



Designation: **B584-06** Designation: **B 584 – 06a**

Standard Specification for Copper Alloy Sand Castings for General Applications¹

This standard is issued under the fixed designation B 584; 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 requirements for copper alloy sand castings for general applications. Nominal compositions of the alloys defined by this specification are shown in Table 1.² This is a composite specification replacing former documents as shown in Table 1.

NOTE 1—Other copper alloy castings are included in the following ASTM specifications: B 22, B 61, B 62, B 66, B 67, B 148, B 176, B 271, B 369, B 427, B 505/B 505M, B 763, B 770, and B 806.

1.2 Component part castings produced to this specification may be manufactured in advance and supplied from stock. In such cases the manufacturer shall maintain a general quality certification of all castings without specific record or date of casting for a specific casting.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are provided for information purposes only.

2. Referenced Documents

2.1 ASTM Standards:³

- B 22 Specification for Bronze Castings for Bridges and Turntables
- B 61 Specification for Steam or Valve Bronze Castings
- B 62 Specification for Composition Bronze or Ounce Metal Castings
- B 66 Specification for Bronze Castings for Steam Locomotive Wearing Parts
- B 67 Specification for Car and Tender Journal Bearings, Lined
- B 148 Specification for Aluminum-Bronze Sand Castings
- B 176 Specification for Copper-Alloy Die Castings
- B 208 Practice for Preparing Tension Test Specimens for Copper Alloy Sand, Permanent Mold, Centrifugal, and Continuous Castings
- B 271 Specification for Copper-Base Alloy Centrifugal Castings
- B 369 Specification for Copper-Nickel Alloy Castings
- B 427 Specification for Gear Bronze Alloy Castings
- B 505/B 505M Specification for Copper Alloy Continuous Castings
- B 763 Specification for Copper Alloy Sand Castings for Valve Applications
- B 770 Specification for Copper-Beryllium Alloy Sand Castings for General Applications
- B 806 Specification for Copper Alloy Permanent Mold Castings for General Applications
- B 824 Specification for General Requirements for Copper Alloy Castings
- B 846 Terminology for Copper and Copper Alloys
- E 255 Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition
- E 527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

2.2 ASME Code:

ASME Boiler and Pressure Vessel Code⁴

¹ This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.05 on Castings and Ingots for Remelting.

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² The UNS system for copper and copper alloys (see Practice E 527) is a simple expansion of the former standard designation system accomplished by the addition of a prefix “C” and a suffix “00”. The suffix can be used to accommodate composition variations of the base alloy.

³ 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.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990.

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

TABLE 1 Nominal Compositions

Classification	Copper Alloy UNS No.	Previous Designation	Commercial Designation	Copper	Tin	Lead	Zinc	Nickel	Iron	Alum-inum	Man-ganese	Sili-con	Nio-bium	Bis-muth
Leaded red brass	C83450	88	2½	2	6½	1
	C83600	B 145-4A	85-5-5-5 or No. 1 composition	85	5	5	5
	C83800	B 145-4B	commercial red brass, 83-4-6-7	83	4	6	7
Leaded semi-red brass	C84400	B 145-5A	valve composition, 81-3-7-9	81	3	7	9
	C84800	B 145-5B	semi-red brass, 76-2½-6½-15	76	2½	6½	15
Leaded yellow brass	C85200	B 146-6A	high-copper yellow brass	72	1	3	24
	C85400	B 146-6B	commercial No. 1 yellow brass	67	1	3	29
	C85700	B 146-6C	leaded naval brass	61	1	1	37
High-strength yellow brass	C86200	B 147-8B	high-strength manganese bronze	63	27	...	3	4	3
	C86300	B 147-8C	high-strength manganese bronze	61	27	...	3	6	3
	C86400	B 147-7A	leaded manganese bronze	58	1	1	38	...	1	½	½
	C86400	B 132-A
	C86500	B 147-8A	No. 1 manganese bronze	58	39	...	1	1	1
Silicon bronze + silicon brass	C86700	B 132-B	leaded manganese bronze	58	1	1	34	...	2	2	2
	C87300	B 198-12A	silicon bronze	95	1	4
	C87400	B 198-13A	silicon brass	82	...	½	14	3½
	C87500	B 198-13B	silicon brass	82	14	4
	C87600	B 198-13C	silicon bronze	91	5	4
	C87610	B 198-12A	silicon bronze	92	4	4
	C87850 ^A	...	silicon brass	76	20.9	3
	C89510 ^A	...	sebiloy I	87	5	...	5	1.0
	C89520 ^B	...	sebiloy II	86	5½	...	5	1.9
	C89520 ^C	...	sebiloy II	86	5½	...	5	1.9
Bismuth red brass	C89833	...	bismuth brass	89	5	...	3	2.2
	C89836	...	lead-free bronze	89.5	5.5	...	3.0	2
Bismuth semi-red brass	C89844	...	bismuth brass	84½	4	...	8	3
	C90300	B 143-1B	modified "G" bronze, 88-8-0-4	88	8	...	4
Tin bronze + leaded tin bronze	C90500	B 143-1A	"G" bronze, 88-10-0-2	88	10	...	2
	C92200	B 143-2A	steam or valve bronze-Navy "M"	88	6	1½	4½
	C92210	88	5	2	4	1
	C92300	B 143-2B	87-5-1-4, Navy PC	87	8	1	4
	C92600	B 143-1A	87-10-1-2	87	10	1	2
	C93200	B 144-3B	83-7-7-3	83	7	7	3
	C93500	B 144-3C	85-5-9-1	85	5	9	1
High-lead tin bronze	C93700	B 144-3A	80-10-10	80	10	10
	C93800	B 144-3D	78-7-15	78	7	15
	C94300	B 144-3E	71-5-24	71	5	24
	C94700	B 292-A	nickel-tin bronze Grade "A"	88	5	...	2	5
	C94800	B 292-B	leaded nickel-tin bronze Grade "B"	87	5	1	2	5
Spinodal alloy	C94900	...	leaded nickel-tin bronze Grade "C"	80	5	5	5	5
	C96800	82	8	10	0.2
Leaded nickel bronze	C97300	B 149-10A	12 % leaded nickel silver	57	2	9	20	12
	C97600	B 149-11A	20 % leaded nickel silver	64	4	4	8	20
	C97800	B 149-11B	25 % leaded nickel silver	66	5	2	2	25

^ASelenium 0.512.

^BSelenium 0.5.

^CSelenium 0.9.

3. Terminology

3.1 Definitions of terms relating to copper alloys can be found in Terminology B 846.

4. General Requirements

4.1 The following sections of Specification B 824 form a part of this specification. In the event of a conflict between this specification and Specification B 824, the requirements of this specification shall take precedence.

4.1.1 Terminology,

4.1.2 Other Requirements,

4.1.3 Dimensions, Mass, and Permissible Variations,

- 4.1.4 Workmanship, Finish, and Appearance,
- 4.1.5 Sampling,
- 4.1.6 Number of Tests and Retests,
- 4.1.7 Specimen Preparation,
- 4.1.8 Test Methods,
- 4.1.9 Significance of Numerical Limits,
- 4.1.10 Inspection,
- 4.1.11 Rejection and Rehearing,
- 4.1.12 Certification,
- 4.1.13 Test Report,
- 4.1.14 Product Marking,
- 4.1.15 Packaging and Package Marking, and
- 4.1.16 Supplementary Requirements.

5. Ordering Information

- 5.1 Orders for castings under this specification should include the following information:
 - 5.1.1 Specification title, number, and year of issue,
 - 5.1.2 Quantity of castings,
 - 5.1.3 Copper alloy UNS Number (Table 1) and temper (as-cast, heat treated, and so forth),
 - 5.1.4 Pattern or drawing number, and condition (as-cast, machined, etc.),
 - 5.1.5 *ASME Boiler and Pressure Vessel Code*—compliance (Section 10),
 - 5.1.6 When material is purchased for agencies of the U.S. government, the Supplementary Requirements of Specification B 824 may be specified.
- 5.2 The following options are available and should be specified in the purchase order when required:
 - 5.2.1 Chemical analysis of residual elements (7.3),
 - 5.2.2 Pressure test or soundness requirements (Specification B 824),
 - 5.2.3 Approval of weld repair or impregnation, or both (Section 9),
 - 5.2.4 Certification (Specification B 824),
 - 5.2.5 Foundry test report (Specification B 824),
 - 5.2.6 Witness inspection (Specification B 824), and
 - 5.2.7 Product marking (Specification B 824).

6. Manufacture

- 6.1 Copper alloy UNS Nos. C94700 and C96800 may be supplied in the heat treated condition to obtain the higher mechanical properties shown in Table 2. Suggested heat treatments for these alloys are given in Table 3. Actual practice may vary by manufacturer.
- 6.2 Separately cast test bar coupons representing castings made in copper alloy UNS Nos. C94700HT and C96800HT shall be heat treated with the castings.

7. Chemical Composition

- 7.1 The castings shall conform to the compositional requirements for named elements as shown in Table 4 for the copper alloy UNS numbers specified in the purchase order.
- 7.2 These specification limits do not preclude the presence of other elements. Limits may be established and analysis required for unnamed elements agreed upon between manufacturer or supplier and purchaser. Copper or zinc, when zinc is 20 % or greater, may be given as remainder and may be taken as the difference between the sum of all elements analyzed and 100 %. When all named elements in Table 4 are analyzed, their sum shall be as specified in Table 5.
- 7.3 It is recognized that residual elements may be present in cast copper alloys. Analysis shall be made for residual elements only when specified in the purchase order.

8. Mechanical Properties

- 8.1 Mechanical properties shall be determined from separately cast test bar castings, and shall meet the requirements shown in Table 2.

9. Casting Repair

- 9.1 The castings shall not be weld repaired without approval of the purchaser (5.2.3).
- 9.2 The castings shall not be impregnated without approval of the purchaser (5.2.3).

10. ASME Requirements

- 10.1 When specified in the purchase order to meet ASME Boiler and Pressure Vessel Code requirements, castings in copper alloy UNS Nos. C92200, C93700, and C97600 shall comply with the following: