



ASTM INTERNATIONAL

استاندارد فرومگنز

ASTM A99:2014



# Standard Specification for Ferromanganese<sup>1</sup>

This standard is issued under the fixed designation A99; 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 ten grades of ferromanganese, designated as follows:

Standard ferromanganese	Grade A Grade B Grade C
Medium-carbon ferromanganese	Grades A,B,C, and D Nitrided
Low-carbon ferromanganese	Grade A Grade B

1.2 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.

## 2. Referenced Documents

2.1 *ASTM Standards*:<sup>2</sup>

[A1025/A1025M Specification for Ferrous Alloys and Other Alloying Materials, General Requirements](#)

[E11 Specification for Woven Wire Test Sieve Cloth and Test Sieves](#)

<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 A01.18 on Castings.

Current edition approved Oct. 1, 2014. Published October 2014. Originally approved in 1925. Last previous edition approved in 2009 as A99 – 03(2009). DOI: 10.1520/A0099-03R14.

<sup>2</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.

## 3. General Conditions for Delivery

3.1 Materials furnished to this specification shall conform to the requirements of Specification [A1025/A1025M](#), including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification [A1025/A1025M](#) constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification [A1025/A1025M](#), this specification shall prevail.

## 4. Chemical Composition

4.1 The material shall conform to the requirements as to chemical composition specified in [Table 1](#).

4.2 The manufacturer shall furnish an analysis of each shipment showing the percentage of each element specified.

## 5. Size

5.1 The various grades are available in sizes as listed in [Table 2](#).

5.2 The sizes and friability ratings listed in [Table 2](#) are typical as shipped from the manufacturer's plant. These alloys exhibit varying degrees of friability; therefore, some attrition may be expected in transit, storage, and handling. A code system has been developed. Therefore, for this purpose, a number rating for each product type is shown in the last column of [Table 2](#). Definitions applicable to these code numbers are given in Specification [A1025/A1025M](#).

## 6. Keywords

6.1 ferrous alloy; ferromanganese

**TABLE 1 Chemical Requirements**

	Standard Ferromanganese			Medium Carbon Ferromanganese				Nitrided Medium Carbon Ferromanganese	Low Carbon Ferromanganese	
	Grade A	Grade B	Grade C	Grade A	Grade B	Grade C	Grade D		Grade A	Grade B
Manganese, %	78.0 to 82.0	76.0 to 78.0	74.0 to 76.0	80.0 to 85.0	80.0 to 85.0	80.0 to 85.0	80.0 to 85.0	75 to 80 <sup>A</sup>	85.0 to 90.0	80.0 to 85.0
Carbon, max, %	7.5	7.5	7.5	1.5	1.5	1.5	1.5	1.5 <sup>A</sup>	As specified	0.75
Silicon, max, %	1.2	1.2	1.2	1.5	1.0	0.70	0.35	1.5 <sup>A</sup>	2.0	5.0 to 7.0
Phosphorus, max, %	0.35	0.35	0.35	0.30	0.30	0.30	0.30	0.3	0.20	0.30
Sulfur, max, %	0.050	0.050	0.050	0.020	0.020	0.020	0.020	0.020	0.020	0.020
Nitrogen, %								4% min		

<sup>A</sup> Based on metallic content.

**TABLE 2 Standard Sizes and Tolerances**

Product	Standard Sizes	Tolerances <sup>A</sup>		Friability Rating
Standard ferromanganese Grades A, B, C	8 × 4 in. (200 × 100 mm) 5 × 2 in. (125 × 50 mm) 4 × 1 in. (100 × 25 mm) 2 × ¼ in. (50 × 6.3 mm) ¾ in. × 12 mesh (9.5 × 1.4 mm) ¼ in. × down (6.3 mm × down) 8 mesh × down (2.36 mm × down) 20 mesh × down (0.85 mm × down)	90 lb (40.8-kg) lump, max 10 % max retained on 5-in. (125-mm) sieve 10 % max retained on 4-in. (100-mm) sieve 10 % max retained on 2-in. (50-mm) sieve 5 % max retained on ¾-in. (9.5-mm) sieve 5 % max retained on ¼-in. (6.3-mm) sieve 5 % max retained on No. 8 (2.36-mm) sieve 5 % max retained on No. 20 (0.85 mm) sieve	10 % max passing 4-in. (100-mm) sieve 10 % max passing 2-in. (50-mm) sieve 10 % max passing 1-in. (25-mm) sieve 10 % max passing ¼-in. (6.3-mm) sieve 5 % max passing No. 14 (1.4-mm) sieve	4
Medium-carbon ferromanganese Grades A, B, C, and D	8 × 4 in. (200 × 100 mm) 5 × 2 in. (125 × 50 mm) 4 in. × down (100 mm × down) 2 in. × down (50 mm × down) 8 mesh × down (2.36 mm × down)	90-lb (40.8-kg) lump, max 10 % max retained on 5-in. (125-mm) sieve 10 % max retained on 4-in. (100-mm) sieve 10 % max retained on 2-in. (50-mm) sieve 5 % max retained on No. 8 (2.36-mm) sieve	10 % max passing 4-in. (100-mm) sieve 10 % max passing 2-in. (50-mm) sieve 12 % max passing ¼-in. (6.3-mm) sieve 15 % max passing No. 8 (2.36-mm) sieve	4½
Medium-carbon ferromanganese Nitrided grade	Briquetted only			4
Low-carbon ferromanganese Grades A and B	6 × 2 in. (150 × 50 mm) 4 × ¼ in. (100 × 6.3 mm) 8 mesh × down (2.36 mm × down) 20 mesh × down (0.85 mm × down)	10 % max retained on 6-in. (150-mm) sieve 10 % max retained on 4-in. (100-mm) sieve 5 % max retained on No. 8 (2.36-mm) sieve 5 % max retained on No. 20 (0.85-mm) sieve	10 % max passing 2-in. (50-mm) sieve 5 % max passing ¼-in. (6.3-mm) sieve	5

<sup>A</sup> Specifications of sieve sizes used to define tolerances herein are as listed in Specification E11.

## SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall apply only when specified by the purchaser in the purchase order or contract.

### S1. Chemical Requirements

The composition shall be further limited to the requirements of **Table S1.1** in addition to those of **Table 1**. The manufacturer shall furnish an analysis of each shipment showing the per-

centage of the elements specified.

**TABLE S1.1 Supplemental Chemical Requirements**

	Composition, max, %		
	Standard Ferromanganese, All Grades	Medium-Carbon Ferromanganese, All Grades	Low-Carbon Ferromanganese, All Grades
Arsenic	0.30	0.15	0.10
Tin	0.020	0.010	0.010
Lead	0.050	0.050	0.020
Chromium	0.50	0.50	0.50
Carbon	0.10 or 0.50 or 0.70 for Grade A only		

*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). Permission rights to photocopy the standard may also be secured from the Copyright Clearance Center, 222 Rosewood Drive, Danvers, MA 01923, Tel: (978) 646-2600; http://www.copyright.com/*