



Standard Specification for Pressure Vessel Plates, Carbon Steel, Manganese-Silicon¹

This standard is issued under the fixed designation A299/A299M; 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.

1. Scope

1.1 This specification² 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 yield strength decreases for 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 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.

2. Referenced Documents

2.1 ASTM Standards:³

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 Ex-

amination 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 Plates supplied to this product specification shall conform to Specification A20/A20M, which outlines the testing and retesting methods and procedures, permitted 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 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 A20/A20M.

3.4 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 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.

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.

Current edition approved March 1, 2014. Published March 2014. Originally approved in 1947. Last previous edition approved in 2009 as A299/A299M – 09. DOI: 10.1520/A0299_A0299M-09R14.

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.

TABLE 1 Chemical Requirements

| Elements | Composition, % |
|------------------------------|----------------|
| Carbon, max: ^A | |
| 1 in. [25 mm] and under | 0.26 |
| Grade A | 0.28 |
| Grade B | |
| Over 1 in. [25 mm] | 0.28 |
| Grade A | 0.30 |
| Grade B | |
| 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 | 0.025 |
| Sulfur, max ^A | 0.025 |
| Silicon: | |
| Heat analysis | 0.15 to 0.40 |
| Product analysis | 0.13 to 0.45 |

^A Applies to both heat and product analyses.

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**.

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 **A20/A20M**.

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

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 **A20/A20M**. 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 (for Material 0.625 in. [16 mm] and over in Thickness),

S7. High-Temperature Tension Test,
 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**.

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