



Designation: A485 – 17 (Reapproved 2022)

Standard Specification for High Hardenability Antifriction Bearing Steel¹

This standard is issued under the fixed designation A485; 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 high hardenability modifications of high-carbon bearing quality steel to be used in the manufacture of antifriction bearings.

1.2 Supplementary requirements of an optional nature are provided and when desired shall be so stated in the order.

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

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

A29/A29M Specification for General Requirements for Steel Bars, Carbon and Alloy, Hot-Wrought

A255 Test Methods for Determining Hardenability of Steel
A751 Test Methods and Practices for Chemical Analysis of Steel Products

E45 Test Methods for Determining the Inclusion Content of Steel

E381 Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings

E1019 Test Methods for Determination of Carbon, Sulfur, Nitrogen, and Oxygen in Steel, Iron, Nickel, and Cobalt Alloys by Various Combustion and Inert Gas Fusion Techniques

E1077 Test Methods for Estimating the Depth of Decarburization of Steel Specimens

2.2 Other Standards:

SAE J148a Grain Size Determination of Steel³

ISO 683 Part 17: Ball and Roller Bearing Steels⁴

3. Ordering Information

3.1 Orders for material under this specification should include the following information:

3.1.1 Quantity (weight or number of pieces),

3.1.2 Grade identification,

3.1.3 ASTM designation and year of issue,

3.1.4 Dimensions,

3.1.5 Supplementary requirements, if included.

4. Process

4.1 The steel shall be made by a process that is capable of providing a high quality product meeting the requirements of this specification.

5. Chemical Composition and Analysis

5.1 Typical examples of chemical compositions are shown in **Table 1**. Other compositions may be specified.

5.2 An analysis of each heat of steel shall be made by the steel manufacturer in accordance with Test Methods and Practices **A751**. The chemical composition thus determined shall conform to the requirements specified in **Table 1** for the ordered grade or to other requirements agreed upon between manufacturer and purchaser.

5.3 Product analysis may be made by the purchaser in accordance with Test Methods and Practices **A751**. Permissible variations in product analysis shall be in accordance with Specification **A29/A29M**.

6. Sizes, Shapes, and Dimensional Tolerances

6.1 The physical size and shape of the material shall be agreed upon between manufacturer and purchaser.

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 **A01.28** on Bearing and Power Transmission Steels.

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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.

³ Available from SAE International (SAE), 400 Commonwealth Dr., Warrendale, PA 15096, <http://www.sae.org>.

⁴ Available from International Organization for Standardization (ISO), ISO Central Secretariat, Chemin de Blandonnet 8, CP 401, 1214 Vernier, Geneva, Switzerland, <http://www.iso.org>.

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

TABLE 1 Chemical Composition^{A, B}

ISO ^C	Name	C	Mn	P (max)	S (max)	Si	Cr	Ni (max)	Ti (max)	Cu (max)	Mo	O (max) ^D	Al (max)
...	Grade 1	0.90–1.05	0.90–1.20	0.025	0.015	0.45–0.75	0.90–1.20	0.25	0.0050	0.30	0.10 (max)	0.0015	0.050
...	Grade 2	0.85–1.00	1.40–1.70	0.025	0.015	0.50–0.80	1.40–1.80	0.25	0.0050	0.30	0.10 (max)	0.0015	0.050
...	Grade 3	0.95–1.10	0.65–0.90	0.025	0.015	0.15–0.35	1.10–1.50	0.25	0.0050	0.30	0.20–0.30	0.0015	0.050
...	Grade 4	0.95–1.10	1.05–1.35	0.025	0.015	0.15–0.35	1.10–1.50	0.25	0.0050	0.30	0.45–0.60	0.0015	0.050
ISO	100CrMnSi4–4	0.93–1.05	0.90–1.20	0.025	0.015	0.45–0.75	0.90–1.20	...	^E	0.30	0.10 (max)	0.0015	0.050
ISO	100CrMnSi6–4	0.93–1.05	1.00–1.20	0.025	0.015	0.45–0.75	1.40–1.65	...	^E	0.30	0.10 (max)	0.0015	0.050
ISO	100CrMnSi6–6	0.93–1.05	1.40–1.70	0.025	0.015	0.45–0.75	1.40–1.65	...	^E	0.30	0.10 (max)	0.0015	0.050
ISO	100CrMo7	0.93–1.05	0.25–0.45	0.025	0.015	0.15–0.45	1.65–1.95	...	^E	0.30	0.15–0.30	0.0015	0.050
ISO	100CrMo7–3	0.93–1.05	0.60–0.80	0.025	0.015	0.15–0.45	1.65–1.95	...	^E	0.30	0.20–0.35	0.0015	0.050
ISO	100CrMo7–4	0.93–1.05	0.60–0.80	0.025	0.015	0.15–0.35	1.65–1.95	...	^E	0.30	0.40–0.50	0.0015	0.050
ISO	100CrMnMoSi8–4–6	0.93–1.05	0.80–1.10	0.025	0.015	0.40–0.60	1.80–2.05	...	^E	0.30	0.50–0.60	0.0015	0.050

^A Elements not quoted shall not be intentionally added to the steel without the agreement of the purchaser.

^B Intentional additions of calcium or calcium alloys for deoxidation or inclusion shape control are not permitted unless specifically approved by the purchaser.

^C Steels listed as ISO meet the requirements of ISO 683, Part 17, Third Edition, Table 3.

^D Oxygen content applies to product analysis and shall be determined in accordance with Test Methods E1019.

^E A maximum titanium content may be agreed upon at the time of inquiry and order.

6.2 Dimensional tolerances for hot-rolled or hot-rolled and annealed bars, in straight lengths or coils, and cold-finished bars furnished under this specification shall conform to the requirements specified in the latest edition of Specification A29/A29M.

7. Quality Tests

7.1 The supplier shall be held responsible for the quality of the material furnished and shall make the necessary tests to ensure this quality. The supplier shall be required to report on the results of the micro-inclusion rating tests detailed below. Quality tests shown in 7.1 through 7.3 are based upon procedures established in Test Methods E45.

7.2 *Sampling*—Samples taken in accordance with the following paragraphs shall be obtained from 4 in. by 4 in. (102 mm by 102 mm) rolled billets or forged sections. Tests may be made on smaller or larger sections by agreement with the purchaser. A minimum of 3 to 1 reduction of rolled billets or forged sections is required for strand cast products.

7.2.1 For top poured products, a minimum of six samples representing the top and bottom of the first, middle and last usable ingots shall be examined.

7.2.2 For bottom poured products, a minimum of six samples shall be taken from semi-finished or finished product representing the top and bottom of three ingots. One ingot shall be taken at random from the first usable plate poured, one ingot at random from the usable plate poured nearest to the middle of the heat, and one ingot at random from the last usable plate poured. When a heat is constituted by two usable plates, two of the sample ingots shall be selected from the second usable plate poured. When a heat consists of a single usable plate, any three random ingots may be selected. Other methods of sampling shall be as agreed upon between manufacturer and purchaser.

7.2.3 For strand cast products, a minimum of six samples representing the first, middle, and last portion of the heat cast shall be examined. At least one sample shall be taken from each strand.

7.3 *Inclusion Rating*—Specimens approximately $\frac{3}{8}$ in. by $\frac{3}{4}$ in. (9.5 mm by 19.1 mm) shall be taken from an area halfway between the center and outside of the billet. The polished face shall be longitudinal to the direction of rolling. The scale used

TABLE 2 Inclusion Rating

Rating Units	
Thin Series	Heavy Series
A—2.5	A—1.5
B—2.0	B—1.0
C—0.5	C—0.5
D—1.0	D—1.0

TABLE 3 Hardenability Values

Grade	Rockwell C		
	Minimum Rockwell C Values at Sixteenth of Inch		
	10	20	28
1	46	...	...
2	...	52	32
3	46	...	...
4	...	52	35

for rating the specimens shall be the chart described in Test Methods E45, Method A, Plate I-A. Inclusion fields with sizes or numbers intermediate between configurations shown on the chart shall be classified as the lesser of the rating number. The worst field of each inclusion type from each specimen shall be recorded as the rating for the specimen. Two thirds of all specimens and at least one from each ingot tested, or from the first, middle and last portion of the strands tested as well as the average of all specimens, shall not exceed the rating specified in Table 2.

8. Grain Size

8.1 The steels covered by this specification shall have the capability of showing fine fracture grain size (approximately ASTM No. 8) (SAE J418a) when quenched from normal austenizing temperatures not exceeding 1550 °F (843 °C).

9. Hardenability

9.1 Each heat of the grades in Table 3 shall be tested for hardenability. Normalizing followed by spheroidize annealing shall precede heating for end quenching. In heating for end quenching, the test specimens shall be held for a minimum of 30 min at 1500 °F $\pm$ 8 °F (815 °C $\pm$ 4.5 °C). End-quench procedure shall be in accordance with Test Methods A255. The “J” values for hardenability as shown in Table 3 shall apply.

TABLE 4 Decarburization and Surface Imperfections for Bars and Tubes

Size, in. (mm)	Maximum Decarburization or Surface Imperfections per Side, in. (mm)				
	Hot-Rolled Bars	Hot-Rolled Annealed		Cold-Finished Annealed	
		Bars	Tubes	Bars	Tubes
Over 1.000 (25.4) to 2.000 (50.8), incl	0.017 (0.43)	0.022 (0.56)	0.020 (0.51)	0.017 (0.43)	0.014 (0.36)
Over 2.000 (50.8) to 3.000 (76.2), incl	0.025 (0.64)	0.030 (0.76)	0.030 (0.76)	0.025 (0.64)	0.019 (0.48)
Over 3.000 (76.2) to 4.000 (101.6), incl	0.035 (0.89)	0.045 (1.14)	0.035 (0.89)	...	0.024 (0.61)
Over 4.000 (101.6) to 5.000 (127.0), incl	0.055 (1.40)	0.065 (1.65)	0.040 (1.02)	...	0.028 (0.71)

TABLE 5 Hardness Limits for Annealed Material

Product	Condition	Maximum Hardness	
		Brinell	Rockwell
Coils	hot-rolled, annealed	...	B97
Bars and tubes	hot-rolled, annealed	217	...
Coils	annealed, cold drawn (stress relieved)	...	B92
Coils, bars, and tubes	annealed, cold drawn ^A	260	...

^A Cold swaged material is not included.

10. Decarburization and Surface Imperfections

10.1 Decarburization and surface imperfections shall not exceed the limits specified in **Table 4**. Decarburization shall be measured using the microscopical methods described in Test Methods **E1077**.

11. Microstructure and Hardness

11.1 The material shall be free of excessive carbide segregation.

11.2 When annealing is specified in the order, the steel shall have a microstructure completely spheroidized, or as agreed upon, and the maximum hardness as specified in **Table 5**.

12. Inspection

12.1 The manufacturer shall afford the purchaser's inspector all reasonable facilities necessary to satisfy him that the

material is being produced and furnished in accordance with this specification. Mill inspection by the purchaser shall not interfere unnecessarily with the manufacturer's operations. All tests and inspections shall be made at the place of manufacture, unless otherwise agreed to.

13. Certification and Reports

13.1 Upon request of the purchaser in the contract or order, a manufacturer's certification that the material was manufactured and tested in accordance with this specification together with a report of the test results shall be furnished at the time of shipment. Special requirements agreed to at the time of purchase must be noted on the certification.

SUPPLEMENTARY REQUIREMENTS

One or more of the supplementary requirements described below apply when included in purchaser's order or contract. When so included, a supplementary requirement shall have the same force as if it were in the body of the specification. Supplementary requirements details not fully described shall be agreed upon between the purchaser and the supplier, but shall not negate any of the requirements in the body of the specification.

S1. "SAM" Inclusion Rating System

S1.1 The purchaser may specify that the "SAM" inclusion rating method, described in Method E of Test Methods **E45**, be used in addition to the micro-inclusion rating method described in **7.3**.

S1.2 *Sampling*—See Section **7**.

S1.3 *Limits*—The "SAM" rating for Type B inclusions shall not exceed 15. The "SAM" rating for Type D inclusions shall not exceed 10.

S2. Magnetic Particle Method

S2.1 The purchaser may specify that the magnetic particles method described below be used in addition to the micro-inclusion rating system described in **7.3**. The magnetic particle

method measures bearing steel cleanliness by evaluating the total length of macro-inclusions for a stated area or per unit area. Results are commonly expressed in mm/m².

S2.2 *Sampling*—See **7.2**.

S2.3 Test specimens shall be straight cylinder quarter section samples prepared and examined in accordance with the magnetic particle method of Test Methods **E45**.

S2.4 For purposes of calculation, an inclusion length shall be taken as the mean length of the length bracket in which it falls; that is, an inclusion in the 1/16 to 1/8 in. bracket shall be taken as being 3/32 in length. The sum of all lengths for each specimen shall be determined and expressed as total length per area inspected. The average total length per area inspected of all six specimens shall not exceed 200 mm/m² (or equivalent).

S3. Sulfur Requirements for Machinability

S3.1 The sulfur content shall be 0.015–0.030 %.

S3.2 The sulfide (type A) rating units in **Table 2** shall be 3.0 thin and 2.0 heavy.

S3.3 The manufacturer's certification shall state that material was produced to this supplementary requirement when applicable.

S4. Calculated Hardenability

S4.1 A calculated hardenability shall be used in lieu of the requirements in **Section 9**. The method used shall be agreed upon between the purchaser and the steel supplier at the time of inquiry and order.

S5. Sample Reduction Ratio

S5.1 For the sampling described in **7.2**, the purchaser may specify that the reduction ratio from as-cast section to test section be provided.

S6. Macroetch Testing

S6.1 *Sampling*—See **7.2**.

S6.2 Specimens representative of the full cross section of bars, billets, or blooms shall be macroetched and rated in accordance with Method **E381** in hydrochloric acid and water (1:1) at a temperature of 160 to 180 °F (71 to 82 °C). Such specimens shall not exceed S2, R2, C2 of Method **E381**. Indications due to sulfur segregation (commonly referred to as Type A segregates) are not to be included in the rating. For ingot cast material only, if the size and weight of the bars, billets, or blooms prevent the full cross section from being macroetched, an oversize quarter-section may be used as an alternative. The quarter-section must meet the reduction requirement of **7.2** and contain both the surface and center of the original cross section before reduction.

SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this standard since the last issue (A485 – 14) that may impact the use of this standard. (Approved Sept. 1, 2017.)

(1) **Table 1**—ISO grade number designations revised.

(2) **Table 1**—Grades 100CrMo7 and 100CrMo7-3, chemistry was revised.

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