



Standard Specification for Investment Castings, Steel and Alloy, Common Requirements, for General Industrial Use¹

This standard is issued under the fixed designation A 957; 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.

1. Scope

1.1 This specification covers a group of requirements that are mandatory for castings produced by the investment casting process to meet the metallurgical requirements of the following steel casting specifications issued by ASTM.

| ASTM Designation | Title of Specification |
|------------------|---|
| A 27/A 27M | Steel Castings, Carbon, for General Application |
| A 148/A 148M | Steel Castings, High-Strength, for Structural Purposes |
| A 297/A 297M | Steel Castings, Iron-Chromium and Iron-Chromium-Nickel, Heat-Resistant, for General Application |
| A 447/A 447M | Steel Castings, Chromium-Nickel-Iron Alloy (25-12 Class), for High-Temperature Service |
| A 494/A 494M | Castings, Nickel and Nickel Alloy |
| A 560/A 560M | Castings, Chromium-Nickel Alloy |
| A 732/A 732M | Castings, Investment, Carbon and Low Alloy Steel for General Application, and Cobalt Alloy for High Strength at Elevated Temperatures |
| A 743/A 743M | Castings, Iron-Chromium, Iron-Chromium-Nickel, Corrosion-Resistant, for General Application |
| A 744/A 744M | Castings, Iron-Chromium-Nickel, Corrosion Resistant, for Severe Service |
| A 747/A 747M | Steel Castings, Stainless, Precipitation Hardening |
| A 890/A 890M | Castings, Iron-Chromium-Nickel-Molybdenum Corrosion-Resistant, Duplex (Austenitic/Ferritic) for General Application |
| A 915/A 915M | Steel Castings, Carbon and Alloy, Chemical Requirements Similar to Standard Wrought Grades |

1.2 This specification also covers a group of supplementary requirements that may be applied to the above specifications as indicated therein. These 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 castings are ordered, the requirements stated herein form an integral part of the material specification. In cases of conflict, 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 standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification. Inch-pound units are applicable for material ordered to Specification A 957 and SI units for material ordered to Specification A 957M.

2. Referenced Documents

2.1 ASTM Standards:

- A 27/A27M Specification for Steel Castings, Carbon, for General Application²
- A 148/A148M Specification for Steel Castings, High Strength, for Structural Purposes²
- A 297/A297M Specification for Steel Castings, Iron-Chromium and Iron-Chromium-Nickel, Heat Resistant, for General Application²
- A 370 Test Methods and Definitions for Mechanical Testing of Steel Products³
- A 447/A447M Specification for Steel Castings, Chromium-Nickel-Iron Alloy (25-12 Class), for High-Temperature Service²
- A 488/A488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel²
- A 494/A494M Specification for Castings, Nickel and Nickel Alloy²
- A 560/A560M Specification for Castings, Chromium-Nickel Alloy²
- A 609/A609M Practice for Castings, Carbon, Low-Alloy, and Martensitic Stainless Steel, Ultrasonic Examination Thereof²
- A 732/A732M Castings, Investment, Carbon and Low Alloy Steel for General Application, and Cobalt Alloy for High Strength at Elevated Temperatures²
- A 743/A743M Specification for Castings, Iron-Chromium, Iron-Chromium-Nickel, Corrosion Resistant, for General Application²
- A 744/A744M Specification for Castings, Iron-Chromium-Nickel, Corrosion Resistant, for Severe Service²
- A 747/A747M Specification for Steel Castings, Stainless, Precipitation Hardening²

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

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² Annual Book of ASTM Standards, Vol 01.02.

³ Annual Book of ASTM Standards, Vol 01.03.

- A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products³
- A 800/A800M Practice for Steel Casting, Austenitic Alloy, Estimating Ferrite Content Thereof²
- A 890/A890M Specification for Castings, Iron-Chromium-Nickel-Molybdenum Corrosion-Resistant, Duplex (Austenitic/Ferritic) for General Application²
- A 903 Specification for Steel Castings, Surface Acceptance Standards, Magnetic Particle and Liquid Penetrant Inspection²
- A 915/A915M Steel Castings, Carbon and Alloy, Chemical Requirements Similar to Standard Wrought Grades²
- A 919 Terminology Relating to Heat Treatment of Metals²
- E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications⁴
- E 94 Guide for Radiographic Testing⁵
- E 125 Reference Photographs for Magnetic Particle Indications on Ferrous Castings⁵
- E 165 Test Method for Liquid Penetrant Examination⁵
- E 186 Reference Radiographs for Heavy-Walled (2 to 4½ in. (51 to 114-mm)) Steel Castings⁵
- E 192 Reference Radiographs for Investment Steel Castings of Aerospace Applications⁵
- E 280 Reference Radiographs for Heavy-Walled (4½ to 12-in. (114 to 305-mm)) Steel Castings⁵
- E 353 Test Methods for Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys⁶
- E 354 Test Methods for Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys⁶
- E 446 Reference Radiographs for Steel Castings Up to 2 in. (51 mm) in Thickness⁵
- E 709 Guide for Magnetic Particle Examination⁵
- 2.2 *SAE Aerospace Recommended Practice*:
 ARP 1341 Determining Decarburization and Carburization in Finished Parts of Carbon and Low-Alloy Steel⁷

3. Terminology

3.1 *Definitions*—The definitions in Test Methods and Definitions A 370, Test Methods, Practices, and Terminology A 751, and Terminology A 919 are applicable to this specification and to those listed in 1.1.

3.2 *Definitions of Terms Specific to This Standard*:

3.2.1 *master heat, n*—a quantity of metal processed in a single furnace or refining vessel at one time in such a manner as to produce the desired composition and properties.

3.2.2 *sub-heat, n*—a portion of a master heat remelted without additional processing for pouring into castings. Synonyms: melt, production heat.

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 that 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.

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), etc., 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 sub-heat.

4.2 *Re-melting Process*—Sub-heats 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 specified in the individual specification or agreed upon between the customer and producer. Revert (gates, sprues, risers, and rejected castings) shall not be re-melted except in master heats.

4.3 *Sampling*:

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

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

4.3.3 Unless otherwise specified by the purchaser, test specimens may be taken from castings or from coupons cast integrally with the castings, in the same molds as the castings, or in separate molds.

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 in accordance with 4.3 or Supplementary Requirement S17 as appropriate, shall be made by the manufacturer to determine the percentages of the elements specified in the individual specification for the grade being poured. When drillings are used, they shall be taken not less than 1/16 in. [1.6 mm] beneath the surface. The chemical composition thus determined 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, sub-heat, lot, or casting. The analysis shall be made on representative material. Samples for carbon analysis of carbon and alloy steel shall be taken no closer than 1/16 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

⁴ Annual Book of ASTM Standards, Vol 14.02.

⁵ Annual Book of ASTM Standards, Vol 03.03.

⁶ Annual Book of ASTM Standards, Vol 03.05.

⁷ Available from Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096-0001.

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 S13 may be specified.

NOTE 1—All commercial metals contain small amounts of various elements in addition to those that are specified. It is neither practical nor necessary to specify limits for every unspecified element that might be present, despite the fact that the presence of many of these elements is often routinely determined by the producer.

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

6. Tensile Requirements

6.1 The individual product specifications vary as to whether tension tests are required; for this reason, and to determine specific test requirements, the individual product specification should be reviewed. If tension testing is required by the product specification, sampling shall be in accordance with 4.3 or with Supplementary Requirement S18 as appropriate.

TABLE 1 Product Analysis Tolerances

| Element | Range, % ^A | Tolerances ^{B,C} Over Maximum or Under Minimum Limit, % |
|---------|--------------------------|--|
| C | up to 0.65 above 0.65 | $0.03 \times \% C_L + 0.02$ 0.04 |
| Mn | up to 1 above 1 | $0.08 \times \% Mn_L + 0.01$ 0.09 |
| Si | up to 0.60 above 0.60 | $0.22 \times \% Si_L - 0.01$ 0.15 |
| P | all | $0.13 \times \% P_L + 0.005$ |
| S | all | $0.36 \times \% S_L + 0.001$ |
| Ni | up to 2 above 2 | $0.10 \times \% Ni_L + 0.03$ 0.25 |
| Cr | up to 2 above 2 | $0.07 \times \% Cr_L + 0.04$ 0.18 |
| Mo | up to 0.6 above 0.6 | $0.04 \times \% Mo_L + 0.03$ 0.06 |
| V | up to 0.25 above 0.25 | $0.23 \times \% V_L + 0.004$ 0.06 |
| W | up to 0.10 above 0.10 | $0.08 \times \% W_L + 0.02$ 0.02 |
| Cu | up to 0.15 above 0.15 | $0.18 \times \% Cu_L + 0.02$ 0.05 |
| 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 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 footnote C.

^C To illustrate the computation of the tolerance, consider the manganese maximum of 0.70 for an 0.30 carbon grade 65-35 in Specification A 27. The maximum permissible deviation is $(0.08 \times 0.70 + 0.01) = 0.066$. Therefore, the highest acceptable product analysis is 0.766. Similarly, for an 0.20 carbon grade 70-40 in Specification A 27, the maximum manganese content is 1.40; thus, the highest acceptable product analysis is $(1.40 + 0.09) = 1.49$.

6.2 Unless otherwise specified by the purchaser, when mechanical properties are required by the product specification, test coupons may be taken from castings, may be cast integrally with the castings, or may be cast in separate molds of the same type and material as those used for the castings, in accordance with Fig. 1, Fig. 2, Fig. 3, or Fig. 4, except when Supplementary Requirement S15 is specified. The test coupon in Fig. 4 shall be employed only for austenitic alloy castings with cross sections less than 2½ in.⁸

6.3 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.

6.4 The specimens may be cast to shape or machined from coupons to dimensions in accordance with Test Methods and Definitions A 370 or the ICI bar shown in Fig. 1.

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

6.6 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 [5 MPa] for yield and tensile strength and to the nearest 1 % for elongation and reduction of area.

7. Workmanship, Finish, and Appearance

7.1 All castings shall be made in a workmanlike manner and shall conform to the dimensions on drawings furnished by the purchaser before manufacture is started. If 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.

8. Quality

8.1 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.

8.2 When additional inspection is desired, Supplementary Requirements S1, S2, S3, S4, or S5 may be specified.

⁸ Information on the relationship of mechanical properties determined on test coupons obtained as specified in 6.2 with those obtained from the casting may be found in "The Steel Casting Handbook," Fifth Edition, Steel Founders' Society of America, 1980, pp. 15-35 through 15-43.

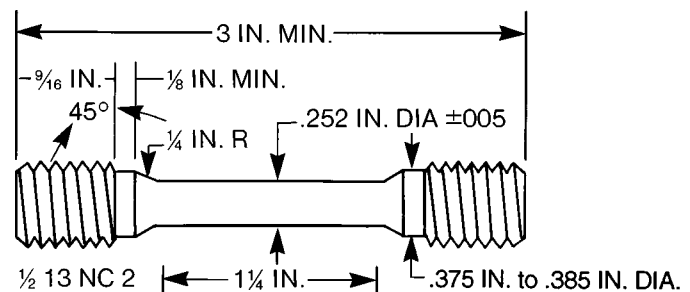


FIG. 1 Design and Dimensions of the ICI Test Bar