



Designation: B 93/B 93M – 03

Standard Specification for Magnesium Alloys in Ingot Form for Sand Castings, Permanent Mold Castings, and Die Castings¹

This standard is issued under the fixed designation B 93/B 93M; 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.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers magnesium alloys in ingot form for remelting for the manufacture of sand castings, permanent mold castings, investment castings, and die castings.

NOTE 1—Supplementary information pertaining to the alloys covered by this specification when used in the form of castings is given in Specifications B 80, B 94, B 199 and B 403.

1.2 The values stated in either inch-pound units or SI units are to be regarded separately as standard. The values stated in each system are not exact equivalents; therefore, each system shall be used independently of the other.

2. Referenced Documents

2.1 The following documents of the issue in effect on date of order acceptance form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards:*

B 275 Practice for Codification of Certain Nonferrous Metals and Alloys, Cast and Wrought²

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications³

E 35 Test Methods for Chemical Analysis of Magnesium and Magnesium Alloys⁴

E 88 Practice for Sampling Nonferrous Metals and Alloys in Cast Form for Determination of Chemical Composition⁴

E 527 Practice for Numbering Metals and Alloys (UNS)⁵

3. Ordering Information

3.1 Orders for ingot to this specification shall include the following information:

¹ This specification is under the jurisdiction of ASTM Committee B07 on Light Metals and Alloys and is the direct responsibility of Subcommittee B07.04 on Magnesium Alloy Cast and Wrought Products.

Current edition approved Aug. 10, 2003. Published September 2003. Originally approved in 1934. Last previous edition approved in 2000 as B 93/B 93M-00.

² *Annual Book of ASTM Standards*, Vol 02.02.

³ *Annual Book of ASTM Standards*, Vol 14.02.

⁴ *Annual Book of ASTM Standards*, Vol 03.05.

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

- 3.1.1 Quantity in pounds (kilograms)
- 3.1.2 Alloy (Section 4 and Table 1 or Table 2), and
- 3.1.3 Form: as agreed upon between the purchaser and seller. Some forms in commercial use are:

Form	Approximate Size Length by Width by Height, in. (mm)	Approximate Weight, lb (kg)
Five-segment	23 by 2¾ by 1¾ (583 by 70 by 44)	5 (2.3)
Four-segment	28 by 4½ by 4 (711 by 114 by 102)	20 (9.1)
Self-Palletizing	26½ by 6½ by 2¾ (672 by 168 by 67)	25 (11.3)

3.1.4 Inspection required at the manufacturer's works (see 8.1).

3.1.5 For inch-pound orders specify B93; for metric orders specify B93M. Do not mix units.

4. Chemical Composition

4.1 The ingots shall conform to the chemical composition limits prescribed in Table 1 for sand cast alloys and permanent mold-cast alloys and in Table 2 for die-cast alloys. Conformance shall be determined by the manufacturer by analyzing samples taken at the time the ingots are poured or samples taken from the ingots. If the manufacturer has determined the chemical composition of the material during manufacture, he shall not be required to sample and analyze the ingots.

4.2 The alloys shall conform to the chemical composition requirements prescribed in Table 1 and Table 2 (Note 2 and Note 3).

NOTE 2—Analysis shall regularly be made only for the elements specifically mentioned in the tables. If, however, the presence of other elements is suspected or indicated in the course of routine analysis, further analysis shall be made to determine that the total of these other elements is not in excess of the limits specified in the last column of the table.

NOTE 3—The following applies to all specified limits in the tables: For purposes of acceptance and rejection, an observed value or a calculated value obtained from analysis shall be rounded off in accordance with the rounding off method of Practice E 29 to the nearest unit in the last right-hand place of figures used in expressing the specified limit.

5. Workmanship, Finish and Appearance

5.1 The ingots shall be uniform in quality and shall be commercially free of slag or other foreign material.