



Standard Test Methods for Chemical Analysis of Tool Steels and Other Similar Medium- and High-Alloy Steels¹

This standard is issued under the fixed designation E352; 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 These test methods cover the chemical analysis of tool steels and other similar medium- and high-alloy steels having chemical compositions within the following limits:

Element	Composition Range, %
Aluminum	0.005 to 1.5
Boron	0.001 to 0.10
Carbon	0.03 to 2.50
Chromium	0.10 to 14.0
Cobalt	0.10 to 14.0
Copper	0.01 to 2.0
Lead	0.001 to 0.01
Manganese	0.10 to 15.00
Molybdenum	0.01 to 10.00
Nickel	0.02 to 4.00
Nitrogen	0.001 to 0.20
Phosphorus	0.002 to 0.05
Silicon	0.10 to 2.50
Sulfur	0.002 to 0.40
Tungsten	0.01 to 21.00
Vanadium	0.02 to 5.50

1.2 The test methods in this standard are contained in the sections indicated below:

	Sections
Carbon, Total, by the Combustion—Thermal Conductivity Method— <i>Discontinued 1986</i>	
Carbon, Total, by the Combustion Gravimetric Method— <i>Discontinued</i>	
Chromium by the Atomic Absorption Method	(0.006 % to 1.00 %) 174
Chromium by the Peroxydisulfate Oxidation—Titration Method	(0.10 % to 14.00 %) 184
Chromium by the Peroxydisulfate-Oxidation Titrimetric Method— <i>Discontinued 1980</i>	
Cobalt by the Ion-Exchange—Potentiometric Titration Method	(2 % to 14 %) 52
Cobalt by the Nitroso-R-Salt Spectrophotometric Method	(0.10 % to 5.0 %) 60
Copper by the Neocuproine Spectrophotometric Method	(0.01 % to 2.00 %) 89

¹ These test methods are under the jurisdiction of the ASTM Committee E01 on Analytical Chemistry for Metals, Ores, and Related Materials and are the direct responsibility of Subcommittee E01.01 on Iron, Steel, and Ferroalloys.

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	Sections
Copper by the Sulfide Precipitation-Electrodeposition Gravimetric Method	(0.01 % to 2.0 %) 70
Lead by the Ion-Exchange—Atomic Absorption Method	(0.001 % to 0.01 %) 99
Nickel by the Dimethylglyoxime Gravimetric Method	(0.1 % to 4.0 %) 144
Manganese by the Periodate Spectrophotometric Method	(0.10 % to 5.00 %) 8
Molybdenum by the Ion Exchange—8-Hydroxyquinoline Gravimetric Method	203
Molybdenum by the Spectrophotometric Method	(0.01 % to 1.50 %) 162
Phosphorus by the Alkalimetric Method	(0.01 % to 0.05 %) 136
Phosphorus by the Molybdenum Blue Spectrophotometric Method	(0.002 % to 0.05 %) 18
Silicon by the Gravimetric Method	(0.10 % to 2.50 %) 45
Sulfur by the Gravimetric Method— <i>Discontinued 1988</i>	
Sulfur by the Combustion-Iodate Titration Method— <i>Discontinued</i>	
Sulfur by the Chromatographic Gravimetric Method— <i>Discontinued 1980</i>	
Tin by the Solvent Extraction—Atomic Absorption Method	(0.002 % to 0.10 %) 152
Vanadium by the Atomic Absorption Method	(0.006 % to 0.15 %) 193

1.3 Test methods for the determination of carbon and sulfur not included in this standard can be found in Test Methods E1019.

1.4 Some of the composition ranges given in 1.1 are too broad to be covered by a single test method and therefore this standard contains multiple test methods for some elements. The user must select the proper test method by matching the information given in the Scope and Interference sections of each test method with the composition of the alloy to be analyzed.

1.5 The values stated in SI units are to be regarded as standard.

1.6 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.* Specific hazards statements are given in Section 6 and in special “Warning” paragraphs throughout these test methods.

2. Referenced Documents

2.1 *ASTM Standards*:²

- D1193 Specification for Reagent Water
 - E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
 - E50 Practices for Apparatus, Reagents, and Safety Considerations for Chemical Analysis of Metals, Ores, and Related Materials
 - E60 Practice for Analysis of Metals, Ores, and Related Materials by Spectrophotometry
 - E135 Terminology Relating to Analytical Chemistry for Metals, Ores, and Related Materials
 - E173 Practice for Conducting Interlaboratory Studies of Methods for Chemical Analysis of Metals (Withdrawn 1998)³
 - E350 Test Methods for Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron
 - E351 Test Methods for Chemical Analysis of Cast Iron—All Types
 - E353 Test Methods for Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys
 - E882 Guide for Accountability and Quality Control in the Chemical Analysis Laboratory
 - E1019 Test Methods for Determination of Carbon, Sulfur, Nitrogen, and Oxygen in Steel, Iron, Nickel, and Cobalt Alloys by Various Combustion and Fusion Techniques
 - E1024 Guide for Chemical Analysis of Metals and Metal Bearing Ores by Flame Atomic Absorption Spectrophotometry (Withdrawn 2004)³
 - E1806 Practice for Sampling Steel and Iron for Determination of Chemical Composition
- ### 2.2 *Other Document*:⁴
- ISO 5725 Precision of Test Methods—Determination of Repeatability and Reproducibility for Inter-Laboratory Tests

3. Terminology

3.1 For definitions of terms used in these test methods, refer to Terminology E135.

4. Significance and Use

4.1 These test methods for the chemical analysis of metals and alloys are primarily intended as referee methods to test such materials for compliance with compositional specifications particularly those under the jurisdiction of ASTM Committee A1 on Steel, Stainless Steel, and Related Alloys. It is assumed that all who use these test methods will be trained analysts capable of performing common laboratory procedures

skillfully and safely. It is expected that work will be performed in a properly equipped laboratory under appropriate quality control practices such as those described in Guide E882.

5. Apparatus, Reagents, and Instrumental Practices

5.1 *Apparatus*—Specialized apparatus requirements are listed in the “Apparatus” Section in each method.

5.2 *Reagents*:

5.2.1 *Purity of Reagents*—Unless otherwise indicated, all reagents used in these test methods shall conform to the “Reagent Grade” Specifications of the American Chemical Society.⁵ Other chemicals may be used, provided it is first ascertained that they are of sufficiently high purity to permit their use without adversely affecting the expected performance of the determination, as indicated in the section on “Precision and Bias.”

5.2.2 *Purity of Water*—Unless otherwise indicated, references to water shall be understood to mean reagent water as conforming to Type I or Type II of Specification D1193. Type III or IV may be used if they effect no measurable change in the blank or sample.

5.3 *Spectrophotometric Practice*—Spectrophotometric practice prescribed in these test methods shall conform to Practice E60.

6. Hazards

6.1 For precautions to be observed in the use of certain reagents and equipment in these methods, refer to Practices E50.

7. Sampling

7.1 For procedures for sampling the material, reference shall be made to Practice E1806.

8. Interlaboratory Studies and Rounding Calculated Values

8.1 These test methods have been evaluated in accordance with Practice E173 (withdrawn 1997) or ISO 5725. The Reproducibility R₂ of E173 corresponds to the Reproducibility Index R of E1601. The Repeatability R₁ of E173 corresponds to the Repeatability Index r of E1601.

8.2 Calculated values shall be rounded to the desired number of places in accordance with the Rounding Method of Practice E29.

MANGANESE BY THE METAPERIODATE SPECTROPHOTOMETRIC METHOD

9. Scope

9.1 This method covers the determination of manganese in compositions from 0.10 % to 5.00 %.

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.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁵ “Reagent Chemicals, American Chemical Society Specifications,” American Chemical Society, Washington, DC. For suggestions on the testing of Reagents not listed by the American Chemical Society, see the *United States Pharmacopeia and National Formulary*, U.S. Pharmacopeial Convention, Inc. (USPC), Rockville, MD.

10. Summary of Method

10.1 Manganous ions are oxidized to permanganate ions by treatment with periodate. Tungsten when present at compositions greater than 0.5 % is kept in solution with phosphoric acid. Solutions of the samples are fumed with HClO_4 so that the effect of periodate is limited to the oxidation of manganese. Spectrophotometric measurement is made at approximately 545 nm.

11. Concentration Range

11.1 The recommended concentration range is 0.15 mg to 0.8 mg of manganese per 50 mL of solution, using a 1-cm cell (Note 1) and a spectrophotometer with a band width of 10 nm or less.

NOTE 1—This method has been written for cells having a 1-cm light path and a “narrow-band” instrument. The concentration range depends upon band width and spectral region used as well as cell optical path length. Cells having other dimensions may be used, provided suitable adjustments can be made in the amounts of sample and reagents used.

12. Stability of Color

12.1 The color is stable for at least 24 h.

13. Interferences

13.1 HClO_4 treatment, which is used in the procedure, yields solutions which can be highly colored due to the presence of Cr (VI) ions. Although these ions and other colored ions in the sample solution undergo no further change in color quality upon treatment with metaperiodate ion, the following precautions must be observed when filter photometers are used: Select a filter with maximum transmittance between 545 nm and 565 nm. The filter must transmit not more than 5 % of its maximum at a wavelength shorter than 530 nm. The band width of the filter should be less than 30 nm when measured at 50 % of its maximum transmittance. Similar restrictions apply with respect to the wavelength region employed when other “wide-band” instruments are used.

13.2 The spectral transmittance curve of permanganate ions exhibits two useful minima, one at approximately 526 nm, and the other at 545 nm. The latter is recommended when a “narrow-band” spectrophotometer is used.

13.3 Tungsten, when present in amounts of more than 0.5 % interferes by producing a turbidity in the final solution. A special procedure is provided for use with samples containing more than 0.5 % tungsten which eliminates the problem by preventing the precipitation of the tungsten.

14. Reagents

14.1 *Manganese, Standard Solution* (1 mL = 0.032 mg Mn)—Transfer the equivalent of 0.4000 g of assayed, high-purity manganese (purity: 99.99 % minimum), to a 500-mL volumetric flask and dissolve in 20 mL of HNO_3 by heating. Cool, dilute to volume, and mix. Using a pipet, transfer 20 mL to a 500-mL volumetric flask, dilute to volume, and mix.

14.2 *Nitric-Phosphoric Acid Mixture*—Cautiously, while stirring, add 100 mL of HNO_3 and 400 mL of H_3PO_4 to 400 mL of water. Cool, dilute to 1 L, and mix. Prepare fresh as needed.

14.3 *Potassium Metaperiodate Solution* (7.5 g/L)—Dissolve 7.5 g of potassium metaperiodate (KIO_4) in 200 mL of hot HNO_3 (1 + 1), add 400 mL of H_3PO_4 , cool, dilute to 1 L, and mix.

14.4 *Water, Pretreated with Metaperiodate*—Add 20 mL of KIO_4 solution to 1 L of water, mix, heat at not less than 90 °C for 20 min to 30 min, and cool. Use this water to dilute solutions to volume that have been treated with KIO_4 solution to oxidize manganese, and thus avoid reduction of permanganate ions by any reducing agents in the untreated water. **Warning**—Avoid the use of this water for other purposes.

15. Preparation of Calibration Curve

15.1 *Calibration Solutions*—Using pipets, transfer 5 mL, 10 mL, 15 mL, 20 mL, and 25 mL of manganese standard solution (1 mL = 0.032 mg Mn) to 50-mL borosilicate glass volumetric flasks, and, if necessary, dilute to approximately 25 mL. Proceed as directed in 15.3.

15.2 *Reference Solution*—Transfer approximately 25 mL of water to a 50-mL borosilicate glass volumetric flask. Proceed as directed in 15.3.

15.3 *Color Development*—Add 10 mL of KIO_4 solution, and heat the solutions at not less than 90 °C for 20 min to 30 min (Note 2). Cool, dilute to volume with pretreated water, and mix.

NOTE 2—Immersing the flasks in a boiling water bath is a preferred means of heating them for the specified period to ensure complete color development.

15.4 Spectrophotometry:

15.4.1 *Multiple-Cell Spectrophotometer*—Measure the cell correction using the Reference Solution (15.2) in absorption cells with a 1-cm light path and using a light band centered at approximately 545 nm. Using the test cell, take the spectrophotometric readings of the calibration solutions versus the Reference Solution (15.2)

15.4.2 *Single-Cell Spectrophotometer*—Transfer a suitable portion of the Reference Solution (15.2) to an absorption cell with a 1-cm light path and adjust the spectrophotometer to the initial setting, using a light band centered at approximately 545 nm. While maintaining this adjustment, take the spectrophotometric readings of the calibration solutions.

15.5 *Calibration Curve*—Follow the instrument manufacturer’s instructions for generating the calibration curve.

16. Procedure

16.1 *Test Solutions*—Select and weigh a sample in accordance with the following:

Manganese, %	Sample Weight, g	Tolerance in Sample Weight, mg	Dilution, mL	Aliquot Volume, mL
0.10 to 0.5	0.80	0.5	100	20
0.45 to 1.0	0.35	0.3	100	20
0.85 to 2.0	0.80	0.5	500	20
0.95 to 5.0	0.80	0.5	500	10

Transfer it to a 300-mL Erlenmeyer flask.

16.1.1 *For Samples Containing Not More Than 0.5 % Tungsten:*