



Designation: B93/B93M – 07

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 B93/B93M; 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 B80, B94, B199 and B403.

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.

1.3 *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.*

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:*²

- B80 Specification for Magnesium-Alloy Sand Castings
- B94 Specification for Magnesium-Alloy Die Castings
- B199 Specification for Magnesium-Alloy Permanent Mold Castings
- B403 Specification for Magnesium-Alloy Investment Castings
- B951 Practice for Codification of Unalloyed Magnesium and Magnesium-Alloys, Cast and Wrought
- E29 Practice for Using Significant Digits in Test Data to

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.

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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.

Determine Conformance with Specifications

- E35 Test Methods for Chemical Analysis of Magnesium and Magnesium Alloys³
- E88 Practice for Sampling Nonferrous Metals and Alloys in Cast Form for Determination of Chemical Composition
- E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

3. Ordering Information

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

- 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 1¼ (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 6¾ 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

³ Withdrawn. The last approved version of this historical standard is referenced on www.astm.org.

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

TABLE 1 Chemical Requirements for Alloy Ingot for Remelt to Sand, Permanent, Mold and Investment Castings—Composition %

Alloy ^A ASTM	UNS	Magnesium	Aluminum	Copper, max	Gadolinium	Iron, max	Lithium, max	Manganese	Neodymium	Nickel, max	Rare Earths	Silicon, max	Silver	Yttrium	Zinc	Zirconium	Others each max ^B	Total Others, max ^B
AM100A	M10101	remainder	9.4–10.6	0.08	0.13–0.35	...	0.010	...	0.20	0.2 max	0.30
AZ63A	M11631	remainder	5.5–6.5	0.20	0.15–0.35	...	0.010	...	0.20	2.7–3.3	0.30
AZ81A	M11811	remainder	7.2–8.0	0.08	0.15–0.35	...	0.010	...	0.20	0.5–0.9	0.30
AZ91C	M11915	remainder	8.3–9.2	0.08	0.15–0.35	...	0.010	...	0.20	0.45–0.9	0.30
AZ91E	M11918	remainder	8.3–9.2	0.015	...	0.005	...	0.17–0.50	...	0.0010	...	0.20	0.45–0.9	...	0.01	0.30
AZ92A	M11921	remainder	8.5–9.5	0.20	0.13–0.35	...	0.010	...	0.20	1.7–2.3	0.30
EQ21A	M18330	remainder	...	0.05–0.10	0.01	1.5–3.0 ^C	0.01	1.3–1.7	0.3–1.0	...	0.30
EV31A ^D	M12311	remainder	...	0.01 max	1.0–1.7	0.010	2.6–3.1	0.0020	0.4 ^E	...	0.05 max	...	0.20–0.50	0.3–1.0	0.01	...
EZ33A	M12331	remainder	...	0.03	0.010	2.6–3.9 ^F	0.01	2.0–3.0	0.3–1.0	...	0.30
K1A	M18011	remainder	...	0.03	0.010	...	0.01	0.3–1.0	...	0.30
QE22A	M18221	remainder	...	0.03	0.15 max	...	0.010	1.9–2.4 ^C	0.01	2.0–3.0	...	0.2 max	0.3–1.0	...	0.30
WE43A	M18431	remainder	...	0.03	0.18	0.15 max	2.0–2.5	0.005	2.4–4.4 ^G	0.01	...	3.7–4.3	0.20 max	0.3–1.0	...	0.30
WE43B	M18433	remainder	...	0.01	0.18	0.03 max	2.0–2.5	0.004	2.4–4.4 ^G	3.7–4.3	...	0.3–1.0	0.01	...
WE54A	M18410	remainder	...	0.03	0.20	0.15 max	1.5–2.0	0.005	1.5–4.0 ^G	0.01	...	4.75–5.5	0.20 max	0.3–1.0	...	0.30
ZC63A	M16331	remainder	...	2.4–3.00	0.25–0.75	...	0.001	...	0.20	5.5–6.5	0.30
ZE41A	M16411	remainder	...	0.03	0.15 max	...	0.010	1.0–1.75 ^F	0.01	3.7–4.8	0.3–1.0	...	0.30
ZE63A	M16631	remainder	...	0.03	0.010	2.0–3.0	0.01	5.5–6.0	0.3–1.0	...	0.30
ZK51A	M16511	remainder	...	0.03	0.010	...	0.01	3.8–5.3	0.3–1.0	...	0.30
ZK61A	M16611	remainder	...	0.03	0.010	...	0.01	5.7–6.3	0.3–1.0	...	0.30

^A These alloy designations were established in accordance with Practice B951. UNS designations were established in accordance with Practice E527.

^B Includes listed elements for which no specific limit is shown.

^C Rare earth elements are in the form of Didymium, not less than 70 % Neodymium balance substantially Praseodymium.

^D Alloy EV31A is a patented composition, suitable for elevated temperature applications. Interested parties are invited to submit information regarding the identification of alternatives to these compositions to ASTM International. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this specification. Users of this specification are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

^E Other Rare Earths may also be present to a total maximum of 0.4 %. These Rare Earths shall principally be Cerium, Lanthanum, and Praseodymium.

^F Total Rare Earths (TRE) are principally a mixture of Cerium, Lanthanum, Neodymium, and Praseodymium. The Cerium content should not be less than 45% of TRE.

^G Other Rare Earths shall be principally heavy rare earths, such as, Gadolinium, Dysprosium, Erbium, and Ytterbium. Other Rare Earths are derived from the Yttrium, typically 80 %, and 20 % heavy rare earths.

^H Zinc + Silver shall be 0.15 % max.

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 E29 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.

6. Sampling for Chemical Analysis

6.1 Sufficient samples shall be taken by the manufacturer to ensure conformance to the chemical composition requirement of the alloy.

6.1.1 Samples may be taken from the molten metal when the ingot is poured or from the ingots. Samples shall be representative of the material.

6.2 In case of dispute, the sampling for chemical analysis shall be according to the requirements of Practice E88.

6.2.1 If the shipment is in less than carload lots and also in the case of magnesium-zirconium alloys, one ingot section shall be taken for sampling for each 2200 lb (1000 kg) or fraction thereof.

7. Methods of Chemical Analysis

7.1 Any suitable method of chemical analysis may be used. In case of dispute, the analysis shall be made by methods given

in Test Methods E35 or any other standard methods of analysis approved by ASTM unless some other method is agreed upon between the purchaser and vendor.

8. Inspection

8.1 If the purchaser desires that inspection be made at the manufacturer's works where the material is made, it shall be so stated in the contract or purchase order.

8.1.1 If the purchaser elects to have the inspection made at the manufacturer's works, the manufacturer shall afford the inspector representing the purchaser all reasonable facilities to satisfy him that the material is being furnished in accordance with this specification.

8.1.2 All tests and inspection shall be so conducted as not to interfere unnecessarily with the operation of the works.

9. Rejection

9.1 Material that does not conform to the requirements of this specification may be rejected and, if rejected, the seller's responsibility shall be limited to replacing the rejected material. The full weight of the rejected material shall be returned to the manufacturer.

10. Product Marking

10.1 Identification shall be by stamping with the alloy designation in Table 1 and Table 2.

11. Packaging and Package Marking

11.1 Ingots shall be packaged in such a manner as to prevent damage in ordinary handling and transportation. The type of