



STAINLESS STEEL FASTENERS

ACCEPTANCE

Acceptance of stainless steel bolts, studs, rods, hex cap screws, nuts and washers shall be on the basis of Mill Test Certification and acceptable test results from an approved manufacturer and sampling and testing by the Iowa Department of Transportation as listed in this IM.

REQUIREMENTS

Stainless steel bolts, studs, rods, and hex cap screws shall meet the requirements of ASTM F593 of the specified group, alloys and condition [(Cold Worked-CW), (Hardened and tempered-H), (Age Hardened-A)].

All nuts used on these fasteners shall conform to the requirements of ASTM F594 and shall be of the same alloy group as required for the bolts, studs, rods, and hex cap screws.

Threads on all stainless steel fasteners can be either rolled or cut, and shall be unified inch screw threads.

Washer material shall meet the requirements of ASTM A240/A240M and ASTM A480/A480M. Dimensions and permissible variations shall meet the requirements of ASTM F436/F436M or ANSI B18.22.1, Type A.

At the time of shipment, one copy of properly identified, certified Mill Test Analysis shall be forwarded to the project engineer and one copy to the respective District Materials Engineer. Stainless steel fasteners shall be made of the dimension, size, group, alloys and conditions specified in the contract documents.

The sampling frequency is one sample per size, per project.

Approved suppliers are listed in Appendix A of this IM.