

Pipe Grade	ASTM Specification	Post-Weld Heat-Treat Temperature Range (Stress Relieving), F(°C)	Normalizing Temperature, max unless otherwise noted, °F(°C)	Quenching Temperature, max unless otherwise noted, °F(°C)	Tempering Temperature, min, °F(°C)
CM-65	A204/A204M	1100 to 1200 [590 to 650]	1700 [925]	—	—
CM-70	A204/A204M	1100 to 1200 [590 to 650]	1700 [925]	—	—
CM-75	A204/A204M	1100 to 1200 [590 to 650]	1700 [925]	—	—
CMSH-70	A537/A537M	1100 to 1200 [590 to 650]	1700 [925]	—	—
CMS-75	A299/A299M	1100 to 1200 [590 to 650]	1700 [925]	—	—
CMSH-80	A537/A537M	1100 to 1200 [590 to 650]	^B	1700 [925]	1100 to 1250 [590 to 675]
½ CR	A387/A387M	1100 to 1300 [590 to 705]	1850 [1010]	1700 [925]	1150 to 1375 [620 to 745]
1CR	A387/A387M	1100 to 1350 [590 to 730]	1850 [1010]	1700 [925]	1150 to 1375 [620 to 745]
1½ CR	A387/A387M	1100 to 1375 [590 to 745]	1850 [1010]	1700 [925]	1150 to 1375 [620 to 745]
2½ CR	A387/A387M	1200 to 1400 [650 to 760]	1850 [1010]	1700 [925]	1250 to 1400 [675 to 760]
3CR	A387/A387M	1200 to 1400 [650 to 760]	1850 [1010]	1700 [925]	1250 to 1400 [675 to 760]
5CR	A387/A387M	1200 to 1400 [650 to 760]	1850 [1010]	1650 [900]	1300 to 1400 [705 to 760]
9CR	A387/A387M	1325 to 1375 [715 to 745]	^C	—	1325 to 1375 [715 to 745]
91	A387/A387M	1350 to 1420 [730 to 770]	1900 to 2000 [1040 to 1095]	1900 min [1040 min]	1350 to 1440 [730 to 780]

^A Where ellipses (...) appear in the table, there is no requirement.

^B Requires quenching and tempering.

^C 9 CR steel is an air-hardenable steel, at times retaining austenite down to near atmospheric temperature. Good practice is to allow the steel to cool to 150°F or lower before subjecting the steel to a tempering treatment or post-weld heat treatment.

Steel Plates Information Table Cat 13

Henry Marion Howe



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