

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

1. SCOPE

1.1 This specification defines the requirements for Hot Rolled Strip Steel, conforming to ASTM A1011 CS type B material standards.

1.2 Material that conforms to ASTM A1011 DS type B standards may be substituted for ASTM A1011 CS type B for all parts except those requiring heat treatment.

2. DRAWING SPECIFICATIONS

2.1 HR Sheet or Strip ASTM A1011 CS type B (preferred)

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

2.3 HR Strip AISI 1020 P & O.

3. RELATED STANDARDS

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

ASTM A1011—Steel, Carbon, Structural, and HSLA Hot-rolled Sheet and Strip.

ASTM A749—Specifications for Steel, Strip, Carbon and HSLA, Hot Rolled, General Requirements.

ASTM A370—Mechanical Testing of Steel Products.

ASTM A621—Standard Specification for Steel, Sheet and Strip, Carbon Hot-Rolled, Drawing Quality.

4. ORDERING INFORMATION

4.1 ASTM designation number A569.

4.2 Hot rolled strip, commercial quality.

4.3 Condition: Material to this specification is furnished in the hot-rolled condition. Pickled (or blast cleaned) must be specified, if required.

4.4 Type of edge (see Section 8.1).

4.5 Specify oiled or not oiled, as required (see Section 8.2).

4.6 Dimensions (thickness, width, and whether cut lengths or coils).

4.7 Coil size (must include inside diameter, outside diameter, and maximum weight).

4.8 Application (part identification and description, if critical application).

4.9 Special requirements, if required.

4.10 Cast or heat analysis report (request, if desired) (see Section 9).

5. MATERIALS AND MANUFACTURE

Condition: Unless otherwise specified, the material is furnished in the as-rolled condition (not annealed or pickled).

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6. CHEMICAL COMPOSITION

The Cast or Heat Analysis of the steel shall conform to the requirements as to chemical composition shown in Table 1.

7. BEND TEST

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 (see bend test section in ASTM A370).

8. WORKMANSHIP, FINISH, AND APPEARANCE

8.1 Edges: Strip can be supplied with mill edge or slit (cut) edge.

8.2 Oiling: Hot-rolled, non-pickled material is commonly furnished not oiled while hot- rolled pickled (or blast cleaned) material is commonly furnished oiled. When required, pickled (or blast cleaned) material may be specified to be furnished not oiled, and non-pickled material may be specified to be furnished oiled.

9. CERTIFICATION AND REPORTS

When requested, the producer shall furnish copies of a report showing test results of the cast or heat analysis. The report shall include the purchase order number, the ASTM designation number, and the cast or heat number representing the material.

10. DIMENSIONS, TOLERANCES, AND ALLOWANCES

Dimensions, tolerances, and allowances applicable to products covered by this specification are contained in Tables 2 through 6.

11. COIL SIZES PERMITTED

11.1 Inside diameter 16" minimum.

11.2 Outside diameter 43" +/- 1".

11.3 Maximum weight 4000 lbs.

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