



Designation: A867 – 24

Standard Specification for Iron-Silicon Relay Steels¹

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1. Scope

1.1 This specification covers wrought iron-silicon (Fe-Si) steels that are generally used in the manufacture of electromechanical devices, such as relays and solenoids, requiring higher electrical resistivity, higher permeability, and lower coercivity and residual magnetism than provided by either carbon steels or soft magnetic low-carbon irons. The steels covered in this specification are:

Steel Type	Nominal Composition
1	1.1 % Si-Fe
1F	1.1 % Si-Fe free machining
2	2.3 % Si-Fe
2F	2.3 % Si-Fe free machining
3	4.0 % Si-Fe

1.2 This specification covers steels in the form and condition required for fabrication into parts. The fabricated parts typically require a final heat treatment to obtain the desired magnetic performance. The term mill annealed as used in this specification applies to a heat treatment, typically applied by the producer, intended to improve formability. The mill anneal does not provide the optimum magnetic performance and is not intended to replace the need for the finish annealing of parts.

1.3 This specification covers steels in the form of forging billets, hot-rolled bar and strip, cold-finished bar, wire, and cold-rolled strip in thicknesses up to 6.35 mm (0.250 in.).

1.4 This specification does not cover electrical sheet steels used in transformer and motor laminations. Please refer to Specifications [A677](#), [A683](#), [A726](#), [A876](#), and [A1086](#) for standards pertaining to these material types.

1.5 This specification does not cover powder metallurgy materials capable of being processed into magnetic core components having similar silicon contents.

1.6 The values stated in SI units are to be regarded as standard. The values given in parentheses are mathematical conversions to customary (cgs-emu and inch-pound) units which are provided for information only and are not considered standard.

¹ This specification is under the jurisdiction of ASTM Committee [A06](#) on Magnetic Properties and is the direct responsibility of Subcommittee [A06.02](#) on Material Specifications.

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1.6.1 There are selected values presented in two units, both of which are in acceptable SI units. These are differentiated by the word “or,” as in “ $\mu\Omega$ -cm, or, Ω -m.”

1.7 *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.*

1.8 *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

- [A34/A34M Practice for Sampling and Procurement Testing of Magnetic Materials](#)
- [A341/A341M Test Method for Direct Current Magnetic Properties of Soft Magnetic Materials Using D-C Permeameters and the Point by Point \(Ballistic\) Test Methods](#)
- [A596/A596M Test Method for Direct-Current Magnetic Properties of Materials Using the Point by Point \(Ballistic\) Method and Ring Specimens](#)
- [A677 Specification for Nonoriented Electrical Steel Fully Processed Types](#)
- [A683 Specification for Nonoriented Electrical Steel, Semi-processed Types](#)
- [A726 Specification for Cold-Rolled Magnetic Lamination Quality Steel, Semiprocessed Types](#)
- [A773/A773M Test Method for Direct Current Magnetic Properties of Low Coercivity Magnetic Materials Using Hysteresisgraphs](#)
- [A876 Specification for Flat-Rolled, Grain-Oriented, Silicon-Iron, Electrical Steel, Fully Processed Types](#)
- [A1086 Specification for Thin-Gauge Nonoriented Electrical Steel Fully Processed Types](#)

² 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.

2.2 IEC Standard:³

IEC 60404-7:2019 Magnetic materials Part 7: Method of measurement of the coercivity (up to 160 kA/m) of magnetic materials in an open magnetic circuit

3. Ordering Information

3.1 Orders to this specification shall include as much of the following information as is required to describe the desired steel:

- 3.1.1 ASTM Specification number and steel type,
- 3.1.2 Dimensions and tolerances. The tolerances are to be mutually agreed upon between the user and the producer,
- 3.1.3 Quantity (weight or number of pieces),
- 3.1.4 Form and condition,
- 3.1.5 Magnetic property requirements if they are otherwise than stated herein,
- 3.1.6 Certification of chemical analysis or magnetic property evaluation, or both,
- 3.1.7 Marking and packaging,
- 3.1.8 *End Use*—Whenever possible the user should specify whether the product will be machined, blanked into flat pieces, blanked and formed, or deep drawn to shape. This information will help the producer provide the most suitable product for the user's fabrication practice.
- 3.1.9 Exceptions to this specification or special requirements.

4. Chemical Composition

4.1 The chemical composition requirements are shown in **Table 1**. Since magnetic and, possibly, mechanical properties are of primary importance, variations in composition from those shown in **Table 1** are permitted by mutual agreement between the user and the producer.

5. Form and Condition

5.1 As the silicon content increases, cold working becomes more difficult, hence, not all product forms are available in each type of steel. The desired form and condition should be specified and discussed with the producer to ensure receiving the appropriate product. Available forms and conditions are:

5.1.1 *Forging Billet* (all steel types)—Billet surface ground, grit blasted, or acid cleaned.

5.1.2 *Hot-Rolled Product* (all steel types)—Hot rolled, hot rolled and acid cleaned, and hot-rolled and mechanically cleaned.

5.1.3 *Cold-Finished Bars*—Mill annealed, centerless ground (all steel types), cold drawn (all grades up to 12.7 mm (0.500 in.) round), cold-processed shapes such as squares, rectangles, hexagons (all types except Type 3), centerless ground, and machine turned.

5.1.4 *Strip* (all types except Type 3)—As-supplied condition must be specified as either cold rolled to a specified hardness or mill annealed. Steel can be supplied in coil form or as straightened and cut to length flat product. Product can be supplied having a rolled edge, either round or flat, or an edge produced by slitting.

5.1.5 *Wire* (all types except Type 3)—Cold drawn, cold drawn and mill annealed in either coils or straightened and cut to length.

6. Magnetic Property Requirements

6.1 Under this specification, only the coercive field strength (H_{CB}) is required to be measured. This measurement can be done either using ring or permeameter methods or by use of a coercimeter. Since coercimeters saturate the test specimen before measurement of the coercive field strength, two different sets of requirements are necessary, one for ring and permeameter testing and one for coercimeter testing.

6.2 *Test Specimen Heat Treatment*—The test specimen shall be heat treated before testing as follows; heat at 845 °C ± 10 °C (1553 °F ± 18 °F) for 4 h in a wet hydrogen atmosphere (dew point of –20 °C to 5 °C (–4 °F to 41 °F)) then cool at a rate of 50 °C to 100 °C per hour (122 °F to 212 °F per hour) to a temperature less than 540 °C (1000 °F) followed by further cooling at any convenient rate. For heat treatment of Type 3 steels, dry hydrogen (dew point less than –40 °C (–40 °F)) shall be used instead of wet hydrogen.

6.3 Conventional dc Magnetic Testing:

6.3.1 Either ring or permeameter techniques may be used. For ring specimens either Test Method **A596/A596M** or Test Method **A773/A773M** is permitted. For straight-length specimens, either Test Method **A341/A341M** or Test Method **A773/A773M** is permitted.

6.3.2 Whenever possible, test specimen size and shape shall conform to Practice **A34/A34M**. The densities of these steels for testing purposes are listed in **Table X1.1**.

6.3.3 *Requirements*—The coercive field strength requirements of specimens heat treated in accordance with **6.2** are shown in **Table 2**. The coercive field strength shall be measured from a maximum magnetic flux density of 1.0 T (10 kG).

6.4 Coercimeter Testing:

TABLE 1 Chemical Composition Requirements

NOTE 1—Values in mass percent

	Type 1	Type 1F	Type 2	Type 2F	Type 3
Carbon	0.04 max	0.04 max	0.04 max	0.04 max	0.04 max
Manganese	0.50 max	0.50 max	0.50 max	0.50 max	0.50 max
Silicon	1.10 nom	1.10 nom	2.30 nom	2.30 nom	4.00 nom
Phosphorus	0.05 max	0.10 to 0.22	0.05 max	0.10 to 0.25	0.05 max
Sulfur	0.04 max	0.04 max	0.04 max	0.04 max	0.04 max
Aluminum	0.35 max	0.35 max	0.50 max	0.50 max	0.50 max
Iron ^A	Balance	Balance	Balance	Balance	Balance

^A Iron is not analyzed nor is it reported.

TABLE 2 DC Coercive Field Strength (H_{CB}) Requirements (Conventional Testing)

	Type 1	Type 1F	Type 2	Type 2F	Type 3
A/m (Oe)	64 (0.80)	64 (0.80)	60 (0.75)	60 (0.75)	56 (0.70)
	max	max	max	max	max