



Designation: B166 – 24

Standard Specification for Nickel-Chromium-Aluminum Alloy, Nickel-Chromium-Iron Alloys, Nickel-Chromium-Cobalt-Molybdenum Alloy, Nickel-Iron-Chromium-Tungsten Alloy, and Nickel-Chromium-Molybdenum-Copper Alloy Rod, Bar, and Wire¹

This standard is issued under the fixed designation B166; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

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

1. Scope*

1.1 This specification² covers nickel-chromium-aluminum alloy, nickel-chromium-iron alloys,³ nickel-chromium-cobalt-molybdenum alloy, nickel-iron-chromium-tungsten alloy, and nickel-chromium-molybdenum-copper alloy in the form of hot-finished and cold-worked rounds, squares, hexagons, rectangles, and cold-worked wire.

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 The following precautionary caveat pertains only to the test methods portion, Section 12, of this specification: *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.*

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 application see related Specification SB-166 in Section II of that Code.

³ Designation established in accordance with Practice E527 and SAE J1086, Practice for Numbering Metals and Alloys (UNS).

2. Referenced Documents

2.1 ASTM Standards:⁴

- B168 Specification for Nickel-Chromium-Aluminum Alloys (UNS N06699), Nickel-Chromium-Iron Alloys (UNS N06600, N06601, N06603, N06690, N06693, N06025, N06045, and N06696), Nickel-Chromium-Cobalt-Molybdenum Alloy (UNS N06617), Nickel-Iron-Chromium-Tungsten Alloy (UNS N06674), and
- 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
- E8/E8M Test Methods for Tension Testing of Metallic Materials
- E18 Test Methods for Rockwell Hardness of Metallic Materials
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E38 Methods for Chemical Analysis of Nickel-Chromium and Nickel-Chromium-Iron Alloys (Withdrawn 1989)⁵
- E112 Test Methods for Determining Average Grain Size
- E140 Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness
- E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)
- E1473 Test Methods for Chemical Analysis of Nickel, Cobalt, and High-Temperature Alloys

⁴ 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.

⁵ The last approved version of this historical standard is referenced on www.astm.org.

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

2.2 Federal Standards:⁶

Fed. Std. No. 102 Preservation, Packaging and Packing Levels

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)

Fed. Std. No. 182 Continuous Identification Marking of Nickel and Nickel-Base Alloys

2.3 Military Standard:⁶

MIL-STD-129 Marking for Shipment and Storage

3. Terminology

3.1 For definitions of terms used in this specification, refer to Terminology **B899**.

3.2 In case of conflict between the definitions of this specification and Terminology **B899**, this specification shall prevail.

3.3 Definitions of Terms Specific to This Standard:

3.3.1 *bar, n*—material of rectangular (flats), hexagonal, or square solid section up to and including 10 in. (254 mm) in width and 1/8 in. (3.2 mm) and over in thickness in straight lengths.

3.3.2 *rod, n*—material of round solid section furnished in straight lengths.

3.3.2.1 *Discussion*—Hot-worked rectangular bar in widths 10 in. and under may be furnished as hot-rolled plate with sheared or cut edges in accordance with Specification **B168**, provided the mechanical property requirements of this specification are met.

3.3.3 *wire, n*—a cold-worked solid product of uniform round cross section along its whole length, supplied in coil form.

4. Ordering Information

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

4.1.1 *Alloy Name or UNS Number*—see **Table 1**,

4.1.2 *ASTM Designation*, including year of issue,

4.1.3 *Section*—Rod (round), bar (square, hexagonal, or rectangular), or wire (round),

4.1.4 *Condition* (see **Table 2** and **Table 3**),

4.1.5 *Finish*,

4.1.6 *Dimensions*, including length (see **Tables 4-8**),

4.1.7 *Quantity*—feet or number of pieces,

4.1.8 *Samples for Product (Check) Analysis*—State whether samples for product (check) analysis shall be furnished, and

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

5. Chemical Composition

5.1 The material shall conform to the composition limits specified 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 in Specification **B880**.

6. Mechanical Properties and Other Requirements

6.1 *Mechanical Properties*—The material shall conform to the mechanical properties specified in **Table 2** for rod and bar and **Table 3** (UNS N06600 and N06690 only) for wire.

6.2 Grain Size:

6.2.1 Grain size for N06674 shall be 7 or coarser as determined in accordance with Test Methods **E112**.

7. Dimensions and Permissible Variations

7.1 *Diameter, Thickness, or Width*—The permissible variations from the specified dimensions as measured on the diameter or between parallel surfaces of cold-worked rod and bar shall be as prescribed in **Table 4**; of hot-worked rod and bar as prescribed in **Table 5**; and of wire as prescribed in **Table 6**.

7.2 *Out-of-Round*—Hot-worked rods and cold-worked rods (except “forging quality”) all sizes, in straight lengths, shall not be out-of-round by more than one half the total permissible variations in diameter shown in **Table 4** and **Table 5**, except for hot-worked rods 1/2 in. (12.7 mm) in diameter and under, which may be out-of-round by the total permissible variations in diameter shown in **Table 5**. Cold-worked wire shall not be out-of-round by more than one-half the total permissible variations in diameter shown in **Table 6**.

7.3 *Corners*—Cold-worked bars will have practically exact angles and sharp corners.

7.4 *Machining Allowances for Hot-Worked Materials*—When the surfaces of hot-worked products are to be machined, the allowances prescribed in **Table 7** are recommended for normal machining operations.

7.5 *Length*—The permissible variations in length of cold-worked and hot-worked rod and bar shall be as prescribed in **Table 8**.

7.5.1 Rods and bars ordered to random or nominal lengths will be furnished with either cropped or saw-cut ends; material ordered to cut lengths will be furnished with square saw-cut or machined ends.

7.6 *Straightness*—The permissible variations in straightness of cold-worked rod and bar as determined by the departure from straightness shall be as prescribed in **Table 9**.

7.6.1 The permissible variations in straightness of hot-worked rod and bar as determined by the departure from straightness shall be as specified in **Table 10**.

8. Workmanship, Finish, and Appearance

8.1 The material shall be uniform in quality and condition, smooth, commercially straight or flat, and free of injurious imperfections.

⁶ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.

TABLE 1 Chemical Requirements^A

Element	Composition Limits, %													
	Alloy N06600	Alloy N06601	Alloy N06617	Alloy N06674	Alloy N06690	Alloy N06693	Alloy N06025	Alloy N06045	Alloy N06603	Alloy N06696	Alloy N06699	Alloy N06235		
Nickel	72.0 min	58.0-63.0	44.5 min	remainder ^B	58.0 min	remainder ^B	remainder ^B	remainder ^B	remainder ^B	remainder ^B	remainder ^B	remainder ^B	remainder ^B	remainder ^B
Chromium	14.0-17.0	21.0-25.0	20.0-24.0	21.5-24.5	27.0-31.0	27.0-31.0	24.0-26.0	26.0-29.0	24.0-26.0	28.0-32.0	26.0-30.0	30.0-32.5	30.0-32.5	30.0-32.5
Cobalt	10.0-15.0
Molybdenum	8.0-10.0
Iron	6.0-10.0	remainder ^B	3.0	20.0-27.0	7.0-11.0	2.5-6.0	8.0-11.0	21.0-25.0	8.0-11.0	1.0-3.0	...	5.0-6.2	5.0-6.2	
Manganese	1.0	1.0	1.0	1.50	0.5	1.0	0.15	1.0	0.15	2.0-6.0	2.5	1.5	1.5	
Aluminum	...	1.0-1.7	0.8-1.5	2.5-4.0	1.8-2.4	...	2.4-3.0	1.0	0.50	0.3-0.65	0.3-0.65	
Carbon	0.15	0.10	0.05-0.15	0.01	0.05 max	0.15	0.15-0.25	0.05-0.12	0.20-0.40	...	1.9-3.0	0.2-0.4	0.2-0.4	
Copper	0.5	1.0	0.5	...	0.5 max	0.5	0.1	0.3	0.50	1.5-3.0	0.50	3.5-4.0	3.5-4.0	
Silicon	0.5	0.5	1.0	1.0	0.5 max	0.5	0.5	2.5-3.0	0.50	1.0-2.5	0.50	0.2-0.6	0.2-0.6	
Sulfur	0.015	0.015	0.015	0.015	0.015 max	0.01	0.010	0.010	0.010	0.010	0.01	0.015	0.015	
Titanium	0.6	0.05-0.20	1.0	1.0	0.1-0.2	...	0.01-0.25	1.0	0.60	0.5	0.5	
Phosphorus	0.030	0.020	0.020	0.20	...	0.02	0.03	0.03	
Zirconium	0.01-0.10	...	0.01-0.10	...	0.10	
Yttrium	0.05-0.12	...	0.01-0.15	
Boron	0.006	0.0005-0.006	
Nitrogen	0.02	0.008	
Niobium	0.10-0.35	0.05	
Cerium	0.5-2.5	0.50	1.0	1.0	
Tungsten	6.0-8.0	0.03-0.09	

^A All values are maximums unless a range is provided or is a minimum or a remainder.

^B Element shall be determined arithmetically by difference.

TABLE 2 Mechanical Properties of Rods and Bars

Condition and Diameter or Distance Between Parallel Surfaces, in. (mm)	Tensile Strength, min, psi (MPa)	Yield Strength (0.2 % offset), min, psi (MPa)	Elongation in 2 in. or 50 mm or 4D, min,%
<i>UNS N06600:</i>			
Cold-worked (as worked):			
Rounds:			
Under ½ (12.7)	120 000 (825)	90 000 (620)	7 ^A
½ to 1 (12.7 to 25.4), incl	110 000 (760)	85 000 (585)	10
Over 1 to 2½ (25.4 to 63.5), incl	105 000 (725)	80 000 (550)	12
Squares, hexagons, and rectangles:			
¼ (6.4) and under	100 000 (690)	80 000 (550)	5 ^A
Over ¼ to ½ (6.4 to 12.7), excl	95 000 (655)	70 000 (480)	7
Hot worked (as worked):			
Rounds:			
¼ to ½ (6.4 to 12.7), incl	95 000 (655)	45 000 (310)	20
Over ½ to 3 (12.7 to 76.2), incl	90 000 (620)	40 000 (275)	25
Over 3 (76.2)	85 000 (585)	35 000 (240)	30
Squares, hexagons, and rectangles:			
All sizes	85 000 (585)	35 000 (240)	20
Rings and disks ^B	—	—	—
Cold-worked (annealed) or hot-worked (annealed):			
Rods and bars, all sizes	80 000 (550)	35 000 (240)	30 ^A
Rings and disks ^C	—	—	—
Forging Quality:			
All sizes	<i>D</i>	<i>D</i>	<i>D</i>
<i>UNS N06601:</i>			
Cold-worked (annealed) or hot-worked (annealed):			
All products, all sizes	80 000 (550)	30 000 (205)	30
Forging Quality:			
All sizes	<i>D</i>	<i>D</i>	<i>D</i>
<i>UNS N06617:</i>			
Cold-worked (annealed) or hot-worked (annealed):			
All products, all sizes	95 000 (655)	35 000 (240)	35
Forging Quality:			
All sizes	<i>D</i>	<i>D</i>	<i>D</i>
<i>UNS N06674:</i>			
Cold-worked (annealed ^E) or hot-worked (annealed ^E):			
All products, all sizes	86 000 (590)	34 000 (235)	30
Forging Quality:			
All sizes	<i>D</i>	<i>D</i>	<i>D</i>
<i>UNS N06690:</i>			
Cold-worked (as worked):			
Rounds:			
Under ½ (12.7)	120 000 (825)	90 000 (620)	7 ^A
½ to 1 (12.7 to 25.4), incl	110 000 (760)	85 000 (585)	10
Over 1 to 2½ (25.4 to 63.5), incl	105 000 (725)	80 000 (550)	12
Squares, hexagons, and rectangles:			
¼ (6.4) and under	100 000 (690)	80 000 (550)	5 ^A
Over ¼ to ½ (6.4 to 12.7), excl	95 000 (655)	70 000 (480)	7
Hot worked (as worked):			
Rounds:			
¼ to ½ (6.4 to 12.7), incl	95 000 (655)	45 000 (310)	20
Over ½ to 3 (12.7 to 76.2), incl	90 000 (620)	40 000 (275)	25
Over 3 (76.2)	85 000 (585)	35 000 (240)	30
Squares, hexagons, and rectangles:			
All sizes	85 000 (585)	35 000 (240)	20
Rings and disks ^B	—	—	—
Cold-worked (annealed) or hot-worked (annealed):			
Rods and bars, all sizes	85 000 (586)	35 000 (240)	30 ^A
Rings and disks ^C	—	—	—
Forging Quality:			
All sizes	<i>D</i>	<i>D</i>	<i>D</i>
<i>UNS N06693:</i>			
Cold-worked (annealed) or hot-worked (annealed):			
Rods and bars, all sizes	100 000 (690)	50 000 (345)	30
Forging Quality:			
All sizes	<i>D</i>	<i>D</i>	<i>D</i>
<i>UNS N06603:</i>			
Cold-worked (annealed) or hot-worked (annealed):			
All products, all sizes	94 000 (650)	43 000 (300)	25
Forging Quality:			
All sizes	<i>D</i>	<i>D</i>	<i>D</i>
<i>UNS N06025:</i>			
Cold-worked (annealed) or hot-worked (annealed):			
All products, all sizes	98 000 (680)	39 000 (270)	30
Forging Quality:			
All sizes	<i>D</i>	<i>D</i>	<i>D</i>
<i>UNS N06045:</i>			
Cold-worked (annealed) or hot-worked (annealed):			