



Designation: B637 – 23

Standard Specification for Precipitation-Hardening and Cold Worked Nickel Alloy Bars, Forgings, and Forging Stock for Moderate or High Temperature Service¹

This standard is issued under the fixed designation B637; 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.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This specification² covers hot- and cold-worked precipitation-hardenable nickel alloy rod, bar, forgings, and forging stock for moderate or high temperature service ([Table 1](#)).

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to become familiar with all hazards including those identified in the appropriate Safety Data Sheet (SDS) for this product/material as provided by the manufacturer, to establish appropriate safety, health, and environmental practices, and determine the applicability of regulatory limitations prior to use.*

1.4 *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:*³

[B880 Specification for General Requirements for Chemical](#)

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.07 on Refined Nickel and Cobalt and Their Alloys.

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SB-637 in Section II of that Code.

³ 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.

- [Check Analysis Limits for Nickel, Nickel Alloys and Cobalt Alloys](#)
- [B899 Terminology Relating to Non-ferrous Metals and Alloys](#)
- [E8/E8M Test Methods for Tension Testing of Metallic Materials](#)
- [E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)
- [E139 Test Methods for Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials](#)
- [E140 Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness](#)
- [E1473 Test Methods for Chemical Analysis of Nickel, Cobalt, and High-Temperature Alloys](#)

3. Terminology

3.1 *Definitions:*

3.1.1 For definitions of terms used in this specification, refer to Terminology [B899](#).

4. Ordering Information

4.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this specification. Examples of such requirements include, but are not limited to, the following:

- 4.1.1 Alloy ([Table 1](#)).
- 4.1.2 Condition (temper or cold worked) ([Tables 2 and 3 and 6.1](#)).
- 4.1.3 *Shape*—Rod or bar (round, rectangle, square, hexagon, octagon).
 - 4.1.3.1 Forging (sketch or drawing).
- 4.1.4 *Dimensions*, including length.
- 4.1.5 Quantity (mass or number of pieces).
- 4.1.6 *Forging Stock*—Specify if material is stock for reforging.
- 4.1.7 Finish.
- 4.1.8 *Samples for Product (Check) Analysis*—Whether samples for product (check) analysis shall be furnished ([9.2](#)).

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

TABLE 1 Chemical Requirements^A

Element	Composition Limits, %							
	UNS N07022	UNS N07208	UNS N07252	UNS N07001	UNS N07500	UNS N07740	UNS N07750	UNS N07718
Carbon	0.010	0.04–0.08	0.10–0.20	0.03–0.10	0.15	0.005–0.08	0.08	0.08
Manganese	0.5	0.3	0.50	1.00	0.75	1.00	1.00	0.35
Silicon	0.08	0.15	0.50	0.75	0.75	1.00	0.50	0.35
Phosphorus	0.025	0.015	0.015	0.030	0.015	0.030	...	0.015
Sulfur	0.015	0.015	0.015	0.030	0.015	0.030	0.01	0.015
Chromium	20.0–21.4	18.5–20.5	18.00–20.00	18.00–21.00	15.00–20.00	23.50–25.50	14.00–17.00	17.0–21.0
Cobalt	1.0	9.0–11.0	9.00–11.00	12.00–15.00	13.00–20.00	15.00–22.00	1.00 ^B	1.0 ^B
Molybdenum	15.5–17.4	8.0–9.0	9.00–10.50	3.50–5.00	3.00–5.00	2.00	...	2.80–3.30
Niobium ^D + Tantalum	0.70–1.20	4.75–5.50
Titanium	...	1.90–2.30	2.25–2.75	2.75–3.25	2.50–3.25	0.50–2.50	2.25–2.75	0.65–1.15
Aluminum	0.5	1.38–1.65	0.75–1.25	1.20–1.60	2.50–3.25	0.20–2.00	0.40–1.00	0.20–0.80
Zirconium	...	0.020	...	0.02–0.12
Boron	0.006	0.003–0.010	0.003–0.01	0.003–0.01	0.003–0.01	0.0008–0.006	...	0.006
Iron	1.8	1.5	5.00	2.00	4.00	3.00	5.00–9.00	rem ^B
Copper	0.5	0.1	...	0.50	0.15	0.50	0.50	0.30
Nickel	rem ^B	rem ^B	rem ^C	rem ^B	rem ^B	rem ^B	70.00 min	50.0–55.0
Tantalum	0.2	0.1 max
Columbium (Niobium)	...	0.2	0.50–2.50
Tungsten	0.8	0.5
	UNS N07080	UNS N07752	UNS N09925	UNS N07725				
Carbon	0.10	0.020–0.060	0.03	0.03				
Manganese	1.00	1.00	1.0	0.35				
Silicon	1.00	0.50	0.5	0.20				
Phosphorus	...	0.008	0.03	0.015				
Sulfur	0.015	0.003	0.03	0.010				
Chromium	18.00–21.00	14.50–17.00	19.5–22.5	19.00–22.50				
Cobalt	...	0.050				
Molybdenum	2.5–3.5	7.00–9.50				
Niobium ^D (Nb) + Tantalum	...	0.70–1.20	0.5 (Nb only)	2.75–4.00				
Titanium	1.80–2.70	2.25–2.75	1.9–2.40	1.00–1.70				
Aluminum	0.50–1.80	0.40–1.00	0.1–0.5	0.35				
Boron	...	0.007				
Iron	3.00	5.00–9.00	22.0 min	rem ^C				
Copper	...	0.50	1.5–3.0	...				
Zirconium	...	0.050				
Vanadium	...	0.10				
Nickel	rem ^C	70.0 min	42.0–46.0	55.0–59.0				

^A Values in the table are maximums, unless a range or a minimum is indicated.

^B If determined.

^C Iron or nickel shall be determined arithmetically by difference, "rem" means remainder.

^D Columbium and Niobium are interchangeable names for the same element and both names are acceptable for use in B02.07 specifications.

4.1.9 *Purchaser Inspection*—If the purchaser wishes to witness tests or inspection of material at the place of manufacture, the purchase order must so state indicating which tests or inspections are to be witnessed (Section 13).

5. Chemical Composition

5.1 The material shall conform to the requirements as to chemical composition prescribed in Table 1.

5.2 If a product (check) analysis is performed by the purchaser, the material shall conform to the product (check) analysis variations prescribed in Specification B880.

6. Mechanical Properties

6.1 Unless otherwise specified, the material shall be supplied in the cold worked or solution treated condition, suitable for subsequent age hardening.

6.2 The cold worked or solution treated material shall be capable of meeting the mechanical property requirements of

Table 3, and the stress rupture requirements of Table 4 (except alloys UNS N07022, N09925 and N07725), following the precipitation hardening treatment described in Table 2.

6.3 When the material is to be supplied in the cold worked or solution treated plus aged condition, the requirements of Table 3 and Table 4 (except alloys UNS N07022, N09925 and N07725) shall apply, with the precipitation hardening treatment of Table 2, or as agreed upon between the purchaser and the manufacturer as part of the purchase contract.

7. Dimensions and Permissible Variations

7.1 *Diameter, Thickness, or Width*—The permissible variations from the specified dimensions of cold-worked rod and bar shall be as prescribed in Table 5, and of hot-worked rod and bar as prescribed in Table 6.

7.1.1 *Out of Round*—Cold-worked and hot-worked rod, all sizes, in straight lengths, shall not be out-of-round by more than one half the total permissible variations in diameter shown

TABLE 2 Heat Treatment^A

Alloy	Recommended Annealing Treatment	Recommended Solution Treatment	Recommended Stabilizing Treatment	Precipitation Hardening Treatment
N07022 ^B Type 1A or 1B	...	1800 °F to 2100 °F (982 °C to 1149 °C), hold ½ h/in., 5 minutes minimum, rapid air cool or water quench	...	
N07022 ^C Type 2	...	1800 °F to 2100 °F (982 °C to 1149 °C), hold ½ h/in., 5 minutes minimum, rapid air cool or water quench	...	1125 °F ± 25 °F (605 °C ± 14 °C), hold 10 h, air cool ^B
N07022 Type 3	...	1800 °F to 2100 °F (982 °C to 1149 °C), hold ½ h/in., 5 minutes minimum, rapid air cool or water quench	...	1300 °F ± 25 °F (705 °C ± 14 °C), hold 16 h, furnace cool to 1125 °F ± 25 °F (605 °C ± 14 °C), hold 32 h, air cool
N07208	...	2000 °F to 2125 °F (1093 °C to 1163 °C), hold ½ h/in., 5 minutes to 10 minutes minimum, water quench or rapid air cool	...	1850 °F ± 25 °F (1010 °C ± 14 °C), hold 2 h, air cool, followed by 1450 °F ± 25 °F (788 °C ± 14 °C), hold 8 h, air cool
N07252	...	1950 °F ± 25 °F (1066 °C ± 14 °C), hold 4 h, air cool	...	1400 °F ± 25 °F (760 °C ± 14 °C), hold 15 h, air cool or furnace cool
N07001	...	1825 °F to 1900 °F (996 °C to 1038 °C), hold 4 h, oil or water quench	1550 °F ± 25 °F (843 °C ± 14 °C), hold 4 h, air cool	1400 °F ± 25 °F (760 °C ± 14 °C), hold 16 h, air cool or furnace cool
N07500	2150 °F ± 25 °F (1177 °C ± 14 °C), hold 2 h, air cool (bars only)	1975 °F ± 25 °F (1080 °C ± 14 °C), hold 4 h, air cool	1550 °F ± 25 °F (843 °C ± 14 °C), hold 24 h, air cool	1400 °F ± 25 °F (760 °C ± 14 °C), hold 16 h, air cool or furnace cool
N07740	...	2012 °F to 2192 °F (1100 °C to 1200 °C) hold ½ hr/in. 5 minutes minimum, water quench or rapid air/gas cool	...	1400 °F to 1500 °F (760 °C to 815 °C), hold 4 h minimum for up to 2 in. thickness + additional ½ h per each additional in. of thickness, air cool
N07750 Type 1 (Service above 1100 °F) (593 °C)	...	2100 °F ± 25 °F (1149 °C ± 14 °C), hold 2 h to 4 h, air cool	1550 °F ± 25 °F (843 °C ± 14 °C), hold 24 h, air cool	1300 °F ± 25 °F (704 °C ± 14 °C), hold 20 h, air cool or furnace cool
N07750 Type 2 (Service up to 1100 °F) (593 °C)	...	1800 °F ± 25 °F (982 °C ± 14 °C), hold ½ h min, cool at rate equivalent to air cool or faster	...	1350 °F ± 25 °F (732 °C ± 14 °C), hold 8 h, furnace cool to 1150 °F ± 25 °F (621 °C ± 14 °C), hold until total precipitation heat treatment has reached 18 h, air cool
N07750 Type 3	...	1975 °F to 2050 °F (1079 °C to 1121 °C), hold 1 h to 2 h, air cool	...	1300 °F ± 25 °F (704 °C ± 14 °C), hold 20 h, + 4 – 0 h, air cool
N07752 Type 1	...	1975 °F ± 25 °F (1080 °C ± 14 °C), hold 1 h to 2 h, cool by water or oil quenching	...	1320 °F ± 25 °F (715 °C ± 14 °C), hold 20 h, +2, –0 h, air cool
N07752 Type 2	...	1975 °F ± 25 °F (1080 °C ± 14 °C), hold 1 h to 2 h, cool by water or oil quenching	...	1400 °F ± 25 °F (760 °C ± 14 °C), hold 100 h, +4, –0 h, air cool