



Designation: **A470/A470M – 05 (Reapproved 2025)**

Standard Specification for Vacuum-Treated Carbon and Alloy Steel Forgings for Turbine Rotors and Shafts¹

This standard is issued under the fixed designation A470/A470M; 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.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This specification covers vacuum-treated carbon and alloy steel forgings for turbine rotors and shafts.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system are not necessarily exact equivalents; therefore, to ensure conformance with the standard, each system shall be used independently of the other, and values from the two systems shall not be combined.

1.3 *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 establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

A275/A275M Practice for Magnetic Particle Examination of Steel Forgings

A293 Specification for Steel Forgings, Carbon and Alloy, for Turbine Generator Rotors and Shafts; Replaced by A 470 (Withdrawn 1984)³

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

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 **A01.06** on Steel Forgings and Billets.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at www.astm.org/contact. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

A418/A418M Practice for Ultrasonic Examination of Turbine and Generator Steel Rotor Forgings

A472/A472M Specification for Heat Stability of Steam Turbine Shafts and Rotor Forgings

A788/A788M Specification for Steel Forgings, General Requirements

E139 Test Methods for Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials

3. Ordering Information and General Requirements

3.1 Material supplied to this specification shall conform to the requirements of Specification **A788/A788M**, which outlines additional ordering information, manufacturing methods and procedures, marking, certification, production analysis variations, and additional supplementary requirements.

3.2 In addition to the ordering information required by Specification **A788/A788M**, the purchaser shall include with the inquiry and order, the grade and class of steel, alternative maximum for silicon content (see **Table 1**), the choice of yield strength offset (0.2 % or 0.02 %), and any tests, supplementary requirements, and purchase options desired.

3.3 *Forging Drawing*—Each forging shall be manufactured in accordance with a drawing furnished by the purchaser showing the dimensions of the forging and bore hole, if any, and the location of mechanical test specimens.

3.4 *Supplementary Requirements*—Supplementary requirements are provided. These requirements shall apply only when specified in the purchase order.

3.5 If the requirements of this specification are in conflict with the requirements of Specification **A788/A788M**, the requirements of this specification shall prevail.

4. Manufacture

4.1 Melting Process:

4.1.1 The steel shall be made by the basic electric-furnace process.

4.1.2 Provisions for subsequent secondary melting of the steel by the consumable electrode-electroslag or vacuum-arc remelting processes are included in Supplementary Requirement S7.

TABLE 1 Chemical Requirements^A

	Grade A	Grade B	Grade C	Grade D	Grade E
	Ni-Mo-V	Ni-Mo-V	Ni-Cr-Mo-V	Cr-Mo-V	Ni-Mo-V
Carbon	0.22–0.30	0.22–0.30	0.28	0.25–0.35	0.30
Manganese	0.20–0.60	0.20–0.60	0.20–0.60	1.00	0.70
Phosphorus	0.012	0.012	0.012	0.012	0.025
Sulfur	0.012	0.012	0.015	0.015	0.025
Silicon	^B	^B	^{B,C}	^B	^B
Nickel	3.20–3.70	3.20–3.70	3.25–4.00	0.75	2.00 min
Chromium	0.75	0.75	1.25–2.00	1.05–1.50	0.75
Molybdenum ^D	0.40–0.60	0.40–0.60	0.25–0.60	1.00–1.50	0.25 min
Vanadium	0.04–0.12	0.04–0.12	0.05–0.15	0.20–0.30	0.03–0.12
Antimony	^E	^E	^E	^E	^E
Aluminum ^F	0.015	0.015	0.015	0.015	0.015
Equivalent	...	...	...	Classes 2 and 3 ^G	...
Specification A293					
Grade Designation (replaced by Specification A470)					

^A Maximum or range, unless otherwise indicated.

^B 0.10 % max, unless an alternative value, not in excess of 0.30 %, is specified in the purchase order.

^C 0.15 % to 0.30 % silicon is permitted for material that is subsequently VAR Processed.

^D Supplementary Requirement, see S1.

^E To be reported for information only on all Grades.

^F Total of soluble and insoluble.

^G Phosphorus of 0.035 max and sulfur of 0.035 max were specified for Specification **A293**.

4.2 Vacuum Treatment—The vacuum degassing requirements of Specification **A788/A788M** are mandatory.

4.3 Discard—Sufficient discard shall be taken from each ingot to secure freedom from pipe and harmful segregation in the finished forging.

4.4 Forging Process—The forging shall receive its hot mechanical work under a press of ample power to adequately work the metal throughout the maximum section of the forging. It is important to maintain the axial center of the forging in common with the axial center of the ingot.

4.5 Heat Treatment:

4.5.1 The heat treatment for mechanical properties shall consist of double-normalizing and tempering for Grades A, B, D, and E and normalizing, quenching, and tempering for Grade C. In normalizing treatments, the forging may be cooled in still air or in an air blast at the manufacturer's option. Faster cooling rates for Grades A, B, D, and E may be used if authorized by the purchaser. These rates are obtained by liquid quenching, or by the addition of water sprays of fog to the air blast.

4.5.1.1 The first normalizing treatment shall be from well above the transformation temperature range. At the manufacturer's option, this operation may be performed as a part of the preliminary treatment of the forging before preliminary machining (see **4.6.1**).

4.5.1.2 The second normalizing or quenching treatment shall be from above the transformation range but below the first normalizing temperature described in **4.5.1.1**. This treatment shall be performed after preliminary machining (see **4.6.1**).

4.5.1.3 The final tempering temperature for Grades A, B, C, and E shall be not less than 1075 °F [580 °C] and for Grade D not less than 1200 °F [650 °C]. With prior purchaser approval, a second tempering operation shall be performed prior to the operations described in **4.6.2** and **4.6.3** to complete the heat treatment cycle. This second temper will be in place of the stress relief specified in **4.5.1.4** and **4.5.1.5**, and the temperatures applied to the second temper will meet the temperature

limits in **4.5.1.4**. However, with the prior approval of the purchaser, the second tempering temperature may be equal, or slightly exceed, the first tempering temperature as a means of adjusting final strength or toughness. The required tests for mechanical properties shall be made after the second tempering operation. Mechanical property tests after the first temper are optional with the manufacturer.

4.5.1.4 After heat treatment and subsequent rough machining and axial boring (see **4.6.2** and **4.6.3**), the forging shall be stress-relieved at a temperature not more than 100 °F [55 °C] below the final tempering temperature, but not less than 1025 °F [550 °C].

4.5.1.5 With the prior approval of the purchaser, the stress-relief temperature may approach, equal, or slightly exceed the final tempering temperature as a means of adjusting final strength or toughness. If the stress-relief temperature is within 25 °F [14 °C] of the final tempering temperature, or higher, additional tension tests must be obtained (**6.1.3**).

4.6 Machining:

4.6.1 Preliminary Rough Machining—All exterior surfaces of the forging shall be machined prior to heat treatment for mechanical properties.

4.6.2 Second Rough Machining—After heat treatment for mechanical properties, all surfaces of the forging shall be rough machined prior to stress relief and the stability test.

4.6.3 Axial Bore:

4.6.3.1 Forgings shall be bored to permissible bore size and tolerance when required by the purchaser's drawing.

4.6.3.2 Forgings may be bored to limits agreed to by the purchaser, or indicated on the purchaser's drawing, to remove objectionable center conditions revealed by ultrasonic examination.

4.6.3.3 Unless otherwise specified by the purchaser, the manufacturer may bore the forging at any time prior to stress relief (see Supplementary Requirement S2).