



Standard Specification for Steel Investment Castings General Requirements, for Pressure-Containing Parts¹

This standard is issued under the fixed designation A 985; 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.

^{ε1} NOTE—A reference in Section S26.3.5 and a requirement in Fig. S26.1 were revised editorially in May 2002. The order of appearance of Fig. S26.2 and Fig. S26.3 was changed editorially in May 2002.

1. Scope

1.1 This specification covers a group of common requirements, which are mandatory for steel castings produced by the investment casting process for pressure-containing parts under each of the following ASTM Specifications:

Title of Specification	ASTM Designation
Steel Castings, Carbon, Suitable for Fusion Welding for High-Temperature Service	A 216/A 216M
Steel Castings, Martensitic Stainless and Alloy, for Pressure-Containing Parts Suitable for High-Temperature Service	A 217/A 217M
Castings, Austenitic, Austenitic-Ferritic (Duplex), for Pressure-Containing Parts	A 351/A 351M
Steel Castings, Ferritic and Martensitic, for Pressure-Containing Parts Suitable for Low-Temperature Service	A 352/A 352M
Steel Castings, Alloy, Specially Heat-Treated, for Pressure-Containing Parts, Suitable for High-Temperature Service	A 389/A 389M
Steel Castings Suitable for Pressure Service	A 487/A 487M

1.2 This specification also covers a group of supplementary requirements, which may be applied to the above specifications as indicated therein. These requirements are provided for use when additional testing or inspection is desired and apply only when specified individually by the purchaser in the order.

1.3 When investment casting are ordered, the requirements of this specification shall take precedence over the individual material specification requirements.

1.4 The values stated in either inch-pound or SI units are to be regarded separately as the standard. Within the text, the SI units are shown in parentheses. The values in each system are not exact equivalent; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with this specification. Inch-pound units are applicable for material ordered to Specification A 985 and SI units for material ordered to Specification A 985M.

¹ This practice is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.18 on Castings.

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1.5 *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 establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

- A 216/A 216M Specification for Steel Castings, Carbon, Suitable for Fusion Welding for High-Temperature Service²
- A 217/A 217M Specification for Steel Castings, Martensitic Stainless and Alloy, for Pressure-Containing Parts Suitable for High-Temperature Service²
- A 351/A 351M Specification for Castings, Austenitic, Austenitic-Ferritic (Duplex), for Pressure-Containing Parts²
- A 352/A 352M Specification for Steel Castings, Ferritic and Martensitic, for Pressure-Containing Parts Suitable for Low-Temperature Service²
- A 370 Test Methods and Definitions for Mechanical Testing of Steel Products³
- A 389/A 389M Specification for Steel Castings, Alloy, Specially Heat-Treated, for Pressure-Containing Parts, Suitable for High-Temperature Service²
- A 487/A 487M Specification for Steel Castings Suitable for Pressure Service²
- A 488/A 488M Practice for Steel Castings, Welding, Qualification of Procedures and Personnel²
- A 609/A 609M Practice for Castings, Carbon, Low-Alloy, and Martensitic Stainless Steel, Ultrasonic Examination Thereof²
- A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products³
- A 800/A 800M Practice for Steel Castings, Austenitic Alloy, Estimating Ferrite Content Thereof²
- A 903/A 903M Specification for Steel Castings, Surface

² Annual Book of ASTM Standards, Vol 01.02.

³ Annual Book of ASTM Standards, Vol 01.03.

Acceptance Standards, Magnetic Particle and Liquid Penetrant Inspection²

A 941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys⁴

A 991/A 991M Test Method for Conducting Temperature Uniformity Surveys of Furnaces Used to Heat Treat Steel Products³

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications⁵

E 94 Guide for Radiographic Examination⁶

E 125 Reference Photographs for Magnetic Particle Indications on Ferrous Castings⁶

E 165 Test Method for Liquid Penetrant Examination⁶

E 186 Reference Radiographs for Heavy-Walled (2 to 4½-in. (51 to 114-mm)) Steel Castings⁶

E 192 Reference Radiographs for Investment Steel Castings of Aerospace Applications⁶

E 208 Test Method for Conducting Drop-Weight Test to Determine Nil-Ductility Transition Temperature of Ferritic Steels⁷

E 280 Reference Radiographs for Heavy-Walled (4½ to 12-in. (114 to 305-mm)) Steel Castings⁶

E 340 Test Method for Macroetching Metals and Alloys⁷

E 353 Test Methods for Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys⁸

E 354 Test Methods for Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys⁸

E 446 Reference Radiographs for Steel Castings Up to 2 in. (51 mm) in Thickness⁶

E 709 Guide for Magnetic Particle Examination⁶

2.2 *ANSI Standard*:⁹

B16.5 Steel Pipe Flanges and Flanged Fittings

2.3 *ASME Standard*:¹⁰ www.astm.org/catalog/standards/sist/6c868

ASME Boiler and Pressure Vessel Code, Section III, NB-2546

2.4 *Standards of the Manufacturer's Standardization Society of the Valve and Fitting Industry*:¹¹

MSS SP 53 Quality Standard for Steel Castings for Valves, Flanges and Fittings, and Other Piping Components (Dry Magnetic Particle Inspection Method)

MSS SP 54 Quality Standard for Steel Castings for Valves, Flanges and Fittings, and Other Piping Components (Radiographic Inspection Method)

2.5 *SAE Aerospace Recommended Practice*:¹²

ARP 1341 Determining Decarburization and Carburization in Finished Parts of Carbon and Low-Alloy Steel

3. Terminology

3.1 *Definitions*—The definitions in Test Methods and Definitions A 370 and Terminology A 941 are applicable to this specification and those listed in 1.1.

3.2 *Definitions of Terms Specific to This Standard*:

3.2.1 *heat, n*—all the molten metal poured from a single furnace or all of the molten metal from two or more furnaces poured into a single ladle or casting prior to the replenishing of the furnace(s).

3.2.2 *master heat, n*—a single furnace charge of alloy that may be either poured directly into castings or into remelt alloy for individual melts.

3.2.3 *investment casting, n*—a metal casting that is produced in a mold obtained by investing (surrounding) an expendable pattern with a ceramic slurry which is allowed to solidify. The expendable pattern may consist of wax, plastic, or other material and is removed prior to filling the mold with liquid metal.

3.2.4 *subheat, n*—a portion of master heat remelted with only minor additions for deoxidation for pouring into castings. Syn. melt, production heat.

4. Materials and Manufacture

4.1 *Melting Process*—Master heats shall be made by the electric furnace process with or without separate refining such as argon-oxygen-decarburization (AOD), vacuum-oxygen-degassing (VOD), vacuum-induction-melting (VIM), and so forth, unless otherwise specified in the individual specification or agreed upon between the customer and producer. Master heats may be used directly for producing castings or converted into ingot, bar, shot, or other suitable form, not including gates and risers from casting production, for later remelting as a subheat.

4.2 *Re-melting Process*—Subheats shall be produced from master heat metal in suitable batch sizes by electric induction furnace, with or without atmosphere protection, such as vacuum or inert gas unless otherwise agreed upon between the customer and producer. Revert (gates, sprues, risers, and rejected) castings shall not be remelted except in master heats.

4.3 *Heat Treatment*—Ferritic and martensitic steel shall be cooled after pouring to provide substantially complete transformation of austenite prior to heat treatment to enhance mechanical properties.

4.4 *Sampling*:

4.4.1 If castings are poured directly from one or more master heats, then the samples for chemical and other required testing also shall be poured directly from each of the master heats.

4.4.2 If castings are poured from a subheat, then the samples for chemical and other required testing also shall be poured from a subheat of that same master heat, but not necessarily from the same sub-heat as the castings. The subheat used for the test samples shall be produced using the same practices and additions as used for the castings.

4.4.3 Test specimens may be taken from castings or from coupons cast either integrally with the castings, in the same

⁴ *Annual Book of ASTM Standards*, Vol 01.01.

⁵ *Annual Book of ASTM Standards*, Vol 14.02.

⁶ *Annual Book of ASTM Standards*, Vol 03.03.

⁷ *Annual Book of ASTM Standards*, Vol 03.01.

⁸ *Annual Book of ASTM Standards*, Vol 03.05.

⁹ Available from American National Standards Institute, 25 W. 43rd St., 4th Floor, New York, NY 10036.

¹⁰ Available from American Society of Mechanical Engineers, Three Park Ave., New York, NY 10016-5990

¹¹ Available from the Manufacturer's Standardization Society of the Valve and Fitting Industry, 127 Park St., NE, Vienna, VA 22180-4602.

¹² Available from the Society of Automotive Engineers, Inc., 400 Commonwealth Dr., Warrendale, PA 15096-0001.

TABLE 1 Product Analysis Tolerances for Carbon and Low-Alloy Steels

Element	Range ^A	Tolerances ^{BC} over max or under min, Limit, %
Carbon (C)	up to 0.65 % above 0.65 %	$0.03 \times \% C_L + 0.02$ 0.04 %
Manganese (Mn)	up to 1 % above 1 %	$0.08 \times \% Mn_L + 0.01$ 0.09
Silicon (Si)	up to 0.60 % above 0.60 %	$0.22 \times \% Si_L - 0.01$ 0.15 %
Phosphorus (P)	all	$0.13 \times \% P_L + 0.005$
Sulfur (S)	all	$0.36 \times \% S_L + 0.001$
Nickel (Ni)	up to 2 % above 2 %	$0.10 \times \% Ni_L + 0.003$ 0.25 %
Chromium (Cr)	up to 2 % above 2 %	$0.07 \times \% Cr_L + 0.04$ 0.18 %
Molybdenum (Mo)	up to 0.6 % above 0.6 %	$0.04 \times \% Mo_L + 0.03$ 0.06 %
Vanadium (V)	up to 0.25 % above 0.25 %	$0.23 \times \% V_L + 0.004$ 0.06 %
Tungsten (W)	up to 0.10 % above 0.10 %	$0.08 \times \% W_L + 0.02$ 0.02 %
Copper (Cu)	up to 0.15 % above 0.15 %	$0.18 \times \% Cu_L + 0.02$ 0.05 %
Aluminum (Al)	up to 0.10 % above 0.10 %	$0.08 \times \% Al_L + 0.02$ 0.03 %

^A The range denotes the composition limits up to which the tolerances are computed by the equation, and above which the tolerances are given by a constant.

^B The subscript _L for the elements in each equation indicates that the limits of the element specified by the applicable specification are to be inserted into the equation to calculate the tolerance for the upper limit and the lower limit, if applicable, respectively. Examples of computing tolerances are presented in the footnote C.

^C To compute the tolerances, consider the manganese limits 0.50 - 80 % of Grade WC4 of Specification A 217/A 217M. According to Table 1, the maximum permissible deviation of a product analysis below the lower limit 0.50 is $0.05 \% = (0.08 \times 0.50 + 0.01)$. The lowest acceptable product analysis of Grade WC4, therefore, is 0.45 %. Similarly, the maximum permissible deviation above the upper limit of 0.80 % is $0.074 \% = (0.08 \times 0.08 + 0.01)$. The highest acceptable product analysis of Grade WC4, therefore is 0.874. For Grade WCC of Specification A 216/A 216M, the maximum manganese content is 1.20 % if the carbon content is 0.20 %. In this case, the highest acceptable product analysis is $1.29 = (1.20 + 0.09)$.

austenitic alloy castings with cross sections less than 2½ in.¹³

5. Chemical Composition

5.1 *Chemical Analysis*—Chemical analysis of materials covered by this specification shall be in accordance with Test Methods, Practices, and Terminology A 751.

5.2 *Heat Analysis*—An analysis of samples obtained according to 4.4 or Supplementary Requirement S27 as appropriate, shall be made by the manufacturer to determine the percentages of the elements specified for the grade being poured. When drillings are used, they shall be taken not less than ¼ in. (1.6 mm) beneath the surface. The chemical composition thus determined shall be reported to the purchaser, or his representative; and shall conform to the requirements in the individual specification for the grade being poured.

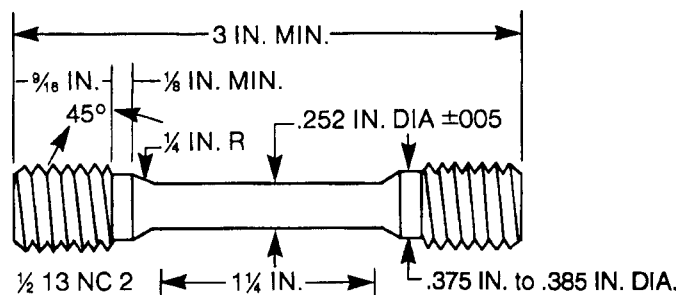
5.3 *Product Analysis*—A product analysis may be made by the purchaser from material representing each master heat, subheat, lot, or casting. The analysis shall be made on representative material. Samples for carbon analysis shall be taken no closer than ¼ in. (1.6 mm) to a cast surface except that castings too thin for this shall be analyzed on representative material. The chemical composition thus determined shall meet the requirements specified in the applicable specification for the grade involved, or shall be subject to rejection by the purchaser, except that the chemical composition determined for carbon and low-alloy steel castings may vary from the specified limits by the amounts shown in Table 1. The product analysis tolerances of Table 1 are not applicable as acceptance criteria for heat analysis by the casting manufacturer. When comparing product and heat analysis for other than carbon and low alloy steels, the reproducibility data R2, in Test Methods E 353 or E 354, as applicable, shall be taken into consideration.

5.4 *Unspecified Elements*—When chemical analysis for elements not specified for the grade ordered is desired, Supplementary Requirement S1 may be specified.

NOTE 1—All commercial metals contain small amounts of various elements in addition to those which are specified. It is neither practical nor

molds as the castings, or in separate molds.

4.4.4 Separately cast specimens for tension testing shall be cast in molds of the same type and material as those used for the castings, as shown in Fig. 1, Fig. 2 and Table 2, Fig. 3, and Fig. 4 except when Supplementary Requirement S26 is specified. The test coupon in Fig. 4 shall be employed only for



Metric Equivalents

in.	0.005	1/8	0.252	0.375	0.385	9/16	1¼	3
(mm)	(0.15)	(3)	(6.40)	(9.50)	(9.75)	(15)	(30)	(75)

FIG. 1 Design and Dimensions of the ICI Test Bar

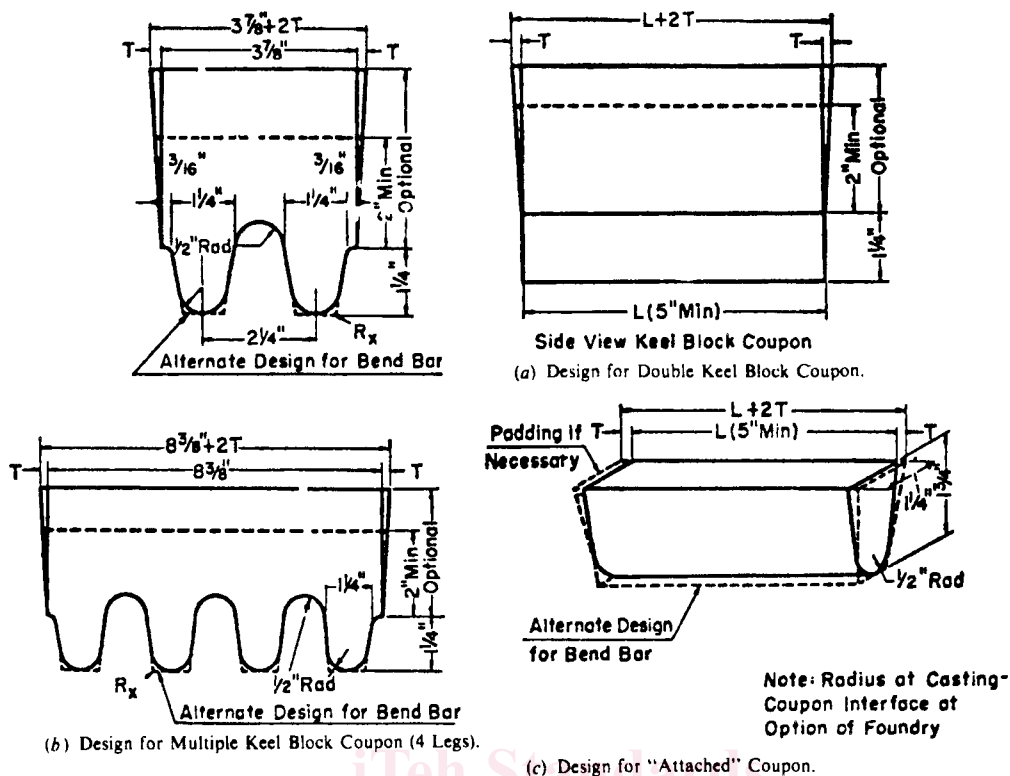


FIG. 2 Test Coupons for Castings (see Table 2 for Details of Design)

TABLE 2 Details of Test Coupon Design for Casting (See Fig. 2)

	Metric Equivalents									
In.	3/16	1/2	1 1/4	1 3/4	2	2 1/2	3 7/8	5	8 7/8	
mm	4.8	13	32	45	51	57	98	127	213	

NOTE 1—Test Coupons for Large and Heavy Steel Castings: The test coupons in Fig. 2 are to be used for large and heavy steel castings. However, at the option of the foundry the cross-sectional area and length of the standard coupon may be increased as desired.

NOTE 2—Bend Bar: If a bend bar is required, an alternate design (as shown by dotted lines in Fig. 2) is indicated.

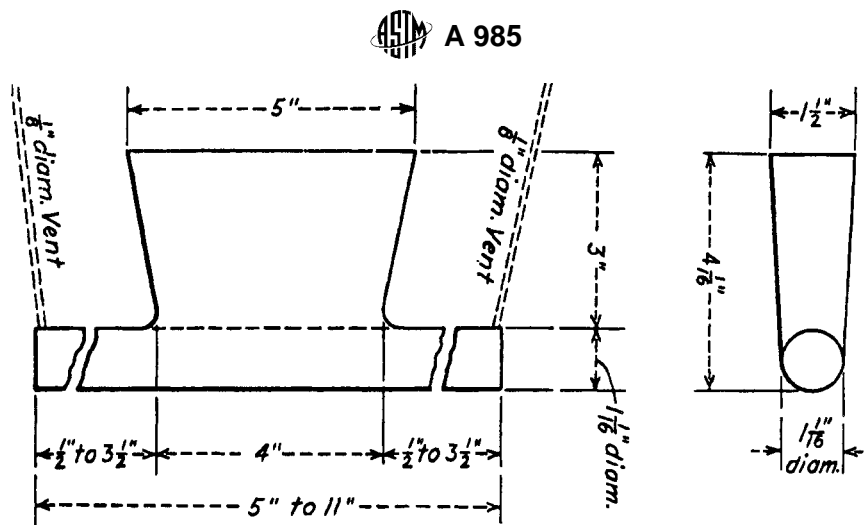
	Leg Design (125 mm)	Riser Design
1. L (length)	A 5 in. (125 mm) minimum length will be used. This length may be increased at the option of the foundry to accommodate additional test bars (see Note 1).	1. L (length) The length of the riser at the base will be the same as the top length of the leg. The length of the riser at the top therefore depends on the amount of taper added to the riser.
2. End taper	Use of and size of end taper is at the option of the foundry.	2. Width The width of the riser at the base of a multiple-leg coupon shall be $n, 2 \frac{1}{4} (57 \text{ mm}) - \frac{5}{8} (16 \text{ mm})$ where n equals the number of legs attached to the coupon. The width of the riser at the top is therefore dependent on the amount of taper added to the riser.
3. Height	1 1/4 in. (32 mm)	3. T (riser taper) Use of and size is at the option of the foundry.
4. Width (at top)	1 1/4 in. (32 mm) (see Note 1).	Height The minimum height of the riser shall be 2 in. (51 mm). The maximum height is at the option of the foundry for the following reasons: (a) Many risers are cast open, (b) different compositions may require variation in risering for soundness, (c) different pouring temperatures may require variation in risering for soundness.
5. Radius (at bottom)	1/2 in. (13 mm), max	
6. Spacing between legs	A 1/2-in. (13-mm) radius will be used between the legs.	
7. Location of test bars	The tensile, bend, and impact bars will be taken from the lower portion of the leg (see Note 1).	
8. Number of legs	The number of legs attached to the coupon is at the option of the foundry providing they are equispaced according to Item 6.	
9. R _s	Radius from 0 to approximately 1/16 in. (2mm).	

necessary to specify limits for every unspecified element that might be present, despite the fact that the presence of many of these elements often is determined routinely by the producer.

5.5 The substitution of a grade or composition different from that specified by the purchaser is prohibited.

6. Mechanical Test Methods

6.1 All mechanical tests shall be conducted in accordance with Test Methods and Definitions A 370.



NOTE 1—Pour through head; cover molten head with powered charcoal, coke dust, etc., immediately after pouring, in order to keep head fluid as long as possible.

Metric Equivalents

in.	mm	in.	mm
1/8	3.2	3 1/2	88.9
1/2	12.7	4	101.6
1 1/16	27.0	4 1/16	103.2
1 1/2	38.1	5	127.0
3	76.2	11	279.4

FIG. 3 Test Block for Tension Test Specimen

7. Tensile Requirements

7.1 Sampling for tension testing shall be in accordance with 4.4 or with Supplementary Requirement S28 as appropriate.

7.2 The coupon from which the test specimen is taken shall be heat-treated in production furnaces to the same procedure as the castings it represents.

7.3 If any specimen shows defective machining or develops flaws, it may be discarded and another substituted from the same heat.

7.4 To determine conformance with the tension test requirements, an observed value or calculated value shall be rounded off in accordance with Practice E 29 to the nearest 500 psi (51 MPa) for yield and tensile strength and to the nearest 1 % for elongation and reduction of area.

8. Repair by Welding

8.1 Repair by welding shall be in accordance with the requirements of individual specifications using procedures and welders qualified in accordance with Practice A 488/A 488M.

9. Flanges

9.1 When a flange from a flanged casting is removed to make a weld-end castings, discontinuities may be observed that would not have been detrimental in a flanged castings. The disposition of the casting shall be subject to agreement between the purchaser and manufacturer.

10. Quality

10.1 The surface of the casting shall be free of adhering ceramic, scale, cracks, and hot tears as determined by visual examination. Other surface discontinuities shall meet the visual acceptance standards specified in the order. Unacceptable

visual surface discontinuities shall be removed and their removal verified by visual examination of the resultant cavities.

10.2 The castings shall not be peened, plugged, or impregnated to stop leaks.

10.3 When additional inspection is desired, Supplementary Requirements S4, S5, S7, or S10 may be specified.

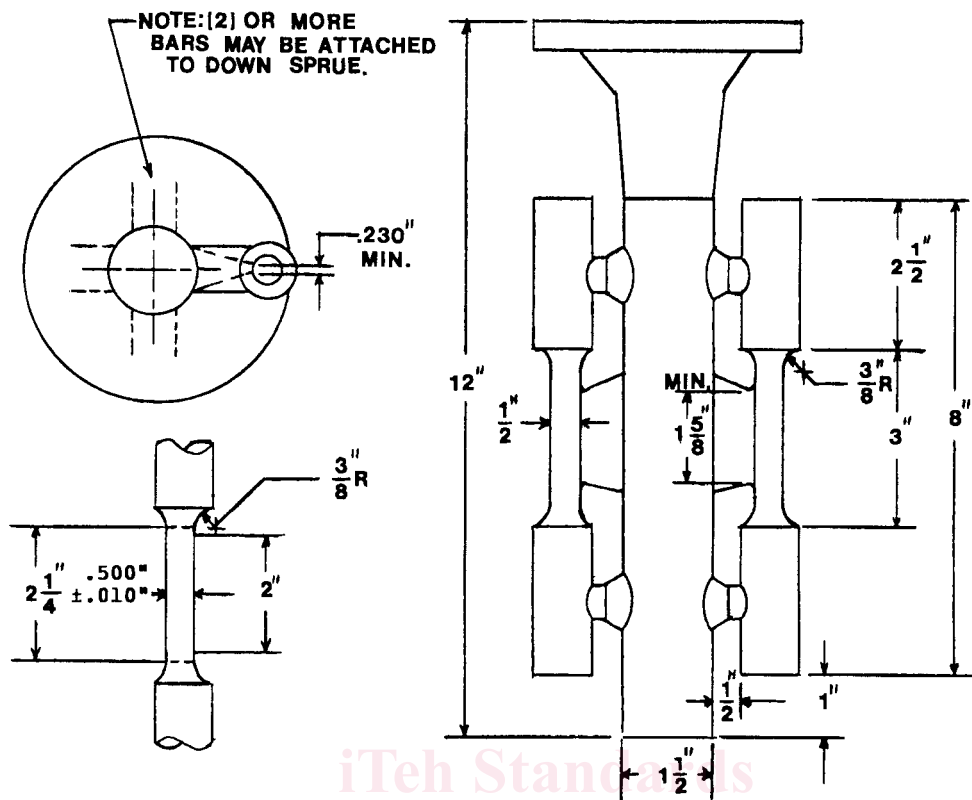
11. Hydrostatic Tests

11.1 Each casting shall be tested after machining to the hydrostatic shell test pressures prescribed in ANSI B16.5 for the applicable steel rating for which the casting is designed. The casting shall not show any leaks. Castings ordered for working pressures other than those in the standard ANSI ratings, or those listed for which test pressures are not specified by ANSI B16.5, shall be tested at a pressure agreed upon between manufacturer and the purchaser.

11.2 It is realized that the foundry may be unable to perform the hydrostatic test prior to shipment, or that the purchaser may wish to defer testing until additional work or machining has been performed on the casting. Castings ordered in the rough state for final machining by the purchaser may be tested hydrostatically prior to shipment by the manufacturer at pressures to be agreed upon with the purchaser. The foundry, however, is responsible for the satisfactory performance of the casting under the final test required in 11.1.

12. Workmanship, Finish, and Appearance

12.1 All castings shall be made in a workmanlike manner and shall conform to the dimensions on drawings furnished by the purchaser. When the pattern is supplied by the purchaser or is produced using a die supplied by the purchaser, the dimensions of the casting shall be as predicated by the pattern or die



NOTE 1—Coupons produced in this manner are suitable for austenitic alloys only. The mold may be preheated for pouring to produce a sound coupon.

Metric Equivalents

in.	mm	in.	mm
0.010	0.254	1 5/8	41.275
0.0230	5.842	2 1/4	57.15
3/8	9.525	2 1/2	63.5
1/2	12.7	3	76.2
1	25.4	8	203.2
1 1/2	38.1	12	304.8

FIG. 4 Cast-To-Shape Test Coupon for Tension Test Specimen

unless otherwise agreed upon.

12.2 Machined welding ends shall be suitably protected against damage during shipping.

13. Retests

13.1 If the results of the mechanical tests do not conform to the requirements specified, retests are permitted as outlined in Test Methods and Definitions A 370. At the manufacturer's option, castings may be reheat-treated and retested. Testing after reheat treatment shall consist of the full number of specimens taken from locations complying with the specification or order.

14. Inspection

14.1 The manufacturer shall afford the purchaser's inspector all reasonable facilities necessary to satisfy that the material is being produced and furnished in accordance with the applicable specification. Foundry inspection by the purchaser shall not interfere unnecessarily with the manufacturer's operations. All tests and inspections, with the exception of product analysis (5.2), are the responsibility of the manufacturer.

15. Rejection and Rehearing

15.1 Any rejection based on test reports shall be reported to the manufacturer within 30 days from the receipt of the test reports by the purchaser.

15.2 Material that shows unacceptable discontinuities as determined by the acceptance standards specified in the order subsequent to its acceptance at the manufacturer's works will be rejected, and the manufacturer shall be notified within 30 days after discovery of the rejectable condition.

15.3 Samples that represent rejected material shall be preserved for two weeks from the date of transmission of the test report. In case of dissatisfaction with the results of the tests, the manufacturer may make claim for a rehearing with that time.

16. Certification

16.1 The manufacturer's certification shall be furnished to the purchaser stating that the material was manufactured, sampled, tested, and inspected in accordance with the material specification (including year of issue) and was found to meet the requirements.

16.2 As applicable, the certification also shall include: