

**SPECIFICATION FOR PRESSURE VESSEL PLATES,
CARBON STEEL, FOR MODERATE- AND
LOWER-TEMPERATURE SERVICE**



SA-516/SA-516M



(Identical with ASTM Specification A516/A516M-17.)

Standard Specification for Pressure Vessel Plates, Carbon Steel, for Moderate- and Lower-Temperature Service

1. Scope

1.1 This specification covers carbon steel plates intended primarily for service in welded pressure vessels where improved notch toughness is important.

1.2 Plates under this specification are available in four grades having different strength levels as follows:

Grade U.S. [SI]	Tensile Strength, ksi [MPa]
55 [380]	55–75 [380–515]
60 [415]	60–80 [415–550]
65 [450]	65–85 [450–585]
70 [485]	70–90 [485–620]

1.3 The maximum thickness of plates is limited only by the capacity of the composition to meet the specified mechanical property requirements.

1.4 For plates produced from coil and furnished without heat treatment or with stress relieving only, the additional requirements, including additional testing requirements and the reporting of additional test results of Specification A20/A20M apply.

1.5 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must 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

2.1 ASTM Standards:

A20/A20M Specification for General Requirements for Steel Plates for Pressure Vessels

A435/A435M Specification for Straight-Beam Ultrasonic Examination of Steel Plates

A577/A577M Specification for Ultrasonic Angle-Beam Examination of Steel Plates

A578/A578M Specification for Straight-Beam Ultrasonic Examination of Rolled Steel Plates for Special Applications

3. General Requirements and Ordering Information

3.1 Material supplied to this product specification shall conform to Specification A20/A20M, which outlines the testing and retesting methods and procedures, permissible variations in dimensions and mass, quality and repair of defects, marking, loading, and ordering information.

3.2 In addition to the basic requirements of this specification, certain supplementary requirements are available where additional control, testing, or examination is required to meet end use requirements. The purchaser is referred to the listed supplementary requirements in this specification and to the detailed requirements in Specification A20/A20M.

3.3 If the requirements of this specification are in conflict with the requirements of Specification A20/A20M, the requirements of this specification shall prevail.

3.4 Coils are excluded from qualification to this specification until they are processed into finished plates. Plates produced from coil means plates that have been cut to individual lengths from coil. The processor directly controls, or is responsible for, the operations involved in the processing of coils into finished plates. Such operations include decoiling, leveling, cutting to length, testing, inspection, conditioning, heat treatment (if applicable), packaging, marking, loading for shipment, and certification.

TABLE 1 Chemical Requirements

Elements	Composition, %			
	Grade 55 [Grade 380]	Grade 60 [Grade 415]	Grade 65 [Grade 450]	Grade 70 [Grade 485]
Carbon, max: ^{A,B}				
½ in. [12.5 mm] and under	0.18	0.21	0.24	0.27
Over ½ in. to 2 in. [12.5 to 50 mm], incl	0.20	0.23	0.26	0.28
Over 2 in. to 4 in. [50 to 100 mm], incl	0.22	0.25	0.28	0.30
Over 4 to 8 in. [100 to 200 mm], incl	0.24	0.27	0.29	0.31
Over 8 in. [200 mm]	0.26	0.27	0.29	0.31
Manganese: ^B				
½ in. [12.5 mm] and under:				
Heat analysis	0.60–0.90	0.60–0.90 ^C	0.85–1.20	0.85–1.20
Product analysis	0.55–0.98	0.55–0.98 ^C	0.79–1.30	0.79–1.30
Over ½ in. [12.5 mm]:				
Heat analysis	0.60–1.20	0.85–1.20	0.85–1.20	0.85–1.20
Product analysis	0.55–1.30	0.79–1.30	0.79–1.30	0.79–1.30
Phosphorus, max ^A	0.025	0.025	0.025	0.025
Sulfur, max ^A	0.025	0.025	0.025	0.025
Silicon:				
Heat analysis	0.15–0.40	0.15–0.40	0.15–0.40	0.15–0.40
Product analysis	0.13–0.45	0.13–0.45	0.13–0.45	0.13–0.45

^A Applies to both heat and product analyses.

^B For each reduction of 0.01 percentage point below the specified maximum for carbon, an increase of 0.06 percentage point above the specified maximum for manganese is permitted, up to a maximum of 1.50 % by heat analysis and 1.60 % by product analysis.

^C Grade 60 plates ½ in. [12.5 mm] and under in thickness may have 0.85–1.20 % manganese on heat analysis, and 0.79–1.30 % manganese on product analysis.

TABLE 2 Tensile Requirements

	Grade			
	55 [380]	60 [415]	65 [450]	70 [485]
Tensile strength, ksi [MPa]	55–75 [380–515]	60–80 [415–550]	65–85 [450–585]	70–90 [485–620]
Yield strength, min, ^A ksi [MPa]	30 [205]	32 [220]	35 [240]	38 [260]
Elongation in 8 in. [200 mm], min, % ^B	23	21	19	17
Elongation in 2 in. [50 mm], min, % ^B	27	25	23	21

^A Determined by either the 0.2 % offset method or the 0.5 % extension-under-load method.

^B See Specification A20/A20M for elongation adjustment.

NOTE 1—For plates produced from coil and furnished without heat treatment or with stress relieving only, three test results are reported for each qualifying coil. Additional requirements regarding plate produced from coil are described in Specification A20/A20M.

3.5 If the requirements of this specification are in conflict with the requirements of Specification A20/A20M, the requirements of this specification shall prevail.

4. Materials and Manufacture

4.1 *Steelmaking Practice*—The steel shall be killed and shall conform to the fine austenitic grain size requirement of Specification A20/A20M.

5. Heat Treatment

5.1 Plates 1.50 in. [40 mm] and under in thickness are normally supplied in the as-rolled condition. The plates may be ordered normalized or stress relieved, or both.

5.2 Plates over 1.50 in. [40 mm] in thickness shall be normalized.

5.3 When notch-toughness tests are required on plates 1½ in. [40 mm] and under in thickness, the plates shall be normalized unless otherwise specified by the purchaser.

5.4 If approved by the purchaser, cooling rates faster than those obtained by cooling in air are permissible for improvement of the toughness, provided the plates are subsequently tempered in the temperature range 1100 to 1300°F [595 to 705°C].

6. Chemical Composition

6.1 The steel shall conform to the chemical requirements given in Table 1 unless otherwise modified in accordance with Supplementary Requirement S17, Vacuum Carbon-Deoxidized Steel, in Specification A20/A20M.

7. Mechanical Properties

7.1 *Tension Test*—The plates, as represented by the tension test specimens, shall conform to the requirements given in Table 2.

8. Keywords

8.1 carbon steel; carbon steel plate; pressure containing parts; pressure vessel steels; steel plates for pressure vessels

SUPPLEMENTARY REQUIREMENTS

Supplementary requirements shall not apply unless specified in the purchase order.

A list of standardized supplementary requirements for use at the option of the purchaser is included in ASTM Specification A20/A20M. Those that are considered suitable for use with this specification are listed below by title.

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| <p>S1. Vacuum Treatment,
 S2. Product Analysis,
 S3. Simulated Post-Weld Heat Treatment of Mechanical Test Coupons,
 S4.1 Additional Tension Test,
 S5. Charpy V-Notch Impact Test,
 S6. Drop Weight Test (for Material 0.625 in. [16 mm] and over in Thickness),
 S7. High-Temperature Tension Test,</p> | <p>S8. Ultrasonic Examination in accordance with Specification A435/A435M,
 S9. Magnetic Particle Examination,
 S11. Ultrasonic Examination in accordance with Specification A577/A577M,
 S12. Ultrasonic Examination in accordance with Specification A578/A578M, and
 S17. Vacuum Carbon-Deoxidized Steel.</p> |
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ADDITIONAL SUPPLEMENTARY REQUIREMENTS

In addition, the following supplementary requirement is suitable for this application.

S54. Requirements for Carbon Steel Plate for Hydrofluoric Acid Alkylation Service

S54.1 Plates shall be provided in the normalized heat-treated condition.

S54.2 The maximum carbon equivalent (CE) shall be as follows:

Plate thickness less than or equal to 1 in. [25 mm]:

$$\text{CE maximum} = 0.43$$

Plate thickness greater than 1 in. [25 mm]:

$$\text{CE maximum} = 0.45$$

S54.3 Determine the CE as follows:

$$\text{CE} = \text{C} + \text{Mn}/6 + (\text{Cr} + \text{Mo} + \text{V})/5 + (\text{Ni} + \text{Cu})/15$$

S54.4 Vanadium (V) and niobium (Nb) maximum content based on heat analysis shall be:

$$\text{Maximum vanadium} = 0.02 \%$$

$$\text{Maximum niobium} = 0.02 \%$$

$$\text{Maximum vanadium plus niobium} = 0.03 \%$$

(Note: niobium = columbium.)

S54.5 The maximum composition based on heat analysis of nickel (Ni) plus copper (Cu) shall be 0.15 %.

S54.6 The minimum carbon (C) content based on heat analysis shall be 0.18 %. The maximum C content shall be as specified for the ordered grade.

S54.7 Welding consumables for repair welds shall be of the low-hydrogen type. E60XX electrodes shall not be used and the resulting weld chemistry shall meet the same chemistry requirements as the base metal.

S54.8 In addition to the requirements for product marking in the specification, an "HF-N" stamp or marking shall be provided on each plate to identify that the plate complies with this supplementary requirement.