

Eliminating Hydrogen Embrittlement per ASTM B766

- Cadmium
- Stress Relieve
- Post Bake

ASTM B766-86

Electrodeposited Coatings of Cadmium

6.3 Stress Relief—Steel parts having an ultimate tensile strength of 1050 MPa (approximately 35 HRC) and above, and that have been machined, ground, cold-formed, or cold-straightened shall be heat-treated at $190 \pm 15^{\circ}\text{C}$ for 5 h or more for stress relief before cleaning and coating.

6.7 Hydrogen Embrittlement Relief—Steel parts having a tensile strength of 1200 MPa (approximately 38 HRC) and higher shall be baked at $190 \pm 15^{\circ}\text{C}$ for 8 h or more within 4 h after electroplating to provide hydrogen embrittlement relief.