

AS 2528—1982

Australian Standard<sup>®</sup>

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**Bolts, studbolts and nuts for  
flanges and other high and low  
temperature applications**

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The following scientific, industrial and governmental organizations and departments were officially represented on the committee entrusted with the preparation of this standard:

Australian Institute of Steel Construction Ltd  
Bureau of Steel Manufacturers of Australia  
Confederation of Australian Industry  
Department of Defence  
Department of Industrial Relations, N.S.W.  
Electricity Supply Association of Australia  
Engineering and Water Supply Department, S.A.  
Fasteners Institute of Australia  
Federal Chamber of Automotive Industries  
Institution of Production Engineers  
Metal Trades Industry Association of Australia  
Metropolitan Water Sewerage & Drainage Board, Sydney  
Petroleum Refinery Engineers Advisory Committee  
Railways of Australia Committee  
Society of Automotive Engineers—Australasia  
Telecom Australia  
Tractor and Machinery Association of Australia  
University of New South Wales  
University of Sydney

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## PREFACE

This standard was prepared jointly by the Association's Committee on Fasteners and Committee on Flanges as a part of the revision of AS 2129—1978, Flanges and Bolting for Pipes, Valves and Fittings. It supersedes the corresponding portion of AS 2129—1978.

During the preparation of this standard it was noted that while AS 2129 covered quite a large proportion of Australian requirements for bolting for flanges there were major sections of industry, most notably the petroleum, chemical and petrochemical industries, which were heavily committed to the use of flanges to ANSI B16.5, Steel Pipe Flanges and Flanged Fittings, Including Ratings for Class 150, 300, 400, 600, 900, 1500 and 2500, which require an inch series of stud bolts with associated nuts. It was recognised that while the ultimate object is to establish a single series of metric pipe flanges and associated bolting to cover all requirements, nevertheless the ANSI B16.5 flanges will continue to be used for some considerable period.

It was also noted that AS 2129 was in effect a soft metric conversion of imperial flanges and bolting and included a series of metric bolting intended for use in the cryogenic and elevated temperature ranges; in reality most fasteners used in these applications were still inch series manufactured in accordance with ASTM A193, Specification for Alloy-steel and Stainless Steel Bolting Materials for High-temperature Service, ASTM A 194, Specification for Carbon and Alloy Steel Nuts for Bolts for High-pressure and High-temperature Service, and ASTM A 320, Specification for Alloy-steel Bolting Materials for Low-temperature Service. To achieve an overall rationalized system of flange bolting, and recognizing current requirements, the committee agreed that the standard would include the following sections:

- (a) A section giving a metric series of bolts, studbolts and nuts used in the temperature range  $-50^{\circ}\text{C}$  to  $+300^{\circ}\text{C}$ , covering the bulk of requirements of AS 2129.
- (b) A section giving all inch series of studbolts and nuts covering the bolting requirement of flanges to ANSI B16.5 and other flanges and which are also suitable for bolting flanges to AS 2129 in the temperature ranges  $-200^{\circ}\text{C}$  to  $-50^{\circ}\text{C}$  and  $+300^{\circ}\text{C}$  to  $+525^{\circ}\text{C}$ .

The metric series of bolting is, with respect to dimensions, materials and properties, in line with ISO standards (where applicable) and it should be noted that the physical properties are specified in such a manner as to make testing in full size possible. This follows the approach used in all Australian metric fastener standards. Conversely, for the inch series bolting, the grades have been selected from ASTM A 193, ASTM A 194 or ASTM A 320 and have been rationalized to suit Australian requirements, but owing to the manner in which the physical properties are specified in those standards it is not possible to test the fasteners in full size. This accounts for the different approach to the test requirements between the inch and the metric fasteners.

During the preparation of the standard it was also noted that the methods of defining the overall length and length of thread were different for the metric and inch series of studbolts. For metric studbolts these lengths include the chamfer on the threaded end, whereas for inch studbolts these lengths do not include the chamfer on the threaded end. The committee gave serious consideration to the rationalization of these practices, but concluded that both methods were so deeply entrenched in the different sections of industry that any change from current practices was not warranted and could cause confusion.

An appendix has been included giving notes on bolting strength and performance at elevated temperatures. The appendix represents material given in BS 4882, Bolting for Flanges and Pressure Containing Purposes, with minor editorial amendments. Acknowledgement is made to the British Standards Institution for the use of this material.

In most sectors of industry, metric conversion is now at an advanced stage and it is anticipated that this rate of conversion will increase during the next few years. As a consequence, measuring capability in imperial units will decline. To meet this situation, an appendix has been provided which gives the approximate metric equivalent of all dimensions, tolerances and mechanical properties given in Section 3 of this standard. The inch designation, however, has been retained because it is currently well entrenched in Australian industry; furthermore, the cost to industry of amending drawings, specifications, and the like to introduce a different designation could not be justified.

Although at present there are no international standards dealing specifically with bolting for flanges, account has been taken where possible of standards prepared by ISO/TC 2, Bolts, Nuts, Fasteners and Accessories, and the provision of the following ISO standards have been incorporated in this standard:

ISO 225	Bolts, Screws and Studs—Dimensioning
ISO 272	Fasteners—Hexagon Products—Widths Across Flats
ISO 885	General Purpose Bolts and Screws—Metric Series—Radii Under the Head
ISO 888	Bolts, Screws and Studs—Nominal Lengths, and Thread Lengths for General Purpose Bolts
ISO 898/1	Mechanical Properties of Fasteners Part 1—Bolts, Screws and Studs
ISO 4759/1	Tolerances for Fasteners Part 1—Bolts, Screws and Nuts with Thread Diameters Between 1.6 (inclusive) and 150 mm (inclusive) and Product Grades A, B and C

In addition, for inch bolting account was also taken of ANSI B16.5, ASTM A 193, ASTM A 194, ASTM A 320, and BS 4882.

This standard may require reference to the following Australian standards:

AS 1014	Gauging of Metric Screw Threads	AS 1544	Methods for Impact Tests on Metals Part 2—Charpy V-notch Part 3—Charpy U-notch and Keyhole Notch
AS 1110	ISO Metric Hexagon Precision Bolts and Screws	AS 1654	Limits and Fits for Engineering
AS 1111	ISO Metric Hexagon Commercial Bolts and Screws	AS 1721	General Purpose Metric Screw Threads
AS 1112	ISO Metric Hexagon Nuts, Including Thin Nuts, Slotted Nuts and Castle Nuts	AS 1815	Method for Rockwell Hardness Test Part 1—Testing of Metals
AS 1214	Hot-dip Galvanized Coatings on Threaded Fasteners (ISO Metric Coarse Thread Series)	AS 1816	Method for Brinell Hardness Test Part 1—Testing of Metals
AS 1252	General Grade High-strength Steel Bolts With Associated Nuts and Washers for Structural Engineering (ISO Metric Series)	AS 1817	Method for Vickers Hardness Test Part 1—Testing of Metals
AS 1275	Metric Screw Threads for Fasteners (Based on ISO Recommendations)	AS 1823	Suppliers Quality Control System—Level 3
AS 1391	Methods for Tensile Testing of Metals	AS 1897	Electroplated Coatings on Threaded Components (Metric Coarse Series)
AS 1442	Carbon Steels and Carbon-manganese Steels— Hot-rolled Bars and Semi-finished Products	AS 2129	Flanges and Bolting for Pipes, Valves and Fittings
AS 1443	Carbon Steels and Carbon-manganese Steels—Bright Bars	AS B133	Unified Screw Threads
AS 1444	Wrought Alloy Steels—AISI-SAE Standard, Hardenability (H) and Stainless Series	AS B193	Hot-dip Galvanized Coating on Fasteners (BSW and UNC Threads)
		AS K132	Electroplated Coatings on Threaded Components Part 1—Cadmium on Steel Part 2—Zinc on Steel

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