

RAW MATERIALS / FERROUS

FNHA-2-A-152.00

HOT-ROLLED CARBON STEEL STRIP, AISI 1008**1. SCOPE**

This specification covers low carbon steel strip material, per AISI 1008 chemistry. Material may be ordered in Hot-rolled or Pickled and oiled condition. Blast cleaning may be substituted for pickling.

2. DESIGNATION

2.1 HR Strip AISI 1008

2.2 HR Strip AISI 1008 P&O

3. RELATED STANDARDS

3.1 AISI Specification for Carbon Steel Chemistry.

3.2 FNHA Engineering Standard 86050115
(FNHA 2-A-026.00): General Requirements for Steel Sheet and Strip.

4. CHEMICAL REQUIREMENTS

ELEMENT	COMPOSITION, %
Carbon	0.10 max.
Manganese	0.30 - .50
Phosphorus	0.04 max.
Sulfur	0.05 max.
Silicon	0.40 max.

5. ORDERING INFORMATION

5.1 AISI 1008 designation .

5.2 Hot rolled strip, commercial quality.

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

5.4 Type of edge (see 8.1).

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

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

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

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

5.9 Special requirements, if required.

5.10 Cast or heat analysis report (request, if desired) (see 9.1).

6. MATERIALS AND MANUFACTURE

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

7. BEND TEST

7.1 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).

					NAME	STD AISI 1008 HR ST	
					 NEW HOLLAND		ENGINEERING SPECIFICATION
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RAW MATERIALS / FERROUS**FNHA-2-A-152.00****8. WORKMANSHIP, FINISH, AND APPEARANCE**

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

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

9.1 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

10.1 Dimensions, tolerances, and allowances applicable to products covered by this specification are contained in Tables 1 and 2.

11. COIL SIZES PERMITTED

11.1 Inside diameter 16" minimum.

11.2 Outside diameter 43" +/- 1".

11.3 Maximum weight 4000 lbs.

**TABLE 1 - Thickness Tolerances of Hot-Rolled Strip Ordered to Nominal Thickness
(Coils and Cut Lengths, Including Pickled)**

Specified Width, inches		Thickness Tolerance, Over and Under, inches, for Specified Nominal Thickness, inches.				
Over	Through	Through 0.057	Over 0.057 to 0.118, incl.	Over 0.118 to 0.187, incl.	Over 0.187 to 0.203, incl.	Over 0.203 to 0.230, incl.
...	3 1/2	0.003	0.004	0.005	0.006	...
3 1/2	6	0.003	0.005	0.005	0.006	...
6	12	0.004	0.005	0.005	0.006	0.006

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