



PED Certified | OHSAS 18001:2007 | ISO 9001 : 2008 | ISO 14001:2004  
| Govt. Recog. Export House.

**Manufacturer, Exporter, Stockiest, Supplier, Trader for  
Carbon Steel, Stainless Steel, Alloy Steel And High Nickel Alloy,  
Nickel Alloy Plate, Sheets And Coils.**



# Standard Specification for Hot-Rolled Structural Steel, High-Strength Low-Alloy Plate with Improved Formability<sup>1</sup>

This standard is issued under the fixed designation A 656/A 656M; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope\*

1.1 This specification covers two types and four strength grades of high-strength low-alloy, hot rolled structural steel plate for use in truck frames, brackets, crane booms, rail cars, and similar applications. Steels that conform to this specification offer improved formability. These steels are normally furnished in the as-rolled condition. The type and strength grade furnished is as agreed upon between the manufacturer and the purchaser. The types and strength grades are shown in the tables.

1.2 The maximum thickness of plates shall be as follows:

Grade	Plate Thickness, max	
	in.	[mm]
50	2	[50]
60	1½	[40]
70	1	[25]
80	¾	[20]

1.3 The values stated in either inch-pound units or SI units are to be regarded as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with this specification. See Appendix X3 of Specification A 6/A 6M for information on weldability.

1.4 For plates produced from coil and furnished without heat treatment or with stress relieving only, the additional requirements, including additional testing requirements and the reporting of additional test results, of Specification A 6/A 6M apply.

## 2. Referenced Documents

### 2.1 ASTM Standards:

A 6/A 6M Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling<sup>2</sup>

<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 A01.02 on Structural Steel for Bridges, Buildings, Rolling Stock, and Ships.

Current edition approved April 10, 2003. Published June 2003. Originally published in 1972. Last previous edition approved in 2000 as A 656/A 656M – 00a.

<sup>2</sup>Annual Book of ASTM Standards, Vol 01.04.

## 3. General Requirements for Delivery

3.1 Plates furnished under this specification shall conform to the requirements of the current edition of Specification A 6/A 6M, for the specific plate ordered, unless a conflict exists, in which case this specification shall prevail.

3.2 Coils are excluded from qualification to this specification until they are processed into finished plates. Plates produced from coil means plates that have been cut to individual lengths from a coil. The processor directly controls, or is responsible for, the operations involved in the processing of a coil into finished plates. Such operations include decoiling, leveling, cutting to length, testing, inspection, conditioning, heat treatment (if applicable), packaging, marking, loading for shipment, and certification.

NOTE 1—For plates produced from coil and furnished without heat treatment or with stress relieving only, two test results are to be reported for each qualifying coil. Additional requirements regarding plate produced from coil are described in Specification A 6/A 6M.

## 4. Materials and Manufacture

4.1 The steel shall be made to fine grain practice.

## 5. Chemical Composition

5.1 Heat analyses shall conform to the chemical requirements given in Table 1. Dependent upon thickness, grade, and intended application, variations in the chemical composition are permitted within the limits given in Table 1 for the applicable type. Where it is of particular importance, the manufacturer should be consulted for specific chemical composition.

5.2 *Product Analysis*—If a product analysis is made, it shall conform to the requirements given in Table 1, subject to the product analysis tolerances of Specification A 6/A 6M.

5.3 Where steel is to be welded, it is presupposed that a welding procedure suitable for the grade of steel and intended use or service will be utilized.

5.4 Unless specifically ordered, the type is at the discretion of the producer.

## 6. Tension Test

6.1 The plates as represented by the test specimens shall conform to the requirements given in Table 2.

\*A Summary of Changes section appears at the end of this standard.

**TABLE 1 Chemical Requirements**

Elements	Composition, %	
	Type 3	Type 7
Carbon, max	0.18	0.18
Manganese, max	1.65	1.65
Phosphorus, max	0.025	0.025
Sulfur, max	0.035	0.035
Silicon, max	0.60	0.60
Vanadium	0.08	0.15 <sup>A</sup>
Nitrogen	0.020	0.020
Columbium	0.008–0.10	0.10 max <sup>A</sup>

<sup>A</sup>The contents of columbium and vanadium shall additionally be in accordance with one of the following:  
columbium 0.008-0.10 % with vanadium <0.008 %;  
columbium <0.008 % with vanadium 0.008-0.15 %; or  
columbium 0.008-0.10 % with vanadium 0.008-0.15 % and columbium plus vanadium not in excess of 0.20 %.

**TABLE 2 Tensile Requirements<sup>A</sup>**

	Grade 50 [345]	Grade 60 [415]	Grade 70 [485]	Grade 80 [550]
Yield point, min, ksi [MPa]	50 [345]	60 [415]	70 [485]	80 [550]
Tensile strength, min, ksi [MPa]	60 [415]	70 [485]	80 [550]	90 [620]
Elongation in 8 in. [200 mm], min, % <sup>B</sup>	20	17	14	12
Elongation in 2 in. [50 mm], min, % <sup>B</sup>	23	20	17	15

<sup>A</sup>See Specimen Orientation under the Tension Tests section of Specification A 6/A 6M.

<sup>B</sup>For plates wider than 24 in. [600 mm], the elongation requirement is reduced two percentage points for Grade 50 [345] and three percentage points for Grades 60, 70, and 80 [415, 485, and 550]. See Elongation Requirement Adjustments in the Tension Tests section of Specification A 6/A 6M.

## 7. Keywords

7.1 high-strength low-alloy steel; steel plates; structural applications

## SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this standard since the last issue (A 656/A 656M - 00a) that may impact the use of this standard.

(1) 1.1, 1.4, Section 3, and Section 6 have been revised to be consistent with the terminology and requirements of Specification A 6/A 6M.

*ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.*

*This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.*

*This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).*