



Standard Specification for Castings, Nickel and Nickel Alloy¹

This standard is issued under the fixed designation A 494/A494M; 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.

1. Scope

1.1 This specification covers nickel, nickel-copper, nickel-copper-silicon, nickel-molybdenum, nickel-chromium, and nickel-molybdenum-chromium alloy castings for corrosion-resistant service.

1.2 The values stated in either inch-pound units 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 494 and SI units for material ordered to Specification A 494M.

2. Referenced Documents

2.1 ASTM Standards:

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products²

A 488/A488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel³

A 732/A732M Specification for Castings, Investment, Carbon and Low-Alloy Steel for General Application, and Cobalt Alloy for High Strength at Elevated Temperatures³

A 781/A781M Specification for Castings, Steel and Alloy, Common Requirements, for General Industrial Use³

E 8 Test Methods for Tension Testing of Metallic Materials⁴

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

E 30 Test Methods for Chemical Analysis of Steel, Cast Iron, Open-Hearth Iron, and Wrought Iron⁶

E 38 Methods for Chemical Analysis of Nickel-Chromium and Nickel-Chromium-Iron Alloys⁷

E 76 Test Methods for Chemical Analysis of Nickel-Copper Alloys⁶

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.

Current edition approved Mar. 10, 2000. Published May 2000. Originally published as B 332 – 58 T. Redesignated as A 494 in 1963. Last previous edition A 494/A 494M – 99.

² Annual Book of ASTM Standards, Vol 01.03.

³ Annual Book of ASTM Standards, Vol 01.02.

⁴ Annual Book of ASTM Standards, Vol 03.01.

⁵ Annual Book of ASTM Standards, Vol 14.02.

⁶ Annual Book of ASTM Standards, Vol 03.05.

⁷ Discontinued, see 1989 Annual Book of ASTM Standards, Vol 03.05.

E 354 Test Methods for Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys⁶

2.2 Military Standards:⁸

NAVSEA T9074-AS-GIB-010/271 Requirements for Non-destructive Testing Methods

NAVSEA S9074-AR-GIB-010/2718 Requirements for Fabrication Welding and Inspection, and Casting Inspection and Repair for Machinery, Piping, and Pressure Vessels

3. Terminology

3.1 Definitions:

3.1.1 *master heat*—a single furnace charge of refined alloy which may either be poured directly into castings or into remelt alloy for individual melts.

3.1.2 *melts*—a single furnace charge poured into castings. When master heats are used to prepare melts, a melt analysis shall be reported.

4. General Conditions for Delivery

4.1 Material furnished to this specification shall conform to the requirements of Specification A 781/A 781M, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A 781/A 781M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A 781/A 781M, this specification shall prevail.

5. Ordering Information

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

5.1.1 Quantity, in pieces, and

5.1.2 Grade designation (Table 1) and class (Table 2).

5.2 The purchaser shall specify any of the following information required to describe adequately the desired material:

5.2.1 Heat treat condition (see 6.1 and 6.2),

5.2.2 Repair welding (see 11)

5.2.3 Source inspection requirements, if any (see Specification A 781/A 781M),

5.2.4 Marking-for-identification requirements, if any (see 13.1), and

5.2.5 Supplementary requirements desired, including the

⁸ Available from DODSSP, Building 4/Section D, 700 Robbins Avenue Philadelphia, PA 19111-5098

TABLE 1 Chemical Requirements

NOTE—Values are maximum unless otherwise indicated.

| Element | Composition, % | | | | | | | | | | | | | | | |
|----------|----------------|---------------------|-----------|-----------|-----------|--------------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|----------------|------------------|
| | CZ-100 | M-35-1 ^A | M-35-2 | M-30H | M-25S | M-30C ^A | N-12MV | N-7M | CY-40 | CW-12MW | CW-6M | CW-2M | CW-6MC | CY5SnBiM | CX2MW (N26022) | CU5MCuC (N28820) |
| C, max | 1.00 | 0.35 | 0.35 | 0.30 | 0.25 | 0.30 | 0.12 | 0.07 | 0.40 | 0.12 | 0.07 | 0.02 | 0.06 | 0.05 | 0.02 | 0.050 max |
| Min, max | 1.50 | 1.50 | 1.50 | 1.50 | 1.50 | 1.50 | 1.00 | 1.00 | 1.50 | 1.00 | 1.00 | 1.00 | 1.00 | 1.5 | 1.00 | 1.0 max |
| Si, max | 2.00 | 1.25 | 2.00 | 2.7–3.7 | 3.5–4.5 | 1.0–2.0 | 1.00 | 1.00 | 3.00 | 1.00 | 0.80 | 1.00 | 0.5 | 0.80 | 1.00 | 1.0 max |
| P, max | 0.03 | 0.03 | 0.03 | 0.03 | 0.03 | 0.03 | 0.040 | 0.040 | 0.03 | 0.040 | 0.040 | 0.03 | 0.015 | 0.03 | 0.025 | 0.030 max |
| S, max | 0.03 | 0.03 | 0.03 | 0.03 | 0.03 | 0.03 | 0.030 | 0.030 | 0.03 | 0.030 | 0.030 | 0.03 | 0.015 | 0.03 | 0.025 | 0.030 max |
| Cu | 1.25 max | 26.0–33.0 | 26.0–33.0 | 27.0–33.0 | 27.0–33.0 | 26.0–33.0 | ... | ... | ... | ... | ... | ... | ... | ... | ... | 1.50–3.50 |
| Mo | ... | ... | ... | ... | ... | ... | 26.0–30.0 | 30.0–33.0 | ... | 16.0–18.0 | 17.0–20.0 | 15.0–17.5 | 8.0–10.0 | 2.0–3.5 | 12.5–14.5 | 2.5–3.5 |
| Fe | 3.00 max | 3.50 max | 3.50 max | 3.50 max | 3.50 max | 3.50 max | 4.0–6.0 | 3.00 max | 11.0 max | 4.5–7.5 | 3.0 max | 2.0 max | 5.0 max | 2.0 max | 2.0–6.0 | balance |
| Ni | 95.00 min | balance | balance | balance | balance | balance | balance | balance | balance | balance | balance | balance | balance | balance | balance | 38.0–44.0 |
| Cr | ... | ... | ... | ... | ... | ... | 1.00 | 1.0 | 14.0–17.0 | 15.5–17.5 | 17.0–20.0 | 15.0–17.5 | 20.0–23.0 | 11.0–14.0 | 20.0–22.5 | 19.5–23.5 |
| Cb (Nb) | ... | 0.5 max | 0.5 max | ... | ... | 1.0–3.0 | ... | ... | ... | ... | ... | ... | 3.15–4.50 | ... | ... | 0.60–1.20 |
| W | ... | ... | ... | ... | ... | ... | ... | ... | ... | 3.75–5.25 | ... | 1.0 max | ... | ... | 2.5–3.5 | ... |
| V | ... | ... | ... | ... | ... | ... | 0.20–0.60 | ... | ... | 0.20–0.40 | ... | ... | ... | ... | 0.35 max | ... |
| Bi | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | 3.0–5.0 | ... | ... |
| Sn | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | 3.0–5.0 | ... | ... |

^A Order M-35-1 or M-30C when weldability is required.

TABLE 2 Heat Treat Requirements

| Grade | Heat Treatment |
|---|---|
| CZ-100, M-35-1, M-35-2, CY-40 Class 1, M-30H, M-30C, M-25S Class 1, CY5SnBiM M-25S, Class 2 ^A | As cast Load into furnace at 600°F [315°C] maximum. Heat to 1600°F [870°C] and hold for 1 h plus an additional 30 min for each ½ in. [13 mm] of cross section over 1 in. ^B Cool to 1300°F [705°C] ^C and hold at temperature for 30 min then quench in oil to room temperature. |
| M-25S, Class 3 | Load into furnace at 600°F [315°C] maximum. Heat slowly to 1100°F [605°C] and hold to develop maximum hardness. Furnace or air cool to room temperature. |
| N-12MV, N-7M | Heat to 2000°F [1095°C] minimum, hold for sufficient time to heat castings to temperature, quench in water or rapid cool by other means. |
| CW-12MW, CW-6M, CW-6MC, CW-2M | Heat to 2150°F [1175°C] minimum, hold for sufficient time to heat castings to temperature, quench in water or rapid cool by other means. |
| CY-40, Class 2 | Heat to 1900°F [1040°C] minimum, hold for sufficient time to heat castings to temperature, quench in water or rapid cool by other means. |
| CX2MW (N26022) | Heat to 2200°F [1205°C] minimum, hold for sufficient time to heat castings to temperature, quench in water or rapid air cool by other means. |
| CU5MCuC (N28820) | Heat to 2100°F [1150°C] minimum, hold for sufficient time to heat castings to temperature, quench in water. Stabilize at 1725–1815°F [940–990°C], hold for sufficient time to heat castings to temperature, quench in water or rapid cool by other means. |

^A M-25S, while machinable in the “as cast” condition, is capable of being solution treated for improved machinability. It may be subsequently age hardened to the hardness specified in Table 3 and finished machined or ground.

^B For cross sections over 6 in. [125 mm] it may be necessary to increase the hold time if maximum softness is desired.

^C For maximum softness and the least variation in hardness levels, castings should be transferred from an oven at 1600°F [870°C] to a second oven at 1300°F [705°C].

standards of acceptance.

6. Heat Treatment

6.1 Castings shall be heat treated in accordance with the requirements in Table 2.

NOTE 1—Proper heat treatment of these alloys is usually necessary to enhance corrosion resistance and, in some cases, to meet mechanical properties. Minimum heat treat temperatures are specified; however, it is sometimes necessary to heat treat at higher temperatures, hold for some minimum time at temperature, and then rapidly cool the castings in order to enhance the corrosion resistance and meet mechanical properties.

6.2 When Class 1 is specified, grades CY40 and M-25S shall be supplied in the as-cast condition. When Class 2 is specified, grades CY40 and M-25S shall be supplied in the solution-treated condition. When Class 3 is specified, grade M-25S shall be supplied in the age-hardened condition.

7. Chemical Composition

7.1 These alloys shall conform to the chemical composition

requirements prescribed in Table 1.

7.2 An analysis of each master heat shall be made by the manufacturer to determine the percentages of the elements specified in Table 1. The analysis shall be made from a representative sample taken during the pouring of the master heat. Chemical composition shall be reported to the purchaser or his representative.

7.3 Test Methods E 76 or Test Methods E 354 shall be used for referee purposes. Test Methods E 30 or Methods E 38 shall be used if Test Methods E 76 or Test Methods E 354 do not include a method for some element present in the material.

8. Tensile Properties

8.1 One tension test shall be made from each master heat except for grades M-25S and CY5SnBiM when the master heat is used to pour the castings. One tension test shall be made from each melt except for grades M-25S and CY5SnBiM. Test results shall conform to the tensile requirements specified in Table 3. Test bars shall be poured in special blocks from the

TABLE 3 Mechanical Properties

| | CZ-100 | M-35-1 | M-35-2 | M-30H | M-25S | M-30C | N-12MV | N-7M | CY-40 | CW-12MW | CW-6M | CW-2M | CW-6MC | CY5SnBiM | CX2MW (N26022) | CU5MCuC (N28820) |
|--|--------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------|----------|----------------|------------------|
| Tensile strength, min, psi [MPa] | 50 000 [345] | 65 000 [450] | 65 000 [450] | 100 00 [690] | ... | 65 000 [450] | 76 000 [525] | 76 000 [525] | 70 000 [485] | 72 000 [495] | 72 000 [495] | 72 000 [495] | 70 000 [485] | ... | 80 000 [550] | 75 000 [520] |
| Yield strength, min, psi [MPa] | 18 000 [125] | 25 000 [170] | 30 000 [205] | 60 000 [415] | ... | 32 500 [225] | 40 000 [275] | 40 000 [275] | 28 000 [195] | 40 000 [275] | 40 000 [275] | 40 000 [275] | 40 000 [275] | ... | 45 000 [280] | 35 000 [240] |
| Elongation in 2 in. [50 mm], ^A min, % | 10.0 | 25.0 | 25.0 | 10.0 | ... | 25.0 | 6.0 | 20.0 | 30.0 | 4.0 | 25.0 | 20.0 | 25.0 | ... | 30.0 | 20.0 |
| Hardness HB | ... | ... | ... | ... | ^B | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |

^A When ICI test bars are used in tensile testing as provided for in Specification A 732/A 732M, the gage length to reduced section diameter ratio shall be 4 to 1.

^B 300 HB minimum for the age hardened condition.

same heat as the castings represented.

8.2 The bar from which the test specimen is taken shall be heat treated in production furnaces to the same procedure as the castings it represents. If the castings are not heat treated, the bar used for the test specimen must not be heat treated.

8.3 Test specimens may be cut from castings, at the producer's option, instead of from test bars.

8.4 When castings are produced by methods other than investment process, tension test coupons shall be machined to the form and dimension shown in Fig. 8 of, and tested in accordance with, Test Methods E 8.

8.4.1 When castings are produced by the investment process, test specimens in accordance with Specification A 732/A 732M shall be used for measurement of tensile properties.

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

8.6 To determine conformance with the tension test requirements, an observed value or calculated value shall be rounded in accordance with Practice E 29 to the nearest 500 psi [3.5 MPa] for yield and tensile strength and to the nearest 1 % for elongation and reduction of area.

9. Workmanship, Finish, and Appearance

9.1 Critical surfaces of all castings intended for corrosion-resistant service shall be cleaned. Cleaning may be accomplished by blasting with clean sand or metallic corrosion-resistant shot or by other approved methods.

10. Quality

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

10.2 Internal chills and chaplets may be used in the manufacture of castings. However, the chills, chaplets and affected cast material must be completely removed.

11. Repair by Welding

11.1 Repairs shall be made by using a welding procedure and operators capable of producing sound welds. The composition of deposited weld metal shall be similar to that of the castings.

11.2 Weld repairs shall be considered major in the case of a casting that has leaked on hydrostatic test or when the depth of the cavity after preparation for repair exceeds 20 % of the

actual wall thickness, or 1 in. [25 mm], whichever is smaller, or when the extent of the cavity exceeds approximately 10 in.²[65 cm²]. All other weld repairs shall be considered minor. Major and minor weld repairs shall be subject to the same quality standards as are used to inspect the castings.

11.3 Castings of M-30H, M-25S, and CY5SnBiM may not be weld repaired.

11.4 Grades N-12MV, N-7M, CW-12MW, CW-6M, CW-2M, and CX2MW may require post weld heat treatment after major weld repairs. If post weld heat treatment is required, it must be specified along with the grade. If required, it shall be performed in accordance with Section 6.

11.5 For grade CU5MCuC, the composition of the deposited weld metal shall be similar to that of AWS A5.14 ER NiCrMo-3 (UNS N06625) or AWS A5.11 E NiCrMo-3 (UNS W86112).

12. Rejection and Rehearing

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

13. Product Marking

13.1 Castings shall be marked for the material identification with the ASTM specification designation (A 494/A 494M) and grade symbol, that is, CY-40. The manufacturer's name or identification mark and the pattern number shall be cast or stamped on all castings except those of such small size as to make such marking impractical. To minimize small defects caused by dislodged particles of molding sand, the number of cast identification marks shall be minimized. The marking of heat numbers on individual castings shall be agreed upon by the manufacturer and the purchaser. Markings shall be in such position as not to injure the usefulness of the casting.

13.1.1 When the castings are too small to mark individually, a symbol traceable to the heat shall be placed on the castings and the required identification then placed on a tag affixed to the container in which these castings are shipped.

14. Keywords

14.1 corrosion resistant applications; nickel; nickel alloy castings; nickel alloys; nickel castings