



Designation: **B472—18 B472 – 23**

Standard Specification for Nickel Alloy Billets and Bars for Reforging¹

This standard is issued under the fixed designation B472; 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—Scope*

1.1 This specification covers UNS N06002, UNS N06030, UNS N06035, UNS N06022, UNS N06200, UNS N10362, UNS N06230, UNS N06600, UNS N06617, UNS N06625, UNS N08020, UNS N08026, UNS N08024, UNS N08120, UNS N08926, UNS N08367, UNS N10242, UNS N10276, UNS N10665, UNS N10675, UNS N12160, UNS R20033, UNS N06059, UNS N06686, UNS N10629, UNS N08031, UNS N06045, UNS N06025, UNS N06699, and UNS R30556² billets and bars for reforging.

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.*

<https://standards.iteh.ai/catalog/standards/sist/79c79448-1bf1-42b2-acb7-c4878572453b/astm-b472-23>

2. Referenced Documents

2.1 ASTM Standards:³

[A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels](#)

[B880 Specification for General Requirements for Chemical Check Analysis Limits for Nickel, Nickel Alloys and Cobalt Alloys](#)

[B899 Terminology Relating to Non-ferrous Metals and Alloys](#)

[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](#).

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 Designation established in accordance with ASTM E527 and SAE J1086, Practice for Numbering Metals and Alloys (UNS).

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.

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

3.1.2 Terminology in this specification shall conform to the requirements of Terminology B899 including any supplementary requirements indicated in the purchase order or contract. In case of conflict between the requirements of this specification and Terminology B899, this specification shall prevail.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *billets and bars, n*—terms billets and bars as used in this specification shall be understood as billets and bars for reforging.

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 Quantity (weight or number of pieces),

4.1.2 Name of material or UNS number,

4.1.3 Form (bar or billet),

4.1.4 Dimensions,

4.1.5 ASTM designation and year of issue,

4.1.6 Inspection (12.1),

4.1.7 Certification—State if certification or a report of test results is required (Section 14),

4.1.8 Supplementary requirements, if any, and

4.1.9 If possible, the intended end use.

NOTE 1—A typical ordering description is as follows: 10 000 lb (4536 kg), UNS N08020, forging bar, 4¼ in. (107.95 mm) round, Specification B472.

5. Materials and Manufacture

5.1 The products shall be hot worked from ingots by rolling, forging, extruding, hammering, or pressing.

5.2 The products may be conditioned by chipping, grinding, or machining to remove injurious surface defects provided the depth of conditioning does not exceed that which will affect the surface condition or dimensions of the article to be forged from the bar or billet.

6. Chemical Composition

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

6.2 If a product (check) analysis is performed by the purchaser, the material shall conform to the requirements specified in Table 1 subject to the permissible tolerances in Specification B880.

7. Dimensions and Permissible Variations

7.1 Billets shall conform to the shapes and dimensions specified by the purchaser within a permissible variation of $\pm 5\%$.

7.2 Bars shall conform to the shape and dimensions specified by the purchaser within the permissible variations prescribed in Table 2.

TABLE 1 Chemical Requirements^A

Element	Composition, %					
	UNS N08026	UNS N08020	UNS N08024	UNS N08367	UNS N08926	UNS R20033
Carbon, max	0.03	0.07	0.03	0.030	0.020	0.015
Carbon	0.03	0.07	0.03	0.030	0.020	0.015
Manganese, max	1.00	2.00	1.00	2.00	2.00	2.0
Manganese	1.00	2.00	1.00	2.00	2.00	2.0
Phosphorus, max	0.03	0.045	0.035	0.040	0.03	0.02
Phosphorus	0.03	0.045	0.035	0.040	0.03	0.02
Sulfur, max	0.03	0.035	0.035	0.030	0.04	0.04
Sulfur	0.03	0.035	0.035	0.030	0.01	0.01
Silicon, max	0.50	1.00	0.50	1.00	0.50	0.50
Silicon	0.50	1.00	0.50	1.00	0.50	0.50
Nickel	33.00–37.20	32.00–38.00	35.00–40.00	23.50–25.50	24.00–26.00	30.0–33.0
Chromium	22.00–26.00	19.00–21.00	22.50–25.00	20.00–22.00	19.00–21.00	31.0–35.0
Molybdenum	5.00–6.70	2.00–3.00	3.50–5.00	6.00–7.00	6.0–7.0	0.50–2.0
Copper	2.00–4.00	3.00–4.00	0.50–1.50	0.75 max	0.5–1.5	0.30–1.20
Copper	2.00–4.00	3.00–4.00	0.50–1.50	0.75	0.5–1.5	0.30–1.20
Columbium (Nb) + tantalum	...	8 × carbon–1.00	0.15–0.35
Niobium ^C (Nb) + Tantalum	...	8 × C–1.00	0.15–0.35
Nitrogen	0.10–0.16	0.18–0.25	0.15–0.25	0.35–0.60
Iron ^A	remainder	remainder	remainder	remainder	balance	balance
Iron ^B	rem	rem	rem	rem	rem	rem

Element	Composition, %									
	UNS N06030	UNS N06022	UNS N06200	UNS N10362	UNS N10276	UNS N10665	UNS N10675	UNS N06002	UNS N06230	
Carbon, max	0.03	0.015	0.010	0.010	0.010	0.02	0.04	0.05–0.15	0.05–0.15	
Carbon	0.03	0.015	0.010	0.010	0.010	0.02	0.01	0.05–0.15	0.05–0.15	
Manganese, max	1.5	0.50	0.50	0.60	1.0	1.0	3.0	1.00	0.30–1.00	
Manganese	1.5	0.50	0.50	0.60	1.0	1.0	3.0	1.00	0.30–1.00	
Phosphorous, max	0.04	0.02	0.025	0.025	0.04	0.04	0.030	0.04	0.030	
Phosphorous	0.04	0.02	0.025	0.025	0.04	0.04	0.030	0.04	0.030	
Sulfur, max	0.02	0.02	0.010	0.010	0.03	0.03	0.010	0.03	0.015	
Sulfur	0.02	0.02	0.010	0.010	0.03	0.03	0.010	0.03	0.015	
Silicon, max	0.8	0.08	0.08	0.08	0.08	0.10	0.10	1.00	0.25–0.75	
Silicon	0.8	0.08	0.08	0.08	0.08	0.10	0.10	1.00	0.25–0.75	
Nickel	remainder	remainder	remainder	remainder	remainder	remainder	65.0 min	remainder ^A	remainder ^A	
Nickel	rem	rem	rem	rem	rem	rem	65.0 min ^B	rem ^B	rem ^B	
Chromium	28.0–31.5	20.0–22.5	22.0–24.0	13.8–15.6	14.5–16.5	1.0 max	1.0–3.0	20.5–23.0	20.0–24.0	
Chromium	28.0–31.5	20.0–22.5	22.0–24.0	13.8–15.6	14.5–16.5	1.0	1.0–3.0	20.5–23.0	20.0–24.0	
Molybdenum	4.0–6.0	12.5–14.5	15.0–17.0	21.5–23.0	15.0–17.0	26.0–30.0	27.0–32.0	8.0–10.0	1.0–3.00	
Copper	1.0–2.4	...	1.3–1.9	0.20	
Columbium (Nb) + tantalum	0.30–1.50	
Niobium ^C (Nb) + Tantalum	0.30–1.50	
Iron	13.0–17.0	2.0–6.0	3.0 max	1.25 max	4.0–7.0	2.0 max	1.0–3.0	17.0–20.0	3.0 max	
Iron	13.0–17.0	2.0–6.0	3.0	1.25	4.0–7.0	2.0	1.0–3.0	17.0–20.0	3.0	
Cobalt, max	5.0	2.5	2.0	...	2.5	1.0	3.0	0.5–2.5	5.0	
Cobalt	5.0	2.5	2.0	...	2.5	1.0	3.0	0.5–2.5	5.0	
Tungsten	1.5–4.0	2.5–3.5	3.0–4.5	...	3.0 max	0.2–1.0	13.0–15.0	
Tungsten	1.5–4.0	2.5–3.5	3.0–4.5	...	3.0	0.2–1.0	13.0–15.0	
Vanadium, max	...	0.35	0.35	...	0.20	
Vanadium	...	0.35	0.35	...	0.20	
Titanium, max	0.2	
Titanium	0.2	
Zirconium, max	0.10	
Zirconium	0.10	
Columbium (Nb)	0.20 max	
Niobium ^C (Nb)	0.20	
Tantalum	0.20 max	
Tantalum	0.20	
Nickel + Molybdenum	94.0–98.0	
Aluminum, max	0.50	0.50	0.50	...	0.20–0.50	
Aluminum	0.50	0.50	0.50	...	0.20–0.50	
Lanthanum	0.005–0.050	
Boron	0.015 max	
Boron	0.015	