



Designation: B386 – 03

Standard Specification for Molybdenum and Molybdenum Alloy Plate, Sheet, Strip, and Foil¹

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1. Scope

1.1 This specification covers unalloyed molybdenum and molybdenum alloy plate, sheet, strip, and foil as follows:

1.1.1 *Molybdenum 360*—Unalloyed vacuum arc-cast molybdenum.

1.1.2 *Molybdenum 361*—Unalloyed powder metallurgy molybdenum.

1.1.3 *Molybdenum Alloy 363*—Vacuum arc-cast molybdenum-0.5 % titanium-0.1 % zirconium (TZM) alloy.

1.1.4 *Molybdenum Alloy 364*—Powder metallurgy molybdenum-0.5 % titanium-0.1 % zirconium (TZM) alloy.

1.1.5 *Molybdenum 365*—Unalloyed vacuum arc-cast molybdenum, low carbon.

1.1.6 *Molybdenum Alloy 366*—Vacuum arc-cast molybdenum-30 % tungsten alloy.

1.1.7 *Drawing Grade*—A drawing grade is defined, which may be specified as a separate requirement by the purchaser.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

2. Referenced Documents

2.1 *ASTM Standards*:²

E8 Test Methods for Tension Testing of Metallic Materials

E345 Test Methods of Tension Testing of Metallic Foil

E643 Test Method for Ball Punch Deformation of Metallic Sheet Material

3. Descriptions of Terms Specific to This Standard

3.1 *Plate*—Any product $\frac{3}{16}$ in. or more in thickness.

¹ This specification is under the jurisdiction of ASTM Committee B10 on Reactive and Refractory Metals and Alloys and is the direct responsibility of Subcommittee B10.04 on Molybdenum and Tungsten.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

3.2 *Sheet*—Any product 0.187 in. (4.75 mm) or less in thickness, to a minimum of 0.005 in. (0.13 mm) in thickness.

3.2.1 *Standard Grade*—Sheet ordered without additional requirements imposed for applications which require drawing to make a product.

3.2.2 *Drawing Grade*—Sheet having thickness between 0.015 in. (0.38 mm) and 0.060 in. (1.52 mm), intended for applications which require drawing of the sheet to make a product.

3.3 *Strip*—Any product 0.187 in. (4.75 mm) or less in thickness and less than 5 in. (127 mm) in width.

3.4 *Foil*—Any product less than 0.005 in. (0.13 mm) in thickness.

4. Ordering Information

4.1 Orders for material under this specification shall include the following information as applicable:

4.1.1 Material number and temper designation (Section 1 and Table 1),

4.1.2 Product form and grade (Section 3),

4.1.3 Chemical requirements (Table 2 and Table 3),

4.1.4 Mechanical requirements (Section 7 and Table 1),

4.1.5 Softening temperature (Section 8),

4.1.6 Tolerances (Section 9, Table 4 and Fig. 1),

4.1.7 Workmanship and quality level requirements (Section 10),

4.1.8 Packaging (Section 16),

4.1.9 Marking (Section 15),

4.1.10 Certification and reports (Section 14), and

4.1.11 Disposition of rejected material (Section 13).

5. Materials and Manufacture

5.1 The various molybdenum mill products covered by this specification shall be formed with the conventional extrusion, forging, or rolling equipment normally found in primary ferrous and nonferrous plants. The ingot metal for Molybdenum 360 and 365 and Molybdenum Alloys 363 and 366 is vacuum arc-melted in furnaces of a type suitable for reactive,

TABLE 1 Mechanical Requirements

Type	Temper Condition ^A	Thickness, in. (mm)	Tensile ^B Strength, min, ksi (MPa)	Yield Strength 0.2 % Offset, min, ksi (MPa)	Elongation in 2 in. or 50 mm, min, %	Minimum Bend Radius
360, 361, 365	SR	to 0.001 (0.025)	115 (795)	95 (655)	1	...
		over 0.001 to 0.002 (0.025 to 0.05)	115 (795)	95 (655)	2	...
		over 0.002 to 0.003 (0.05 to 0.075)	115 (795)	95 (655)	3	...
		over 0.003 to 0.004 (0.075 to 0.1)	115 (795)	95 (655)	4	...
		0.005 to 0.010 (0.13 to 0.25)	110 (760)	90 (620)	5	2t ^C
		over 0.010 to 0.020 (0.25 to 0.5)	110 (760)	90 (620)	6	2t
		over 0.020 to 0.060 (0.5 to 1.5)	105 (725)	85 (585)	10	2t
		over 0.060 to 0.100 (1.5 to 2.5)	100 (690)	80 (550)	14	2t
		over 0.100 to 0.187 (2.5 to 4.75)	100 (690)	80 (550)	18	2t
		3/16 to 1/2 (4.75 to 12.7)	100 (690)	80 (550)	10	...
over 1/2 to 1 (12.7 to 25.4)	95 (655)	80 (550)	2 ^D	...		
over 1 to 1 1/2 (25.4 to 38)	95 (655)	80 (550)	1 ^D	...		
363, 364	SR	0.010 to 0.025 (0.25 to 0.635)	120 (830)	100 (690)	6	2t
		over 0.025 to 0.060 (0.635 to 1.5)	120 (830)	100 (690)	7	2t
		over 0.060 to 0.090 (1.5 to 2.3)	120 (830)	100 (690)	9	...
		over 0.090 to 0.187 (2.3 to 4.75)	120 (830)	100 (690)	10	...
		3/16 to 1/2 (4.75 to 12.7)	120 (830)	100 (690)	10	...
		over 1/2 to 1 (12.7 to 25.4)	110 (760)	95 (655)	10	...
over 1 to 1 1/2 (25.4 to 38)	100 (690)	85 (585)	8	...		
360	RX	3/16 to 1 1/2 (4.75 to 38)	55 (380)	25 (170)	20	...
363, 364	RX	3/16 to 1 1/2 (4.75 to 38)	75 (515)	45 (310)	10	...

^A SR = stress-relieved. RX = essentially fully recrystallized.

^B Both longitudinal and transverse tests between 65 and 85°F (18 and 29°C).

^C Material thickness = t.

^D Transverse elongation variable due to cross rolling limitations.

TABLE 2 Chemical Requirements

Element	Composition, %					
	Material Number					
	360	361	363	364	365	366
C	0.030 max	0.010 max	0.010–0.030	0.010–0.040	0.010 max	0.030 max
O, max ^A	0.0015	0.0070	0.0030	0.030	0.0015	0.0025
N, max ^A	0.002	0.002	0.002	0.002	0.002	0.002
Fe, max	0.010	0.010	0.010	0.010	0.010	0.010
Ni, max	0.002	0.005	0.002	0.005	0.002	0.002
Si, max	0.010	0.010	0.010	0.005	0.010	0.010
Ti	0.40–0.55	0.40–0.55
W	27–33
Zr	0.06–0.12	0.06–0.12
Mo	balance	balance	balance	balance	balance	balance

^A Pending approved methods of analysis, deviations from these limits alone shall not be cause for rejection.

TABLE 3 Permissible Variations in Check Analysis

	Material No.	Check Analysis Limits, max or range, %	Permissible Variations in Check Analysis, %
C	360, 363, 364, 366, 361, 365	0.010–0.040	±0.005
		0.010	±0.002
O ^A	361	0.0070	+10 % relative
		0.0030	+10 % relative
		0.030	+10 % relative
N ^A	361, 364, 365	0.0020	+0.0005
		0.0010	+0.0005
Fe	360, 361, 363, 364, 365, 366	0.010	+0.001
Ni	360, 361, 363, 364, 365, 366	0.005	+0.0005
Si	360, 361, 363, 364, 365, 366	0.010	+0.002
Ti	363, 364	0.40–0.55	±0.05
W	366	27.0–33.0	±1.0
Zr	363, 364	0.06–0.12	±0.02

^A See Table 2, Footnote^A

refractory metals and for Molybdenum 361 and Molybdenum Alloy 364, the metal is consolidated by powder metallurgy methods.

6. Chemical Composition

6.1 The molybdenum and molybdenum alloy ingots and billets for conversion to finished products covered by this specification shall conform to the requirements of the chemical composition prescribed in Table 2.

6.2 Check Analysis:

6.2.1 Check analysis is an analysis made by the purchaser or the manufacturer of the metal after it has been processed into finished mill forms, and is either for the purpose of verifying the composition of a heat or lot or to determine variations in the composition within a heat or lot.