



Designation: B 662 – 94 (Reapproved 2000)

Standard Specification for Silver-Molybdenum Electrical Contact Material¹

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1. Scope

1.1 This specification covers electrical contact components made from silver-molybdenum by powder metallurgical procedures.

1.2 This specification covers compositions within the silver-molybdenum system normally specified by users of contacts.

1.3 It is the responsibility of the user to become familiar with all hazards including those identified in the appropriate Material Safety Data Sheet for this product/material as provided by the manufacturer.

2. Referenced Documents

2.1 *ASTM Standards*:

B 328 Test Method for Density, Oil Content, and Interconnected Porosity of Sintered Metal Structural Parts and Oil-Impregnated Bearings²

3. Ordering Information

3.1 Orders for this material under this specification shall include the following information:

3.1.1 Dimensions (see Section 10),

3.1.2 Chemical composition (see tables in the appendix as a guideline),

3.1.3 Physical properties (see Section 5 and the appendix as a guideline),

3.1.4 Certification (see Section 13), and

3.1.5 Other features as agreed upon between the manufacturer and purchaser.

4. Chemical Composition

4.1 The material shall conform to composition limits as agreed upon between the manufacturer and the purchaser.

4.2 The chemical analysis shall be made in accordance with the methods prescribed in the newest edition of Volume 01.02

of the *Annual Book of ASTM Standards* or by any other approved method agreed upon between the manufacturer and the purchaser.

5. Physical Properties

5.1 The manufacturer and the purchaser shall agree on qualification tests for determination of physical properties.

5.2 The tests shall be performed on production parts, wherever practical or applicable. (Small size contacts do not lend themselves to accurate conductivity measurement.)

5.3 The tests shall be determined after consideration of the function of the part.

5.4 The typical properties of two most common types of silver-molybdenum contacts are given in the appendix.

6. Finishing of Contacts

6.1 The material shall be finished by such operations as necessary to meet requirements agreed upon between the manufacturer and the purchaser of the contacts (brazing alloy backing, tumbling to polish surfaces, special surface finish, silver-rich surface layer, cleaning, etc.).

7. Dimensions, Mass and Permissible Variations

7.1 Permissible variations in dimensions shall be within the limits specified on drawings describing the contacts and accompanying the order; or shall be within the limits specified in the purchase order.

8. Workmanship, Finish, and Appearance

8.1 The parts shall be free of defects in material or processing that would seriously affect their performance.

9. Significance and Use

9.1 Proprietary methods for the manufacture of these materials vary significantly among suppliers, and these methods influence such properties as arc erosion, contact resistance, and the tendency to weld in service. Since the performance of contacts in a device depends on numerous factors outside the contact itself (opening speed, closing speed, contact pressure, contact bounce, environmental variations, assembly technique and variations, etc.), this specification cannot ensure performance control in the application. As part of the qualification on

¹ This test method is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B2.05 on Precious Metals.

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² *Annual Book of ASTM Standards*, Vol 02.05.



initial samples, it is recommended that the user functionally and electrically test the materials for all devices applicable to the material's use. This specification will provide a means for the contact manufacturer and contact user to reach agreement on the details of the material to be supplied for a specific use, and reasonable assurance that future lots will be similar in properties and microstructure to the initial test or sample contacts supplied.

10. Sampling

10.1 *Lot*—Unless otherwise specified, a lot shall consist of parts of the same form and dimensions, made of powders of the same particle size range and composition, processed under the same conditions, and submitted for inspection at one time.

10.2 Chemical Analysis:

10.2.1 At least one sample for chemical analysis shall be taken from each lot. A representative sample of chips may be obtained by milling, drilling, or crushing at least two pieces with dry tools, without lubrication. In order to obtain oil-free chips, the parts selected for test shall have the oil extracted in accordance with Test Method B 328 if necessary.

10.2.2 These specification limits do not preclude the possible presence of other unnamed elements, impurities, or additives. Analysis shall be regularly made only for the minor elements listed in the table. However, if a user knows of elements that might be detrimental to their application or has other reasons for requiring analysis for specific elements, then

agreement between manufacturer and purchaser for both limits and methods of analysis should be required for elements not specified.

10.3 *Physical Tests*—The manufacturer and the purchaser shall agree on a representative number of specimens for physical tests including microstructure.

11. Inspection

11.1 Unless otherwise specified, inspection of parts supplied on contract shall be made by the purchaser.

12. Rejection

12.1 Unless otherwise specified, rejections based on tests made in accordance with the specification shall be reported to the manufacturer within 30 days of the receipt of shipment.

13. Certification

13.1 A certification, when requested by the user, based on the manufacturer's quality control that the material conforms to the requirements of this specification, shall be furnished upon request of the purchaser, provided the request is made at the time of cost quotation and at the time of order placement.

14. Keywords

14.1 arcing contacts; contacts; electrical contacts; molybdenum; molybdenum silver; powder metallurgy; silver; silver molybdenum

APPENDIX

(Nonmandatory Information)

X1. TYPICAL PROPERTY VALUES

X1.1 The following information provides guidelines for users and manufacturers of silver-molybdenum contact material. Typical ranges of chemistry and properties are given for the two most popular compositions, 40 % silver/60 % molybdenum and 50 % silver/50 % molybdenum. These properties are influenced by the particle size, shape, and distribution of molybdenum, homogeneity, impurities or additives, and other manufacturing process variables.

NOTE X1.1—Table X1.1 and Table X1.2 represent the major manufacturing techniques used in industry. The size and shape of the part is important in choosing the optimum technique as well as other consider-

ations such as frequency of operation of the device, and how crucial is its application.

X1.1.1 The best choice for a given application should be mutually decided between the purchaser and the manufacturer using their mutual experience and application engineering knowledge.

X1.2 With the knowledge that several types are available, care should be taken to ensure that production lots are the same in all respects as samples, and that if a seller change is made, noticeable property or performance variations are possible.