

Hot-Rolled Carbon Steel Sheet—Commercial Quality ASTM A1011 CS Type B (Formerly ASTM A569)

1. SCOPE

1.1 This standard covers the requirements for hot-rolled carbon steel sheet of commercial quality having a maximum carbon content of 0.15 percent. This material issued for parts that involve bending, moderate forming or drawing, and welding.

1.2 MATERIAL SUBSTITUTION

The following material may be substituted for ASTM A1011 CS type B for all parts except those requiring heat treatment, unless otherwise specified on the drawing:

ASTM A1011 HSLAS-F grade 50 (formerly A715 grade 50)

ASTM A1011 DS type B (formerly A621 drawing quality steel)

ASTM A622, special killed drawing quality

2. DRAWING SPECIFICATIONS

2.1 HR Sheet or Strip, ASTM A1011 CS type B

2.2 HR Sheet or Strip ASTM A1011 CS type B P&O

2.3 Replaces the following call-outs:

HR Sheet or Strip ASTM A569

HR Sheet or Strip ASTM A569 P&O

3. RELATED STANDARDS

86050115 (FNHA 2-A-026.00)—General Requirements: Hot-Rolled Sheet, Hot-Rolled Strip, Cold-Rolled Sheet

86563033 (FNHA-2-A-151.01)—Materials List for Hot-Rolled A1011 CS type B Sheet

ASTM A1011—CS type B Steel, Carbon Hot-Rolled Sheet and Strip, Commercial Quality
This standard replaces ASTM A569

ASTM A370—Mechanical Testing of Steel Products

ASTM A1011—DS type B Standard Specification for Steel, Sheet and Strip, Carbon Hot-Rolled, Drawing Quality

This standard replaces ASTM A621 and A622

European Specifications—DIN 1016 QstE220 TM or RST 37-2 or StW 22

4. CHEMICAL REQUIREMENTS

The heat or cast analysis of the steel shall meet the chemical requirements listed in Table 1.

Table 1: Chemical Requirements

Element	Composition, %
Carbon	0.02 – 0.15
Manganese	0.60 max.
Phosphorus	0.030 max.
Sulfur	0.035 max.
Copper (When Required)	0.20 min.

5. DIMENSIONS AND TOLERANCES

See the applicable tables in 86050115 (FNHA 2-A-026.00).

6. BENDING REQUIREMENTS

The material shall be capable of being bent at room temperature in any direction through 180 degrees flat on itself without cracking on the outside of the bent portion.

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7. FINISH AND APPEARANCE**7.1 EDGES**

Specify cut edge or mill edge.

7.2 OILING

Specify pickled and oiled, if required.

8. GENERAL REQUIREMENTS

Material furnished under this standard shall meet the applicable general requirements outlined in 86050115 (FNHA 2-A-026.00).

9. GENERAL DELIVERY REQUIREMENTS

General delivery requirements for sheet and strip are outlined in 86050115 (FNHA 2-A-026.00).

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