



Designation: B 584 – 00

Standard Specification for Copper Alloy Sand Castings for General Applications¹

This standard is issued under the fixed designation B 584; 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 approval. 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 Department of Defense.

1. Scope*

1.1 This specification covers requirements for copper alloy sand castings for general applications. Nominal compositions of the alloys defined by this specification are shown in Table 1.² This is a composite specification replacing former documents as shown in Table 1.

NOTE 1—Other copper alloy castings are included in the following ASTM specifications: B 22, B 61, B 62, B 66, B 67, B 148, B 176, B 271, B 369, B 427, B 492, B 505, B 763, B 770, and B 806.

1.2 Component part castings produced to this specification may be manufactured in advance and supplied from stock. In such cases the manufacturer shall maintain a general quality certification of all castings without specific record or date of casting for a specific casting.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are provided for information purposes only.

2. Referenced Documents

2.1 ASTM Standards:

- B 22 Specification for Bronze Castings for Bridges and Turntables³
- B 61 Specification for Steam or Valve Bronze Castings³
- B 62 Specification for Composition Bronze or Ounce Metal Castings³
- B 66 Specification for Bronze Castings for Steam Locomotive Wearing Parts³
- B 67 Specification for Car and Tender Journal Bearings, Lined³
- B 148 Specification for Aluminum-Bronze Sand Castings³
- B 176 Specification for Copper-Alloy Die Castings³
- B 208 Practice for Preparing Tension Test Specimens for Copper Alloy Sand, Permanent Mold, Centrifugal, and

Continuous Castings³

- B 271 Specification for Copper-Base Alloy Centrifugal Castings³
- B 369 Specification for Copper-Nickel Alloy Castings³
- B 427 Specification for Gear Bronze Alloy Castings³
- B 492 Specification for Cast Copper-Nickel Ship Tailshaft Sleeves⁴
- B 505 Specification for Copper-Base Alloy Continuous Castings³
- B 763 Specification for Copper Alloy Sand Castings for Valve Application³
- B 770 Specification for Copper-Beryllium Alloy Sand Castings for General Applications³
- B 806 Specification for Copper Alloy Permanent Mold Castings for General Applications³
- B 824 Specification for General Requirements for Copper Alloy Castings³
- B 846 Terminology for Copper and Copper Alloys³
- E 527 Practice for Numbering Metals and Alloys (UNS)⁵

2.2 ASME Code:

- ASME Boiler and Pressure Vessel Code⁶

3. Terminology

3.1 Definitions of terms relating to copper alloys can be found in Terminology B 846.

4. General Requirements

4.1 The following sections of Specification B 824 form a part of this specification. In the event of a conflict between this specification and Specification B 824, the requirements of this specification shall take precedence.

- 4.1.1 Terminology,
- 4.1.2 Other Requirements,
- 4.1.3 Dimensions, Mass, and Permissible Variations,
- 4.1.4 Workmanship, Finish, and Appearance,
- 4.1.5 Sampling,
- 4.1.6 Number of Tests and Retests,
- 4.1.7 Specimen Preparation,

¹ This practice is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.05 on Castings and Ingots for Remelting.

Current edition approved May 10, 2000. Published August 2000. Originally published as B 584 - 73. Last previous edition B 584 - 98a.

² The UNS system for copper and copper alloys (see Practice E 527) is a simple expansion of the former standard designation system accomplished by the addition of a prefix "C" and a suffix "00". The suffix can be used to accommodate composition variations of the base alloy.

³ *Annual Book of ASTM Standards*, Vol 02.01.

⁴ Discontinued—*Annual Book of ASTM Standards*, Vol 02.01.

⁵ *Annual Book of ASTM Standards*, Vol 01.01.

⁶ Available from the American Society of Mechanical Engineers, United Engineering Center, 345 E. 47th St., New York, NY 10017.

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

TABLE 1 Nominal Compositions

Classification	Copper Alloy UNS No.	Previous Designation	Commercial Designation	Copper	Tin	Lead	Zinc	Nickel	Iron	Alum- inum	Man- ganese	Sili- con	Nio- bium	Bis- muth
Leaded red brass	C83450	88	2½	2	6½	1
	C83600	B 145-4A	85-5-5-5 or No. 1 composition	85	5	5	5
	C83800	B 145-4B	commercial red brass, 83-4-6-7	83	4	6	7
Leaded semi-red brass	C84400	B 145-5A	valve composition, 81-3-7-9	81	3	7	9
	C84800	B 145-5B	semi-red brass, 76-2½-6½-15	76	2½	6½	15
Leaded yellow brass	C85200	B 146-6A	high-copper yellow brass	72	1	3	24
	C85400	B 146-6B	commercial No. 1 yellow brass	67	1	3	29
	C85700	B 146-6C	leaded naval brass	61	1	1	37
High-strength yellow brass	C86200	B 147-8B	high-strength manganese bronze	63	27	...	3	4	3
	C86300	B 147-8C	high-strength manganese bronze	61	27	...	3	6	3
	C86400	B 147-7A	leaded manganese bronze	58	1	1	38	...	1	½	½
	C86400	B 132-A
	C86500	B 147-8A	No. 1 manganese bronze	58	39	...	1	1	1
	C86700	B 132-B	leaded manganese bronze	58	1	1	34	...	2	2	2
Silicon bronze + silicon brass	C87300	B 198-12A	silicon bronze	95	1	4
	C87400	B 198-13A	silicon brass	82	...	½	14	3½
	C87500	B 198-13B	silicon brass	82	14	4
	C87600	B 198-13C	silicon bronze	91	5	4
	C87610	B 198-12A	silicon bronze	92	4	4
	C89510 ^A	...	sebiloy I	87	5	...	5	1.0
Bismuth selenium brass	C89520 ^B	...	sebiloy II	86	5½	...	5	1.9
	C89844	...	bismuth brass	84½	4	...	8	3
Tin bronze + leaded tin bronze	C90300	B 143-1B	modified "G" bronze, 88-8-0-4	88	8	...	4
	C90500	B 143-1A	"G" bronze, 88-10-0-2	88	10	...	2
	C92200	B 143-2A	steam or valve bronze-Navy "M"	88	6	1½	4½
	C92210	88	5	2	4	1
	C92300	B 143-2B	87-5-1-4, Navy PC	87	8	1	4
	C92600	...	87-10-1-2	87	10	1	2
High-lead tin bronze	C93200	B 144-3B	83-7-7-3	83	7	7	3
	C93500	B 144-3C	85-5-9-1	85	5	9	1
	C93700	B 144-3A	80-10-10	80	10	10
	C93800	B 144-3D	78-7-15	78	7	15
	C94300	B 144-3E	71-5-24	71	5	24
	C94700	B 292-A	nickel-tin bronze Grade "A"	88	5	...	2	5
Nickel-tin bronze + leaded nickel-tin bronze	C94800	B 292-B	leaded nickel-tin bronze Grade "B"	87	5	1	2	5
	C94900	...	leaded nickel-tin bronze Grade "C"	80	5	5	5	5
	C96800	82	8	10	0.2	...
Spinodal alloy	C97300	B 149-10A	12 % leaded nickel silver	57	2	9	20	12
	C97600	B 149-11A	20 % leaded nickel silver	64	4	4	8	20
	C97800	B 149-11B	25 % leaded nickel silver	66	5	2	2	25

^ASelenium 0.5.

^BSelenium 0.9.

- 4.1.8 Test Methods,
- 4.1.9 Significance of Numerical Limits,
- 4.1.10 Inspection,
- 4.1.11 Rejection and Rehearing,
- 4.1.12 Certification,
- 4.1.13 Test Report,
- 4.1.14 Product Marking,
- 4.1.15 Packaging and Package Marking, and
- 4.1.16 Supplementary Requirements.

5. Ordering Information

5.1 Orders for castings under this specification should include the following information:

- 5.1.1 Specification title, number, and year of issue,
- 5.1.2 Quantity of castings,

5.1.3 Copper alloy UNS Number (Table 1) and temper (as-cast, heat treated, and so forth),

5.1.4 Pattern or drawing number, and condition (as-cast, machined, etc.),

5.1.5 *ASME Boiler and Pressure Vessel Code*—compliance (Section 10),

5.1.6 When material is purchased for agencies of the U.S. Government, the Supplementary Requirements of Specification B 824 may be specified.

5.2 The following options are available and should be specified in the purchase order when required:

5.2.1 Chemical analysis of residual elements (7.3),

5.2.2 Pressure test or soundness requirements (Specification B 824),

5.2.3 Approval of weld repair or impregnation, or both (Section 9),

5.2.4 Certification (Specification B 824),

5.2.5 Foundry test report (Specification B 824),

5.2.6 Witness inspection (Specification B 824), and

5.2.7 Product marking (Specification B 824).

6. Manufacture

6.1 Copper alloy UNS Nos. C94700 and C96800 may be supplied in the heat treated condition to obtain the higher mechanical properties shown in Table 2. Suggested heat treatments for these alloys are given in Table 3. Actual practice may vary by manufacturer.

6.2 Separately cast test bar coupons representing castings made in copper alloy UNS Nos. C94700HT and C96800HT shall be heat treated with the castings.

TABLE 2 Mechanical Requirements

Copper Alloy UNS No.	Tensile Strength, min		Yield Strength, ^A min		Elongation in 2 in. or 50 mm, min, %
	ksi ^B	MPa ^C	ksi ^B	MPa ^C	
C83450	30	207	14	97	25
C83600	30	207	14	97	20
C83800	30	207	13	90	20
C84400	29	200	13	90	18
C84800	28	193	12	83	16
C85200	35	241	12	83	25
C85400	30	207	11	76	20
C85700	40	276	14	97	15
C86200	90	621	45	310	18
C86300	110	758	60	414	12
C86400	60	414	20	138	15
C86500	65	448	25	172	20
C86700	80	552	32	221	15
C87300	45	310	18	124	20
C87400	50	345	21	145	18
C87500	60	414	24	165	16
C87600	60	414	30	207	16
C87610	45	310	18	124	20
C89510	26	184	17	120	8
C89520	25	176	17	120	6
C89844	28	193	13	90	15
C90300	40	276	18	124	20
C90500	40	276	18	124	20
C92200	34	234	16	110	22
C92210	32	225	15	103	20
C92300	36	248	16	110	18
C92600	40	276	18	124	20
C93200	30	207	14	97	15
C93500	28	193	12	83	15
C93700	30	207	12	83	15
C93800	26	179	14	97	12
C94300	24	165	10
C94700	45	310	20	138	25
C94700 (HT)	75	517	50	345	5
C94800	40	276	20	138	20
C94900	38	262	15	103	15
C96800	125	862	100 ^D	689 ^D	3
C96800 (HT)	135	931	120 ^D	821 ^D	...
C97300	30	207	15	103	8
C97600	40	276	17	117	10
C97800	50	345	22	152	10

^AYield strength shall be determined as the stress producing an elongation under load of 0.5 %, that is, 0.01 in. (0.254 mm) in a gage length of 2 in. or 50 mm.

^Bksi = 1000 psi.

^CSee Appendix X1.

^DYield strength 0.2 %, offset.

TABLE 3 Suggested Heat Treatments

Copper Alloy UNS No.	Solution Treatment (not less than 1 h followed by water quench)	Annealing Treatment (not less than 2 h followed by air cool)
C96800	1500°F (815°C)	(Age to develop properties) 660°F (350°C) Precipitation hardening (5 h)
C94700	1425–1475°F (775–800°C)	580–620°F (305–325°C)

7. Chemical Composition

7.1 The castings shall conform to the compositional requirements for named elements as shown in Table 4 for the copper alloy UNS numbers specified in the purchase order.

7.2 These specification limits do not preclude the presence of other elements. Limits may be established and analysis required for unnamed elements agreed upon between manufacturer or supplier and purchaser. Copper or zinc, when zinc is 20 % or greater, may be given as remainder and may be taken as the difference between the sum of all elements analyzed and 100 %. When all named elements in Table 4 are analyzed, their sum shall be as specified in Table 5.

7.3 It is recognized that residual elements may be present in cast copper alloys. Analysis shall be made for residual elements only when specified in the purchase order.

8. Mechanical Properties

8.1 Mechanical properties shall be determined from separately cast test bar castings, and shall meet the requirements shown in Table 2.

9. Casting Repair

9.1 The castings shall not be weld repaired without approval of the purchaser (5.2.3).

9.2 The castings shall not be impregnated without approval of the purchaser (5.2.3).

10. ASME Requirements

10.1 When specified in the purchase order to meet ASME Boiler and Pressure Vessel Code requirements, castings in copper alloy UNS Nos. C92200, C93700, and C97600 shall comply with the following:

10.1.1 Certification requirements of Specification B 824.

10.1.2 Foundry test report requirements of Specification B 824.

10.1.3 Castings shall be marked with the manufacturer’s name, the copper alloy UNS number, and the casting quality factor. In addition, heat numbers or serial numbers that are traceable to heat numbers shall be marked on all pressure-containing castings individually weighing 50 lbs (22.7 kg) or more. Pressure-containing castings weighing less than 50 lbs (22.7 kg) shall be marked with either the heat number or a serial number that will identify the casting as to the month in which it was poured. Marking shall be in such a position as to not impair the usefulness of the casting.

10.2 The castings shall not be repaired, plugged, welded, or “burned in” unless permission from the purchaser has been