



Designation: B 283 – 04

Standard Specification for Copper and Copper-Alloy Die Forgings (Hot-Pressed)¹

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

1. Scope*

1.1 This specification establishes the requirements for copper and copper alloy die forgings produced by the hot pressing method. The following copper and copper alloys are included:

Copper or Copper Alloy UNS No.	Name
C11000	copper
C14500	copper-tellurium
C14700	copper-sulfur
C36500	leaded Muntz metal
C37000	free-cutting Muntz metal
C37700	forging brass
C46400	naval brass
C48200	medium leaded naval brass
C48500	leaded naval brass
C61900	aluminum bronze
C62300	aluminum bronze, 9 %
C63000	aluminum-nickel bronze
C63200	aluminum-nickel bronze
C64200	aluminum-silicon bronze
C64210	aluminum-silicon bronze, 6.7 %
C65500	high-silicon bronze (A)
C67500	manganese bronze (A)
C67600	...
C70620	copper-nickel 90-10
C71520	copper-nickel 70-30
C77400	nickel silver, 45-10

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

NOTE 1—Nominal composition and relative forgeability ratings are given in **Appendix X1**. Copper-nickel alloys C70620 and C71520 are intended for welded applications with seawater exposure.

NOTE 2—Wrought product intended for hot forging is described in Specification **B 124/B 124M**.

1.3 The following safety caveat pertains only to Section 10 of this specification. *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.*

¹ This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.02 on Rod, Bar, Wire, Shapes, and Forgings.

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2. Referenced Documents

2.1 *ASTM Standards*:²

B 124/B 124M Specification for Copper and Copper Alloy Forging Rod, Bar, and Shapes

B 249/B 249M Specification for General Requirements for Wrought Copper and Copper Alloy Rod, Bar, Shapes and Forgings

B 846 Terminology for Copper and Copper Alloys

E 8 Test Methods for Tension Testing of Metallic Materials

E 62 Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Method)

E 75 Test Methods for Chemical Analysis of Copper-Nickel and Copper-Nickel-Zinc Alloys

E 478 Test Methods for Chemical Analysis of Copper Alloys

2.2 *ISO Standard*:

7602 Determination of Tellurium Content (High Content)—Flame Atomic Absorption Spectrometric Method³

2.3 *Military Standards*:

MIL-STD-792 Identification Marking Requirements for Special Purpose Components⁴

NAVSEA T9074-AS-GIB-010/271 Requirements for Non-destructive Testing Method⁴

3. General Requirements

3.1 The following sections of Specification **B 249/B 249M** constitute a part of this specification:

3.1.1 Terminology,

3.1.2 Materials and Manufacture,

3.1.3 Workmanship, Finish and Appearance,

3.1.4 Sampling,

3.1.5 Number of Tests and Retests,

3.1.6 Specimen Preparation,

3.1.7 Test Methods,

3.1.8 Significance of Numerical Limits,

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

⁴ Available from DODSSP, Bldg. 4/Sec. D, 700 Robbins Ave., Philadelphia, PA 19111-5098.

*A Summary of Changes section appears at the end of this standard.

- 3.1.9 Inspection,
- 3.1.10 Rejection and Reheating,
- 3.1.11 Certification,
- 3.1.12 Test Reports,
- 3.1.13 Packaging and Package Marking, and
- 3.1.14 Supplementary Requirements.

3.1.15 In addition, when a section with a title identical to one of those referenced in 3.1, above, appears in this specification, it contains additional requirements that supplement those appearing in Specification B 249/B 249M.

4. Terminology

4.1 Definitions:

4.1.1 For definitions of terms related to copper and copper alloys, refer to Terminology B 846.

4.2 Definition of Term Specific to This Standard:

4.2.1 *hot pressed forging, n*—a product made by pressing a heated blank or section of wrought or cast copper or copper alloy in a closed impression die.

5. Ordering Information

5.1 Include the following information when placing orders for products to this specification, as applicable:

5.1.1 ASTM designation and year of issue,

5.1.2 Copper or Copper Alloy UNS No. designation (Scope),

5.1.3 Drawing showing the shape dimensions and tolerances (Dimensions and Permissible Variations),

5.1.4 Temper (as specified herein),

5.1.5 Quantity: total weight or number of pieces for each form, temper, and copper or copper alloy,

5.1.6 When product is purchased for agencies of the U.S. government (as specified herein), and

5.1.7 When product must adhere to the requirements of ASME Boiler and Pressure Vessel Code (Mechanical Property Requirements).

5.2 The following requirements are optional and shall be specified in the contract or purchase order.

5.2.1 Certification (as specified herein and Supplementary Requirements),

5.2.2 Mill test report (as specified in B 249/B 249M), and

5.2.3 Ultrasonic inspection report (Supplementary Requirements).

6. Material and Manufacture

6.1 Materials:

6.1.1 The material of manufacture shall be a form of rods, billets, or blanks cut from cast or wrought material of one of the copper or copper alloys listed in the Scope of this specification and of purity and soundness as to be suitable for processing in to the products prescribed herein.

6.1.2 In the event heat identification or traceability is required, the purchaser shall specify the details desired.

NOTE 3—Due to the discontinuous nature of the processing of castings into wrought products, it is not always practical to identify specific casting analysis with a specific quantity of finished material.

6.2 Manufacture:

6.2.1 The product shall be manufactured by hot pressing material between the upper and lower sections of a set of dies conforming to the configuration defined by the purchaser's submitted drawings.

6.2.2 Product of Copper Alloy UNS No. C63000 and C63200 shall be heat treated (as specified herein).

7. Chemical Composition

7.1 The material shall conform to the chemical composition requirements in Table 1 for the Copper or Copper Alloy UNS No. designation specified in the ordering information.

7.2 These composition limits do not preclude the presence of other elements. By agreement between manufacturer and purchaser, limits may be established and analysis required for unnamed elements.

7.2.1 For alloys in which zinc is listed as a remainder, zinc is the difference between the sum of results for all elements determined and 100 %.

7.2.2 For alloys in which copper is listed as the remainder, copper is the difference between the sum of results of all elements determined and 100 %.

7.3 When all elements in Table 1 are determined for Copper Alloy UNS No. C36500, C37000, C46400, C48200, C48500, the sum of results shall be 99.6 % min, for all other alloys the sum of results shall be 99.5 % min.

8. Temper

8.1 The standard tempers for products described in this specification are as follows:

8.1.1 As hot forged-air cooled M10,

8.1.2 As forged-quenched M11,

8.1.3 Hot forged and annealed O20.

8.2 UNS Alloy Nos. C63000 and C63200 shall be furnished as:

8.2.1 Quench hardened and temper annealed, TQ50.

8.3 Alloys C70620 and C71520 shall be furnished in the following tempers:

8.3.1 As hot forged-air cooled M10, unless,

8.3.2 Hot forged and annealed O20 is specified.

8.4 Other tempers, shall be subjected to agreement between the manufacturer and the purchaser.

9. Mechanical Property Requirements

9.1 Mechanical property requirements are subject to agreement between the manufacturer and the purchaser.

9.2 Product furnished to this specification for UNS Alloy No. C70620 and C71520 and specified to meet the requirements of the ASME Boiler and Pressure Vessel Code shall conform to the tensile requirements prescribed in Table 2, when tested in accordance with Test Methods E 8.

9.2.1 Acceptance or rejection based upon mechanical properties for UNS Alloy No. C70620 and C71520 shall depend only on tensile strength.

10. Heat Treatment

10.1 Product produced from Copper Alloy UNS No. C63200 shall be heat treated as follows:

10.1.1 Heat to 1550°F (843°C) minimum for 1 h minimum and quench in water or other suitable medium.

TABLE 1 Chemical Requirements

Copper or Copper Alloy UNS No.	Composition, %												
	Copper	Lead	Tin	Iron	Nickel (incl Co)	Aluminum	Silicon	Manganese	Zinc	Sulfur	Tellurium	Phosphorus	Arsenic
C11000	99.90 ^A min
C14500 ^B	99.90 ^C min	0.40–0.7	0.004–0.012 ^D	...
C14700 ^B	99.90 ^E min	0.20–0.50	...	0.002–0.005 ^D	...
C36500	58.0–61.0	0.25–0.7	0.25 max	0.15 max	remainder
C37000	59.0–62.0	0.8–1.5	...	0.15 max	remainder
C37700	58.0–61.0	1.5–2.5	...	0.30 max	remainder
C46400	59.0–62.0	0.20 max	0.50–1.0	0.10 max	remainder
C48200	59.0–62.0	0.40–1.0	0.50–1.0	0.10 max	remainder
C48500	59.0–62.0	1.3–2.2	0.50–1.0	0.10 max	remainder
C61900	remainder	0.02 max	0.6 max	3.0–4.5 ^F	...	8.5–10.00	0.8 max
C62300	remainder	...	0.6 max	2.0–4.0	1.0 max	8.5–10.0	0.25 max	0.50 max
C63000	remainder	...	0.20 max	2.0–4.0	4.0–5.5	9.0–11.0	0.25 max	1.5 max	0.30 max
C63200	remainder	0.02 max	...	3.5–4.3 ^G	4.0–4.8	8.7–9.5	0.10 max	1.2–2.0
C64200	remainder	0.05 max	0.20 max	0.30 max	0.25 max	6.3–7.6	1.5–2.2	0.10 max	0.50 max	0.15 max
C64210	remainder	0.05 max	0.20 max	0.30 max	0.25 max	6.3–7.0	1.50–2.0	0.10 max	0.50 max	0.15 max
C65500	remainder	0.05 max	...	0.8 max	0.6 max	...	2.8–3.8	0.50–1.3	1.5 max
C67500	57.0–60.0	0.20 max	0.50–1.5	0.8–2.0	...	0.25 max	...	0.05–0.50	remainder
C67600	57.0–60.0	0.50–1.0	0.50–1.5	0.40–1.3	0.05–0.50	remainder
C70620 ^H	86.5 ^A min	0.02 max	...	1.0–1.8	9.0–11.0	1.0 max	0.50 max	0.02 max	...	0.02 max	...
C71520 ^H	65.0 ^A min	0.02 max	...	0.40–1.0	29.0–33.0	1.0 max	0.50 max	0.02 max	...	0.02 max	...
C77400	43.0–47.0	0.20 max	9.0–11.0	remainder

^A Silver counting as copper.

^B Includes oxygen-free or deoxidized grades with deoxidizers (such as phosphorus, boron, lithium, or others) in amount agreed upon.

^C This includes copper plus silver plus tellurium.

^D Other deoxidizers may be used as agreed upon, in which case phosphorus need not be present.

^E This includes copper plus silver plus sulfur plus phosphorus.

^F For boiler code application maximum iron content shall be 4.0 %.

^G Iron content shall not exceed nickel content.

^H Carbon shall be 0.05 % max.

TABLE 2 Tensile Requirements

Diameter or Section Thickness, in. (mm)	Temper Designation Standard Former	Tensile Strength, min		Yield Strength at 0.5 % Extension Under Load, min		Elongation in 4 × Diameter or Thickness of Specimen, min, %
		ksi	MPa ^A	ksi	MPa ^A	
Copper Alloy UNS No. C37700						
Up to 1½ (38.1), incl	M10 As Hot Forged–Air Cooled	50	345	18	124	25
Over 1½ (38.1)	M10 As Hot Forged–Air Cooled	46	317	15	103	30
Copper Alloy UNS No. C64200						
Up to 1½ (38.1), incl	M10 As Hot Forged–Air Cooled	70	483	25	172	30
Over 1½ (38.1)	M10 As Hot Forged–Air Cooled	68	469	23	156	35
Copper Alloy UNS Nos. C46400, C48200 and C48500						
All sizes	M10 As Hot Forged–Air Cooled	52	358	22	152	25
Copper Alloy UNS No. C70620						
Up to 6 (152.3), incl	M10 As Hot Forged–Air Cooled	45	310	18	124	30
Over 6 (152.3)	M10 As Hot Forged–Air Cooled	40	276	15	103	30
All sizes	O20 Hot Forged and Annealed	40	276	15	103	30
Copper Alloy UNS No. C71520						
Up to 6 (152.3), incl	M10 As Hot Forged – Air Cooled	50	345	20	138	30
Over 6 (152.3)	M10 As Hot Forged – Air Cooled	45	310	18	124	30
All sizes	O20 Hot Forged and Annealed	45	310	18	124	30

^A See Appendix X4.

10.1.2 Temper Anneal at 1300 ± 25°F (704 ± 14°C) for 3 to 9 h as required to meet mechanical properties.

11. Special Government Requirements

11.1 Product purchased for agencies of the U.S. government shall conform to the additional requirements prescribed in the Supplementary Requirements section of this specification.

12. Dimensions and Permissible Variations

12.1 The dimensions and tolerances for forgings shall be those agreed upon between the manufacturer and the purchaser, and such dimensions and tolerances shall be specified on the drawings which form a part of the contract or purchase order.

NOTE 4—Typical tolerances commonly used for forgings are shown in Table X2.1.

13. Test Methods

13.1 Chemical Analysis:

13.1.1 In case of disagreement, determine the composition using the following methods:

Element	ASTM Test Method
Aluminum	E 478
Arsenic	E 62
Copper	E 478
Iron	E 478, E 75 for CuNi
	E 478, E 75 for CuNi
Lead	E 478 (AA)
Manganese	E 62, E 75 for CuNi
Nickel	E 478 (photometric)
	E 478 (gravimetric)
Phosphorus	E 62

Silicon

Tin

Zinc

Tellurium

NOTE— < = less than; > = greater than

E 62 (perchloric acid)
E 478
E 478
E 478 (AA)
E 478 (titrimetric)
ISO Test Method
7602

13.1.2 Test method(s) to be followed for the determination of element(s) resulting from contractual or purchase order agreement shall be as agreed upon between the manufacturer or supplier and purchaser.

14. Certification

14.1 Certification to this specification is mandatory for product purchased for ASME Boiler and Pressure Vessel applications.

15. Keywords

15.1 copper and copper alloy die forgings (hot pressed); die forgings (hot pressed); UNS No. C11000; UNS No. C14500; UNS No. C14700; UNS No. C36500; UNS No. C37000; UNS No. C37700; UNS No. C46400; UNS No. C48200; UNS No. C48500; UNS No. C61900; UNS No. C62300; UNS No. C63000; UNS No. C63200; UNS No. C64200; UNS No. C64210; UNS No. C65500; UNS No. C67500; UNS No. C67600; UNS No. C70620; UNS No. C71520; UNS No. C77400