

Product and Application

TruSTRENGTH structural steel flats heat treated to 150 ksi yield strength, as well as other mechanical testing requirements. After heat treatment, product is intended for use in applications requiring a combination of high strength, weldability and toughness.

Available in thickness 1/4" - 2", widths 3" - 12" and lengths up to 56'.

Mechanical Properties

Yield Strength (0.2%)	150 ksi (1034 MPa)
Tensile Strength	155 - 175 ksi (1069 - 1207 MPa)
Elongation in 2"	13%
Reduction of Area	35%
Charpy V-Notch @ -40° F	15 ft-lbs (20.3 J), average of 3 specimens, longitudinal
Methods	Mechanical tests in accordance with ASTM A370, latest revision
Frequency	Per heat, per size and per load

* Minimum values unless otherwise noted.

Dimensional Tolerances

Cross-Sectional Dimensions	Per ASTM A6, Table 26 (flats)
Length	Per ASTM A6, Table 30
Width	Per ASTM A6
Straightness	1/8" in 5' maximum deviation

Chemical Composition

	C	Mn	P	S	Si	Cu	Ni	Cr	Mo
Min	0.14	0.90	-	-	0.15	-	-	0.40	-
Max	0.22	1.55	0.035	0.040	0.40	0.50	0.50	0.70	0.50
CE* (typical):	0.58		*Carbon Equivalency calculated using the following formula: CEV = C + Mn/6 + (Cr+Mo+V)/5 + (Ni+Cu)/15						

150 Flat Bar

Recommended Welding Practices

TruSTRENGTH 150 flat bar can be welded by conventional processes such as SMAW, SAW and GMAW, provided the weld procedures used are suitable for this grade and design of the welded structure. Proper weld procedures should include the following:

1. Low Hydrogen conditions must be used.
2. Preheating to 200-500 °F is required for heavy section (>0.750"), and is recommended for thinner sections to eliminate moisture.
3. Slow cooling rates should be avoided to prevent low toughness in the heat-affected zone (HAZ).

*These statements are general guidelines. CMC Impact Metals is not responsible for the results of any welding work performed. Contact your CMC Impact Metals representative to receive more detailed technical information about any fabrication or machining processes.

Standard Delivery Conditions

Test Reports

Supplied with shipment for each production lot in the shipment. Reports include description of product and heat treatment processing, and heat number, heat treatment lot and chemical analysis of all elements listed from ladle analysis.