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ASTM Designation: **A194/A194M - 11**

Standard Specification for Carbon and Alloy Steel Nuts for Bolts for High Pressure or High Temperature Service, or Both¹

This specification covers nuts for high pressure, high-temperature, non-austenitic stainless steels including the designation includes the use of original designations in the case of reissues. A number in parentheses indicates the year of last approval. An asterisk indicates an alternate design after the last revision or reapproval.

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

1. Scope²

1.1 This specification³ covers a variety of carbon, alloy, and non-austenitic stainless steel nuts in the size range 1/8 through 4 in. and metric M8 through M100 nominal. It also covers non-austenitic stainless steel nuts in the size range 1/8, 1/4, and M8 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 Nuts from which the nuts are made shall be hot-rolled. The material may be further processed by centrifugal 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 S1.2, 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 applicable⁴ identification designation (SI units), the manufacturer shall be furnished to inch-pound units.

1.5 The values stated in either this particular unit 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-conformity with the standard. Within the text, the SI units are shown in brackets.

2. Referenced Documents

2.1 **ASTM Standards⁵**

A193/A193M Specification for Zinc Coating (Hot Dip) on Iron and Steel Hardware
A276 Specification for Stainless Steel Bars and Shapes
A276/A276M Specification for Alloy-Steel and Stainless Steel Bolting for Low-Temperature Service
A923/A923M Specification for Common Requirements for Bolting Intended for Use at Low Temperatures from Cryogenics to the Creep Range
B91 Specification for Electrodeposited Coatings of Zinc on Iron and Steel
B91M Specification for Coatings of Zinc Mechanically Deposited on Iron and Steel
B95M Specification for Coatings of Cadmium Mechanically Deposited
E112 Specification for Electrodeposited Coatings of Cadmium
E112 Test Methods for Determining Average Grain Size
F191M Test Method for Process Control Verification in Process Hydrogen Embrittlement in Flared or Conical Fasteners
F2141 Specification for Electrodeposited Coatings on Threaded Fasteners (Unflared Inch Screw Threads) (UNS) (ENR)
F2239 Specification for Zinc Coating, Hot Dip, Requirements for Application to Carbon and Alloy Steel Bolts, Nuts, Washers, Nails, and Special Threaded Fasteners
2.2 **ASME Standards⁶**

B 1.1 Unified Screw Threads
B 1.1.3 Gages and Gaging for Unified Inch Screw Threads
B 1.1.3M Metric Screw Threads

¹For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at astm@astm.org. For Annual Book of ASTM Standards contact ASTM Customer Service at astm@astm.org.

²The values stated in either this particular unit 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-conformity with the standard. Within the text, the SI units are shown in brackets.

³This 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 Fasteners and Wrenching Fasteners for Pipeline Applications and Bolting Members for Bridge and Heavy Equipment. Technical Committee A01.22, responsible for this standard, consists of the following members: A01.22.01, A01.22.02, A01.22.03, A01.22.04, A01.22.05, A01.22.06, A01.22.07, A01.22.08, A01.22.09, A01.22.10, A01.22.11, A01.22.12, A01.22.13, A01.22.14, A01.22.15, A01.22.16, A01.22.17, A01.22.18, A01.22.19, A01.22.20, A01.22.21, A01.22.22, A01.22.23, A01.22.24, A01.22.25, A01.22.26, A01.22.27, A01.22.28, A01.22.29, A01.22.30, A01.22.31, A01.22.32, A01.22.33, A01.22.34, A01.22.35, A01.22.36, A01.22.37, A01.22.38, A01.22.39, A01.22.40, A01.22.41, A01.22.42, A01.22.43, A01.22.44, A01.22.45, A01.22.46, A01.22.47, A01.22.48, A01.22.49, A01.22.50, A01.22.51, A01.22.52, A01.22.53, A01.22.54, A01.22.55, A01.22.56, A01.22.57, A01.22.58, A01.22.59, A01.22.60, A01.22.61, A01.22.62, A01.22.63, A01.22.64, A01.22.65, A01.22.66, A01.22.67, A01.22.68, A01.22.69, A01.22.70, A01.22.71, A01.22.72, A01.22.73, A01.22.74, A01.22.75, A01.22.76, A01.22.77, A01.22.78, A01.22.79, A01.22.80, A01.22.81, A01.22.82, 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