



Standard Specification for UNS N06002, UNS N06230, UNS N12160, and UNS R30556 Rod¹

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1. Scope

1.1 This specification² covers alloys UNS N06002, UNS N06230, UNS N12160, and UNS R30556* in the form of rod for heat resisting and general-corrosive service.

1.2 The following products are covered under this specification:

1.2.1 Rods $\frac{5}{16}$ to $\frac{3}{4}$ in. (7.94 to 19.05 mm) exclusive in diameter, hot or cold finished, solution-annealed, and pickled or mechanically descaled.

1.2.2 Rods $\frac{3}{4}$ to $3\frac{1}{2}$ in. (19.05 to 88.9 mm) inclusive in diameter, hot or cold finished, solution annealed, ground, or turned.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.4 *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 become familiar with all hazards including those identified in the appropriate Material Safety Data Sheet for this product/material as provided by the manufacturer, to establish appropriate safety and health practices, and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

B 880 Specification for General Requirements for Chemical Check Analysis Limits for Nickel, Nickel Alloys and Cobalt Alloys³

E 8 Test Methods for Tension Testing of Metallic Materials⁴

E 29 Practice for Using Significant Digits in Test Data to

Determine Conformance with Specifications⁵

E 55 Practice for Sampling Wrought Nonferrous Metals and Alloys for Determination of Chemical Composition⁶

E 1473 Test Methods for Chemical Analysis of Nickel, Cobalt, and High-Temperature Alloys⁶

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *rod*—product of round solid section furnished in straight lengths.

4. Ordering Information

4.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this specification. Examples of such requirements include, but are not limited to the following:

4.1.1 *Alloy* .

4.1.2 *Dimensions*—Nominal diameter and length. The shortest useable multiple length should be specified (Table 1).

4.1.3 *Certification*—State if certification or a report of test results is required (Section 16).

4.1.4 *Purchaser Inspection*—State which tests or inspections are to be witnessed (Section 13).

4.1.5 *Samples for Product (Check) Analysis*—State whether samples should be furnished (9.2.2).

5. Chemical Composition

5.1 The material shall conform to the requirements as to chemical composition prescribed in Table 2.

5.2 If a product (check) analysis is made by the purchaser, the material shall conform to the requirements specified in Table 2 subject to the permissible tolerances in Specification B 880.

6. Mechanical and Other Requirements

6.1 The mechanical properties of the material at room temperature shall conform to those shown in Table 3.

6.2 *Grain Size*—Annealed alloy (UNS N12160) shall conform to an average grain size of ASTM Number 5 or coarser.

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.07 on Refined Nickel and Cobalt and Their Alloys.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-572 in Section II of that Code.

* New designation established in accordance with ASTM E 527 and SAE J1086, Practice for Numbering Metals and Alloys (UNS).

³ *Annual Book of ASTM Standards*, Vol 02.04.

⁴ *Annual Book of ASTM Standards*, Vol 03.01.

⁵ *Annual Book of ASTM Standards*, Vol 14.02.

⁶ *Annual Book of ASTM Standards*, Vol 03.05.

TABLE 1 Permissible Variations in Length of Rods

Random mill lengths	2 to 12 ft (610 to 3660 mm) long with not more than 25 weight % under 4 ft (1.22 m).
Multiple lengths	Furnished in multiples of a specified unit length, within the length limits indicated above. For each multiple, an allowance of ¼ in. (6.35 mm) shall be made for cutting, unless otherwise specified. At the manufacturer's option, individual specified unit lengths may be furnished.
Nominal lengths	Specified nominal lengths having a range of not less than 2 ft (610 mm) with no short lengths allowed.
Cut lengths	A specified length to which all rods shall be cut with a permissible variation of + ⅛ in. (3.17 mm) – 0.

TABLE 2 Chemical Requirements

Element	Composition Limits, %			
	UNS N06002	UNS N06230	UNS N12160	UNS R30556
Nickel	remainder ^A	remainder ^A	remainder ^A	19.0–22.5
Iron	17.0–20.0	3.0 max	3.5 max	remainder ^A
Chromium	20.5–23.0	20.0–24.0	26.0–30.0	21.0–23.0
Cobalt	0.5–2.5	5.0 max	27.0–33.0	16.0–21.0
Molybdenum	8.0–10.0	1.0–3.00	1.0 max	2.5–4.0
Tungsten	0.2–1.0	13.0–15.0	1.0 max	2.0–3.5
Carbon	0.05–0.15	0.05–0.15	0.15 max	0.05–0.15
Silicon	1.00 max	0.25–0.75	2.4–3.0	0.20–0.80
Manganese	1.00 max	0.30–1.00	1.5 max	0.50–2.00
Phosphorus	0.04	0.030 max	0.030 max	0.04 max
Sulfur	0.03	0.015 max	0.015 max	0.015 max
Columbium	1.0 max	0.30 max
Tantalum	0.30–1.25
Aluminum	...	0.20–0.50	...	0.10–0.50
Zirconium	0.001–0.10
Lanthanum	...	0.005–0.050	...	0.005–0.10
Nitrogen	0.10–0.30
Boron	...	0.015 max	...	0.02 max
Titanium	0.20–0.80	...

^A See 12.1.1.

TABLE 3 Mechanical Property Requirements

UNS	Tensile Strength, min, ksi (MPa)	Yield Strength (0.2 % Offset), min, ksi (MPa)	Elongation in 2 in. (50.8 mm) or 4D ^A min, %
N06002	95 (660)	35 (240)	35
N06230 ^B	110 (760)	45 (310)	40
N12160 ^C	90 (620)	35 (240)	40
R30556 ^D	100 (690)	45 (310)	40

^A D refers to the diameter of the tension specimen.

^B Solution annealed at a temperature between 2200 to 2275°F (1204 to 1246°C) followed by a water quench or rapidly cooled by other means.

^C Solution annealed at 1950°F (1065°C) minimum.

^D Solution annealed at 2100°F (1150°C) minimum.

TABLE 4 Permissible Variations in Diameter and Out-of-Roundness of Finished Rods

Specified Diameter, in. (mm)	Permissible Variations, in. (mm)		
	Diameter		Out of Roundness, max
	+	–	
Hot-Finished, Annealed, and Descaled Rods			
⅝ to ⅞ (7.94–11.11), incl	0.012 (0.30)	0.012 (0.30)	0.018 (0.46)
Over ⅞ to 1 (11.11–15.87), incl	0.014 (0.36)	0.014 (0.36)	0.020 (0.51)
Over 1 to 1¼ (15.87–19.05), excl	0.016 (0.41)	0.016 (0.41)	0.024 (0.61)
Hot-Finished, Annealed, and Ground or Turned Rods			
¾ to 1½ (19.05–38.9), incl	0.010 (0.25)	0	0.008 (0.20)

7. Dimensions, Mass, and Permissible Variations

7.1 *Diameter*—The permissible variations from the specified diameter shall be as prescribed in Table 4.

7.2 *Out-of-Roundness*—The permissible variation in roundness shall be as prescribed in Table 4.

7.3 *Machining Allowances*—When the surfaces of finished material are to be machined, the following allowances are suggested for normal machining operations:

7.3.1 *As-finished* (Annealed and Descaled)—For diameters of ⅝ to 1⅛ in. (7.94 to 17.46 mm) inclusive, an allowance of ⅛ in. (1.59 mm) on the diameter should be made for finish machining.

7.4 *Length*:

7.4.1 Unless multiple, nominal, or cut lengths are specified, random mill lengths shall be furnished.

7.4.2 The permissible variations in length of multiple, nominal, or cut length rod shall be as prescribed in Table 1. Where rods are ordered in multiple lengths, a ¼ -in. (6.35-mm) length addition shall be allowed for each uncut multiple length.

7.5 *Ends*:

7.5.1 Rods ordered to random or nominal lengths shall be furnished with either cropped or sawed ends.

7.5.2 Rods ordered to cut lengths shall be furnished with square saw cut or machined ends.

7.6 *Weight*—For calculations of mass or weight, the following densities shall be used:

Alloy	Density lb/in. ³	Density (g/cm ³)
N06002	0.297	(8.23)
N06230	0.324	(8.97)
N12160	0.292	(8.08)
R30556	0.297	(8.23)

7.7 *Straightness*—The maximum curvature (depth of chord) shall not exceed 0.050 in. multiplied by the length of the chord in feet (0.04 mm multiplied by the length in centimetres).

8. Workmanship, Finish, and Appearance

8.1 The material shall be uniform in quality and condition, smooth, and free of injurious defects.

9. Sampling

9.1 *Lots for Chemical Analysis and Mechanical Testing*:

9.1.1 A lot for chemical analysis shall consist of one heat.

9.1.2 A lot of bar for mechanical testing shall be defined as the material from one heat in the same condition and specified diameter.

9.2 *Sampling for Chemical Analysis*:

9.2.1 A representative sample shall be obtained from each heat during pouring or subsequent processing.

9.2.2 Product (check) analysis shall be wholly the responsibility of the purchaser.

9.3 *Sampling for Mechanical Testing*—A representative sample shall be taken from each lot of finished material.

10. Number of Tests and Retests

10.1 *Chemical Analysis*, One test per heat.

10.2 *Tension Tests*—One test per lot.

10.3 *Retests*—If the specimen used in the mechanical test of any lot fails to meet the specified requirements, two additional specimens shall be taken from different sample pieces and tested. The results of the tests on both of these specimens shall meet the specified requirements.

11. Specimen Preparation

11.1 Tension test specimens shall be taken from material after final heat treatment and tested in the direction of fabrication.

11.2 Tension test specimens shall be any of the standard or sized specimens shown in Test Methods E 8.

11.3 In the event of disagreement, the referee specimen shall be the largest possible round specimen shown in Test Methods E 8.

12. Test Methods

12.1 The chemical composition and mechanical properties of the material as enumerated in this specification shall be determined, in case of disagreement, in accordance with the following ASTM methods:

12.1.1 *Chemical Analysis*—Test Methods E 1473. For elements not covered by Test Methods E 1473, the referee method shall be as agreed upon between the manufacturer and the purchaser. The composition of the remainder element shall be determined arithmetically by difference.

12.1.2 *Tension Test*—Test Methods E 8.

12.1.3 *Method of Sampling*—Practice E 55.

12.1.4 *Determining Significant Places*—Practice E 29.

12.2 For purposes of determining compliance with the limits in this specification, an observed value or a calculated value shall be rounded in accordance with the rounding method of Practice E 29:

Requirements	Rounded Unit for Observed or Calculated Value
Chemical composition and tolerance	nearest unit in the last right-hand place of figures of the specified limit
Tensile strength and yield strength	nearest 1000 psi (7 MPa)
Elongation	nearest 1 %

13. Inspection

13.1 Inspection of the material shall be made as agreed upon between the manufacturer and the purchaser as part of the purchase contract.

14. Rejection and Rehearing

14.1 Material, tested by the purchaser, that fails to conform to the requirements of this specification may be rejected. Rejection should be reported to the producer or supplier promptly and in writing. In case of dissatisfaction with the results of the test, the producer or supplier may make claim for a rehearing.

15. Certification

15.1 When specified in the purchase order or contract, a manufacturer's certification shall be furnished to the purchaser stating that material has been manufactured, tested, and inspected in accordance with this specification, and that the test results on representative samples meet specification requirements. When specified in the purchase order or contract, a report of the test results shall be furnished.

16. Product Marking

16.1 Each piece of material ½ in. (12.7 mm) and over in diameter shall be marked with this specification number alloy, name of the material, and size of the product.

16.2 Each bundle or shipping container shall be marked with the name of the material; this specification number alloy; the size; gross, tare, and net weight; consignor and consignee address; contract or order number; and such other information as may be defined in the contract or order.

17. Keywords

17.1 rod; N06002; N06230; N12160; R30556

APPENDIX**(Nonmandatory Information)****X1. HEAT TREATMENT**

X1.1 Proper heat treatment during or subsequent to fabrication is necessary for optimum performance, and the manufacturer shall be consulted for details.

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