



Designation: A743/A743M – 06

Standard Specification for Castings, Iron-Chromium, Iron-Chromium-Nickel, Corrosion Resistant, for General Application¹

This standard is issued under the fixed designation A743/A743M; 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.

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

1. Scope*

1.1 This specification covers iron-chromium and iron-chromium-nickel alloy castings for general corrosion-resistant application. The grades covered by this specification represent types of alloy castings suitable for broad ranges of application which are intended for a wide variety of corrosion environments.

NOTE 1—For alloy castings for severe corrosion-resistant service, reference should be made to Specification A744/A744M. For general heat-resistant alloy castings, reference should be made to Specification A297/A297M. For nickel alloy castings for corrosion-resistant service, reference should be made to Specification A494/A494M.

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 A743 and SI units for material ordered to Specification A743M.

2. Referenced Documents

2.1 ASTM Standards:²

A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels

A297/A297M Specification for Steel Castings, Iron-Chromium and Iron-Chromium-Nickel, Heat Resistant, for General Application

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A494/A494M Specification for Castings, Nickel and Nickel Alloy

A744/A744M Specification for Castings, Iron-Chromium-Nickel, Corrosion Resistant, for Severe Service

A781/A781M Specification for Castings, Steel and Alloy, Common Requirements, for General Industrial Use

A890/A890M Specification for Castings, Iron-Chromium-Nickel-Molybdenum Corrosion-Resistant, Duplex (Austenitic/Ferritic) for General Application

A957 Specification for Investment Castings, Steel and Alloy, Common Requirements, for General Industrial Use

3. General Conditions for Delivery

3.1 Except for investment castings, castings furnished to this specification shall conform to the requirements of Specification A781/A781M, including any supplementary requirements that are indicated on the purchase order. Failure to comply with the general requirements of Specification A781/A781M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A781/A781M, this specification shall prevail.

3.2 Steel investment castings furnished to this specification shall conform to the requirements of Specification A957, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A957 constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A957, Specification A957 shall prevail.

4. Ordering Information

4.1 Orders for material to this specification should include the following, as required, to describe the material adequately:

4.1.1 Description of the casting by pattern number or drawing,

4.1.2 Grade,

4.1.3 Heat treatment,

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

Current edition approved March 1, 2006. Published March 2006. Originally approved in 1977. Last previous edition approved in 2003 as A743/A743M – 03. DOI: 10.1520/A0743_A0743M-06.

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.

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

- 4.1.4 Options in the specification,
- 4.1.5 Whether castings are to be produced using the investment casting process, and
- 4.1.6 Supplementary requirements desired, including the standards of acceptance.

5. Process

5.1 The steel shall be made by the electric furnace process with or without separate refining such as argon-oxygen decarburization (AOD).

6. Heat Treatment

6.1 Castings shall be heat treated in accordance with the requirements in **Table 1**.

NOTE 2—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.

7. Chemical Requirements

7.1 The chemical requirements are shown in **Table 2**

TABLE 1 Heat Treatment Requirements

Grade	Heat Treatment
CF8, CG3M, CG8M, CG12, CF20, CF8M, CF8C, CF16F, CF16Fa, CH10, CH20, CE30, CK20	Heat to 1900°F [1040°C] minimum, hold for sufficient time to heat casting to temperature, quench in water or rapid cool by other means.
CA15, CA15M, CA40, CA40F	Heat to 2000°F [1093°C] minimum, hold for sufficient time to heat casting to temperature, quench in water or rapid cool by other means.
CB30, CC50	(1) Heat to 1750°F [955°C] minimum, air cool and temper at 1100°F [595°C] minimum, or (2) Anneal at 1450°F [790°C] minimum.
CF3, CF3M, CF3MN	(1) Heat to 1450°F [790°C] minimum, and air cool, or (2) Heat to 1450°F [790°C] minimum, and furnace cool.
CN3M	(1) Heat to 1900°F [1040°C] minimum, hold for sufficient time to heat casting to temperature, and cool rapidly. (2) As cast if corrosion resistance is acceptable.
CN3MN	Heat to 2150°F [1175°C] minimum, hold for sufficient time to heat casting to temperature, quench in water or rapid cool by other means.
CN7M, CG6MMN	Heat to 2100°F [1150°C] minimum, hold for sufficient time to heat casting to temperature, quench in water or rapid cool by other means.
CN7MS	Heat to 2050°F [1120°C] minimum, hold for sufficient time to heat casting to temperature, quench in water or rapid cool by other means.
CA6NM	Heat to 2100°F [1150°C] minimum, 2150°F [1180°C] maximum, hold for sufficient time (2 h minimum) to heat casting to temperature and quench in water.
CA6N	Heat to 1850°F [1010°C] minimum, air cool to 200°F [95°C] or lower prior to any optional intermediate temper and prior to the final temper. The final temper shall be between 1050°F [565°C] and 1150°F [620°C].
CF10SMnN	Heat to 1900°F [1040°C], air cool, reheat to 1500°F [815°C], air cool, and age at 800°F [425°C], holding at each temperature sufficient time to heat casting uniformly to temperature.
CA28MWV	Heat to 1950°F [1065°C] minimum, hold for sufficient time to heat casting to temperature, quench in water or rapid cool by other means.
CK3MCuN	(1) Heat to 1875–1925°F [1025–1050°C], quench in air or oil, and temper at 1150°F [620°C] minimum, or (2) Anneal at 1400°F [760°C] minimum.
CK35MN	Heat to 2100°F [1150°C] minimum, hold for sufficient time to heat casting to temperature, quench in water or rapid cool by other means.
CB6	Heat to 2100–2190°F [1150–1200°C], hold for sufficient time to heat casting to temperature, quench in water or rapid cool by other means.
	Heat between 1800°F [980°C] and 1920°F [1050°C], forced air, cool to 120°F [50°C] maximum, and temper between 1100°F and 1160°F [595°C and 625°C].

TABLE 2 Chemical Requirements

Grade (UNS)	Type	Composition, %													
		Carbon, max	Manganese, max	Silicon, max	Phosphorus, max	Sulfur, max	Chromium	Nickel	Molybdenum	Columbium	Selenium	Copper	Tungsten, max	Vanadium, max	Nitrogen
CF8 (J92600)	19 Chromium,	0.08	1.50	2.00	0.04	0.04	18.0–21.0	8.0–
	9 Nickel							11.0							
CG12 (J93001)	22 Chromium,	0.12	1.50	2.00	0.04	0.04	20.0–23.0	10.0–
	12 Nickel							13.0							
CF20 (J92602)	19 Chromium,	0.20	1.50	2.00	0.04	0.04	18.0–21.0	8.0–
	9 Nickel							11.0							
CF8M (J92900)	19 Chromium,	0.08	1.50	2.00	0.04	0.04	18.0–21.0	9.0–	2.0–3.0



TABLE 2 Continued

Grade (UNS)	Type	Composition, %													
		Carbon, max	Man- ganese, max	Silicon, max	Phospho- rus, max	Sulfur, max	Chromium	Nickel	Molybde- num	Colum- bium	Sele- nium	Copper	Tung- sten, max	Vana- dium, max	Nitrogen
CF8C (J92710)	10 Nickel, with Molybdenum	0.08	1.50	2.00	0.04	0.04	18.0–21.0	12.0	...	A	
	19 Chromium,							9.0–							
CF16F (J92701)	10 Nickel, with Columbium	0.16	1.50	2.00	0.17	0.04	18.0–21.0	12.0	1.50 max	...	0.20–	
	19 Chromium,							9.0–							
CF16Fa	9 Nickel, Free Machining	0.16	1.50	2.00	0.04	0.20– 0.40	18.0–21.0	12.0	0.40–0.80	...	0.35	
	19 Chromium, 9 Nickel, Free Machining							9.0– 12.0							
CH10 (J93401)	25 Chromium,	0.10	1.50	2.00	0.04	0.04	22.0–26.0	12.0–	
CH20 (J93402)	12 Nickel	0.20	1.50	2.00	0.04	0.04	22.0–26.0	15.0	
	25 Chromium,							12.0–							
CK20 (J94202)	12 Nickel	0.20	2.00	2.00	0.04	0.04	23.0–27.0	15.0	
	25 Chromium,							19.0–							
CE30 (J93423)	20 Nickel	0.30	1.50	2.00	0.04	0.04	26.0–30.0	22.0	
	29 Chromium,							8.0–							
CA15 (J91150)	9 Nickel	0.15	1.00	1.50	0.04	0.04	11.5–14.0	11.0	0.50 max	
	12 Chromium							1.00							
CA15M (J91151)	12 Chromium	0.15	1.00	0.65	0.040	0.040	11.5–14.0	max 1.0	0.15–1.0	
								2.00							
CB30 (J91803)	20 Chromium	0.30	1.00	1.50	0.04	0.04	18.0–21.0	max 2.00	B	
								4.00							
CC50 (J92615)	28 Chromium	0.50	1.00	1.50	0.04	0.04	26.0–30.0	max 4.00	
								1.0							
CA40 (J91153)	12 Chromium	0.20–	1.00	1.50	0.04	0.04	11.5–14.0	max 1.0	0.5 max	
		0.40													
CA40F (J91154)	12 Chromium,	0.20–	1.00	1.50	0.04	0.20–	11.5–14.0	max 1.0	0.5 max	
		0.40													
CF3 (J92500)	Free Machining	0.40	1.50	2.00	0.04	0.40	17.0–21.0	max 8.0–	
	19 Chromium,	0.03													
CF10SMnN (J92972)	9 Nickel	0.10	7.00–	3.50–	0.060	0.030	16.0–18.0	12.0	0.08–	
	17 Chromium, 8.5 Nickel with Nitrogen		9.00												
CF3M (J92800)	19 Chromium,	0.03	1.50	1.50	0.04	0.04	17.0–21.0	9.0–	2.0–3.0	
	10 Nickel, with Molybdenum	0.03	1.50	1.50	0.040	0.040	17.0–22.0	13.0	2.0–3.0	0.10–	
19 Chromium, 10 Nickel, with Molybdenum, and Nitrogen	9.0– 13.0														
CG6MMN (J93790)	19 Chromium,	0.06	4.00–	1.00	0.04	0.03	20.5–23.5	11.5–	1.50–3.00	0.10–	0.10–	0.20–	
	11 Nickel, with Molybdenum		6.00				18.0–21.0	13.5		0.30			0.30	0.40	
CG3M (J92999)	19 Chromium,	0.03	1.50	1.50	0.04	0.04	18.0–21.0	9.0–	3.0–4.0	
	11 Nickel, with Molybdenum							9.0– 13.0							
CG8M (J93000)	19 Chromium,	0.08	1.50	1.50	0.04	0.04	18.0–21.0	9.0–	3.0–4.0	
	11 Nickel, with Molybdenum							13.0							
CN3M (J94652)	19 Chromium,	0.03	2.0	1.0	0.03	0.03	20.0–22.0	23.0–	4.5–5.5	
	11 Nickel, with Molybdenum							27.0							