made using procedures and welders qualified in accordance with Practice **A488/A488M**.

8.2 Repair welds shall be inspected to the same quality standards that are used to inspect the castings. When castings are produced with Supplementary Requirement S1 specified, weld repairs shall be inspected by magnetic particle examination to the same standards that are used to inspect the castings. When castings are produced with Supplementary S2 or S4, or both, as specified, weld repairs in which the depth of the cavity prepared for weld repair exceeds 20 % of the wall thickness or 1 in. [25 mm], whichever is smaller, or in which the cavity prepared for welding is greater than approximately 10 in.² [65 cm²], shall be radiographed or ultrasonically tested, or both, to the same standards that are used to inspect the castings.