



Standard Specification for High-Strength Low-Alloy Columbium-Vanadium Structural Steel¹

This standard is issued under the fixed designation A 572/A 572M; 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.

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

1. Scope

1.1 This specification covers five grades of high-strength low-alloy structural steel shapes, plates, sheet piling, and bars. Grades 42 [290], 50 [345], and 55 [380] are intended for riveted, bolted, or welded structures. Grades 60 [415] and 65 [450] are intended for riveted or bolted construction of bridges, or for riveted, bolted, or welded construction in other applications.

1.2 For applications, such as welded bridge construction, where notch toughness is important, notch toughness requirements are to be negotiated between the purchaser and the producer.

1.3 The use of columbium, vanadium, titanium, nitrogen, or combinations thereof, within the limitations noted in Section 5, is required; the selection of type (1, 2, 3, 4, or 5) is at the option of the producer, unless otherwise specified by the purchaser. (See Supplementary Requirement S90.)

1.4 The maximum thicknesses available in the grades and products covered by this specification are shown in Table 1.

1.5 When the steel is to be welded, a welding procedure suitable for the grade of steel and intended use or service is to be utilized. See Appendix X3 of Specification A 6/A 6M for information on weldability.

1.6 Supplementary requirements are provided for use where additional testing or additional restrictions are desired by the purchaser. Such requirements apply only when specified in the purchase order.

1.7 For Group 4 and 5 wide flange shapes for use in tension, it is recommended that the purchaser consider specifying supplementary requirements, such as fine austenitic grain size and Charpy V-notch impact testing.

1.8 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 is to

be used independently of the other, without combining values in any way.

1.9 The text of this specification contains notes or footnotes, or both, that provide explanatory material. Such notes and footnotes, excluding those in tables and figures, do not contain any mandatory requirements.

1.10 For plates cut from coiled product, the additional requirements, including additional testing requirements and the reporting of additional tests, of A 6/A 6M apply.

2. Referenced Documents

2.1 ASTM Standards:

A 6/A 6M Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling²

A 36/A 36M Specification for Carbon Structural Steel²

A 514/A 514M Specification for High-Yield Strength, Quenched and Tempered Alloy Steel Plate, Suitable for Welding²

3. General Requirements for Delivery

3.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification A 6/A 6M, for the ordered material, unless a conflict exists in which case this specification shall prevail.

3.1.1 Coiled product is excluded from qualification to this specification until levelled and cut to length. Plates produced from coil means plates that have been cut to individual lengths from a coiled product and are furnished without heat treatment. The processor decoils, levels, cuts to length and marks the product. The processor is responsible for performing and certifying all tests, examinations, repairs, inspections or operations not intended to affect the properties of the material. For plates produced from coils, two test results shall be reported for each qualifying coil (Note 1).

NOTE 1—Additional requirements regarding plate from coil are described in A 6/A 6M.

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel and Related Alloys, and is the direct responsibility of Subcommittee A01.02 on Structural Steel for Bridges, Buildings, Rolling Stock, and Ships.

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² Annual Book of ASTM Standards, Vol 01.04.

TABLE 1 Maximum Product Thickness

Grade	Yield Point, min		Maximum Thickness or Size				
	ksi	[MPa]	Plates and Bars		Structural Shapes Groups ^A	Sheet Piling	Zees and Rolled Tees
			in.	[mm]			
42 [290] ^B	42	[290]	6	[150]	all	all	all
50 [345] ^B	50	[345]	4 ^C	[100]	all	all	all
55 [380]	55	[380]	2	[50]	all	all	all
60 [415] ^B	60	[415]	1¼	[32]	1, 2, and 3	all	all
65 [450]	65	[450]	1¼	[32]	1, 2, and 3	not available	all

^A See Specification A 6/A 6M.

^B In the above tabulation, Grades 42, 50, and 60 [290, 345, and 415], are the yield point levels most closely approximating a geometric progression pattern between 36 ksi [250 MPa], min, yield point steels covered by Specification A 36/A 36M and 100 ksi [690 MPa], min, yield strength steels covered by Specification A 514/A 514M.

^C Round bars up to and including 9 in. [225 mm] maximum diameter are permissible.

**TABLE 2 Chemical Requirements^A
(Heat Analysis)**

Diameter Thickness, or Distance Between Parallel Faces, in. [mm] Plates and Bars	Structural Shapes Groups ^B	Grade	Carbon, max, %	Manganese, ^C max, %	Phosphorus, max, %	Sulfur, max, %	Silicon ^D	
							Plates to 1½-in. [40-mm] Thick, Shapes to 426 lb/ft [634 kg/m], Sheet Piling, Bars, Zees, and Rolled Tees ^E	Plates Over 1½-in. [40-mm] Thick and Shapes Over 426 lb/ft [634 kg/m]
							max, %	range, %
6 [150]	all	42 [290]	0.21	1.35 ^F	0.04	0.05	0.40	0.15–0.40
4 [100] ^G	all	50 [345]	0.23	1.35 ^F	0.04	0.05	0.40	0.15–0.40
2 [50]	all	55 [380]	0.25	1.35 ^F	0.04	0.05	0.40	0.15–0.40
1¼ [32]	1,2,3	60 [415]	0.26	1.35 ^F	0.04	0.05	0.40	^H
>½ – 1¼ [13–32]	2,3	65 [450]	0.23	1.65	0.04	0.05	0.40	^H
≤½ [13] ^I	1 ^I	65 [450]	0.26	1.35	0.04	0.05	0.40	^H

^A Copper when specified shall have a minimum content of 0.20 % by heat analysis (0.18 % product analysis).

^B See Specification A 6/A 6M.

^C Manganese, minimum by heat analysis of 0.80 % (0.75 % product analysis) shall be required for all plates over ¾ in. [10 mm] in thickness; a minimum of 0.50 % (0.45 % product analysis) shall be required for plates ¾ in. [10 mm] and less in thickness, and for all other products. The manganese to carbon ratio shall not be less than 2 to 1.

^D Silicon content in excess of 0.40 % by heat analysis must be negotiated.

^E Bars over 1½ in. [40 mm] in diameter, thickness, or distance between parallel faces, shall be made by a killed steel practice.

^F For each reduction of 0.01 % below the specified carbon maximum, an increase of 0.06 % manganese above the specified maximum will be permitted up to a maximum of 1.50 %.

^G Round bars up to and including 9 in. [225 mm] maximum diameter are permissible.

^H The size and grade is not described in this specification.

^I An alternative chemical requirement with a maximum carbon of 0.21 % and a maximum manganese of 1.65 % is permissible with the balance of the elements as shown in Table 2.

4. Process

4.1 The steel shall be made by one or more of the following processes: open-hearth, basic-oxygen, or electric-furnace.

4.2 Rimmed-type steels shall not be used.

5. Chemical Composition

5.1 The heat analysis shall conform to the requirements prescribed in Table 2 and Table 4.

5.2 The steel shall conform on product analysis to the requirements prescribed in Table 2 and Table 4 subject to the product analysis tolerances in Specification A 6/A 6M.

6. Mechanical Properties

6.1 Tensile Properties:

6.1.1 The material as represented by the test specimens shall conform to the tensile properties given in Table 3.

7. Keywords

7.1 bars; bolted construction; bridges; buildings; columbium-vanadium; high-strength; low-alloy; plates; riveted

TABLE 3 Tensile Requirements^A

Grade	Yield Point, min		Tensile Strength, min		Minimum Elongation, % ^{B,C,D}	
	ksi	[MPa]	ksi	[MPa]	in 8 in. [200 mm]	in 2 in. [50 mm]
42 [290]	42	[290]	60	[415]	20	24
50 [345]	50	[345]	65	[450]	18	21
55 [380]	55	[380]	70	[485]	17	20
60 [415]	60	[415]	75	[520]	16	18
65 [450]	65	[450]	80	[550]	15	17

^A See specimen Orientation under the Tension Tests section of Specification A 6/A 6M.

^B Elongation not required to be determined for floor plate.

^C For wide flange shapes over 426 lb/ft [634 kg/m] elongation in 2 in. [50 mm] of 19 % minimum applies.

^D For plates wider than 24 in. [600 mm], the elongation requirement is reduced two percentage points for Grades 42, 50 and 55 [290, 345 and 380], and three percentage points for Grades 60 and 65 [415 and 450]. See elongation requirement adjustments in the Tension Tests section of Specification A 6/A 6M.

construction; shapes; sheet piling; steel; structural steel; welded construction

TABLE 4 Alloy Content

Type ^A	Elements	Heat Analysis, %
1	Columbium ^B	0.005–0.05 ^C
2	Vanadium	0.01–0.15
3	Columbium ^B	0.005–0.05 ^C
	Vanadium	0.01–0.15
	Columbium plus Vanadium	0.02–0.15 ^D
4	Vanadium	0.01–0.15 ^E
	Nitrogen	0.015 max ^E
5	Titanium	0.006–0.04
	Nitrogen	0.003–0.015
	Vanadium	0.06 max

^AAlloy content shall be in accordance with Type 1, 2, 3, 4 or 5 and the contents of the applicable elements shall be reported on the test report.

^BColumbium shall be restricted to the following thicknesses and sizes unless killed steel is furnished. Killed steel shall be confirmed by a statement of killed steel on the test report, or by a report on the presence of a sufficient quantity of a strong deoxidizing element, such as silicon at 0.10 % or higher, or aluminum at 0.015 % or higher. See table below.

^CProduct analysis limits = 0.004 to 0.06 %.

^DProduct analysis limits = 0.01 to 0.16 %.

^EThe vanadium to nitrogen ratio shall be 4 to 1 or greater.

Grades	Maximum Plate, Bar, Sheet Piling, Zees, and Rolled Tee Thicknesses, in. [mm]		Structural Shape Size Groupings (Specification A 6/A 6M, Table A)
42, 50 and 55 [290, 345 and 380]	¾	[20]	Groups 1 and 2 Groups 1 and 2
60 and 65 [415 and 450]	½	[13]	Group 1 Group 1

SUPPLEMENTARY REQUIREMENTS

Supplementary requirements shall not apply unless specified in the order or contract. Standardized supplementary requirements for use at the option of the purchaser are listed in Specification A 6/A 6M. Those that are considered suitable for use with this specification are listed by title:

S5. Charpy V-Notch Impact Test.

S14. Bend Test.

S18. Maximum Tensile Strength

In addition, the following supplementary requirements are suitable for use:

S81. Tensile Strength

S81.1 For Grade 50 [345] steel of thicknesses ¾-in. [20 mm] and less, the tensile strength shall be a minimum of 70 ksi [485 MPa].

S91. Fine Austenitic Grain Size

S91.1 The steel shall be killed with a fine austenitic grain size.

S90. Type

S90.1 The specific type of steel shall be as specified by the purchaser in the order or contract.

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