



Designation: **A747/A747M – 16a** A747/A747M – 18

Standard Specification for Steel Castings, Stainless, Precipitation Hardening¹

This standard is issued under the fixed designation A747/A747M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This specification covers iron-chromium-nickel-copper corrosion-resistant steel castings, capable of being strengthened by precipitation hardening heat treatment.

1.2 These castings may be used in services requiring corrosion resistance and high strengths at temperatures up to 600°F [315°C]–600°F [315°C]. They may be machined in the ~~solution-annealed~~ solution heat-treated condition and subsequently precipitation hardened to the desired high-strength mechanical properties specified in [Table S24.1](#) with little danger of cracking or distortion.

1.3 The material is not intended for use in the ~~solution-annealed~~ solution heat-treated condition.

NOTE 1—If the service environment in which the material is to be used is considered conducive to stress-corrosion cracking, precipitation hardening should be performed at a temperature that will minimize the susceptibility of the material to this type of attack.

1.4 Supplementary requirements of an optional nature are provided for use at the option of the purchaser. The ~~Supplementary~~ supplementary requirements shall apply only when specified individually by the purchaser in the purchase order or contract.

1.5 This specification is expressed in both inch-pound units and in SI units; however, unless the purchase order or contract specifies the applicable ~~M-specification~~ M-specification designation (SI units), the inch-pound units shall apply.

1.6 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in ~~non-conformance~~ nonconformance with the standard.

1.6.1 Within the text, the SI units are shown in brackets.

1.7 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[A781/A781M Specification for Castings, Steel and Alloy, Common Requirements, for General Industrial Use](#)

[A957/A957M Specification for Investment Castings, Steel and Alloy, Common Requirements, for General Industrial Use](#)

[A1067/A1067M Specification for Test Coupons for Steel Castings](#)

[A1080 Practice for Hot Isostatic Pressing of Steel, Stainless Steel, and Related Alloy Castings](#)

2.2 *ASME Standard:*³

[ASME Boiler and Pressure Vessel Code, Supplementary Requirements Section II, Part A](#)

3. General Conditions for Delivery

3.1 Except for investment castings, castings furnished to this specification shall be in accordance with the requirements of Specification [A781/A781M](#), including any supplementary requirements that are indicated in the purchase order. Failure to comply

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.18 on Castings.

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² For referenced ASTM standards, visit the ASTM website, [www.astm.org](#), or contact ASTM Customer Service at [service@astm.org](#). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, [http://www.asme.org](#).

*A Summary of Changes section appears at the end of this standard

with the general requirements of Specification **A781/A781M** constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification **A781/A781M**, this specification shall prevail.

3.2 Steel investment castings furnished to this specification shall conform to the requirements of Specification **A957/A957M**, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification **A957/A957M** constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification **A957/A957M**, Specification **A957/A957M** shall prevail.

4. Ordering Information

4.1 Orders for material to this specification should include the following:

- 4.1.1 Quantity,
- 4.1.2 Specification designation and date of issue,
- 4.1.3 Grade designation (**Table 1**), and
- 4.1.4 Description of casting by part, pattern, or drawing number. (Dimensional tolerances and machined surfaces should be indicated on the casting ~~drawing~~-drawing.)
- 4.1.5 ~~Heat treatment~~Heat-treatment condition (SA, H900, and so forth,forth); see **5.2** and **Table 1**,
- 4.1.6 Options in the specification, if any, in accordance with **5.2** and Section **7**, and
- 4.1.7 Supplementary requirements, if any, including the standards of acceptance.
- 4.1.8 For ASME Boiler & Pressure Vessel Code applications and equipment, if applicable, ~~supplementary requirements~~Supplementary Requirements S6, S14, and S27 are mandatory and shall be specified in the purchase order.

5. Materials and Manufacture

5.1 The steel shall be made by the electric furnace process with or without separate refining such as argon-oxygen decarburization (AOD).

5.2 ~~Heat Treatment~~—Castings may be given a homogenization heat treatment in accordance with **5.2.1** at the supplier’s option or when specified by the purchaser (see S56) prior to solution heat treatment. All castings, whether homogenized or not, shall be given a solution heat treatment in accordance with **5.2.2** and, unless ordered in the ~~solution-annealed condition~~ solution heat-treated condition, shall be precipitation hardened to the ordered condition (**Table 1**).

5.2.1 Homogenization heat treatment shall consist of heating the castings and test material to a minimum of ~~1900°F~~ 1040°C; 1900 °F [1040 °C], holding for a minimum of 1½ h, and cooling to below ~~90°F~~ 30°C; 90 °F [30 °C].

5.2.1.1 When agreed upon between purchaser and supplier, ~~supplementary requirement S18, Hot Isostatic Pressing~~Supplementary Requirement S18, hot isostatic pressing (HIPing), in accordance with Practice **A1080** may be used in place of the homogenization heat treatment.

5.2.2 ~~Solution annealing~~heat treatment shall consist of heating the castings and test material to ~~1925°F ± 50°F~~ 1050°C ± 30°C; 30 °C], holding the 30 min/in. [1.2 min/mm] of section but not less than 30 min, and cooling to below ~~90°F~~ 30°C; 90 °F [30 °C].

5.2.3 Temperature used for precipitation hardening shall be maintained within the range of ~~±25°F~~ ±15°C; ±25 °F [±15 °C] of that listed in **Table 1** for the heat-treatment condition ordered. (See **Note 1**.)

5.2.4 When the order or contract specifies a minimum columbium (niobium) content, the minimum precipitation hardening temperature shall be ~~925°F~~ 495°C; 925 °F [495 °C].

TABLE 1 Precipitation Hardening Heat Treatment^{A,B}

Condition	PH Temperature, ^C Temperature, °F [°C] °F [°C]	Time in hours hours, minimum	Cooling—Treatment Treatment
SA	Not precipitation hardened (see 5.2.3)		
H900	900 [480]	1.5	air cool
H925	925 [495]	1.5	air cool
H1025	1025 [550]	4.0	air cool
H1075	1075 [580]	4.0	air cool
H1100	1100 [595]	4.0	air cool
H1150	1150 [620]	4.0	air cool
H1150M	1400 [760]	2.0	air cool
	1150 [620]	4.0	air cool
H1150 DBL	1150 [620]	4.0	air cool
	1150 [620]	4.0	air cool

^A The furnace and controls used shall be calibrated and capable of uniformity of heating in order to ensure consistent results.

^B See **Note 1**.

^C ~~±25°F~~ ±15°C; ±25 °F [15 °C].

6. Chemical Composition

6.1 The steel shall be in accordance with the requirements as to chemical composition prescribed in **Table 2**.

6.2 When the H900 condition is ordered, the minimum columbium (niobium) content (**Table 2**) shall not apply. It is recommended that columbium (niobium) other than that in revert material not be added.

7. Repair by Welding

7.1 Repairs shall be made only in one of the following conditions: homogenized, solution ~~annealed~~, ~~heat treated~~, H1100, H1150, H1150M, H1150DBL, or stress relieved at ~~1150 °F ± 25 °F [620 °C ± 15 °C]~~ 1150 °F ± 25 °F [620 °C ± 15 °C] for a minimum of 4 h.

7.2 Castings welded in one of the aged conditions noted in 7.1 shall be ~~post-weld~~ ~~post-weld~~ heat treated by the same aging treatment used prior to welding, or, where necessary to meet mechanical property requirements, shall be solution ~~annealed~~ ~~heat treated~~ and aged after welding. Castings welded in the stress-relieved condition shall receive the ~~specifications~~ specified heat treatment after welding.

7.3 When agreed upon between purchaser and supplier, castings may be repaired in the as-cast condition. (See S58.)

8. Keywords

8.1 precipitation hardening stainless steel; stainless steel; steel castings

SUPPLEMENTARY REQUIREMENTS

A list of standardized supplementary requirements for use at the option of the purchaser is described in Specifications **A781/A781M** and **A957/A957M**. Those that are considered suitable for use with this specification are listed below by title only. Additional supplementary requirements suitable for use with this specification at the option of the purchaser are described below. One or more of the supplementary requirements indicated below may be included in the purchaser's order or contract. When so included, a supplementary requirement shall have the same force as if it were in the body of the specification. Supplementary requirements details not fully described shall be agreed upon between the purchaser and the supplier, but shall not negate any of the requirements in the body of the specification.

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<https://standards.iteh.ai/catalog/standards/sist/30833c66-5350-43f8-a68b-42244267bf4a/astm-a747-a747m-18>

TABLE 2 Chemical Requirements-Requirements^A

Grade	CB7Cu-1	CB7Cu-2
UNS	J92180	J92110
Type	17-4	15-5
Carbon	0.07	0.07
Manganese	0.70	0.70
Phosphorus	0.035	0.035
Sulfur	0.03	0.03
Silicon	1.00	1.00
Chromium	15.50–17.70	14.0–15.50
Nickel	3.60–4.60	4.50–5.50
Copper	2.50–3.20	2.50–3.20
Columbium (niobium)	0.15–0.35 ^B	0.15–0.35 ^B
Columbium (niobium) ^B	0.15–0.35 ^C	0.15–0.35 ^C
Nitrogen ^C	0.05	0.05
Nitrogen ^D	0.05	0.05

^A Limits are percent maximum unless shown as a range or stated otherwise.

^B Columbium (Cb) and niobium (Nb) are interchangeable names for the same element 41.

^C See ~~5.2.4 and 6.25.2.4~~ and 6.2. When the H900 condition is ordered, the minimum columbium content shall not apply.

^D To be determined and reported when specified by the order or contract.