



**Designation: E353 – 93 (Reapproved 2006) E353 – 14**

# Standard Test Methods for Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys<sup>1</sup>

This standard is issued under the fixed designation E353; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope

1.1 These test methods cover the chemical analysis of stainless, heat-resisting, maraging, and other similar chromium-nickel-iron alloys having chemical compositions within the following limits:

—Element Element	Concentration Range, % Composition Range, %	
Aluminum	0.002	to 5.50
Boron	0.001	to 0.20
Carbon	0.01	to 1.50
Chromium	0.01	to 35.00
Cobalt	0.01	to 15.00
Columbium (Niobium)	<del>0.01</del>	<del>to 4.00</del>
Niobium	<u>0.01</u>	<u>to 4.00</u>
Copper	0.01	to 5.00
Lead	0.001	to 0.50
Manganese	0.01	to 20.00
Molybdenum	0.01	to 7.00
Nickel	0.01	to 48.00
Nitrogen	0.001	to 0.50
Phosphorus	0.002	to 0.35
Selenium	0.01	to 0.50
Silicon	0.01	to 4.00
Sulfur	0.002	to 0.50
Tantalum	0.01	to 0.80
Tin	0.001	to 0.05
Titanium	0.01	to 4.50
Tungsten	0.01	to 4.50
Vanadium	0.005	to 1.00
Zirconium	0.001	to 0.20

1.2 The test methods in this standard are contained in the sections indicated below:

	Sections
Aluminum, Total, by the 8-Quinolinol Gravimetric Method (0.20 to 7.00%)	119
Aluminum, Total, by the 8-Quinolinol Photometric Method (0.003 to 0.20%)	74
Carbon, Total, by the Combustion—Thermal Conductivity Method	<sup>a</sup>
Carbon, Total, by the Combustion Gravimetric Method (0.05 to 1.50%)	98
Chromium by the Atomic Absorption Method (0.006 to 1.00%)	202
Chromium by the Peroxydisulfate Oxidation—Titration Method (0.10 to 35.00%)	242
Chromium by the Peroxydisulfate Oxidation Titrimetric Method	<sup>b</sup>
Cobalt by the Ion-Exchange—Potentiometric Titration Method (2 to 15.%)	53
Cobalt by the Nitroso-R Salt Photometric Method (0.01 to 5.0%)	61
Copper by the Neocuproine Photometric Method (0.01 to 5.00%)	109
Copper by the Sulfide Precipitation-Electrodeposition Gravimetric Method (0.01 to 5.00%)	82
Lead by the Ion-Exchange—Atomic Absorption Method (0.001 to 0.50%)	127

<sup>1</sup> These test methods are under the jurisdiction of ASTM Committee E01 on Analytical Chemistry for Metals, Ores, and Related Materials and are the direct responsibility of Subcommittee E01.01 on Iron, Steel, and Ferroalloys.

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Manganese by the Periodate-Photometric Method (0.01 to 5.00 %)	8
Molybdenum by the Ion-Exchange—8-Hydroxyquinoline-Gravimetric Method	242
Molybdenum by the Photometric Method (0.01 to 1.50 %)	190
Nickel by the Dimethylglyoxime-Gravimetric Method (0.1 to 48.0 %)	172
Phosphorus by the Alkalimetric Method (0.02 to 0.35 %)	164
Phosphorus by the Molybdenum-Blue-Photometric Method (0.002 to 0.35 %)	18
Silicon by the Gravimetric Method (0.05 to 4.00 %)	46
Sulfur by the Gravimetric Method	e
Sulfur by the Combustion-Iodate-Titration Method (0.005 to 0.5 %)	37
Sulfur by the Chromatographic-Gravimetric Method	b
Tin by the Solvent-Extraction—Atomic-Absorption Method (0.002 to 0.10 %)	180
Tin by the Sulfide-Iodometric-Titration Method (0.01 to 0.05 %)	90
Titanium, Total, by the Diantiprylmethane-Spectrophotometric Method (0.01 to 0.35 %)	231
Vanadium by the Atomic-Absorption Method (0.006 to 0.15 %)	221

Sections

Aluminum, Total, by the 8-Quinolinol Gravimetric Method (0.20 % to 7.00 %)	119
Aluminum, Total, by the 8-Quinolinol Spectrophotometric Method (0.003 % to 0.20 %)	71
Carbon, Total, by the Combustion-Thermal Conductivity Method	Discontinued
Carbon, Total, by the Combustion Gravimetric Method (0.05 % to 1.50 %)	Discontinued
Chromium by the Atomic Absorption Method (0.006 % to 1.00 %)	202
Chromium by the Peroxydisulfate Oxidation—Titration Method (0.10 % to 35.00 %)	212
Chromium by the Peroxydisulfate-Oxidation Titrimetric Method	Discontinued
Cobalt by the Ion-Exchange—Potentiometric Titration Method (2 % to 15 %)	53
Cobalt by the Nitroso-R-Salt Spectrophotometric Method (0.01 % to 5.0 %)	61
Copper by the Neocuproine Spectrophotometric Method (0.01 % to 5.00 %)	109
Copper by the Sulfide Precipitation-Electrodeposition Gravimetric Method (0.01 % to 5.00 %)	82
Lead by the Ion-Exchange-Atomic Absorption Method (0.001 % to 0.50 %)	127
Manganese by the Periodate Spectrophotometric Method (0.01 % to 5.00 %)	8
Molybdenum by the Ion-Exchange—8-Hydroxyquinoline Gravimetric Method	242
Molybdenum by the Spectrophotometric Method (0.01 % to 1.50 %)	190
Nickel by the Dimethylglyoxime Gravimetric Method (0.1 % to 48.0 %)	172
Phosphorus by the Alkalimetric Method (0.02 % to 0.35 %)	164
Phosphorus by the Molybdenum-Blue Spectrophotometric Method (0.002 % to 0.35 %)	18
Silicon by the Gravimetric Method (0.05 % to 4.00 %)	46
Sulfur by the Gravimetric Method	Discontinued
Sulfur by the Combustion-Iodate Titration Method (0.005 % to 0.5 %)	Discontinued
Sulfur by the Chromatographic Gravimetric Method	Discontinued
Tin by the Solvent-Extraction—Atomic Absorption Method (0.002 % to 0.10 %)	180
Tin by the Sulfide-Iodometric Titration Method (0.01 % to 0.05 %)	90
Titanium, Total, by the Diantiprylmethane Spectrophotometric Method (0.01 % to 0.35 %)	231
Vanadium by the Atomic Absorption Method (0.006 % to 0.15 %)	221

1.3 Test methods for the determination of several elements—carbon and sulfur not included in this standard can be found in Test Methods E30 and Test Methods E1019.

1.4 Some of the concentration/composition ranges given in 1.1 are too broad to be covered by a single test method and therefore this standard contains multiple test methods for some elements. The user must select the proper test method by matching the information given in the Scope and Interference sections of each method with the composition of the alloy to be analyzed.

1.5 The values stated in SI units are to be regarded as standard. In some cases, exceptions allowed in Practice E380 are also used.

1.6 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. Specific hazards statements are given in Section 56 and in special “Warning” paragraphs throughout these test methods.

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>2</sup>

D1193 Specification for Reagent Water

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

<sup>2</sup> 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.

- ~~E30 Test Methods for Chemical Analysis of Steel, Cast Iron, Open-Hearth Iron, and Wrought Iron (Withdrawn 1995)<sup>4</sup>~~
- [E50 Practices for Apparatus, Reagents, and Safety Considerations for Chemical Analysis of Metals, Ores, and Related Materials](#)
- [E60 Practice for Analysis of Metals, Ores, and Related Materials by Spectrophotometry](#)
- [E135 Terminology Relating to Analytical Chemistry for Metals, Ores, and Related Materials](#)
- [E173 Practice for Conducting Interlaboratory Studies of Methods for Chemical Analysis of Metals \(Withdrawn 1998\)<sup>3</sup>](#)
- [E350 Test Methods for Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron](#)
- [E351 Test Methods for Chemical Analysis of Cast Iron—All Types](#)
- [E352 Test Methods for Chemical Analysis of Tool Steels and Other Similar Medium- and High-Alloy Steels](#)
- [E354 Test Methods for Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys](#)
- ~~E380 Practice for Use of the International System of Units (SI) (the Modernized Metric System) (Withdrawn 1997)<sup>4</sup>~~
- [E882 Guide for Accountability and Quality Control in the Chemical Analysis Laboratory](#)
- [E1019 Test Methods for Determination of Carbon, Sulfur, Nitrogen, and Oxygen in Steel, Iron, Nickel, and Cobalt Alloys by Various Combustion and Fusion Techniques](#)
- [E1024 Guide for Chemical Analysis of Metals and Metal Bearing Ores by Flame Atomic Absorption Spectrophotometry \(Withdrawn 2004\)<sup>3</sup>](#)
- [E1601 Practice for Conducting an Interlaboratory Study to Evaluate the Performance of an Analytical Method](#)
- [E1806 Practice for Sampling Steel and Iron for Determination of Chemical Composition](#)
- 2.2 *Other Document:*
- [ISO 5725 Precision of Test Methods—Determination of Repeatability and Reproducibility for Inter-Laboratory Tests<sup>4</sup>](#)

### 3. Terminology

3.1 For definitions of terms used in these test methods, refer to Terminology [E135](#).

### 4. Significance and Use

4.1 These test methods for the chemical analysis of metals and alloys are primarily intended as referee methods to test such materials for compliance with compositional specifications, particularly those under the jurisdiction of ASTM Committee A1 on Steel, Stainless Steel, and Related Alloys. It is assumed that all who use these test methods will be trained analysts capable of performing common laboratory procedures skillfully and safely. It is expected that work will be performed in a properly equipped laboratory under appropriate quality control practices such as those described in Guide [E882](#).

### 5. Apparatus, Reagents, and Instrumental Practices

5.1 *Apparatus*—Specialized apparatus requirements are listed in the “Apparatus” Section in each method. ~~In some cases reference may be made to Practices [E50](#).~~

#### 5.2 Reagents:

5.2.1 *Purity of Reagents*—Unless otherwise indicated, all reagents used in these test methods shall conform to the “Reagent Grade” Specifications of the American Chemical Society.<sup>5</sup> Other chemicals may be used, provided it is first ascertained that they are of sufficiently high purity to permit their use without adversely affecting the expected performance of the determination, as indicated in the ~~section on “Precision and Bias.”~~ Precision and Bias section.

5.2.2 *Purity of Water*—Unless otherwise indicated, references to water shall be understood to mean reagent water as defined by ~~Type conforming to Type I or Type II of Specification [D1193](#). Type III or IV may be used if they effect no measurable change in the blank or sample.~~

5.3 ~~*Photometric Spectrophotometric Practice*~~—~~Photometric Spectrophotometric practice~~ prescribed in these test methods shall conform to Practice [E60](#).

### 6. Hazards

6.1 For precautions to be observed in the use of certain reagents and equipment in these methods, refer to Practices [E50](#).

### 7. Sampling

7.1 For procedures for sampling the material, reference shall be made to Practice [E1806](#).

<sup>3</sup> The last approved version of this historical standard is referenced on [www.astm.org](http://www.astm.org).

<sup>4</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

<sup>5</sup> “Reagent Chemicals, American Chemical Society Specifications,” ~~Am. American Chemical Soc., Society~~, Washington, DC. For suggestions on the testing of Reagents not listed by the American Chemical Society, see “~~Reagent Chemicals and Standards,~~” by Joseph Rosin, D. Van Nostrand Co., Inc., New York, NY, and the “~~United States Pharmacopeia,~~” ~~United States United States Pharmacopeia and National Formulary~~, U.S. Pharmacopeial Convention, Rockville, MD 20852, Inc. (USPC), Rockville, MD.

## 8. Interlaboratory Studies and Rounding Calculated Values

8.1 These test methods have been evaluated ~~using in accordance with Practice E173 or ISO 5725 (withdrawn 1997) or ISO 5725.~~ The reproducibility  $R_2$  of Practice E173 corresponds to the reproducibility index  $R$  of Practice E1601. The repeatability  $R_1$  of Practice E173 corresponds to the repeatability index  $r$  of Practice E1601.

8.2 Calculated values shall be rounded to the desired number of places ~~as directed in 3.4 to 3.6~~ in accordance with the rounding method of Practice E29.

## MANGANESE BY THE META PERIODATE PHOTOMETRIC/SPECTROPHOTOMETRIC METHOD

## 9. Scope

9.1 This method covers the determination of manganese in ~~concentrations/compositions~~ from 0.01 % to 5.00 %.

## 10. Summary of Method

10.1 Manganous ions are oxidized to permanganate ions by treatment with periodate. Tungsten when present at ~~concentrations/compositions~~ greater than 0.5 % is kept in solution with ~~phosphoric  $H_3PO_4$  acid.~~ Solutions of the samples are fumed with ~~perchloric  $HClO_4$  acid~~ so that the effect of periodate is limited to the oxidation of manganese. ~~Photometric/Spectrophotometric~~ measurement is made at approximately 545 nm.

## 11. ~~Concentration/Composition~~ Range

11.1 The recommended ~~concentration/composition~~ range is 0.15 mg to 0.8 mg of manganese per 50 mL of solution, using a 1-cm cell (see Note 1) and a spectrophotometer with a band width of 10 nm or less.

NOTE 1—This method has been written for cells having a 1-cm light path and a “narrow-band” instrument. The ~~concentration/composition~~ range depends upon band width and spectral region used as well as cell optical path length. Cells having other dimensions may be used, provided suitable adjustments can be made in the amounts of sample and reagents used.

## 12. Stability of Color

12.1 The color is stable for at least 24 h.

## 13. Interferences

13.1 ~~Perchloric  $HClO_4$  acid~~ treatment, which is used in the procedure, yields solutions which can be highly colored due to the presence of Cr (VI) ions. Although these ions and other colored ions in the sample solution undergo no further change in color quality upon treatment with metaperiodate ion, the following precautions must be observed when filter ~~photometers/spectrophotometers~~ are used: Select a filter with maximum transmittance between 545 nm and 565 nm. The filter must transmit not more than 5 % of its maximum at a wavelength shorter than 530 nm. The band width of the filter should be less than 30 nm when measured at 50 % of its maximum transmittance. Similar restrictions apply with respect to the wavelength region employed when other “wide-band” instruments are used.

13.2 The spectral transmittance curve of permanganate ions exhibits two useful minima, one at approximately 526 nm, and the other at 545 nm. The latter is recommended when a “narrow-band” spectrophotometer is used.

13.3 Tungsten, when present in amounts of more than 0.5 % interferes by producing a turbidity in the final solution. A special procedure is provided for use with samples containing more than 0.5 % tungsten which eliminates the problem by preventing the precipitation of the tungsten.

## 14. Reagents

14.1 *Manganese, Standard Solution* (1 mL = 0.032 mg Mn)—Transfer the equivalent of 0.4000 g of assayed, high-purity manganese (purity: 99.99 % minimum), to a 500-mL volumetric flask and dissolve in 20 mL of  $HNO_3$  by heating. Cool, dilute to volume, and mix. Using a pipet, transfer 20 mL to a 500-mL volumetric flask, dilute to volume, and mix.

14.2 *Nitric-Phosphoric Acid Mixture*—Cautiously, while stirring, add 100 mL of  $HNO_3$  and 400 mL of  $H_3PO_4$  to 400 mL of water. Cool, dilute to 1 L, and mix. Prepare fresh as needed.

14.3 *Potassium Metaperiodate Solution* (7.5 g/L)—Dissolve 7.5 g of potassium metaperiodate ( $KIO_4$ ) in 200 mL of hot  $HNO_3$  (1 + 1), add 400 mL of  $H_3PO_4$ , cool, dilute to 1 L, and mix.

14.4 *Water, Pretreated with Metaperiodate*—Add 20 mL of  $KIO_4$  solution to 1 L of water, mix, heat at not less than 90°C for 20 min to 30 min, and cool. Use this water to dilute solutions to volume that have been treated with  $KIO_4$  solution to oxidize manganese, and thus avoid reduction of permanganate ions by any reducing agents in the untreated water. **Caution**—Avoid the use of this water for other purposes.

## 15. Preparation of Calibration Curve

15.1 *Calibration Solutions*—Using pipets, transfer ~~5, 10, 15, 20, 5 mL~~, 10 mL, 15 mL, 20 mL, and 25 mL of manganese standard solution (1 mL = 0.032 mg Mn) to 50-mL borosilicate glass volumetric flasks, and if necessary, dilute to approximately 25 mL. Proceed as directed in [14.315.3](#).

15.2 *Reference Solution*—Transfer approximately 25 mL of water to a 50-mL borosilicate glass volumetric flask. Proceed as directed in [14.315.3](#).

15.3 *Color Development*—Add 10 mL of KIO<sub>4</sub> solution, and heat the solutions at not less than 90°C for 20 min to 30 min (**Note 2**). Cool, dilute to volume with pretreated water, and mix.

NOTE 2—Immersing the flasks in a boiling water bath is a preferred means of heating them for the specified period to ensure complete color development.

### 15.4 *Photometry: Spectrophotometry:*

15.4.1 *Multiple-Cell Photometer—Spectrophotometer*—Measure the cell correction using the Reference Solution ([14.215.2](#)) in absorption cells with a 1-cm light path and using a light band centered at approximately 545 nm. Using the test cell, take the ~~photometric~~spectrophotometric readings of the calibration solutions versus the Reference Solution ([14.215.2](#)).

15.4.2 *Single-Cell Photometer—Spectrophotometer*—Transfer a suitable portion of the Reference Solution ([14.215.2](#)) to an absorption cell with a 1-cm light path and adjust the ~~photometer~~spectrophotometer to the initial setting, using a light band centered at approximately 545 nm. While maintaining this adjustment, take the ~~photometric~~spectrophotometric readings of the calibration solutions.

15.5 *Calibration Curve*—Plot the net photometric readings of the calibration solutions against milligrams of manganese per 50 mL of solution. Follow the instrument manufacturer's instructions for generating the calibration curve.

## 16. Procedure

16.1 *Test Solution*— Select and weigh a sample in accordance with the following:

Manganese, %	Sample Weight, g	Tolerance in Sample Weight, mg	Dilution, mL	Aliquot Volume, mL
0.01 to 0.5	0.80	0.5	100	20
0.45 to 1.0	0.35	0.3	100	20
0.85 to 2.0	0.80	0.5	500	20
1.95 to 5.0	0.80	0.5	500	10

Transfer it to a 300-mL Erlenmeyer flask.

16.1.1 To dissolve samples that do not require HF, add 8 mL to 10 mL of HCl (1 + 1), and heat. Add HNO<sub>3</sub> as needed to hasten dissolution, and then add 3 mL to 4 mL in excess. When dissolution is complete, cool, then add 10 mL of HClO<sub>4</sub>; evaporate to fumes to oxidize chromium, if present, and to expel HCl. Continue fuming until salts begin to separate. Cool, add 50 mL of water, and digest if necessary to dissolve the salts. Cool and transfer the solution to either a ~~100-100-mL~~ or ~~500-mL~~500-mL volumetric flask as indicated in [6.16.1](#). Proceed to [15.2.216.2.2](#).

16.2 For samples whose dissolution is hastened by HF, add 8 mL to 10 mL of HCl (1 + 1), and heat. Add HNO<sub>3</sub> and a few drops of HF as needed to hasten dissolution, and then add 3 mL to 4 mL of HNO<sub>3</sub>. When dissolution is complete, cool, then add 10 mL of HClO<sub>4</sub>, evaporate to fumes to oxidize chromium, if present, and to expel HCl. Continue fuming until salts begin to separate. Cool, add 50 mL of water, digest if necessary to dissolve the salts, cool, and transfer the solution to either a ~~100-100-mL~~ or 500-mL volumetric flask as indicated in [15.16.1](#). Proceed to [15.2.216.2.2](#).

16.2.1 *For Samples Containing More Than 0.5 % Tungsten:*

16.2.1.1 To dissolve samples that do not require HF, add 8 mL to 10 mL of H<sub>3</sub>PO<sub>4</sub>, 10 mL of HClO<sub>4</sub>, 5 mL to 6 mL of H<sub>2</sub>SO<sub>4</sub>, and 3 mL to 4 mL of HNO<sub>3</sub>. Heat moderately until the sample is decomposed, and then heat to copious white fumes for 10 min to 12 min or until the chromium is oxidized and the HCl is expelled, but avoid heating to fumes of SO<sub>3</sub>. Cool, add 50 mL of water, and digest, if necessary, to dissolve the salts. Transfer the solution to either a ~~100-100-mL~~ or 500-mL volumetric flask as directed in [15.16.1](#). Proceed to [15.2.216.2.2](#).

16.2.1.2 For samples whose dissolution is hastened by HF: Add 8 mL to 10 mL of H<sub>3</sub>PO<sub>4</sub>, 10 mL of HClO<sub>4</sub>, 5 mL to 6 mL of H<sub>2</sub>SO<sub>4</sub>, 3 mL to 4 mL of HNO<sub>3</sub>, and a few drops of HF. Heat moderately until the sample is decomposed, and then heat to copious white fumes for 10 min to 12 min or until the chromium is oxidized and the HCl is expelled, but avoid heating to fumes or SO<sub>3</sub>. Cool, add 50 mL of water, digest, if necessary, to dissolve the salts, cool, and transfer the solution to a ~~100-100-mL~~ or 500-mL volumetric flask as directed in [15.16.1](#). Proceed to [15.2.216.2.2](#).

16.2.2 Cool the solution to room temperature, dilute to volume, and mix. Allow insoluble matter to settle, or dry-filter through a coarse paper and discard the first 15 mL to 20 mL of the filtrate, before taking aliquots.

16.2.3 Using a pipet, transfer 10 mL to ~~20-mL~~20 mL aliquots as specified in [15.16.1](#) to two 50-mL borosilicate glass volumetric flasks. Treat one portion as directed in [15.416.4](#). Treat the other portion as directed in [15.5.16.5.1](#).

16.3 *Reagent Blank Solution*—Carry a reagent blank through the entire procedure using the same amounts of all reagents with the sample omitted.

16.4 *Color Development*—Proceed as directed in [14.315.3](#).

16.5 *Reference Solutions:*

16.5.1 *Background Color Solution*—To one of the sample aliquots in a 50-mL volumetric flask, add 10 mL of ~~nitric-phosphoric~~  $\text{HNO}_3\text{-H}_3\text{PO}_4$  acid mixture, and heat the solution at not less than  $90^\circ\text{C}$  ~~90~~  $^\circ\text{C}$  for 20 min to 30 min (Note 2). Cool, dilute to volume (with untreated water), and mix.

16.5.2 *Reagent Blank Reference Solution*—Transfer the reagent blank solution ([15.316.3](#)) to the same size volumetric flask as used for the test solutions and transfer the same size aliquots as used for the test solutions to two 50-mL volumetric flasks. Treat one portion as directed in [15.416.4](#) and use as reference solution for test samples. Treat the other as directed in [15.5.16.5.1](#) and use as reference solution for Background Color Solutions.

16.6 *Photometry—Spectrophotometry*—Establish the cell corrections with the Reagent Blank Reference solution to be used as a reference solution for Background Color solutions. Take the ~~photometric~~ spectrophotometric readings of the Background Color Solutions and the test solutions versus the respective Reagent Blank Reference Solutions as directed in [14.415.4](#).

**17. Calculation**

17.1 Convert the net ~~photometric~~ spectrophotometric reading of the test solution and of the background color solution to milligrams of manganese by means of the calibration curve. Calculate the percentage of manganese as follows:

$$\text{Manganese, \%} = (A - B)/(C \times 10) \tag{1}$$

where:

- A = manganese, mg, found in 50 mL of the final test solution,
- B = apparent manganese, mg, found in 50 mL of the final background color solution, and
- C = sample weight, g, represented in 50 mL of the final test solution.

**18. Precision and Bias**

18.1 *Precision*—Nine laboratories cooperated in testing this method and obtained the data summarized in Table 1.

18.2 *Bias*—No information on the accuracy of this method is known. The accuracy of this method may be judged by comparing accepted reference values with the corresponding arithmetic average obtained by interlaboratory testing.

**PHOSPHORUS BY THE MOLYBDENUM BLUE PHOTOMETRICSPECTROPHOTOMETRIC METHOD**

**19. Scope**

19.1 This method covers the determination of phosphorus in concentrationscompositions from 0.002 % to 0.35 %.

**20. Summary of Method**

20.1 See ~~Section 19 of Test Methods~~ The sample is dissolved in mixed ~~E350~~ acids and the solution is fumed with  $\text{HClO}_4$ . Ammonium molybdate is added to react with the phosphorus to form the heteropoly phosphomolybdate. This species is then reduced with hydrazine sulfate to form the molybdenum blue complex. Spectrophotometric measurement is made at 650 nm or 825 nm, depending upon the concentration.

**TABLE 1 Statistical Information—Manganese by the Metaperiodate PhotometricSpectrophotometric Method**

Test Material	Manganese Found, %	Repeatability ( $R_1$ , E173 <sup>A</sup> )	Reproducibility ( $R_2$ , E173 <sup>A</sup> )
1. Maraging steel 18Ni-8Co-5Mo	0.020	0.005	0.007
2. Maraging steel (NIST 1156, 0.21 Mn)	0.209	0.009	0.017
3. Stainless steel 24Cr-13Ni (NIST 447, 0.23 Mn)	0.208	0.008	0.016
4. Stainless steel 18Cr-9Ni (NIST 101e, 1.77 Mn)	1.79	0.04	0.06
5. Stainless steel 18.5Cr-9.5Ni (NIST 443, 3.38 Mn)	3.37	0.05	0.11
6. Stainless steel 20.5Cr-10Ni (NIST 444, 4.62 Mn)	4.60	0.04	0.13

<sup>A</sup> This test was performed in accordance with the 1980 version of Practice E173.

## 21. Concentration Range

21.1 See Section 20 of Test Methods. The recommended concentration range is from 0.005 mg to 0.05 mg of phosphorus per 100 mL of solution when measured at 825 nm and from 0.05 mg to 0.3 mg of phosphorus per 100 mL of solution when measured at 650 nm, using a 1-cm cell.

NOTE 3—This test method has been written for cells having a 1-cm light path. Cells having other dimensions may be used, provided suitable adjustments are made in the amounts of sample and reagents used.

## 22. Stability of Color

22.1 See Section 21 of Test Methods. The molybdenum blue complex is stable for at least 2 h.

## 23. Interferences

23.1 See Section 22 of Test Methods. None of the elements usually present interfere except arsenic, which is removed by volatilization as the bromide.

## 24. Apparatus

24.1 See Section 23 of Test Methods. Glassware must be phosphorus- and arsenic-free. Boil the glassware with HCl and rinse with water before use. It is recommended that the glassware used for this determination be reserved for this use only. Many detergents contain phosphorus and must not be used for cleaning purposes.

## 25. Reagents

25.1 *Ammonium Molybdate Solution (20 g/L)*—Cautiously, while stirring and cooling, add 300 mL of H<sub>2</sub>SO<sub>4</sub> to 500 mL of water and cool. Add 20 g of ammonium heptamolybdate (NH<sub>4</sub>)<sub>6</sub>Mo<sub>7</sub>O<sub>24</sub> · 4 H<sub>2</sub>O, cautiously dilute to 1 L, and mix.

25.2 *Ammonium Molybdate-Hydrazine Sulfate Solution*—Dilute 250 mL of the ammonium molybdate solution to 600 mL, add 100 mL of the hydrazine sulfate solution, dilute to 1 L, and mix. Do not use a solution that has stood for more than 1 h.

25.3 *Hydrazine Sulfate Solution (1.5 g/L)*—Dissolve 1.5 g of hydrazine sulfate ((NH<sub>2</sub>)<sub>2</sub> · H<sub>2</sub>SO<sub>4</sub>) in water, dilute to 1 L, and mix. Discard any unused solution after 24 h.

25.4 *Phosphorus Standard Solution A (1 mL = 1.0 mg P)*—Proceed as directed. Transfer 2.292 g of anhydrous disodium hydrogen phosphate (Na<sub>2</sub>HPO<sub>4</sub> in 24.1 through 24.7 of Test Methods), previously dried to constant weight at 105 °C, to a 500-mL volumetric flask; dissolve in about 100 mL of water, dilute to volume, and mix.

25.5 *Phosphorus Standard Solution B (1 mL = 0.01 mg P)*—Using a pipet, transfer 10 mL of Solution A (1 mL = 1.0 mg P) to a 1-L volumetric flask, add 50 mL of HClO<sub>4</sub> (1 + 5), dilute to volume, and mix.

25.6 *Phosphorus Standard Solution C (1 mL = 0.10 mg P)*—Using a pipet, transfer 50 mL of Solution A (1 mL = 1.0 mg P) to a 500-mL volumetric flask, add 50 mL of HClO<sub>4</sub> (1 + 5), dilute to volume, and mix.

25.7 *Sodium Sulfite Solution (100 g/L)*—Dissolve 100 g of sodium sulfite (Na<sub>2</sub>SO<sub>3</sub>) in water, dilute to 1 L, and mix.

## 26. Preparation of Calibration Curve for Concentrations from 0.005 mg/100 mL to 0.05 mg/100 mL

26.1 *Calibration Solutions*—Proceed as directed. Using pipets, transfer 5 mL, 10 mL, 15 mL, 25 mL, and 50 mL of Phosphorus Standard Solution B (1 mL = 0.01 mg P) to 100-mL volumetric flasks. Add 20 mL of HClO<sub>4</sub> in 25.1 through 25.4, dilute to volume, and mix. Using a pipet, transfer 10 mL of each solution to a 100-mL borosilicate glass volumetric flask. Proceed in accordance with 26.3.25.6 of Test Methods. E350.

26.2 *Reagent Blank*—Transfer 12 mL of HClO<sub>4</sub> (1 + 5) to a 100-mL borosilicate glass volumetric flask.

26.3 *Color Development:*

26.3.1 Add 15 mL of Na<sub>2</sub>SO<sub>3</sub> solution, boil gently for 30 s, and add 50 mL of ammonium molybdate-hydrazine sulfate solution that has been prepared within the hour.

26.3.2 Heat the solutions at not less than 90 °C for 20 min, quickly cool, dilute to volume, and mix.

NOTE 4—Immersing the flasks in a boiling water bath is the preferred means of heating them for complete color development.

26.4 *Reference Solution—Water.*

26.5 *Spectrophotometry:*

26.5.1 *Multiple-Cell Spectrophotometer*—Measure the reagent blank (which includes the cell correction) versus the reference solution (26.4) using absorption cells with a 1-cm light path and using a light band centered at approximately 825 nm. Using the test cell, take the spectrophotometric readings of the calibration solutions versus the reference solution.

26.5.2 *Single-Cell Spectrophotometer*—Transfer a suitable portion of the reference solution (26.4) to an absorption cell with a 1-cm light path and adjust the spectrophotometer to the initial setting using a light band centered at approximately 825 nm. While maintaining this adjustment, take the spectrophotometric readings of the reagent blank solution and of the calibration solutions.

26.6 Calibration Curve—Follow the instrument manufacturer’s instructions for generating the calibration curve.

## **27. Preparation of Calibration Curve for Concentrations from 0.05 mg/100 mL to 0.30 mg/100 mL**

27.1 Calibration Solutions—Using pipets, transfer 5 mL, 10 mL, 15 mL, 20 mL, 25 mL, and 30 mL of Phosphorus Standard Solution C (1 mL = 0.10 mg P) to 100-mL volumetric flasks. Add 20 mL of HClO<sub>4</sub>, dilute to volume, and mix. Using a pipet, transfer 10 mL of each solution to a 100-mL borosilicate glass volumetric flask.

27.2 Reagent Blank—Proceed as directed in 26.1 through in accordance with 26.2 of Test Methods E350.

27.3 Color Development—Proceed in accordance with 26.3.

27.4 Reference Solution—Water.

27.5 Spectrophotometry:

27.5.1 Multiple-Cell Spectrophotometer—Measure the reagent blank (which includes the cell correction) versus the reference solution (27.4) using absorption cells with a 1-cm light path and a light band centered at approximately 650 nm. Using the test cell, take the spectrophotometric readings of the calibration solutions versus the reference solution.

27.5.2 Single-Cell Spectrophotometer—Transfer a suitable portion of the reference solution (27.4) to an absorption cell with a 1-cm light path and adjust the spectrophotometer to the initial setting using a light band (no change) centered at approximately 650 nm. While maintaining this adjustment, take the spectrophotometric readings of the reagent blank solution and of the calibration solutions.

27.6 Calibration Curve—Follow the instrument manufacturer’s instructions for generating the calibration curve.

## **28. Procedure**

28.1 For Samples Containing Less Than 0.5%–0.5 % Tungsten:

28.1.1 Test Solution:

28.1.1.1 For ~~concentrations~~compositions not greater than 0.30 percent% phosphorus, use a 1.0-g sample; for the ~~concentration~~composition range from 0.30 % to ~~0.35%–0.35 %~~ phosphorus, use a 0.85-g sample. Weigh the sample to the nearest 0.5 mg, and transfer it to a 250-mL Erlenmeyer flask.

28.1.1.2 ~~Proceed as directed~~Add 15 mL of a freshly prepared mixture of 1 volume of HNO<sub>3</sub> in 27.1.2 and 3 volumes of HCl, slowly and in small portions. When the reaction has ceased, add 10 mL of HClO<sub>4</sub> and 27.1.3 of Test ~~evaporate to fumes~~ and evaporate to fumes. Remove the flask immediately to avoid undue loss of HClO<sub>4</sub> ~~Methods~~, cool, E350 and add 20 mL of HBr (1 + 4). Evaporate the solution to copious white fumes and then, without delay, fume strongly enough to cause the white fumes to clear the neck of the flask, and continue at this rate for 1 min.

28.1.1.3 Cool the solution, add 60 mL of HClO<sub>4</sub> (1 + 5), and swirl to dissolve the salts. Transfer to a 100-mL volumetric flask, cool, dilute to volume, and mix. Allow insoluble matter to settle or dry filter the solution. Using a pipet, transfer 10-mL portions to two 100-mL borosilicate glass volumetric flasks; treat one in accordance with 28.1.3 and the other in accordance with 28.1.4.2.

28.1.2 Reagent Blank Solution—Carry a reagent blank through the entire procedure using the same amount of all reagents with the sample omitted.

28.1.3 Color Development—Proceed with one of the 10-mL portions obtained in 28.1.1.3, in accordance with 26.3.

28.1.4 ~~Proceed as directed in 27.2 through 27.5 of Test Methods~~ E350. Reference Solutions:

28.1.4.1 Water—Use this as the reference solution for the reagent blank solution.

28.1.4.2 Background Color Reference Solution—Add 15 mL of Na<sub>2</sub>SO<sub>3</sub> solution to the second 10-mL portion obtained in 28.1.1.3. Boil gently for 30 s, add 50 mL of H<sub>2</sub>SO<sub>4</sub> (3 + 37), cool, dilute to volume, and mix. Use this as the reference solution for the test solution.

28.1.5 Spectrophotometry—Take the spectrophotometric readings of the reagent blank solution and of the test solution (using the respective reference solutions) in accordance with 26.5 or 27.5 depending upon the estimated composition of phosphorus in the sample.

28.2 For Samples Containing More Than 0.5%–0.5 % Tungsten:

28.2.1 Test Solution:

28.2.1.1 For ~~concentrations~~compositions not greater than 0.30%–0.30 % phosphorus, transfer 0.100-g samples, weighed to the nearest 0.1 mg, to two 100-mL Erlenmeyer flasks; for the ~~concentration~~composition range from 0.30 % to ~~0.35%–0.35 %~~ phosphorus, transfer 0.085-g samples, weighed to the nearest 0.1 mg, to two 100-mL Erlenmeyer flasks.

28.2.1.2 Add 5 mL of a mixture of 1 volume of HNO<sub>3</sub> and 3 volumes of HCl. When the reaction has ceased, add 2.5 mL of HClO<sub>4</sub> and 5 mL of HBr (1 + 4). Evaporate the solutions to copious white fumes; then, without delay, fume strongly enough to cause the white fumes to clear the neck of the flasks, and continue at this rate for 1 min.



28.2.1.3 Proceed—Cool the solutions, and add 10 mL of water. Filter through a 9-cm fine paper collecting the filtrate in a 100-mL borosilicate glass volumetric flask. Wash the paper and insoluble matter 5 times with 3-mL portions of water. Treat one solution as directed in 26.2.1.2, 28.2.3 and 26.2.1.3 of Test Methods the other as directed E352 in 28.2.4.

28.2.2 Reagent Blank Solution—Proceed as directed in 28.2.1.2 and 28.2.1.3.

28.2.3 Color Development—Proceed as directed in 26.2.2, 26.3 through 26.2.5 of Test Methods E352.

28.2.4 Reference Solutions:

28.2.4.1 Water—Use this as the reference solution for the reagent blank solution.

28.2.4.2 Background Color Reference Solution—Add 15 mL of Na<sub>2</sub>SO<sub>3</sub> solution to the second 10-mL portion obtained in 28.2.1.3. Boil gently for 30 s, add 50 mL of H<sub>2</sub>SO<sub>4</sub> (3 + 37), cool, dilute to volume, and mix. Use this as the reference solution for the test solution.

28.2.5 Spectrophotometry—Proceed as directed in 28.1.5.

## 29. Calculation

29.1 Proceed as directed in Section 28, Test Methods Convert the net spectrophotometric reading of the test E350 solution and of the reagent blank solution to milligrams of phosphorus by means of the appropriate calibration curve. Calculate the percent of phosphorus as follows:

$$\text{phosphorus, \%} = (A - B)/(C \times 10) \tag{2}$$

where:

A = phosphorus found in 100 mL of the final test solution, mg,

B = phosphorus found in 100 mL of the final reagent blank solution, mg, and

C = sample represented in 100 mL of the final test solution, g.

## 30. Precision

30.1 Nine laboratories cooperated in testing this method and obtained the data summarized in Table 2.

### SULFUR BY THE COMBUSTION-IODATE TITRATION GRAVIMETRIC METHOD

#### SULFUR BY THE GRAVIMETRIC METHOD

(This method, which consisted of Sections 30 through 36 of this standard, was discontinued in 1988.)

### SULFUR BY THE COMBUSTION-IODATE TITRATION METHOD

#### 37. Scope

37.1 This method covers the determination of sulfur in concentrations from 0.005 to 0.5 % (This method, which consisted of Sections 37 through 45 of this standard, was discontinued in 2014.)

38. Summary of Method was discontinued in 2014.)

38.1 See Section 38 of Test Methods E350.

## 39. Interferences

TABLE 2 Statistical Information—Phosphorus

Test Material	Phosphorus Found, %	Repeatability (R <sub>1</sub> , E173 <sup>A</sup> )	Reproducibility (R <sub>2</sub> , E173 <sup>A</sup> )
1. Stainless steel 18Cr-9Ni (NBS 101e, 0.025 P)	0.025	0.004	0.004
2. Stainless steel 19Cr-14Ni-3Mo (NBS 160a, 0.027 P)	0.026	0.002	0.004
3. Stainless steel 17Cr-9Ni-0.25Se (NBS 339, 0.129 P)	0.128	0.007	0.012

TABLE 2 Statistical Information—Phosphorus

Test Material	Phosphorus Found, %	Repeatability (R <sub>1</sub> , E173 <sup>A</sup> )	Reproducibility (R <sub>2</sub> , E173 <sup>A</sup> )
1. Stainless steel 18Cr-9Ni (NIST 101e, 0.025 P)	0.025	0.001	0.004
2. Stainless steel 19Cr-14Ni-3Mo (NIST 160a, 0.027 P)	0.026	0.002	0.004
3. Stainless steel 17Cr-9Ni-0.25Se (NIST 339, 0.129 P)	0.128	0.007	0.012

<sup>A</sup> This test was performed in accordance with the 1980 version of Practice E173.

39.1 The elements ordinarily present do not interfere if their concentrations are under the maximum limits shown in 1.1.

#### 40. Apparatus

40.1 See Section 40 of Test Methods E350.

#### 41. Reagents

41.1 Proceed as directed in 41.1 through 41.6 of Test Methods E350.

#### 42. Calibration

42.1 Proceed as directed in 42.1 through 42.6 of Test Methods E350.

#### 43. Procedure

43.1 Proceed as directed in 43.1 and 43.2 of Test Methods E350.

#### 44. Calculation

44.1 Proceed as directed in Section 44 of Test Methods E350.

#### 45. Precision

45.1 Twenty-two laboratories cooperated in testing this method; six used resistance furnaces and reported eight sets of values (Note 3); sixteen used induction furnaces (Note 4). They obtained the data summarized in Table 3 for material 7. Although samples covered by this method with sulfur concentration near the lower limit of the scope were not available for testing, the precision data obtained using the methods indicated in Table 3 should apply. None was available to permit a test near the upper limit of the scope.

NOTE 3—The recovery of sulfur as  $\text{SO}_2$  ranged from 72 to 97 % with an average value of 83 % based on calibration standards designated *b*, *c*, and *d* in Table 3.

NOTE 4—The recovery of sulfur as  $\text{SO}_2$  ranged from 80 to 96 % with an average value of 88 % based on calibration standards designated *b*, *c*, and *d* in Table 3.

### SILICON BY THE GRAVIMETRIC METHOD

#### 46. Scope

46.1 This method covers the determination of silicon in concentrations/compositions from 0.05 % to 4.00 %.

#### 47. Summary of Method

47.1 See Section 47 of Test Methods E350. After dissolution of the sample, silicic acid is dehydrated by fuming with  $\text{H}_2\text{SO}_4$  or  $\text{HClO}_4$ . The solution is filtered, and the impure silica is ignited and weighed. The silica is then volatilized with HF. The residue is ignited and weighed; the loss in weight represents silica.

#### 48. Interferences

48.1 The elements normally present do not interfere if their concentrations/compositions are under the maximum limits shown in 1.1.

#### 49. Reagents

49.1 The analyst should make certain by analyzing blanks and other checks that possible silicon contamination of reagents will not significantly bias the results.

##### 49.2 Perchloric Acid:

49.2.1 Select a lot of  $\text{HClO}_4$  that contains not more than 0.0002 % silicon for the analysis of samples containing silicon in the range from 0.02 % to 0.10 % and not more than 0.0004 % silicon for samples containing more than 0.10 % by determining duplicate values for silicon in accordance with 49.2.2–49.2.6.

49.2.2 Transfer 15 mL of  $\text{HClO}_4$  (Note 5) to each of two 400-mL beakers. To one of the beakers transfer an additional 50 mL of  $\text{HClO}_4$ . Using a pipet, transfer 20 mL of  $\text{Na}_2\text{SiO}_3$  solution (1 mL = 1.00 mg Si) to each of the beakers. Evaporate the solutions to fumes and heat for 15 min to 20 min at such a rate that  $\text{HClO}_4$  refluxes on the sides of the beakers. Cool sufficiently, and add 100 mL of water (40 °C to 50 °C).

NOTE 5—The 15-mL addition of  $\text{HClO}_4$  can be from the same lot as the one to be tested. Once a lot has been established as having less than 0.0002 % silicon, it should preferably be used for the 15-mL addition in all subsequent tests of other lots of acid.

49.2.3 Add paper pulp and filter immediately, using low-ash 11-cm medium-porosity filter papers. Transfer the precipitates to the papers, and scrub the beakers thoroughly with a rubber-tipped rod. Wash the papers and precipitates alternately with 3-mL to 5-mL portions of hot HCl (1 + 19) and hot water, for a total of 6 times. Finally wash the papers twice with  $\text{H}_2\text{SO}_4$  (1 + 49). Transfer the papers to platinum crucibles.

49.2.4 Dry the papers and heat at 600 °C until the carbon is removed. Finally ignite at 1100 °C to 1150 °C or to constant weight (at least 30 min). Cool in a desiccator and weigh.

49.2.5 Add enough H<sub>2</sub>SO<sub>4</sub> (1 + 1) to moisten the SiO<sub>2</sub>, and add 3 mL to 5 mL of HF. Evaporate to dryness and then heat at a gradually increasing rate until H<sub>2</sub>SO<sub>4</sub> is removed. Ignite for 15 min at 1100 °C to 1150 °C, cool in a desiccator, and weigh.

49.2.6 Calculate the percent of silicon as follows:

$$\text{silicon, \%} = [(A - B) - (C - D)] \times 0.4674E \times 100 \quad (3)$$

- A = initial weight of crucible plus impure SiO<sub>2</sub> when 65 mL of HClO<sub>4</sub> was taken, g,
- B = final weight of crucible plus impurities when 65 mL of HClO<sub>4</sub> was taken, g,
- C = initial weight of crucible plus impure SiO<sub>2</sub> when 15 mL of HClO<sub>4</sub> was taken, g,
- D = final weight of crucible plus impurities when 15 mL of HClO<sub>4</sub> was taken, g, and
- E = nominal weight (80 g) of 50 mL of HClO<sub>4</sub>.

49.3 *Sodium Silicate Solution*—Transfer 11.0 g of sodium silicate (Na<sub>2</sub>SiO<sub>3</sub> · 9H<sub>2</sub>O) to a 400-mL beaker. Add 150 mL of water and dissolve the salt. Filter through a medium paper, collecting the filtrate in a 1-L volumetric flask, dilute to volume, and mix. Store in a polyethylene bottle. Use this solution to determine the suitability of the HClO<sub>4</sub>.

49.4 *Tartaric Acid Solution (20.6 g/L)*—Dissolve 20.6 g of tartaric acid (C<sub>4</sub>H<sub>6</sub>O<sub>6</sub>) in water, dilute to 1 L, and filter.

49.149.5 *Proceed Water*—as directed in 49.1 through 49.4 of Test Methods—Use freshly prepared Type II water known to be free of silicon. Water distilled from glass, demineralized in columns containing silicon compounds, or stored E350 for extended periods in glass, or combination thereof, has been known to absorb silicon.

## 50. Procedure

50.1 Select and weigh a sample in accordance with the following:

Silicon, % H <sub>2</sub> SO <sub>4</sub> (1 + 4) H <sub>2</sub> SO <sub>4</sub> (1 + 4)	Sample Weight, g	Tolerance in Sample Weight, mg	Dehydrating Acid, mL	Sample Weight, g
	HClO <sub>4</sub>		Dehydrating Acid, mL	
0.05 to 1.00	4.0	4	150	60
1.00 to 2.00	3.0	3	100	50
2.00 to 4.00	2.0	2	100	40

Transfer it to a 400-mL beaker or a 300-mL porcelain casserole.

50.2 *Proceed as directed Sulfuric Acid Dehydration*, in 50.2 of Test Methods E350 if tungsten is greater than 0.5 % to 0.5 %.

50.2.1 Add amounts of HCl or HNO<sub>3</sub>, or mixtures and dilutions of these acids, that are sufficient to dissolve the sample; and then add the H<sub>2</sub>SO<sub>4</sub> (1 + 4) as specified in 50.1, and cover. Heat until dissolution is complete. Remove and rinse the cover glass; substitute a ribbed cover glass.

50.2.2 Evaporate until salts begin to separate; at this point evaporate the solution rapidly to the first appearance of fumes and fume strongly for 2 min to 3 min. Cool sufficiently, and add 100 mL of water (40 °C to 50 °C). Stir to dissolve the salts and heat, if necessary, but do not boil. Proceed immediately in accordance with 50.4.

50.3 *Proceed as directed Perchloric Acid Dehydration*, in 50.2 or 50.3 of Test Methods E350 if tungsten is less than 0.5 % to 0.5 %, or use 50.2.

50.3.1 Add amounts of HCl or HNO<sub>3</sub>, or mixtures and dilutions of these acids, which are sufficient to dissolve the sample, and cover. Heat until dissolution is complete. Add HNO<sub>3</sub> to provide a total of 35 mL to 40 mL, followed by HClO<sub>4</sub> as specified in the table in 50.1. Remove and rinse the cover glass; substitute a ribbed cover glass.

50.3.2 Evaporate the solution to fumes and heat for 15 min to 20 min at such a rate that the HClO<sub>4</sub> refluxes on the sides of the container. Cool sufficiently and add 100 mL of water (40 °C to 50 °C). Stir to dissolve the salts and heat to boiling. If the sample solution contains more than 100 mg of chromium, add, while stirring, 1 mL of tartaric acid solution for each 25 mg of chromium.

50.4 *Proceed as directed in 50.4 through 50.6 of Test Methods* Add paper pulp and filter immediately, on a low-ash 11-cm medium-porosity filter paper. Collect the filtrate in a 600-mL beaker. Transfer the precipitate to the paper, and scrub the container thoroughly with a rubber-tipped rod. Wash the paper and precipitate alternately with 3-mL to 5-mL portions of hot HCl E350 (1 + 19) and hot water until iron salts are removed but for not more than a total of ten washings. If 50.3 was followed, wash the paper twice more with H<sub>2</sub>SO<sub>4</sub> (1 + 49), but do not collect these washings in the filtrate; discard the washings. Transfer the paper to a platinum crucible and reserve.

50.5 Add 15 mL of HNO<sub>3</sub> to the filtrate, stir, and evaporate in accordance with either 50.2 or 50.3, depending upon the dehydrating acid used. Filter immediately, using a low-ash, 9-cm-100-porosity filter paper, and wash in accordance with 50.4.

50.6 Transfer the paper and precipitate to the reserved platinum crucible. Dry the papers and then heat the crucible at 600 °C until the carbon is removed. Finally ignite at 1100 °C to 1150 °C to constant weight (at least 30 min). Cool in a desiccator and weigh.

50.5 Proceed as directed. 50.7 Add enough  $H_2SO_4$  in 50.7(1 + 1) to moisten the impure  $SiO_2$  of Test Methods, and add 3 mL to 5 mL of HF. Evaporate ~~E350~~, but if to dryness and then heat at a gradually increasing rate until  $H_2SO_4$  is removed. Ignite at 1100 °C to 1150 °C for 15 min, cool in a desiccator, and weigh. If the sample contains more than ~~0.5 %~~ 0.5 % tungsten, ignite at 750 °C instead of 1100 °C to 1150 °C after volatilization of  $SiO_2$ .

### 51. Calculation

Calculate the percent of silicon as follows:

$$\text{silicon, \%} = [(A - B) \times 0.4674]C \times 100 \quad (4)$$

where:

$A$  = initial weight of crucible and impure  $SiO_2$ , g,

$B$  = final weight of crucible and residue, g, and

$C$  = sample used, g.

51.1 Proceed as directed in Section 51 of Test Methods ~~E350~~.

### 52. Precision

52.1 Eleven laboratories cooperated in testing this method and obtained the data summarized in Table 43. Samples with silicon concentrations/compositions near the extreme limits of the scope were not available for testing.

## COBALT BY THE ION-EXCHANGE—POTENTIOMETRIC TITRATION METHOD

### 53. Scope

53.1 This method covers the determination of cobalt in concentrations/compositions from 2 % to 15 %.

### 54. Summary of Method

54.1 See Section 54 of Test Methods. Cobalt is separated from interfering elements by ~~E351~~ selective elution from an anion-exchange column using HCl. The cobalt is oxidized to the trivalent state with ferricyanide, and the excess ferricyanide is titrated potentiometrically with cobalt solution.

### 55. Interferences

55.1 The elements ordinarily normally present do not interfere if their concentrations/compositions are under the maximum limits shown in 1.1.

### 56. Apparatus

56.1 *Ion-Exchange Column*, approximately 25 mm in diameter and 300 mm in length, tapered at one end, and provided with a stopcock to control the flow rate, and a second, lower stopcock to stop the flow. A Jones Reductor may be adapted to this method. A reservoir for the eluants may be added at the top of the column.

56.156.2 See Section *pH meter*, 56 of Test Methods with a platinum and ~~E351~~ a saturated calomel electrode.

### 57. Reagents

57.1 *Ammonium Citrate Solution (200 g/l)*—Dissolve 200 g of di-ammonium hydrogen citrate in water and dilute to 1 L.

57.2 *Cobalt, Standard Solution (1 mL = 1.5 mg of Co)*:

57.2.1 *Preparation*—Dry a weighing bottle in an oven at 130 °C for 1 h, cool in a desiccator, and weigh. Transfer 3.945 g of cobalt sulfate ( $CoSO_4$ )<sup>6</sup> that has been heated at 550 °C for 1 h to the weighing bottle. Dry the bottle and contents at 130 °C for 1 h, cool in desiccator, stopper the bottle, and weigh. The difference in weight is the amount of  $CoSO_4$  taken. Transfer the weighed  $CoSO_4$  to a 400-mL beaker, rinse the weighing bottle with water, and transfer the rinsings to the beaker. Add 150 mL of water and 20 mL of  $HNO_3$ , and heat to dissolve the salts. Cool, transfer to a 1-L volumetric flask, dilute to volume, and mix.

57.2.2 *Standardization*—Calculate the cobalt concentration as follows:

$$\text{cobalt, mg/mL} = \text{weight of } CoSO_4, \text{ g} \times 0.38026 \quad (5)$$

57.3 *Ion-Exchange Resin*:<sup>7</sup>

57.3.1 Use an anion exchange resin of the alkyl quaternary ammonium type (chloride form) consisting of spherical beads having a nominal crosslinkage of 8 %, and 200-nominal to 400-nominal mesh size. To remove those beads greater than about 180- $\mu\text{m}$  in diameter as well as the excessively fine beads, treat the resin as follows: Transfer a supply of the resin to a beaker, cover with water, and allow sufficient time (at least 30 min) for the beads to undergo maximum swelling. Place a No. 80 (180- $\mu\text{m}$ ) screen, 150 mm

<sup>6</sup> Cobalt sulfate (99.9 % minimum) prepared from the hexamine salt by G. Frederick Smith Chemical Co., Columbus, OH, is satisfactory for this purpose.

<sup>7</sup> Available from the Dow Chemical Co., Midland, MI.

TABLE 3 Statistical Information—Sulfur

Test Material	Sulfur Found, %	Repeatability ( $R_1$ , E173 <sup>A</sup> )	Reproducibility ( $R_2$ , E173 <sup>A</sup> )
Induction Furnace			
1. No. 1, E352	0.006 <sup>B</sup>	0.0016	0.0032
2. No. 2, E352	0.008 <sup>B</sup>	0.0013	0.0044
3. No. 3, E350	0.014 <sup>B</sup>	0.0025	0.0029
4. No. 4, E350	0.016 <sup>B</sup>	0.0018	0.0024
5. No. 6, E350	0.032 <sup>C</sup>	0.0032	0.0049
6. No. 7, E350	0.141 <sup>D</sup>	0.0066	0.0126
7. Stainless steel 13Cr-0.3Mo (NBS 133a, 0.329S + NBS 10 g, 0.109S; 0.286S)	0.286 <sup>E</sup>	0.0135	0.0201
Resistance Furnace			
1. No. 1, E352	0.006 <sup>B</sup>	0.0014	0.0024
2. No. 2, E352	0.009 <sup>B</sup>	0.0007	0.0020
3. No. 3, E350	0.014 <sup>B</sup>	0.0014	0.0025
4. No. 4, E350	0.015 <sup>B</sup>	0.0017	0.0029
5. No. 6, E350	0.032 <sup>C</sup>	0.0028	0.0041
6. No. 7, E350	0.140 <sup>D</sup>	0.0074	0.0111
7. Stainless steel 13Cr-0.3Mo (NBS 133a, 0.329S + NBS 10g, 0.109 S; 0.286S)	0.288 <sup>E</sup>	0.0123	0.0206

<sup>A</sup> This test was performed in accordance with the 1980 version of Practice E173.

<sup>B</sup> Calibration standards: See Footnote <sup>A</sup>, Table 5, Methods E350.

<sup>C</sup> Calibration standards: See Footnote <sup>B</sup>, Table 5, Methods E350.

<sup>D</sup> Calibration standards: See Footnote <sup>C</sup>, Table 5, Methods E350.

<sup>E</sup> Calibration standards: see Footnote <sup>D</sup>, Table 5, Methods E350

TABLE 43 Statistical Information—Silicon

Test Material	Silicon Found, %	Repeatability ( $R_1$ , E173 <sup>A</sup> )	Reproducibility ( $R_2$ , E173 <sup>A</sup> )
HClO <sub>4</sub> Dehydration			
1. Stainless steel 18Cr-9Ni (NBS 101e, 0.43 Si)	0.428	0.014	0.021
1. Stainless steel 18Cr-9Ni (NIST 101e, 0.43 Si)	0.428	0.014	0.021
2. Stainless steel 19Cr-14Ni-3Mo (NBS 160a, 0.605 Si)	0.602	0.018	0.031
2. Stainless steel 19Cr-14Ni-3Mo (NIST 160a, 0.605 Si)	0.602	0.018	0.031
3. Stainless steel 18Cr-10Ni-0.4Ti (NBS 121c, 0.64 Si)	0.642	0.019	0.031
3. Stainless steel 18Cr-10Ni-0.4Ti (NIST 121c, 0.64 Si)	0.642	0.019	0.031
H <sub>2</sub> SO <sub>4</sub> Dehydration			
1. Stainless steel 18Cr-9Ni (NBS 101e, 0.43 Si)	0.428	0.021	0.033
1. Stainless steel 18Cr-9Ni (NIST 101e, 0.43 Si)	0.428	0.021	0.033
2. Stainless steel 19Cr-14Ni-3Mo (NBS 160a, 0.605 Si)	0.603	0.017	0.014
3. Stainless steel 18Cr-10Ni-0.4Ti (NBS 121c, 0.64 Si)	0.642	0.026	0.033
3. Stainless steel 18Cr-10Ni-0.4Ti (NIST 121c, 0.64 Si)	0.642	0.026	0.033

<sup>A</sup> This test was performed in accordance with the 1980 version of Practice E173.

in diameter over a 2-L beaker. Prepare a thin slurry of the resin and pour it onto the screen. Wash the fine beads through the screen, using a small stream of water. Discard the beads retained on the screen, periodically, if necessary, to avoid undue clogging of the openings. When the bulk of the collected resin has settled, decant the water and transfer approximately 100 mL of resin to a 400-mL beaker. Add 200 mL of HCl (1 + 19), stir vigorously, allow the resin to settle for 4 min to 6 min, decant 150 mL to 175 mL of the suspension, and discard. Repeat the treatment with HCl (1 + 19) twice more, and reserve the coarser resin for the column preparation.

57.3.2 Prepare the column as follows:

57.3.2.1 Place a 10-mm to 20-mm layer of glass wool or polyvinyl chloride plastic fiber in the bottom of the column, and add a sufficient amount of the prepared resin to fill the column to a height of approximately 140 mm. Place a 20-mm layer of glass wool or polyvinyl chloride plastic fiber at the top of the resin bed to protect it from being carried into suspension when the solutions

are added. While passing a minimum of 35 mL of HCl (7 + 5) through the column, with the hydrostatic head 100 mm above the top of the resin bed, adjust the flow rate to not more than 3.0 mL per min. Drain to 10 mm to 20 mm above the top of the resin bed and then close the lower stopcock.

**NOTE 6**—The maximum limits of 0.125 g of cobalt and 0.500 g in the sample solution take into account the exchange capacity of the resin, the physical dimensions of the column, and the volume of eluants.

**57.4 Potassium Ferricyanide, Standard Solution (1 mL = 3.0 mg of Co):**

**57.4.1** Dissolve 16.68 g of potassium ferricyanide ( $K_3Fe(CN)_6$ ) in water and dilute to 1 L. Store the solution in a dark-colored bottle. Standardize the solution each day before use as follows: Transfer from a 50-mL buret approximately 20 mL of  $K_3Fe(CN)_6$  solution to a 400-mL beaker. Record the buret reading to the nearest 0.01 mL. Add 25 mL of water, 10 mL of ammonium citrate solution, and 25 mL of  $NH_4OH$ . Cool to 5 °C to 10 °C, and maintain this temperature during the titration. Transfer the beaker to the potentiometric titration apparatus. While stirring, titrate the  $K_3Fe(CN)_6$  with the cobalt solution (1 mL = 1.5 mg Co) using a 50-mL buret. Titrate at a fairly rapid rate until the end point is approached, and then add the titrant in 1-drop increments through the end point. After the addition of each increment, record the buret reading and voltage when equilibrium is reached. Estimate the buret reading at the end point to the nearest 0.01 mL by interpolation.

**57.4.2** Calculate the cobalt equivalent as follows (**Note 7**):

$$\text{cobalt equivalent, mg/mL} = (A \times B)/C \quad (6)$$

where:

$A$  = cobalt standard solution required to titrate the potassium ferricyanide solution, mL,

$B$  = cobalt standard solution, mg/mL, and

$C$  = potassium ferricyanide solution, mL.

**57.4**

**NOTE 7**—Duplicate or triplicate values should be obtained for the cobalt equivalent. The values obtained should check within 1 mg/g to 2 mg/g. Proceed as directed in 57.1 through 57.4 of Test Methods **E351**.

## 58. Procedure

**58.1** Transfer a 0.50-g sample, weighed to the nearest 0.1 mg, to a 150-mL beaker. Add 20 mL of a mixture of 5 parts of HCl and 1 part of  $HNO_3$  (**Note 8**). Cover the beaker and digest at 60 °C to 70 °C until the sample is decomposed. Rinse and remove the cover. Place a ribbed cover glass on the beaker, and evaporate the solution nearly to dryness, but do not bake. Cool, add 20 mL of HCl (7 + 5), and digest at 60 °C to 70 °C until salts are dissolved (approximately 10 min).

**NOTE 8**—Other ratios and concentrations of acids, with or without the addition of 1 mL to 2 mL of HF, are used for the decomposition of special grades of alloys.

**NOTE 9**—Some alloys are decomposed more readily by a mixture of 5 mL of bromine, 15 mL of HCl, and 1 drop to 2 drops of HF.

**58.2** Cool to room temperature and transfer the solution to the ion-exchange column. Place a beaker under the column and open the lower stopcock. When the solution reaches a level 10 mm to 20 mm above the resin bed, rinse the original beaker with 5 mL to 6 mL of HCl (7 + 5) and transfer the rinsings to the column. Repeat this at 2-min intervals until the beaker has been rinsed four times. Wash the upper part of the column with HCl (7 + 5) 2 times or 3 times and allow the level to drop to 10 mm to 20 mm above the resin bed each time. Maintain the flow rate at not more than 3.0 mL/min and add HCl (7 + 5) to the column until a total of 175 mL to 185 mL of solution (sample solution and washings) containing mainly chromium, manganese, and nickel is collected (**Note 10**). When the solution in the column reaches a level 10 mm to 20 mm above the resin bed, discard the eluate and then use a 400-mL beaker for the collection of the cobalt eluate.

**NOTE 10**—To prevent any loss of cobalt, the leading edge of the cobalt band must not be allowed to proceed any farther than 25 mm from the bottom of the resin. Normally, when the cobalt has reached this point in the column, the chromium, manganese, and nickel have been removed. Elution can be stopped at this point, although the total volume collected may be less than 175 mL.

**58.3** Add HCl (1 + 2) to the column and collect 165 mL to 175 mL of the solution while maintaining the 3.0 mL/min flow rate. Reserve the solution. If the sample solution did not contain more than 0.200 g of iron, substitute a 250-mL beaker and precondition the column for the next sample as follows: Drain the remaining solution in the column to 10 mm to 20 mm above the resin bed, pass 35 mL to 50 mL of HCl (7 + 5) through the column until 10 mm to 20 mm of the solution remains above the resin bed, then close the lower stopcock. If the sample solution contained more than 0.200 g of iron, or if the column is not to be used again within 3 h, discard the resin and recharge the column as directed in 57.3.

**58.4** Add 30 mL of  $HNO_3$  and 15 mL of  $HClO_4$  to the solution from 58.3 and evaporate to fumes of  $HClO_4$ . Cool, add 25 mL to 35 mL of water, boil for 1 min to 2 min, cool, and add 10 mL of ammonium citrate solution.

**58.5** Using a 50-mL buret, transfer to a 400-mL beaker a sufficient volume of  $K_3Fe(CN)_6$  solution to oxidize the cobalt and to provide an excess of about 5 mL to 8 mL. Record the buret reading to the nearest 0.01 mL. Add 50 mL of  $NH_4OH$  and cool to 5 °C to 10 °C. Transfer the beaker to the potentiometric titration apparatus and maintain the 5 °C to 10 °C temperature during the titration.