



Designation: A962/A962M – 17

Standard Specification for Common Requirements for Bolting Intended for Use at Any Temperature from Cryogenic to the Creep Range¹

This standard is issued under the fixed designation A962/A962M; 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.

1. Scope*

1.1 This specification covers a group of common requirements that shall apply to carbon, alloy, stainless steel, and nickel alloy bolting under any of the following ASTM Specifications (or under any other ASTM Specifications that invoke this specification or portions thereof):

Title of Specifications	ASTM Designation
Alloy-Steel and Stainless Steel Bolting Materials for High-Temperature Service	A193/A193M
Carbon and Alloy Steel Nuts for Bolts for High Pressure and High-Temperature Service	A194/A194M
Alloy Steel Bolting Materials for Low-Temperature Service	A320/A320M
Alloy-Steel Turbine-Type Bolting Material Specially Heat Treated for High-Temperature Service	A437/A437M
High-Temperature Bolting Materials With Expansion Coefficients Comparable to Austenitic Stainless Steels	A453/A453M
Alloy-Steel Bolting Materials for Special Applications	A540/A540M
Precipitation-Hardening Bolting Material (UNS N07718) for High Temperature Service	A1014/A1014M
High Strength Precipitation Hardening and Duplex Stainless Steel Bolting for Special Purpose Applications	A1082/A1082M

1.2 In case of conflict, the requirements of the individual product specification shall prevail over those of this specification.

1.3 Fasteners are a wide-ranging classification that includes screws, bolts, nuts, washers, stud bolts, rivets, powder-actuated studs, staples, tacks, and pins. Bolting, which is composed of bolting materials, such as rods, bars, flats, and forgings, which are subsequently manufactured into bolting components, are a special sub-group of fasteners. Bolting materials and components have designated compositions and specific properties intended for applications in aggressive service where commercial generic fasteners may not be suitable or have insufficient fitness for purpose under certain conditions. These conditions include cryogenic or high temperature service, or excessive

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 A01.22 on Steel Forgings and Wrought Fittings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications.

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vibration, impact, or shock. To further address any other special service conditions where bolting is intended for use, additional requirements may be specified by mutual agreement between the purchaser and supplier.

1.4 Supplementary requirements are provided for use at the option of the purchaser. The supplementary requirements only apply when specified individually by the purchaser in the purchase order or contract.

1.5 This specification is expressed in both inch-pound units and in SI units. Unless the purchase order or contract specifies the applicable “M” specification designation (SI units) the inch-pound units shall apply. 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 nonconformance with the specification.

1.6 *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

The following documents shall form a part of this specification to the extent specified. The latest issue shall apply unless otherwise specified.

2.1 ASTM Standards:²

- A29/A29M Specification for General Requirements for Steel Bars, Carbon and Alloy, Hot-Wrought
- A193/A193M Specification for Alloy-Steel and Stainless Steel Bolting for High Temperature or High Pressure Service and Other Special Purpose Applications
- A194/A194M Specification for Carbon Steel, Alloy Steel, and Stainless Steel Nuts for Bolts for High Pressure or

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.

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

High Temperature Service, or Both
A320/A320M Specification for Alloy-Steel and Stainless Steel Bolting for Low-Temperature Service
A370 Test Methods and Definitions for Mechanical Testing of Steel Products
A380/A380M Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment, and Systems
A437/A437M Specification for Stainless and Alloy-Steel Turbine-Type Bolting Specially Heat Treated for High-Temperature Service
A453/A453M Specification for High-Temperature Bolting, with Expansion Coefficients Comparable to Austenitic Stainless Steels
A484/A484M Specification for General Requirements for Stainless Steel Bars, Billets, and Forgings
A540/A540M Specification for Alloy-Steel Bolting for Special Applications
A700 Guide for Packaging, Marking, and Loading Methods for Steel Products for Shipment
A751 Test Methods, Practices, and Terminology 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
A967/A967M Specification for Chemical Passivation Treatments for Stainless Steel Parts
A1014/A1014M Specification for Precipitation-Hardening Bolting (UNS N07718) for High Temperature Service
A1058 Test Methods for Mechanical Testing of Steel Products—Metric
A1082/A1082M Specification for High Strength Precipitation Hardening and Duplex Stainless Steel Bolting for Special Purpose Applications
E3 Guide for Preparation of Metallographic Specimens
E381 Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings
E384 Test Method for Microindentation Hardness of Materials
E566 Practice for Electromagnetic (Eddy Current) Sorting of Ferrous Metals
E1417/E1417M Practice for Liquid Penetrant Testing
E1444/E1444M Practice for Magnetic Particle Testing
E1916 Guide for Identification of Mixed Lots of Metals
F606/F606M Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, Direct Tension Indicators, and Rivets
F788/F788M Specification for Surface Discontinuities of Bolts, Screws, and Studs, Inch and Metric Series
F812 Specification for Surface Discontinuities of Nuts, Inch and Metric Series
F1470 Practice for Fastener Sampling for Specified Mechanical Properties and Performance Inspection
F2328 Test Method for Determining Decarburization and Carburization in Hardened and Tempered Threaded Steel Bolts, Screws, Studs, and Nuts

F2328M Test Method for Determining Decarburization and Carburization in Hardened and Tempered Threaded Steel Bolts, Screws, Studs, and Nuts (Metric)

2.2 *AIAG Standard*:³

AIAG B-5 02.00 Primary Metals Identification Tag Application Standard

2.3 *ASME Standards*:⁴

B1.1 Screw Threads

B1.13M Metric Screw Threads – M Profile

B1.2 Gages and Gaging for Unified Screw Threads

B1.3M Screw Thread Gaging Systems for Dimensional Acceptability of Metric Screw Threads

B18.2.1 Square and Hex Bolts and Screws

B18.2.2 Metric Heavy Hex Nuts

B18.2.3.3M Metric Heavy Hex Screws

B18.2.3.6M Metric Heavy Bolts

B18.2.4.6M Nuts for General Applications

B18.2.6 Fasteners Used in Structural Applications

B18.2.6M Metric Fasteners for Use in Structural Applications

B18.3 Hexagon Socket and Spline Socket Screws

B18.18 Quality Assurance for Fasteners

B18.31.2 Continuous Thread Stud, Double-End Stud, and Flange Bolting Stud (Stud Bolt) (Inch Series)

2.4 *ISO Standards*:⁵

ISO 4762 Hex Socket Cap Screw

2.5 *Other Documents*:

ASNT Recommended Practice No. SNT-TC-1A⁶

3. Terminology

3.1 *Definitions of Terms Specific to This Standard*:

3.1.1 *annealing*—material shall be uniformly reheated to a temperature above the transformation range and, after holding for a sufficient time at this temperature, cooled slowly to a temperature below the transformation range.

3.1.2 *bar*—a solid rolled or forged section that is long in relationship to its cross-sectional dimensions with a relatively constant cross section throughout its length. See Specification **A29/A29M** for definitions relating to the production of hot wrought and cold finished bars.

3.1.3 *bolting*—a general term which includes bolting materials (rolled or forged bars or blanks, wire, rod, threaded bar, rotary pierced or extruded seamless tubes, bored bars, or forged hollows from forged or rolled bar segments), which are manufactured into bolting components, including but not limited to, connectors, pins, restraining device components, shafts, bolts, nuts, screws, studs, and washers.

³ Available from Automotive Industry Action Group (AIAG), 26200 Lahser Rd., Suite 200, Southfield, MI 48033, <http://www.aiag.org>.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

⁵ Available from International Organization for Standardization (ISO), ISO Central Secretariat, BIBC II, Chemin de Blandonnet 8, CP 401, 1214 Vernier, Geneva, Switzerland, <http://www.iso.org>.

⁶ Available from American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlingate Ln., Columbus, OH 43228-0518, <http://www.asnt.org>.

3.1.4 *bolting components*—components, such as bolts, nuts, screws, studs, washers, connectors, and pins, are finished products which join, fasten, restrain, or position objects.

3.1.5 *bolting materials*—starting materials used for the manufacture of bolting components, such as rolled or forged or threaded solid bars, blanks, wires, rods, or tubes or other hollow sections, that may be further processed by heat treatment, cold working, forging, threading, or machining.

3.1.6 *certifying organization*—the company or association responsible for the conformance and marking of the product to the specification requirements.

3.1.7 *class*—a term used to differentiate between different heat treatment conditions or strength levels, or both, often within the same grade but sometimes within the same family of materials. May also apply to work hardened condition or strength level, or both.

3.1.8 *grade*—an alloy described individually and identified by its own designation in a table of chemical requirements within any specification.

3.1.9 *length, components subject to full size testing*—that portion of the bolting component whose body diameter is approximately the same as the nominal thread size.

3.1.10 *lot*—unless otherwise specified, a lot shall consist of:

3.1.10.1 *bolting, heat treated in batch type furnaces*—all bolting material of the same heat or cast of material, condition, finish, and size subjected to the same heat treatment in one tempering charge and submitted for inspection at the same time.

3.1.10.2 *bolting, heat treated in continuous type furnaces*—all bolting material of the same heat or cast of material, condition, finish, and size heat treated without interruption in a continuous type furnace.

3.1.10.3 *bolting, non heat treated (strain hardened)*—all bolting material of the same heat or cast of material, condition, reduction (cold work), finish, and size.

3.1.10.4 *components, machined from bolting material*—all bolting components machined from the same lot of bolting material defined as outlined in either 3.1.10.1 or 3.1.10.2, above without any subsequent heat treatment or hot or cold forming.

3.1.10.5 *components, heat treated in batch type furnaces*—all bolting component items produced by any manufacturing process (such as rolling, forging, or machining) from the same heat or cast of material, of the same prior condition, the same size, and subjected to the same heat treatment in one tempering charge.

3.1.10.6 *components, heat treated in continuous type furnaces*—all bolting component items produced by any manufacturing process (such as rolling, forging, or machining) from the same heat or cast of material, of the same prior condition, of the same size, and then subjected to the same heat treatment in a four hour period and in one tempering charge.

3.1.10.7 *components, non heat treated (strain hardened)*—all bolting components of the same heat or cast of material, condition, reduction (cold work), finish, and size.

3.1.10.8 *solution treat or treatment (or solution annealing)*—material shall be heated to a temperature that causes the carbides to go into solution and then quenched in water or rapidly cooled by other means to prevent re-precipitation.

3.1.10.9 *stress relieving*—material shall be uniformly heated to the selected stress relieving temperature, held long enough to reduce stresses and then cooled at a rate that will result in the properties required for the material grade and minimize the development of new residual stresses.

3.1.10.10 *strain hardened material*—austenitic stainless steel material which has been subjected to cold working sufficient to cause a significant increase in strength.

3.2 *Definitions*—For definitions of other terms used in this specification, refer to Terminology A941.

4. Ordering Information

4.1 It is the purchaser's responsibility to specify in the purchase order all information necessary to purchase the needed material. Examples of such information include, but are not limited, to the following:

4.1.1 Quantity and size,

4.1.2 Product specification number with grade, class, type, as applicable, and including the product specification year date,

4.1.3 Choice of testing track from the options listed in Test Methods A1058 when material is ordered to an M suffix (SI units) product standard. If the choice of test track is not specified in the order, then the default ASTM track shall be used as noted in Test Methods A1058.

4.1.4 Any additional information required by the individual product specification,

4.1.5 Supplementary requirements,

4.1.6 Additional requirements (see 5.3, 5.5, 5.6, 6.1, 7.4, 13.1, 13.3.1, 13.3.3, 13.5.2, 13.6, 15.8, and 19.1).

4.1.7 Additional ordering options provided in the individual product specification, and

4.1.8 Dimensions (diameter, length of point, overall length, finish, shape, threads, etc.).

5. Melting Process

5.1 The steel shall be produced by any of the following processes: basic-oxygen, electric-furnace, or vacuum-induction melting (VIM). The molten steel may be vacuum-treated prior to or during pouring of the ingot or strand casting.

5.2 Unless otherwise specified in the individual product specification, the steel shall be fully killed. Use of the basic oxygen process shall be limited to grades containing less than 6 % chromium.

5.3 If a specific type of melting is required by the purchaser, it shall be stated on the purchase order.

5.4 The primary melting may incorporate separate degassing or refining and may be followed by secondary melting such as electroslag remelting or vacuum remelting. If secondary melting is employed, the heat shall be defined as all of the ingot remelted from a single primary heat.