



Designation: B26/B26M – 09

Standard Specification for Aluminum-Alloy Sand Castings¹

This standard is issued under the fixed designation B26/B26M; 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 specification² covers aluminum-alloy sand castings designated as shown in [Table 1](#).

1.2 This specification is not intended for aluminum-alloy sand castings used in aerospace applications.

1.3 Alloy and temper designations are in accordance with ANSI H35.1/H35.1M. Unified Numbering System alloy designations are in accordance with Practice [E527](#).

1.4 Unless the order specifies the “M” specification designation, the material shall be furnished to the inch-pound units.

1.5 For acceptance criteria for inclusion of new aluminum and aluminum alloys and their properties in this specification, see [Annex A1](#) and [Annex A2](#).

1.6 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.7 *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 material purchase form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards*:³

[B179](#) Specification for Aluminum Alloys in Ingot and Molten Forms for Castings from All Casting Processes

¹ This specification is under the jurisdiction of ASTM Committee [B07](#) on Light Metals and Alloys and is the direct responsibility of Subcommittee [B07.01](#) on Aluminum Alloy Ingots and Castings.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-26/SB-26M in Section II of that Code.

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.

[B275](#) Practice for Codification of Certain Nonferrous Metals and Alloys, Cast and Wrought

[B557](#) Test Methods for Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products

[B557M](#) Test Methods for Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products (Metric)

[B660](#) Practices for Packaging/Packing of Aluminum and Magnesium Products

[B881](#) Terminology Relating to Aluminum- and Magnesium-Alloy Products

[B917/B917M](#) Practice for Heat Treatment of Aluminum-Alloy Castings from All Processes

[D3951](#) Practice for Commercial Packaging

[E29](#) Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

[E34](#) Test Methods for Chemical Analysis of Aluminum and Aluminum-Base Alloys

[E94](#) Guide for Radiographic Examination

[E155](#) Reference Radiographs for Inspection of Aluminum and Magnesium Castings

[E165](#) Practice for Liquid Penetrant Examination for General Industry

[E527](#) Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

[E607](#) Test Method for Atomic Emission Spectrometric Analysis Aluminum Alloys by the Point to Plane Technique Nitrogen Atmosphere

[E716](#) Practices for Sampling Aluminum and Aluminum Alloys for Spectrochemical Analysis

[E1251](#) Test Method for Analysis of Aluminum and Aluminum Alloys by Atomic Emission Spectrometry

[IEEE/ASTM SI 10](#) Standard for Use of the International System of Units (SI): The Modern Metric System

2.3 *AMS Standard*:⁴

[AMS 2771](#) Heat Treatment of Aluminum Alloy Castings

2.4 *American National Standards*:⁵

[H35.1/H35.1\(M\)](#) Alloy and Temper Designation System for Aluminum

⁴ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

⁵ Available from Aluminum Association, Inc., 1525 Wilson Blvd., Suite 600, Arlington, VA 22209, <http://www.aluminum.org/bookstore>.

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

TABLE 1 Chemical Composition Limits

NOTE 1—When single units are shown, these indicate the maximum amounts permitted.

NOTE 2—Analysis shall be made for the elements for which limits are shown in this table.

NOTE 3—The following applies to all specified limits in this table: For purposes of determining conformance to these limits, an observed value or a calculated value obtained from analysis shall be rounded to the nearest unit in the last right-hand place of figures used in expressing the specified limit in accordance with the rounding method of Practice E29.

Alloy		Aluminum	Composition, (Values in Weight Percent)										Others	
ANSI	UNS		Silicon	Iron	Copper	Man-ganese	Magne-sium	Chromium	Nickel	Zinc	Tin	Titanium	Each	Total
201.0	A02010	remainder	0.10	0.15	4.0–5.2	0.20–0.50	0.15–0.55	0.15–0.35	0.05 ^A	0.10
204.0	A02040	remainder	0.20	0.35	4.2–5.0	0.10	0.15–0.35	...	0.05	0.10	0.05	0.15–0.30	0.05	0.15
242.0	A02420	remainder	0.7	1.0	3.7–4.5	0.35	1.2–1.8	0.25	1.7–2.3	0.35	...	0.25	0.05	0.15
A242.0	A12420	remainder	0.6	0.8	3.7–4.5	0.10	1.2–1.7	0.15–0.25	1.8–2.3	0.10	...	0.07–0.20	0.05	0.15
295.0	A02950	remainder	0.7–1.5	1.0	4.0–5.0	0.35	0.03	0.35	...	0.25	0.05	0.15
319.0	A03190	remainder	5.5–6.5	1.0	3.0–4.0	0.50	0.10	...	0.35	1.0	...	0.25	...	0.50
328.0	A03280	remainder	7.5–8.5	1.0	1.0–2.0	0.20–0.6	0.20–0.6	0.35	0.25	1.5	...	0.25	...	0.50
355.0	A03550	remainder	4.5–5.5	0.6 ^B	1.0–1.5	0.50 ^B	0.40–0.6	0.25	...	0.35	...	0.25	0.05	0.15
C355.0	A33550	remainder	4.5–5.5	0.20	1.0–1.5	0.10	0.40–0.6	0.10	...	0.20	0.05	0.15
356.0	A03560	remainder	6.5–7.5	0.6 ^B	0.25	0.35 ^B	0.20–0.45	0.35	...	0.25	0.05	0.15
A356.0	A13560	remainder	6.5–7.5	0.20	0.20	0.10	0.25–0.45	0.10	...	0.20	0.05	0.15
443.0	A04430	remainder	4.5–6.0	0.8	0.6	0.50	0.05	0.25	...	0.50	...	0.25	...	0.35
B443.0	A24430	remainder	4.5–6.0	0.8	0.15	0.35	0.05	0.35	...	0.25	0.05	0.15
512.0	A05120	remainder	1.4–2.2	0.6	0.35	0.8	3.5–4.5	0.25	...	0.35	...	0.25	0.05	0.15
514.0	A05140	remainder	0.35	0.50	0.15	0.35	3.5–4.5	0.15	...	0.25	0.05	0.15
520.0	A05200	remainder	0.25	0.30	0.25	0.15	9.5–10.6	0.15	...	0.25	0.05	0.15
535.0	A05350	remainder	0.15	0.15	0.05	0.10–0.25	6.2–7.5	0.10–0.25	0.05 ^C	0.15
705.0	A07050	remainder	0.20	0.8	0.20	0.40–0.6	1.4–1.8	0.20–0.40	...	2.7–3.3	...	0.25	0.05	0.15
707.0	A07070	remainder	0.20	0.8	0.20	0.40–0.6	1.8–2.4	0.20–0.40	...	4.0–4.5	...	0.25	0.05	0.15
710.0 ^D	A07100	remainder	0.15	0.50	0.35–0.65	0.05	0.6–0.8	6.0–7.0	...	0.25	0.05	0.15
712.0 ^D	A07120	remainder	0.30	0.50	0.25	0.10	0.50–0.65	0.40–0.6	...	5.0–6.5	...	0.15–0.25	0.05	0.20
713.0	A07130	remainder	0.25	1.1	0.40–1.0	0.6	0.20–0.50	0.35	0.15	7.0–8.0	...	0.25	0.10	0.25
771.0	A07710	remainder	0.15	0.15	0.10	0.10	0.8–1.0	0.06–0.20	...	6.5–7.5	...	0.10–0.20	0.05	0.15
850.0	A08500	remainder	0.7	0.7	0.7–1.3	0.10	0.10	...	0.7–1.3	...	5.5–7.0	0.20	...	0.30
851.0 ^D	A08510	remainder	2.0–3.0	0.7	0.7–1.3	0.10	0.10	...	0.30–0.7	...	5.5–7.0	0.20	...	0.30
852.0 ^D	A08520	remainder	0.40	0.7	1.7–2.3	0.10	0.6–0.9	...	0.9–1.5	...	5.5–7.0	0.20	...	0.30

^A Contains silver 0.40–1.0 %.

^B If iron exceeds 0.45 %, manganese content shall not be less than one half of the iron content.

^C Contains beryllium 0.003–0.007 %, boron 0.005 % max.

^D 710.0 formerly A712.0, 712.0 formerly D712.0, 851.0 formerly A850.0, 852.0 formerly B850.0.

2.5 Military Standards:⁶

MIL-STD-129 Marking for Shipment and Storage

MIL-STD-276 Impregnation of Porous Nonferrous Metal Castings

NAVSEA Technical Publication S9074-AR-GIB-010/278

2.6 Federal Standard:⁶

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)

2.7 Other Standards:⁷

EN 14242 Aluminum and Aluminum Alloys — Chemical Analysis — Inductively Coupled Plasma Optical Emission Spectral Analysis

3. Terminology

3.1 *Definitions*—Refer to Terminology B881 for definitions of product terms used in this specification.

3.2 *sand casting*—a metal object produced by pouring molten metal into a sand mold and allowing it to solidify.

4. Ordering Information

4.1 Orders for material under this specification shall include the following information (1.4 and 1.5):

4.1.1 This specification designation (which includes the number, year, and revision letter, if applicable),

NOTE 1—For inch-pound application, specify Specification B26 and for metric application specify Specification B26M. Do not mix units.

4.1.2 The quantity in either pieces or pounds [kilograms],

4.1.3 Alloy (Section 7 and Table 1),

4.1.4 Temper (Section 10 and Table 2), and

4.1.5 Applicable drawing or part number,

4.2 Additionally, orders for material to this specification shall include the following information when required by the purchaser:

4.2.1 Whether chemical analysis and tensile property reports are required (Table 1 and Table 2),

4.2.2 Whether castings or test bars, or both, may be artificially aged for Alloys 705.0-T5, 707.0-T5, 712.0-T5, and 713.0-T5 (10.2) and whether yield strength tests are required for these alloys;

4.2.3 Whether test specimens cut from castings are required in addition to, or instead of, separately cast specimens (Sections 10 and 13);

4.2.4 Whether repairs are permissible (16.1),

4.2.5 Whether inspection is required at the producer's works (Section 18);

4.2.6 Whether certification is required (21.1);

⁶ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.

⁷ Available from European Committee for Standardization (CEN), 36 rue de Stassart, B-1050, Brussels, Belgium, <http://www.cenorm.be>.

TABLE 2 Tensile Requirements^A (Inch-Pound Units)

NOTE 1—For purposes of determining conformance with this specification, each value for tensile strength and yield strength shall be rounded to the nearest 0.1 ksi and each value for elongation shall be rounded to the nearest 0.5 %, both in accordance with the rounding method of Practice E29.

Alloy		Temper ^B	Tensile Strength, min, ksi	Yield Strength (0.2 % offset), min, ksi	Elongation in 2 in. or 4 x diameter, min, %	Typical Brinell Hard- ness, ^C 500 kgf, 10 mm
ANSI ^D	UNS					
201.0	A02010	T7	60.0	50.0	3.0	...
204.0	A02040	T4	45.0	28.0	6.0	...
242.0	A02420	O ^E	23.0	F	F	70
		T61	32.0	20.0	F	105
A242.0	A12420	T75	29.0	F	1.0	75
295.0	A02950	T4	29.0	13.0	6.0	60
		T6	32.0	20.0	3.0	75
		T62	36.0	28.0	F	95
		T7	29.0	16.0	3.0	70
319.0	A03190	F	23.0	13.0	1.5	70
		T5	25.0	F	F	80
		T6	31.0	20.0	1.5	80
328.0	A03280	F	25.0	14.0	1.0	60
		T6	34.0	21.0	1.0	80
355.0	A03550	T6	32.0	20.0	2.0	80
		T51	25.0	18.0	F	65
		T71	30.0	22.0	F	75
C355.0	A33550	T6	36.0	25.0	2.5	...
356.0	A03560	F	19.0	9.5	2.0	55
		T6	30.0	20.0	3.0	70
		T7	31.0	F	F	75
		T51	23.0	16.0	F	60
		T71	25.0	18.0	3.0	60
A356.0	A13560	T6	34.0	24.0	3.5	80
		T61	35.0	26.0	1.0	...
443.0	A04430	F	17.0	7.0	3.0	40
B443.0	A24430	F	17.0	6.0	3.0	40
512.0	A05120	F	17.0	10.0	...	50
514.0	A05140	F	22.0	9.0	6.0	50
520.0	A05200	T4	42.0	22.0	12.0	75
535.0	A05350	F	35.0	18.0	9.0	70
705.0	A07050	T5	30.0	17.0 ^G	5.0	65
707.0	A07070	T7	37.0	30.0 ^G	1.0	80
710.0 ^H	A07100	T5	32.0	20.0	2.0	75
712.0 ^H	A07120	T5	34.0	25.0 ^G	4.0	75
713.0	A07130	T5	32.0	22.0	3.0	75
771.0	A07710	T5	42.0	38.0	1.5	100
		T51	32.0	27.0	3.0	85
		T52	36.0	30.0	1.5	85
		T6	42.0	35.0	5.0	90
		T71	48.0	45.0	2.0	120
850.0	A08500	T5	16.0	F	5.0	45
851.0 ^H	A08510	T5	17.0	F	3.0	45
852.0 ^H	A08520	T5	24.0	18.0	F	60

^A If agreed upon between the manufacturer and the purchaser, other mechanical properties may be obtained by other heat treatments such as annealing, aging, or stress relieving.

^B Refer to ANSI H35.1/H35.1M, or both, for description of tempers.

^C For information only, not required for acceptance.

^D ASTM alloy designations are recorded in Practice B275.

^E Formerly designated as 222.0-T2 and 242.0-T21.

^F Not required.

^G Yield strength to be determined only when specified in the contract or purchase order.

^H 710.0 formerly A712.0, 712.0 formerly D712.0, 851.0 formerly A850.0, 852.0 formerly B850.0.

4.2.7 Whether surface requirements shall be checked against observational standards where such standards are established (19.1);

4.2.8 Whether liquid penetrant inspection is required (19.2);

4.2.9 Whether radiographic inspection is required (19.3);

4.2.10 Whether foundry control is required (Section 9); and

4.2.11 Whether Practice B660 applies and, if so, the levels of preservation, packaging, and packing required (23.4).

5. Quality Assurance

5.1 Unless otherwise specified in the contract or purchase order, the producer shall be responsible for the performance of

all inspections and test requirements specified herein. Unless disapproved by the purchaser, the producer may use his own or any other suitable facilities for the performance of the inspection and test requirements specified herein. The purchaser shall have the right to perform any of the inspections and tests set forth in this specification where such inspections are deemed necessary to confirm that the material conforms to prescribed requirements.

6. Manufacture

6.1 The responsibility of furnishing castings that can be laid out and machined to the finished dimensions within the

permissible variations specified, as shown on the blueprints or drawings, shall rest with the producer, except where pattern equipment is furnished by the purchaser.

7. Chemical Composition

7.1 The Product shall conform to the chemical composition limits prescribed in **Table 1**. Conformance shall be determined by the producer by taking samples at the time castings are poured in accordance with Practice **E716** and analyzed in accordance with Test Methods **E607**, **E1251**, or **E34**, or **EN 14242**. If the producer has determined the composition of the material during casting, they shall not be required to sample and analyze the finished product.

7.2 If it becomes necessary to analyze castings for conformance to chemical composition limits, the method used to sample castings for the determination of chemical composition shall be by agreement between the producer and the purchaser. Analysis shall be performed in accordance with Practice **E716**, Test Methods **E607**, **E1251**, or **E34**, or **EN 14242** (ICP method).

7.3 Other methods of analysis or in the case of a dispute the method of analysis shall be agreed upon by the producer and the purchaser.

7.4 A sample for determining of chemical composition shall be taken to represent the following:

7.4.1 Not more than 4000 lb [2000 kg] of clean castings (gates and risers removed) or a single casting poured from one furnace.

7.4.2 The maximum elapsed time between determinations shall be established for each alloy, but in any case the maximum elapsed time shall not exceed 8 h.

8. Material Requirements—Castings Produced for Governmental and Military Agencies

8.1 Unless otherwise specified, only aluminum alloy conforming to the requirements of Specification **B179** or producer's foundry scrap (identified as being made from alloy conforming to Specification **B179**) shall be used in the remelting furnace from which molten metal is taken for pouring directly into castings. Additions of small amounts of modifiers and grain refining elements or alloys are permitted.

8.1.1 Pure materials, recycled materials, and master alloys may be used to make alloys conforming to this specification, provided chemical analysis can be taken and adjusted to conform to **Table 1** prior to pouring any castings.

9. Foundry Control—Castings Produced for Governmental or Military Agencies, or Both

9.1 When specified, castings shall be produced under foundry control approved by the purchaser. Foundry control shall consist of examination of castings by radiographic or other approved methods for determining internal discontinuities until the gating, pouring, and other foundry practices have been established to produce castings meeting the quality standards furnished by the purchaser or agreed upon between the purchaser and the producer. When foundry practices have been so established, the production method shall not be significantly changed without demonstrating to the satisfaction

of the purchaser that the change does not adversely affect the quality of the castings. Minor changes in pouring temperature of $\pm 50^{\circ}\text{F}$ [$\pm 28^{\circ}\text{C}$] from the established nominal temperature are permissible.

10. Tensile Properties

10.1 The separately cast test specimens representing the castings shall meet the mechanical properties prescribed in **Table 2**.

10.2 Although Alloys 705.0, 707.0, 712.0, and 713.0 are most frequently used in the naturally aged condition, by agreement between the producer and the purchaser, the castings may be artificially aged to the T5 temper. The producer and the purchaser may also agree to base the acceptance of castings on artificially aged test bars. The conditions of artificial aging shown in Practice **B917/B917M** shall be employed unless other conditions are accepted by mutual consent.

10.3 When specified, the tensile strength, yield strength, and elongation values of specimens cut from castings shall be not less than 75 % of the tensile and yield strength values and not less than 25 % of the elongation values specified in **Table 2** [**Table 3**]. The measurement of the elongation is not required for test specimens cut from castings if 25 % of the specified minimum elongation value published in **Table 2** [**Table 3**] is 0.5 % or less. If grade D quality castings as described in **Table 4** are specified, no tensile tests shall be specified nor tensile requirements be met on specimens cut from castings.

11. Workmanship, Finish, and Appearance

11.1 The finished castings shall be uniform in composition and free of blowholes, cracks, shrinks, and other discontinuities except as designated and agreed upon as acceptable by the purchaser.

12. Number of Tests and Retests

12.1 Unless otherwise agreed upon between the purchaser and producer, a minimum of two tension test specimens shall be separately cast and tested to represent the following:

12.1.1 Not more than 4000 lb [2000 kg] of clean castings (gates and risers removed) or a single casting poured from one furnace.

12.1.2 The castings poured continuously from one furnace in not more than eight consecutive hours.

12.2 When tensile properties from castings are to be determined, one per melt-heat combination shall be tested unless otherwise shown on the drawing or specified in the purchase order.

12.3 If any test specimen shows defective machining or flaws, it may be discarded; in which case the purchaser and the producer shall agree upon the selection of another specimen in its stead.

12.4 If the results of the tension tests do not conform to the requirements prescribed in **Table 2** [**Table 3**]; the test bars representative of the castings may be retested in accordance with the replacement tests and retest provisions of Test Methods **B557** and **B557M**, and the results of retests shall conform to the requirements as to mechanical properties specified in **Table 2** [**Table 3**].

TABLE 3 Tensile Requirements (SI Units)—[Metric]^A

NOTE 1—For purposes of determining conformance with this specification, each value for tensile strength and yield strength shall be rounded to the nearest 1 MPa and each value for elongation shall be rounded to the nearest 0.5 %, both in accordance with the rounding method of Practice E29.

Alloy		Temper ^B	Tensile Strength, min, MPa ^C	Yield Strength (0.2 % offset), min, MPa ^C	Elongation in 5× diameter, min %	Typical Brinell Hardness, ^D 500 kgf, 10 mm
ANSI ^E	UNS					
201.0	A02010	T7	415	345	3.0	...
204.0	A02040	T4	310	195	6.0	...
242.0	A02420	O ^F	160	^G	^G	70
		T61	220	140	^G	105
A242.0	A12420	T75	200	^G	1.0	75
295.0	A02950	T4	200	90	6.0	60
		T6	220	140	3.0	75
		T62	250	195	^G	95
		T7	200	110	3.0	70
319.0	A03190	F	160	90	1.5	70
		T5	170	^G	^G	80
		T6	215	140	1.5	80
328.0	A03280	F	170	95	1.0	60
		T6	235	145	1.0	80
355.0	A03550	T6	220	140	2.0	80
		T51	170	125	^G	65
		T71	205	150	^G	75
C355.0	A33550	T6	250	170	2.5	...
356.0	A03560	F	130	65	2.0	55
		T6	205	140	3.0	70
		T7	215	^G	^G	75
		T51	160	110	^G	60
		T71	170	125	3.0	60
A356.0	A13560	T6	235	165	3.5	80
		T61	245	180	1.0	...
443.0	A04430	F	115	50	3.0	40
B443.0	A24430	F	115	40	3.0	40
512.0	A05120	F	115	70	...	50
514.0	A05140	F	150	60	6.0	50
520.0	A05200	T4	290	150	12.0	75
535.0	A05350	F	240	125	9.0	70
705.0	A07050	T5	205	115 ^H	5.0	65
707.0	A07070	T7	255	205 ^H	1.0	80
710.0 ^I	A07100	T5	220	140	2.0	75
712.0 ^I	A07120	T5	235	170 ^H	4.0	75
713.0	A07130	T5	220	150	3.0	75
771.0	A07710	T5	290	260	1.5	100
		T51	220	185	3.0	85
		T52	250	205	1.5	85
		T6	290	240	5.0	90
		T71	330	310	2.0	120
850.0	A08500	T5	110	^G	5.0	45
851.0 ^I	A08510	T5	115	^G	3.0	45
852.0 ^I	A08520	T5	165	125	^G	60

^A If agreed upon between the manufacturer and the purchaser, other mechanical properties may be obtained by other heat treatments such as annealing, aging, or stress relieving.

^B Temper designations:

F As fabricated.

O Annealed.

T1 Cooled from an elevated temperature shaping process and naturally aged to a substantially stable condition.

T4 Solution heat-treated and naturally aged to a substantially stable condition.

T5 Cooled from an elevated temperature shaping process and then artificially aged.

T6 Solution heat-treated and then artificially aged.

T7 Solution heat-treated and stabilized.

Additional digits, the first of which shall not be zero, may be added to designation T1 through T10 to indicate a variation in treatment that significantly alters the characteristics of the product.

^C For explanation of the SI unit "MPa" see Appendix X2.

^D For information only, not required for acceptance.

^E ASTM alloy designations are recorded in Practice B275.

^F Formerly designated as 222.0-T2 and 242.0-T21.

^G Not required.

^H Yield strength to be determined only when specified in the contract or purchase order.

^I 710.0 formerly A712.0, 712.0 formerly D712.0, 851.0 formerly A850.0, 852.0 formerly B850.0.

TABLE 4 Discontinuity-Level Requirements for Aluminum Sand Castings (Reference Radiographs E155)

Discontinuity	Radiograph	Section Thickness in. [mm]							
		Grade A ^A		Grade B		Grade C		Grade D	
		1/4 [6.4]	3/4 [19.0]	1/4 [6.4]	3/4 [19.0]	1/4 [6.4]	3/4 [19.0]	1/4 [6.4]	3/4 [19.0]
Gas holes	1.1	none		1	1	2	2	5	5
Gas porosity (round)	1.21	none		1	1	3	3	7	7
Gas porosity (elongated)	1.22	none		1	1	3	4	5	5
Shrinkage cavity	2.1	none		1	B	2	B	3	B
Shrinkage porosity or sponge	2.2	none		1	1	2	2	4	3
Foreign material (less dense material)	3.11	none		1	1	2	2	4	4
Foreign material (more dense material)	3.12	none		1	1	2	1	4	3
Segregation	3.2	none		none		none		none	
Cracks	...	none		none		none		none	
Cold shuts	...	none		none		none		none	
Surface irregularity		not to exceed drawing tolerance		not to exceed drawing tolerance	
Core shift		not to exceed drawing tolerance		not to exceed drawing tolerance	

^A Caution should be exercised in requesting Grade A.

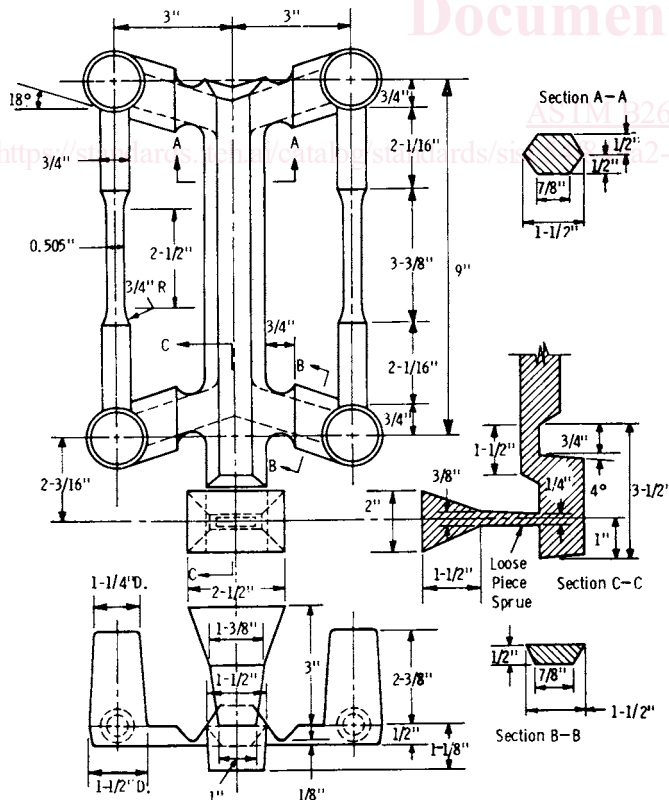
^B Not available.

13. Specimen Preparation

13.1 The tension test specimens shall be cast to size in sand without chills in accordance with the dimensions shown in Fig. 1 [Fig. 2]. They shall not be machined prior to test except to adapt the grip ends in such a manner as to ensure axial loading.

13.2 The recommended method for casting tension test specimens is shown in Fig. 1 [Fig. 2].

13.3 When properties of castings are to be determined, tension test specimens shall be cut from the locations designated on the drawing, unless otherwise negotiated. If no locations are designated, one or more specimens shall be taken to include locations having significant variation in casting



NOTE 1—1 in. = 25.4 mm.
FIG. 1 Tension Test Specimen Casting

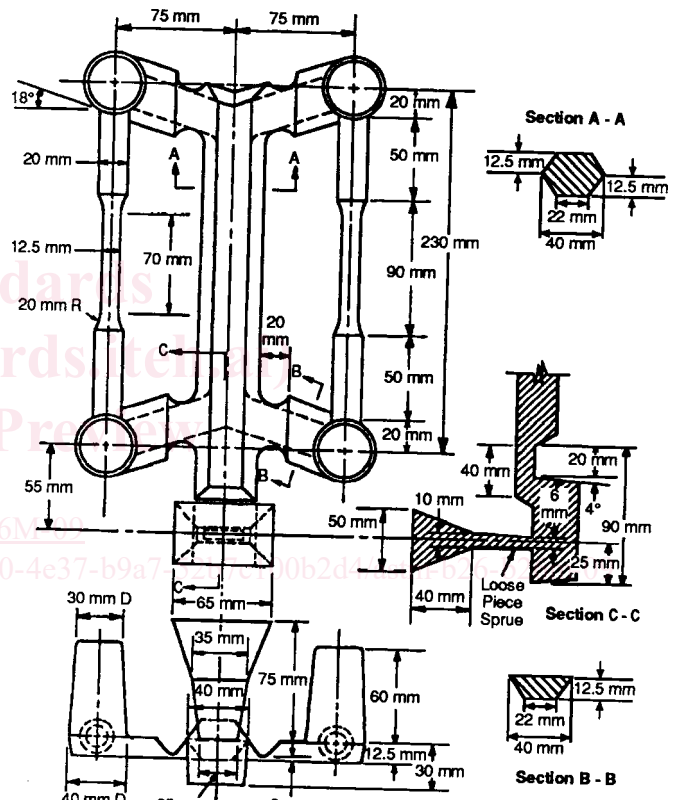


FIG. 2 Tension Test Specimen Casting [Metric]

thickness, except that specimens shall not be taken from areas directly under risers. The tension test specimens shall be the standard 0.500-in. [12.5-mm] diameter specimens shown in Fig. 9 of Test Methods B557 and B557M or a round specimen of smaller size proportional to the standard specimen.

	in.	mm
Diameter of reduced section	0.250	6.00
Length of reduced section	1 1/4	36
Gage length	1.000	30.00
Radius of fillet	3/16	6
Diameter of end section	3/8	9
Overall length:		
With shouldered ends	2 3/8	60
With threaded ends	3	75