



Standard Specification for Nickel-Iron-Chromium-Molybdenum-Columbium Stabilized Alloy (UNS N08700) Plate, Sheet, and Strip¹

This standard is issued under the fixed designation B 599; 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.

^{e1} NOTE—Keywords were added editorially in November 2003.

1. Scope

1.1 This specification covers nickel-iron-chromium-molybdenum-columbium stabilized alloy (UNS N08700)* plate, sheet, and strip in the solution-annealed condition.

1.2 The values stated in inch-pound units are to be regarded as the standard.

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 become familiar with all hazards including those identified in the appropriate Material Safety Data Sheet for this product/material as provided by the manufacturer, to establish appropriate safety and health practices, and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

- A 262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels
- E 8 Test Methods for Tension Testing of Metallic Materials
- E 10 Test Method for Brinell Hardness of Metallic Materials
- E 18 Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials
- E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

- E 55 Practice for Sampling Wrought Nonferrous Metals and Alloys for Determination of Chemical Composition
- E 140 Hardness Conversion Tables for Metals (Relationship Between Brinell Hardness, Vickers Hardness, Rockwell Hardness, Rockwell Superficial Hardness, and Knoop Hardness)
- E 350 Test Methods for Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron
- E 353 Test Methods for Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

- 3.1.1 The terms plate, sheet, and strip as used in this specification are described as follows:
 - 3.1.1.1 *plate*—material 0.1875 in. (4.76 mm) and over in thickness and over 10 in. (254 mm) in width.
 - 3.1.1.2 *sheet*—material under 0.1875 in. (4.76 mm) in thickness and over 24 in. (610 mm) in width.
 - 3.1.1.3 *strip*—material under 0.1875 in. (4.76 mm) in thickness and under 24 in. (610 mm) in width.

4. Ordering Information

- 4.1 Orders for material under this specification should include the following information:
 - 4.1.1 Quantity (weight or number of pieces).
 - 4.1.2 Name of material or UNS N08700.
 - 4.1.3 Form (plate, sheet, or strip).
 - 4.1.4 Dimensions.
 - 4.1.5 Type of edge required (for strip only, see 9.4).
 - 4.1.6 *Finish* (Section 10)—For sheet ordered with No. 4 finish, specify whether one or both sides are to be polished.
 - 4.1.7 ASTM designation and year of issue.
 - 4.1.8 *Corrosion Test*—State if intergranular corrosion test is required (Section 8).
 - 4.1.9 *Marking*—State if metal die identification is required on plate ¼ in. (6.35 mm) or thicker (Section 17).

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* New designation established in accordance with ASTM E 527 and SAE J1086, Practice for Numbering Metals and Alloys (UNS).

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.



4.1.10 *Certification or Test Reports*—State if certification or test reports are required (Section 16).

5. Materials and Manufacture

5.1 *Heat Treatment*—The final heat treatment shall be a solution anneal. Minor cold working such as flattening or temper rolling may be performed after the final solution annealing treatment.

NOTE 1—This recommended solution anneal consists of heating to a minimum temperature of 2000°F (1090°C) and cooling rapidly to room temperature.

6. Chemical Composition

6.1 The material sampled, in accordance with 11.2, shall conform to the composition limits prescribed in Table 1.

6.2 If a product analysis is subsequently made, the material shall conform to the composition limits with the product analysis variation prescribed in Table 2.

7. Mechanical Requirements

7.1 The material shall conform to the requirements as to the mechanical property prescribed in Table 3.

8. Intergranular Corrosion Test

8.1 All material supplied to this specification shall be capable of passing the intergranular corrosion test, but the test need not be performed on any given lot unless it is specified on the purchase order. If the test is specified, it shall be performed by the manufacturer on specimens taken in the as-shipped condition. Specimens shall be tested in the sensitized condition (1 h at 1250°F (677°C)), and tested in accordance with Practice C of Practices A 262. The corrosion rate shall not exceed 2.5 mils/month (165 mg/dm²-day).

9. Dimensions and Permissible Variations

9.1 *Sheet*—The material referred to as sheet shall conform to the variations in dimensions prescribed in Tables 4-9, inclusive.

9.2 *Cold-Rolled Strip*—The material referred to as cold-rolled strip shall conform to the permissible variations in dimensions prescribed in Tables 10-13, inclusive.

9.3 *Plate*—The material referred to as plate shall conform to the permissible variations in dimensions prescribed in Tables 14-19, inclusive.

9.4 *Edges for Cold-Rolled Strip*:

Element	Composition, %
Nickel	24.0–26.0
Iron	remainder ^A
Chromium	19.0–23.0
Molybdenum	4.3–5.0
Columbium	8 × carbon to 0.40
Carbon, max	0.04
Silicon, max	1.00
Manganese, max	2.00
Phosphorus, max	0.040
Sulfur, max	0.030
Copper, max	0.50

^A Determined arithmetically by difference.

TABLE 2 Product (Check) Analysis

Element	Tolerances Over the Maximum Limit or Under the Minimum Limit, %
Nickel	0.20
Chromium	0.20
Molybdenum	0.10
Columbium	0.05
Carbon	0.01
Silicon	0.05
Manganese	0.04
Phosphorus	0.005
Sulfur	0.005
Copper	0.03

9.4.1 The various types of edges procurable shall be as follows:

9.4.1.1 *No. 1 Edge*—Rolled edge, contour as specified.

9.4.1.2 *No. 3 Edge*—An edge produced by slitting.

9.4.1.3 *No. 5 Edge*—Approximately square edge produced by rolling or filing, or both, after slitting.

10. Workmanship, Finish, and Appearance

10.1 The material shall be free of injurious imperfections and shall correspond to the designated finish as described as follows:

10.1.1 *Sheet*—The various types of finish procurable on sheet products shall be as follows:

10.1.1.1 *No. 1 Finish*—Hot rolled, annealed, and descaled; produced by hot rolling to specified thicknesses followed by annealing and descaling (see 10.2).

10.1.1.2 *No. 2D Finish*—Dull, cold-rolled finish; produced by cold rolling to the specified thickness, annealing, and descaling. The dull finish results from the descaling and pickling operations.

10.1.1.3 *No. 2B Finish*—Bright, cold-rolled finish; produced by giving a final light cold-rolled pass with polished rolls, to a sheet that has been annealed and descaled.

10.1.1.4 *No. 4 Finish*—General-purpose polished finish. Following initial grinding with coarser abrasives, sheets are generally finished last with abrasives approximately 120 to 150 mesh. Sheets can be produced with one or two sides polished. When polished on one side only, the other side may be rough ground in order to obtain the necessary flatness.

10.1.1.5 *Bright Annealed*—Bright finish produced by cold rolling to thickness, then annealing in a protective atmosphere.

10.1.2 *Strip*—The type of finish procurable on cold-rolled strip shall be as follows:

10.1.2.1 *No. 1 Finish*—Cold rolled to specified thickness, annealed, and pickled (see 10.2). Appearance of this finish is a dull gray.

10.1.2.2 *No. 2 Finish*—Same as No. 1 finish, followed by a final light cold-rolled pass, generally on highly polished rolls.

10.1.2.3 *Bright Annealed*—Bright finish produced by cold rolling to thickness, then annealing in a protective atmosphere.

10.1.3 *Plate*—The types of finish procurable on plates shall be as follows:

10.1.3.1 *Hot- or Cold-Rolled, Annealed*—Scale not removed (see 10.2).

10.1.3.2 *Hot- or Cold-Rolled, Annealed, Descaled*—Scale removed by a blast cleaning or pickling operation (see 10.2).



TABLE 3 Mechanical Property Requirements

Form	Tensile Strength, min, ksi (MPa)	Yield Strength (0.2 % offset), min, ksi (MPa)	Elongation in 2 in. or 50 mm, or 4D, min, %	Rockwell Hardness (or equivalent) ^A
Sheet	80 (550)	35 (240)	30	75–90 HRB
Strip	80 (550)	35 (240)	30	75–90 HRB
Plate	80 (550)	35 (240)	30	75–90 HRB

^A Hardness values are shown for information only and shall not constitute a basis for acceptance or rejection as long as the other mechanical properties are met.

TABLE 4 Thickness Tolerances for Hot-Rolled and Cold-Rolled Sheets

Specified Thickness, in. (mm)	Tolerance, over and under, in. (mm)
Over 0.145 to less than 0.1875 (3.68 to less than 4.76)	0.014 (0.36)
Over 0.130 to 0.145 (3.30 to 3.68), incl	0.012 (0.30)
Over 0.114 to 0.130 (2.90 to 3.30), incl	0.010 (0.25)
Over 0.098 to 0.114 (2.49 to 2.90), incl	0.009 (0.23)
Over 0.083 to 0.098 (2.11 to 2.49), incl	0.008 (0.20)
Over 0.072 to 0.083 (1.83 to 2.11), incl	0.007 (0.18)
Over 0.058 to 0.072 (1.47 to 1.83), incl	0.006 (0.15)
Over 0.040 to 0.058 (1.02 to 1.47), incl	0.005 (0.13)
Over 0.026 to 0.040 (0.66 to 1.02), incl	0.004 (0.10)
Over 0.016 to 0.026 (0.41 to 0.66), incl	0.003 (0.08)
Over 0.007 to 0.016 (0.18 to 0.41), incl	0.002 (0.05)
Over 0.005 to 0.007 (0.13 to 0.18), incl	0.0015 (0.04)
0.005 (0.13)	0.001 (0.03)

TABLE 5 Width and Length Tolerances for Hot-Rolled and Cold-Rolled Resquared Sheets (Stretcher Leveled Flatness)

Specified Dimensions, in. (mm)	Tolerance, in. (mm)	
	Over	Under
For thicknesses under 0.031 (0.79):		
Widths up to 48 (1219), excl	1/16 (1.6)	0
Widths 48 (1219) and over	1/8 (3.2)	0
Lengths up to 120 (3048), excl	1/16 (1.6)	0
Lengths 120 (3048) and over	1/8 (3.2)	0
For thicknesses 0.031 (0.79) and over:		
All widths and lengths	1/4 (6.4)	0

10.2 Spot grinding to remove surface imperfections is permitted for material produced in accordance with 10.1.1.1, 10.1.2.1, 10.1.3.1, and 10.1.3.2, provided such grinding does not reduce the thickness or width at any point beyond the permissible variations in dimensions.

11. Sampling

11.1 *Lots of Chemical Analysis, Mechanical Testing, and Corrosion Testing:*

11.1.1 A lot for chemical analysis shall consist of one heat.

11.1.2 *Plate*—A lot of plate for testing and inspection purposes shall consist of the products resulting from the rolling of one heat of material in the same condition and specified thickness, solution annealed by the same practice, but in no case more than 25 000 lb (11 340 kg).

11.1.3 *Sheet and Strip*—A lot of sheet or strip for testing and inspection purposes shall consist of material from one heat in the same form (sheet or strip), condition, finish, and specified thickness, solution annealed by the same practice but in no case more than 25 000 lb (11 340 kg).

11.2 *Sampling for Chemical Analysis:*

11.2.1 A representative sample shall be taken from each lot during pouring or subsequent processing.

TABLE 6 Width, Length, and Camber Tolerances for Hot-Rolled and Cold-Rolled Sheets Not Resquared

Width Tolerances		
Specified Thickness, in. (mm)	Tolerance for Specified Width, in. (mm)	
		24 to 48 (610 to 1219), excl
Less than 3/16 (4.76)	1/16 (1.6) over, 0 under	1/8 in. (3.2) over, 0 under
Length Tolerances		
Specified Length, ft (mm)	Tolerance, in. (mm)	
	Over	Under
Up to 10 (3050), incl	1/4 (6.4)	0 (0)
Over 10 to 20 (3050 to 6100), incl	1/2 (12.7)	0 (0)
Camber Tolerances ^A		
Specified Width, in. (mm)	Tolerance per Unit Length of any 8 ft (2440 mm), in. (mm)	
	24 to 36 (610 to 914), incl	1/8 (3.2)
Over 36 (914)	3/32 (2.4)	

^A Camber is the greatest deviation of a side edge from a straight line, and measurement is taken by placing an 8-ft (2440-mm) straightedge on the concave side and measuring the greatest distance between the sheet edge and the straightedge.

11.2.2 Product analysis, if performed, shall be wholly the responsibility of the purchaser.

11.3 *Sampling for Mechanical Tests:*

11.3.1 A sample of the material to provide test specimens for mechanical tests shall be taken from such a location in each lot as to be representative of that lot.

11.3.2 When samples are to be taken after delivery, the purchaser of material ordered to cut lengths may request on the purchase order additional material of adequate size to provide sample coupons for inspection purposes.

11.4 *Sampling for Corrosion Tests*—A sample for corrosion testing shall be taken from a location chosen to be representative of the lot.

12. Number of Tests and Retests

12.1 In the case of sheet or strip supplied in coil form, two or more tension tests (one from each end of each coil), and one or more hardness tests shall be made on specimens taken from each end of the coil. When material is supplied in flat sheet, flat strip, or plate, one tension and one or more hardness tests shall be made on each 100 or less sheets, strips, or plates of the same lot. When specified, one corrosion test shall be conducted for each lot.

12.2 If any specimens selected to represent any lot fail to meet any of the test requirements, the material represented by such specimens may be retested. If there is valid reason to believe the result is not representative, the material may be re-annealed and retested.



TABLE 7 Flatness Tolerances for Hot-Rolled and Cold-Rolled Sheets

Table with 4 columns: Specified Thickness, in. (mm), Width, in. (mm), Length, in. (mm), Flatness Tolerance, in. (mm). It is divided into two sections: 'Sheets not Specified to Stretcher Level Standard of Flatness' and 'Sheets Specified to Stretcher Level Standard of Flatness'.

TABLE 8 Diameter Tolerances for Hot-Rolled and Cold-Rolled Sheets, Sheared Circles

Table with 4 columns: Specified Thickness, in. (mm), Tolerance Over Specified Diameter (No Tolerance Under), in. (mm) - Under 30 (762), 30 to 48 (762 to 1219), incl, Over 48 (1219).

TABLE 9 Weight Tolerances for Hot-Rolled and Cold-Rolled Sheets

It is not practicable to produce hot-rolled and cold-rolled sheets to exact theoretical weight. Sheets of any one item of a specified thickness and size in any finish may be overweight to the following extent:

- (1) An item of five sheets or less, or an item estimated to weight 200 lb (90.7 kg) or less, may actually weigh as much as 10 % over the theoretical weight.
(2) An item of more than five sheets and estimated to weigh more than 200 lb (90.7 kg) may actually weigh as much as 7 1/2 % over the theoretical weight.
(3) The underweight variations for sheets are limited by the under thickness tolerances shown in Table 4.
For determining theoretical weight the factor, 42 lb/ft²-in. (0.0008 kg/cm²-mm) thickness may be used.

13. Specimen Preparation

13.1 Tension test specimens from material under 1/2 in. (12.7 mm) in thickness shall be of the full thickness of the material and machined to the form and dimensions shown for the sheet-type specimen in Test Methods E 8. Tension test specimens from material 1/2 in. (12.7 mm) and over shall be of the full thickness of the material, machined to the form and dimensions shown for the plate-type specimen in Test Methods E 8, or shall be the largest possible round specimen shown in Test Methods E 8. Tension test specimens shall be taken from material after final heat treatment and shall be selected in the transverse direction unless prohibited by width.

13.2 Corrosion test specimens shall be prepared so that at least one major surface represents the as-supplied surface, with only light surface grinding permitted on this surface.

14. Test Methods

14.1 Determine the chemical composition and properties of the material as enumerated in this specification, in case of disagreement, in accordance with the following methods:

Table with 2 columns: Test, ASTM Designations. Lists tests like Chemical analysis, Tension, Brinell hardness, Rockwell hardness, Hardness conversion, Rounding procedure, Method of sampling for product analysis, Intergranular corrosion test.

^AIron shall be determined arithmetically by difference.

^BTest Method E 350 are to be used only for elements not covered by Test Methods E 353.

14.2 For purpose of determining compliance with the limits in this specification, an observed value or a calculated value shall be rounded as indicated in accordance with the rounding method of Practice E 29.

Table with 2 columns: Requirements, Rounded Unit for Observed or Calculated Value. Lists requirements like Chemical composition hardness and tolerance, Tensile strength and yield strength, Elongation.

15. Rejection and Rehearing

15.1 Material that fails to conform to the requirements of this specification may be rejected. Rejection should be reported to the producer or supplier promptly and in writing. In case of dissatisfaction with the results of the test, the producer or supplier may make claim for a rehearing.

16. Certification

16.1 When specified in the purchase order or contract, a manufacturer's certification shall be furnished to the purchaser stating that material has been manufactured, tested, and inspected in accordance with this specification, and that the test results on representative samples meet specification requirements. When specified in the purchase order or contract, a report of the test results shall be furnished.



TABLE 10 Thickness Tolerances^{A,B,C} for Cold-Rolled Strip for the Thicknesses and Widths Given, Over and Under

Specified Thickness, in.	Width, in.							
	0.187 to 1, incl	Over 1 to 3, incl	Over 3 to 6, incl	Over 6 to 9, incl	Over 9 to 12, incl	Over 12 to 16, incl	Over 16 to 20, incl	Over 20 to 24, incl
	Thickness Tolerance, in.							
Over 0.160 to less than 0.1875	0.002	0.003	0.004	0.004	0.004	0.005	0.006	0.006
Over 0.099 to 0.160, incl	0.002	0.002	0.003	0.003	0.004	0.004	0.005	0.005
Over 0.068 to 0.099, incl	0.002	0.002	0.003	0.003	0.003	0.004	0.004	0.004
Over 0.049 to 0.068, incl	0.002	0.002	0.003	0.003	0.003	0.003	0.004	0.004
Over 0.039 to 0.049, incl	0.002	0.002	0.0025	0.003	0.003	0.003	0.004	0.004
Over 0.034 to 0.039, incl	0.002	0.002	0.0025	0.0025	0.003	0.003	0.003	0.003
Over 0.028 to 0.034, incl	0.0015	0.0015	0.002	0.002	0.0025	0.0025	0.003	0.003
Over 0.025 to 0.028, incl	0.001	0.0015	0.0015	0.002	0.002	0.002	0.0025	0.003
Over 0.019 to 0.025, incl	0.001	0.001	0.0015	0.0015	0.002	0.002	0.0025	0.0025
Over 0.016 to 0.019, incl	0.001	0.001	0.001	0.0015	0.0015	0.002	0.002	0.002
Over 0.012 to 0.016, incl	0.001	0.001	0.001	0.001	0.0015	0.0015	0.002	0.002
Over 0.011 to 0.012, incl	0.001	0.001	0.001	0.001	0.0015	0.0015	0.0015	0.0015
Over 0.010 to 0.011, incl	0.001	0.001	0.001	0.001	0.001	0.0015	0.0015	0.0015
0.010	0.001	0.001	0.001	0.001	0.001	0.001	0.0015	0.0015

Specified Thickness, mm	Width, mm							
	4.76 to 2.54	Over 25.4 to 76.2, incl	Over 76.2 to 152.4, incl	Over 152.4 to 228.6, incl	Over 228.6 to 304.8, incl	Over 304.8 to 406.4, incl	Over 406.4 to 508, incl	Over 508 to 609.6, incl
	Thickness Tolerance, mm							
Over 4.06 to less than 4.75	0.05	0.08	0.10	0.10	0.10	0.13	0.15	0.15
Over 2.51 to 4.06, incl	0.05	0.05	0.08	0.08	0.10	0.10	0.13	0.13
Over 1.73 to 2.51, incl	0.05	0.05	0.08	0.08	0.08	0.10	0.10	0.10
Over 1.24 to 1.73, incl	0.05	0.05	0.08	0.08	0.08	0.08	0.10	0.10
Over 0.99 to 1.24, incl	0.05	0.05	0.06	0.08	0.08	0.08	0.10	0.10
Over 0.86 to 0.99, incl	0.05	0.05	0.06	0.06	0.08	0.08	0.08	0.08
Over 0.71 to 0.86, incl	0.04	0.04	0.05	0.05	0.06	0.06	0.08	0.08
Over 0.64 to 0.71, incl	0.02	0.04	0.04	0.05	0.05	0.05	0.06	0.08
Over 0.48 to 0.64, incl	0.02	0.02	0.04	0.04	0.05	0.05	0.06	0.06
Over 0.41 to 0.48, incl	0.02	0.02	0.02	0.04	0.04	0.05	0.05	0.05
Over 0.30 to 0.41 incl	0.02	0.02	0.02	0.02	0.04	0.04	0.05	0.05
Over 0.28 to 0.30, incl	0.02	0.02	0.02	0.02	0.04	0.04	0.04	0.04
Over 0.25 to 0.28, incl	0.02	0.02	0.02	0.02	0.02	0.04	0.04	0.04
0.25	0.02	0.02	0.02	0.02	0.02	0.02	0.04	0.04

^A For thicknesses under 0.010 to 0.005 in. (0.254 to 0.127 mm), incl, in widths up to and including 16 in. (406 mm), a tolerance of $\pm 10\%$ of the thickness applies. For thicknesses under 0.010 to 0.005 in. (0.254 to 0.127 mm), incl, in widths over 16 to 24 in. (406 to 610 mm), excl, a tolerance of $\pm 15\%$ of the thickness applies. For thickness tolerances on thicknesses under 0.005 in. (0.127 mm) in widths up to 24 in. (610 mm), excl, the producer should be consulted.

^B Thickness measurements are taken $\frac{3}{8}$ in. (9.5 mm) in from the edge of the strip, except that on widths less than 1 in. (25.4 mm) the tolerances are applicable for measurements at all locations.

^C The tolerances in this table do not include crown tolerances.

TABLE 11 Crown Tolerances for Cold-Rolled Strip

Specified Thickness, in. (mm)	Additional Thickness, at Middle of Strip Over That Shown in Table 10 for Edge Measurement, for Widths and Thicknesses Given, in. (mm)		
	Width, in. (mm)		
	To 5 (127), incl	Over 5 to 12 (127 to 305), incl	Over 12 to 24 (305 to 610), excl
0.005 to 0.010 (0.127 to 0.254), incl	0.0075 (0.19)	0.001 (0.02)	0.0015 (0.04)
Over 0.010 to 0.025 (0.254 to 0.635), incl	0.001 (0.02)	0.0015 (0.04)	0.002 (0.05)
Over 0.025 to 0.065 (0.635 to 1.65), incl	0.0015 (0.04)	0.002 (0.05)	0.0025 (0.06)
Over 0.065 to 0.1875 (1.65 to 4.76), excl	0.002 (0.05)	0.0025 (0.06)	0.003 (0.08)

17. Product Marking

17.1 Each piece (plate, sheet, strip, or coil) shall be marked legibly with the specification number, UNS number, heat number, and the name of the manufacturer. When specified, marking shall be by die stamping on plates $\frac{1}{4}$ in. (6.35 mm) or thicker.

18. Keywords

18.1 plate; sheet; strip; N08700



TABLE 12 Width Tolerances for Cold-Rolled Strip on Edge Nos. 1, 5, and 3

Edge Nos. 1 and 5						
Specified Edge No.	Width, in.	Thickness, in.	Width Tolerance for Thickness and Width Given, in.			
			Over	Under		
1 and 5	3/32 and under	1/16 and under	0.005	0.005		
1 and 5	over 3/32 to 3/4, incl	3/32 and under	0.005	0.005		
1 and 5	over 3/4 to 5, incl	1/8 and under	0.005	0.005		
5	over 5 to 9, incl	1/8 to 0.008, incl	0.010	0.010		
5	over 9 to 20, incl	0.105 to 0.015	0.010	0.010		
5	over 20 to 23 15/16, incl	0.080 to 0.023	0.015	0.015		

Edge No. 3						
Specified Thickness, in.	Width Tolerance for Thickness and Width Given, Over and Under, in.					
	Under 1/2 to 3/16, incl	1/2 to 6, incl	Over 6 to 9, incl	Over 9 to 12, incl	Over 12 to 21, incl	Over 21 to 24, incl
Under 0.1875 to 0.161, incl	...	0.016	0.020	0.020	0.031	0.031
0.160 to 0.100, incl	0.010	0.010	0.016	0.016	0.020	0.020
0.099 to 0.069, incl	0.008	0.008	0.010	0.010	0.016	0.020
0.068 and under	0.005	0.005	0.005	0.010	0.016	0.020

Edge Nos. 1 and 5						
Specified Edge No.	Width, mm	Thickness, mm	Width Tolerance for Thickness and Width Given, mm			
			Over	Under		
1 and 5	7.1 and under	1.6 and under	0.13	0.13		
1 and 5	Over 7.1 to 19.0, incl	2.4 and under	0.13	0.13		
1 and 5	Over 19.0 to 127	3.2 and under	0.13	0.13		
5	Over 127 to 229	3.2 to 0.203, incl	0.25	0.25		
5	Over 229 to 508	2.7 to 0.381, incl	0.25	0.25		
5	Over 508 to 608	2.0 to 0.584, incl	0.38	0.38		

Edge No. 3						
Specified Thickness, mm	Width Tolerance for Thickness and Width Given, Over and Under, mm					
	Under 12.7 to 4.76, incl	12.7 to 152, incl	Over 152 to 229, incl	Over 229 to 305, incl	Over 305 to 533, incl	Over 533 to 610, excl
Under 4.76 to 4.09, incl	...	0.41	0.51	0.51	0.79	0.79
4.06 to 2.54, incl	0.25	0.25	0.41	0.41	0.51	0.51
2.51 to 1.75, incl	0.20	0.20	0.25	0.25	0.41	0.51
1.73 and under	0.13	0.13	0.13	0.25	0.41	0.51

TABLE 13 Length and Camber^A Tolerances for Cold-Rolled Strip

Length Tolerances	
Specified Length, ft (mm)	Tolerance Over Specified Length (No Under Tolerance), in. (mm)
To 5 (1524), incl	3/8 (9.5)
Over 5 to 10 (1520 to 3050), incl	1/2 (12.7)
Over 10 to 20 (3050 to 6100), incl	5/8 (15.9)

Camber Tolerances	
Specified Width, in. (mm)	Tolerance per Unit Length of any 8 ft (2440 mm), in. (mm)
To 1 1/2 (38.1), incl	1/2 (12.7)
Over 1 1/2 to 24 (38.1 to 610), excl	1/4 (6.4)

^A Camber is the deviation of a side edge from a straight line, and measurement is taken by placing an 8-ft straightedge on the concave side and measuring the greatest distance between the strip edge and the straightedge.

**B 599 – 92 (2003)^{€1}****TABLE 14 Thickness^A Tolerances on Plates^{B, C}**

Specified Thickness, in. (mm)	Width, in. (mm) Tolerance Over Specified Thickness, in. (mm)			
	To 84 (2134), incl	Over 84 to 120 (2134 to 3048), incl	Over 120 to 144 (3048 to 3658), incl	Over 144 (3658)
$\frac{3}{16}$ to $\frac{3}{8}$ (4.76 to 9.53), excl	0.046 (1.17)	0.050 (1.27)		
$\frac{3}{8}$ to $\frac{3}{4}$ (9.53 to 19.05), excl	0.054 (1.37)	0.058 (1.47)	0.075 (1.91)	0.090 (2.29)
$\frac{3}{4}$ to 1 (19.05 to 25.4), excl	0.060 (1.52)	0.064 (1.63)	0.083 (2.11)	0.100 (2.54)
1 to 2 (25.4 to 50.8), incl	0.070 (1.78)	0.074 (1.88)	0.095 (2.41)	0.115 (2.92)

^A Thickness is measured along the longitudinal edges of the plate at least $\frac{3}{8}$ in. (9.53 mm), but not more than 3 in. (76.20 mm), from the edge.

^B For circles, the above over-thickness tolerances apply to the diameter of the circle corresponding to the width ranges shown. For plates of irregular shape, the above over-thickness tolerances apply to the greatest width corresponding to the width ranges shown.

^C For plates up to 2 in. (50.8 mm), incl, in thickness, the tolerance under specified thickness is 0.01 in. (0.254 mm).



TABLE 15 Width and Length Tolerances for Plates^{A,B}

		Tolerance Over Specified Width and Length for Given Width, Length, and Thickness, in.					
Width, in.	Length, in.	Under 3/8 in.		3/8 to 1/2, incl, in Thickness		Over 1/2 in Thickness	
		Width	Length	Width	Length	Width	Length
48 and under	144 and under	1/8	3/16	3/16	1/4	5/16	3/8
Over 48 to 60, incl		3/16	1/4	1/4	5/16	3/8	7/16
Over 60 to 84, incl		1/4	5/16	5/16	3/8	7/16	1/2
Over 84 to 108, incl		5/16	3/8	3/8	7/16	1/2	9/16
Over 108		3/8	7/16	7/16	1/2	5/8	11/16
48 and under	over 144 to 240	3/16	3/8	1/4	1/2	5/16	5/8
Over 48 to 60, incl		1/4	7/16	5/16	5/8	3/8	3/4
Over 60 to 84, incl		3/8	1/2	7/16	11/16	1/2	3/4
Over 84 to 108, incl		7/16	1/2	1/2	3/4	5/8	7/8
Over 108		1/2	5/8	5/8	7/8	11/16	1
48 and under	over 240 to 360	1/4	1/2	5/16	5/8	3/8	3/4
Over 48 to 60, incl		5/16	5/8	3/8	3/4	1/2	3/4
Over 60 to 84, incl		7/16	11/16	1/2	3/4	5/8	7/8
Over 84 to 108, incl		9/16	3/4	5/8	7/8	3/4	1
Over 108		5/8	7/8	11/16	1	7/8	1
60 and under	over 360 to 480	7/16	11/8	1/2	11/4	5/8	13/8
Over 60 to 84, incl		1/2	11/4	5/8	13/8	3/4	11/2
Over 84 to 108, incl		9/16	11/4	3/4	13/8	7/8	11/2
Over 108		3/4	13/8	7/8	11/2	1	15/8
60 and under	over 480 to 600	7/16	11/4	1/2	11/2	5/8	15/8
Over 60 to 84, incl		1/2	13/8	5/8	11/2	3/4	15/8
Over 84 to 108, incl		5/8	13/8	3/4	11/2	7/8	15/8
Over 108		3/4	11/2	7/8	15/8	1	13/4 3/4
60 and under	over 600	1/2	13/4	5/8	17/8	3/4	17/8
Over 60 to 84, incl		5/8	13/4	3/4	17/8	7/8	17/8
Over 84 to 108, incl		5/8	13/4	3/4	17/8	7/8	17/8
Over 108		7/8	13/4	1	2	11/8	21/4

		Tolerance Over Specified Width and Length for Given Width, Length, and Thickness, mm					
Width, mm	Length, mm	Under 9.5 mm		9.5 to 12.7 mm incl, in Thickness		Over 12.7 mm in Thickness	
		Width	Length	Width	Length	Width	Length
1219 mm and under	3658 and under	3.2	4.8	4.8	6.4	7.9	9.5
Over 1219 to 1524, incl		4.8	6.4	6.4	7.9	9.5	11.1
Over 1524 to 2134, incl		6.4	7.9	7.9	9.5	11.1	12.7
Over 2134 to 2743, incl		7.9	9.5	9.5	11.1	12.7	14.3
Over 2743		9.5	11.1	11.1	12.7	15.9	17.5
1219 mm and under	over 3658 to 6096	4.8	9.5	6.4	12.7	7.9	15.9
Over 1219 to 1524, incl		6.4	11.1	7.9	15.9	9.5	19.1
Over 1524 to 2134		9.5	12.7	11.1	17.5	12.7	19.1
Over 2134 to 2743, incl		11.1	14.3	12.7	19.1	15.9	22.2
Over 2743		12.7	15.9	15.9	22.2	17.5	25.4
1219 mm and under	over 6096 to 9144	6.4	12.7	7.9	15.9	9.5	19.1
Over 1219 to 1524, incl		7.9	15.9	9.5	19.1	12.7	19.1
Over 1524 to 2134		11.1	17.5	12.7	19.1	15.9	22.2
Over 2134 to 2743, incl		14.3	19.1	15.9	22.2	19.1	25.4
Over 2743		15.9	22.2	17.5	25.4	22.2	25.4
1524 mm and under	over 9144 to 12 192	11.1	28.6	12.7	31.8	15.9	34.9
Over 1524 to 2134, incl		12.7	31.8	15.9	34.9	19.1	38.1
Over 2134 to 2743, incl		14.3	31.8	19.1	34.9	22.2	38.1
Over 2743		19.1	34.9	22.2	38.1	25.4	41.3
1524 mm and under	over 12 192 to 15 240	11.1	31.8	12.7	38.1	19.1	41.3
Over 1524 to 2134, incl		12.7	34.9	15.9	38.1	22.2	41.3
Over 2134 to 2743, incl		15.9	34.9	19.1	38.1	22.2	41.3
Over 2743		19.1	38.1	22.2	41.3	25.4	44.5
1524 mm and under	over 15 240	12.7	44.5	15.9	47.6	19.1	47.6
Over 1524 to 2134, incl		15.9	44.5	19.1	47.6	22.2	47.6
Over 2134 to 2743, incl		15.9	44.5	19.1	47.6	22.2	47.6
Over 2743		22.2	44.5	25.4	50.8	28.6	57.2

^A The tolerance under specified width and length is 1/4 in. (6.35 mm).

^B Rectangular plates over 1 in. (25.4 mm) in thickness are not commonly sheared and are machined or otherwise cut to length and width or produced in the size as rolled, uncropped.

TABLE 16 Camber Tolerance for Plates

Maximum camber^A = 1/8 in. (3.2 mm) in any 5 ft (1524 mm)

^A Camber is the deviation of a side edge from a straight line, and measurement is taken by placing a 5-ft (1524-mm) straightedge on the concave side and measuring the greatest distance between the plate and the straightedge.



TABLE 17 Diameter Tolerances for Circular Plates

Specified Diameter, in. (mm)	Tolerance over Specified Diameter for Given Diameter and Thickness (No Under Tolerance), in. (mm)		
	Thickness		
	To 0.375 (9.53), excl	0.375 to 0.625 (9.53 to 15.88), excl	0.625 (15.88) and over
To 60 (1524), excl	1/4 (6.4)	3/8 (9.5)	1/2 (12.7)
60 to 84 (1524 to 2134), excl	5/16 (7.9)	7/16 (11.1)	9/16 (14.3)
84 to 108 (2134 to 2743), excl	3/8 (9.5)	1/2 (12.7)	5/8 (15.9)
108 to 130 (2743 to 3302), excl	7/16 (11.1)	9/16 (14.3)	1 1/16 (17.5)

TABLE 18 Flatness Tolerances for Plates

Specified Thickness, in.	Flatness Tolerance (Deviation from a Flat Horizontal Surface) for Thickness and Width Given, in.									
	Width, in.									
	48 and Under	Over 48 to 60, excl	60 to 72, excl	72 to 84, excl	84 to 96, excl	96 to 108, excl	108 to 120, excl	120 to 144, excl	144 and Over	
3/16 to 1/4, excl	3/4	1 1/16	1 1/4	1 3/8	1 5/8	1 5/8	1 7/8	2		
1/4 to 3/8, excl	1 1/16	3/4	1 5/16	1 1/2	1 3/8	1 7/16	1 9/16	1 7/8		
3/8 to 1/2, excl	1/2	9/16	1 1/16	3/4	1 5/16	1 1/8	1 1/4	1 7/16	1 3/4	
1/2 to 3/4, excl	1/2	9/16	5/8	5/8	1 3/16	1 1/8	1 1/8	1 1/8	1 3/8	
3/4 to 1, excl	1/2	9/16	5/8	5/8	3/4	1 3/16	1 5/16	1	1 1/8	
1 to 1 1/2, excl	1/2	9/16	9/16	9/16	1 1/16	1 1/16	1 1/16	3/4	1	
1 1/2 to 4, excl	3/16	5/16	3/8	7/16	1/2	9/16	5/8	3/4	7/8	
4 to 6, excl	1/4	3/8	1/2	9/16	5/8	3/4		1	1 1/8	

Specified Thickness, mm	Flatness Tolerance (Deviation from a Flat Horizontal Surface) for Thickness and Width Given, mm									
	Width, mm									
	1219 and Under	Over 1219 to 1524, excl	1524 to 1829, excl	1829 to 2134, excl	2134 to 2438, excl	2438 to 2743, excl	2743 to 3048, excl	3048 to 3658, excl	3658 and Over	
4.76 to 6.35, excl	19.1	27.0	31.8	34.9	41.3	41.3	47.6	50.8		
6.35 to 9.53, excl	17.5	19.1	23.8	28.6	34.9	36.5	39.7	47.6		
9.53 to 12.7, excl	12.7	14.3	17.5	19.1	23.8	28.6	31.8	36.5	44.5	
12.7 to 19.05, excl	12.7	14.3	15.9	15.9	20.6	28.6	28.6	28.6	34.9	
19.05 to 25.4, excl	12.7	14.3	15.9	15.9	19.1	20.6	23.8	25.4	28.6	
25.4 to 38.1, excl	12.7	14.3	14.3	14.3	17.5	17.5	17.5	19.1	25.4	
38.1 to 102, excl	4.8	7.9	9.5	11.1	12.7	14.3	15.9	19.1	22.2	
102 to 152, excl	6.4	9.5	12.7	14.3	15.9	19.1	22.2	25.4	28.6	



TABLE 19 Recommended Plate Flame-Cutting Tolerances to Cleanup in Machining

Specified Thickness, in. (mm)	Machining Allowance per Edge, in. (mm)
2 (51) and under	1/4 (6.4)
Over 2 to 3 (51 to 76), incl	3/8 (9.5)
Over 3 to 6 (76 to 152), incl	1/2 (12.7)

TABLE 20 Abrasive-Cutting Width and Length Tolerances

Specified Thickness, in. (mm)	Tolerance Over ^A Specified Width and Length, in. (mm)	
	Width	Length
Up to 1 1/4 (32)	1/8 (3.2)	1/8 (3.2)
Over 1 1/4 to 2 3/4 (32 to 70)	3/16 (4.8)	3/16 (4.8)

^A The tolerance under the specified width and length is 1/8 in. (3.2 mm).

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