

Standard Specification for Abrasion-Resistant Cast Irons¹

This standard is issued under the fixed designation A 532/A 532M; 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—The technical changes constituting this edition of the standard can also be found in A 532/A 532M – 93.

1. Scope

1.1 This specification covers a group of white cast irons that have been alloyed to secure high resistance to abrasive wear in the applications of the mining, milling, earth-handling, and manufacturing industries.

1.2 Simple and low-alloy white cast irons that consist essentially of iron carbides and pearlite are specifically excluded from this specification.

1.3 The values stated in inch-pound units or SI units are to be regarded separately as the standard. Within the text, 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:

E 10 Test Method for Brinell Hardness of Metallic Materials²

E 18 Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials²

E 92 Test Method for Vickers Hardness of Metallic Materials²

E 350 Test Methods for Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron³

E 351 Test Methods for Chemical Analysis of Cast Iron—All Types³

3. Ordering Information

3.1 Orders for material in this specification should include the following information:

3.1.1 Quantity,

3.1.2 Specification number, class, and type,

3.1.3 Description of the casting, pattern number, or drawing,

3.1.4 Chilling of the casting, if required (see 4.2),

4. Method of Manufacture

4.1 These alloys may be made by any suitable melting process.

4.2 If the casting is to be chilled or otherwise specially treated on any portion, the inquiries and the purchase order shall so state and a properly marked drawing of the casting will accompany both the inquiry and the purchase order.

5. Heat Treatment

5.1 The casting will be supplied in one of the following conditions:

5.1.1 As-cast,

5.1.2 As-cast and stress relieved,

5.1.3 Hardened,

5.1.4 Hardened and stress relieved, or

5.1.5 Softened for machining.

5.2 Unless otherwise specified by the purchaser, the manufacturer shall supply the castings in the heat treatment he deems best for the application.

5.3 If the heat treatment specified for delivered condition is not that of final use, it shall be the responsibility of the purchaser to provide the additional heat treatment.

5.4 Class II and Class III alloys are frequently ordered in the annealed condition with a maximum hardness of 400 HB. After machining operations are performed the castings may then be hardened. If both annealing and machining are to be performed by the manufacturer, as specified in the inquiry, contract, or order, the purchaser may then specify delivery in the hardened condition. If the purchaser specifies delivery in the annealed condition, subsequent hardening (and stress-relief, if it is desired) is the responsibility of the purchaser.

6. Chemical Composition

6.1 The composition of the metal of a class and type produced under this specification shall fall within the ranges prescribed in Table 1 for that class and type.

6.2 Spectrographic, X-ray, or wet chemical laboratory techniques are acceptable for routine and control determinations, but shall be standardized against, and give essentially the same results as, the umpire methods specified in 6.3 of this specification.

6.3 In case of dispute, umpire determinations of the chemical analysis of the metal shall be made using ASTM standard methods detailed as follows:

6.3.1 The following is in accordance with Test Methods E 351:

6.3.1.1 Carbon, Total by the Combustion Gravimetric Method.

6.3.1.2 Chromium by the Peroxydisulfate-Oxidation Titrimetric Method.

6.3.1.3 Copper by the Sulfide Precipitation-Electrodeposition Gravimetric Method.

6.3.1.4 Manganese by the Peroxydisulfate-Arsenite Titrimetric Method.

6.3.1.5 Nickel by the Dimethylglyoxime Gravimetric Method.

6.3.1.6 Phosphorus by the Molybdenum Blue Photometric Method.

6.3.1.7 Sulfur by the Combustion-Iodate Titration Method.

6.3.2 The following is in accordance with Test Methods E 350:

6.3.2.1 Molybdenum by the Photometric Method.

7. Microstructure

7.1 The alloys covered by this specification are expected to have microstructures that consist essentially of carbides, martensite, bainite, austenite, and in exceptional cases minor amounts of graphite or pearlite.

7.2 The microstructure will not be routinely determined nor reported except in accordance with special agreement between the manufacturer and the purchaser, or in cases of dispute.

8. Hardness Requirements

8.1 The castings shall conform to the hardness requirements specified in Table 2.

8.2 The hardness test shall be performed on the original surface of the casting or up to 1/8 in. (3 mm) below that surface.

9. Hardness Method

9.1 Perform the hardness test in accordance with one of the following methods to be specified by the purchaser:

9.1.1 Test Method E 10 (Brinell) using a tungsten carbide ball and 3000 kgf load,

9.1.2 Test Method E 18 (Rockwell) using a diamond cone penetrator, 150 kgf load, and the Rockwell C Scale, or

9.1.3 Test Method E 92 (Vickers).

TABLE 1 Chemical Requirements, Weight %

Class	Type	Designation	Carbon	Manganese	Silicon	Nickel	Chromium	Molybdenum	Copper	Phosphorus	Sulfur
I	A	Ni-Cr-HC	2.8-3.6	2.0 max	0.8 max	3.3-5.0	1.4-4.0	1.0 max	...	0.3 max	0.15 max
I	B	Ni-Cr-LC	2.4-3.0	2.0 max	0.8 max	3.3-5.0	1.4-4.0	1.0 max	...	0.3 max	0.15 max
I	C	Ni-Cr-GB	2.5-3.7	2.0 max	0.8 max	4.0 max	7.0-11.0	1.5 max	...	0.10 max	0.15 max
I	D	Ni-HiCr	2.5-3.6	2.0 max	2.0 max	4.5-7.0	7.0-11.0	1.5 max	1.2 max	0.10 max	0.15 max
II	A	12% Cr	2.0-3.3	2.0 max	1.5 max	2.5 max	11.0-14.0	3.0 max	1.2 max	0.10 max	0.06 max
II	B	15% Cr-Mo	2.0-3.3	2.0 max	1.5 max	2.5 max	14.0-18.0	3.0 max	1.2 max	0.10 max	0.06 max
II	D	20% Cr-Mo	2.0-3.3	2.0 max	1.0-2.2	2.5 max	18.0-23.0	3.0 max	1.2 max	0.10 max	0.06 max

Class	Type	Designation	Carbon	Manganese	Silicon	Nickel	Chromium	Molybdenum	Copper	Phosphorus	Sulfur
III	A	25% Cr	2.0-3.3	2.0 max	1.5 max	2.5 max	23.0-30.0	3.0 max	1.2 max	0.10 max	0.06 max

TABLE 2 Hardness Requirements

Designation	As Cast or As Cast and Stress Relieved						Chill Cast, min*		
	Level 1			Level 2					
	HB	HRC	HV	HB	HRC	HV	HB	HRC	HV
Ni-Cr-HC	550	53	560	600	56	650	600	56	650
Ni-Cr-LC	550	53	560	600	56	650	600	56	650
Ni-Cr-GB	550	53	560	600	56	650	600	56	650
Ni-HiCr	550	53	560	600	56	650	600	56	650
12% Cr	550	53	560	600	56	650	600	56	650
15% Cr-Mo	550	53	560	600	56	650	600	56	650
20% Cr-Mo	450	46	485	600	56	650	550	53	560
25% Cr	450	46	485	600	56	650	550	53	560

*A casting shall be considered to be chill cast if 75% of the casting section, with any portion of the section, with any portion of the casting specified, will be harder than the minimum hardness for chill cast requirements.

¹ This specification is under the jurisdiction of ASTM Committee A-4 on Iron Castings and is the direct responsibility of Subcommittee A04.01 on Gray and White Iron Castings.

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² Annual Book of ASTM Standards, Vol 03.01.

³ Annual Book of ASTM Standards, Vol 03.05.