Designation: A 299/A 299M – 04

Standard Specification for Pressure Vessel Plates, Carbon Steel, Manganese-Silicon[1]

This standard is issued under the fixed designation A 299/A 299M; 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.

Note—Grades A and B were added editorially to the entry for Carbon in Table 1 and the year date changed on Feb. 2, 2004.

1. Scope*

1.1 This specification[2] covers manganese-silicon carbon steel plates for use in welded boilers and other pressure vessels.

1.2 Plates under this specification are produced in two grades. The specified minimum the yield strength decreases on thicknesses over 1 in. [25 mm].

1.3 The maximum thickness of plates is limited only by the capacity of the composition to meet the specified mechanical property requirements; however, current practice normally limits the maximum thickness of plates furnished under this specification to 8 in. [200 mm].

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 A 20/A 20M 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.

2. Referenced Documents

2.1 *ASTM Standards:* [3]

A 20/A 20M Specification for General Requirements for Steel Plates for Pressure Vessels

3. General Requirements and Ordering Information

3.1 Plates supplied to this product specification shall conform to Specification A 20/A 20M, which outlines the testing and retesting methods and procedures, permissible variations in dimensions and mass, quality and repair of defects, marking, loading, and so forth.

3.2 Specification A 20/A 20M also establishes the rules for the ordering information that should be complied with when purchasing plates to this specification.

3.3 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.

3.4 The purchaser is referred to the listed supplementary requirements in this specification and to the detailed requirements in Specification A 20/A 20M.

3.5 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.

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 plates from coil are described in Specification A 20/A 20M.

3.6 If the requirements of this specification are in conflict with the requirements of Specification A 20/A 20M, 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 A 20/A 20M.

[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 A01.11 on Steel Plates for Boilers and Pressure Vessels.

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[2] For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-299/SA-299M in Section II of that Code.

[3] 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.**

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5. Heat Treatment

5.1 Plates 2 in. [50 mm] and under in thickness are normally supplied in the as-rolled condition. Plates may be ordered normalized or stress relieved, or both.

5.2 Plates over 2 in. [50 mm] in thickness shall be normalized.

6. Chemical Composition

6.1 The steel shall conform to the requirements given in Table 1 unless otherwise modified in accordance with Supplementary Requirement S17, Vacuum Carbon-Deoxidized Steel, in Specification A 20/A 20M.

7. Mechanical Properties

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

8. Keywords

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

TABLE 1 Chemical Requirements

Elements	Composition, %
†Carbon, max[A]:	
1 in. [25 mm] and under	
Grade A	0.26
Grade B	0.28
Over 1 in. [25 mm]	
Grade A	0.28
Grade B	0.30
Manganese:	
1 in. [25 mm] and under	
Heat analysis	0.90 to 1.40
Product analysis	0.84 to 1.52
Over 1 in. [25 mm]	
Heat analysis	0.90 to 1.50
Product analysis	0.84 to 1.62
Phosphorus, max[A]	0.035
Sulfur, max[A]	0.035
Silicon:	
Heat analysis	0.15 to 0.40
Product analysis	0.13 to 0.45

† Editorially corrected.

[A]Applies to both heat and product analyses.

TABLE 2 Tensile Requirements

	Grade A	Grade B
Tensile strength, ksi [MPa]	75–95 [515–655]	80-100 [550-690]
Yield strength, min,[A] ksi [MPa]:		
1 in. [25 mm] and under	42 [290]	47 [325]
Over 1 in. [25 mm]	40 [275]	45 [310]
Elongation in 8 in. [200 mm], min, %[B]	16	16
Elongation in 2 in. [50 mm], min, %[B]	19	19

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

[B]See the Elongation Requirement Adjustments subsection in the Tension Tests section of Specification A 20/A 20M.

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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 Specification A 20/A 20M. Those that are considered suitable for use with this specification are listed below by title.

S1. Vacuum Treatment,
S2. Product Analysis,
S3. Simulated Post-Weld Heat Treatment of Mechanical Test Coupons,
S4. Additional Tension Test,
S5. Charpy V-Notch Impact Test,
S6. Drop Weight Test,
S7. High-Temperature Tension Test,
S8. Ultrasonic Examination in accordance with Specification A 435/A 435M,
S9. Magnetic Particle Examination,
S11. Ultrasonic Examination in accordance with Specification A 577/A 577M,
S12. Ultrasonic Examination in accordance with Specification A 578/A 578M,
S17. Vacuum Carbon-Deoxidized Steel.

SUMMARY OF CHANGES

This section identifies the principal changes incorporated since A299/A299M-01 was issued:

(1) Table 1 - The current chemical requirements have been incorporated as a higher strength Grade B listed in Table 2. The current tensile requirements are incorporated with a lower carbon content requirement in Table 1 as Grade A.

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