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Endorsed by  
Manufacturers Standardization Society  
of the Iron and Steel Industry  
Lead in ASTM A194/A194M – 15

## Standard Specification for Carbon and Alloy Steel, Alloy Steel, and Stainless Steel Nuts for Bolts for High Pressure or High Temperature Service, or Both<sup>1</sup>

This standard is issued under the fixed designation A194/A194M; 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 approval. A superscript symbol (n) indicates an editorial change since the last revision or approval.

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

### 1. Scope<sup>2</sup>

1.1 This specification<sup>3</sup> covers a variety of carbon, alloy, and martensitic stainless steel nuts in the size range 3/4 through 4 in. and metric M6 through M100 nominal. It also covers austenitic stainless steel nuts in the size range 3/4 in. and M6 nominal and above. These nuts are intended for high-pressure or high-temperature service, or both. Grade substitutions without the purchaser's permission are not allowed.

1.2 Bars from which the nuts are made shall be hot-wrought. The material may be further processed by centerless grinding or by cold drawing. Austenitic stainless steel may be solution annealed or annealed and strain-hardened. When annealed and strain hardened austenitic stainless steel is ordered in accordance with Supplementary Requirement S1, the purchaser should take special care to ensure that 8.2.2, Supplementary Requirement S1, and Appendix X1 are thoroughly understood.

1.3 Supplementary requirements of an optional nature are provided. These shall apply only when specified in the inquiry, contract, and order.

1.4 This specification is expressed in both inch-pound units and in SI units. However, unless the order specifies the applicable<sup>4</sup> "M" specification designation (SI units), the material shall be furnished in inch-pound units.

1.5 The values stated in either inch-pound units or SI units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard. Within the text, the SI units are shown in brackets.

### 2. Referenced Documents

#### 2.1 ASTM Standards<sup>5</sup>

**A153/A153M** Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware

**A276** Specification for Stainless Steel Bars and Shapes

**A320/A320M** Specification for Alloy-Steel and Stainless Steel Bolting for Low-Temperature Service

**A370** Test Methods and Definitions for Mechanical Testing of Steel Products

**A962/A962M** Specification for Common Requirements for Bolting Intended for Use at Any Temperature from Cryogenic to the Creep Range

**B633** Specification for Electrodeposited Coatings of Zinc on Iron and Steel

**B695** Specification for Coatings of Zinc Mechanically Deposited on Iron and Steel

**B696** Specification for Coatings of Cadmium Mechanically Deposited

**B766** Specification for Electrodeposited Coatings of Cadmium

**E112** Test Methods for Determining Average Grain Size

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.22 on Steel Forgings and Wrought Fixings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications.

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<sup>2</sup> For ASME Boiler and Pressure Vessel Code applications see related Specification SA-194 in Section III of that code.

<sup>3</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For Annual Book of ASTM Standards volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>4</sup> A Summary of Changes section appears at the end of this standard.

# A194 A194m Standard Specification For Carbon And Alloy

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