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Standard Specification for Precipitation Hardening Iron Base Superalloy Forgings for Turbine Rotor Disks and Wheels¹

This standard is issued under the fixed designation A891/A891M; 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.

1. Scope*Scope

1.1 This specification covers precipitation hardening iron base superalloy forgings which are primarily intended for use as turbine rotor disks and wheels.

1.2 Two heat treatments are covered. Selection will depend upon design, service conditions, mechanical properties, and elevated temperature characteristics.

1.3 All of the provisions of Specification **A788/A788M**, apply, except as amended herein.

1.4 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.

2. Referenced Documents

2.1 *ASTM Standards*:²

A788/A788M Specification for Steel Forgings, General Requirements

E112 Test Methods for Determining Average Grain Size

E139 Test Methods for Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials

E165/E165M Practice for Liquid Penetrant Examination for General Industry

E292 Test Methods for Conducting Time-for-Rupture Notch Tension Tests of Materials

3. Ordering Information

3.1 Orders for material under this specification shall include the following:

3.1.1 *Condition*—See Section 4.

3.1.2 *Stress Rupture Test*—Parameters for material furnished in condition 2 of 7.3.3: [https://www.astm.org/standards/A891/A891M-10\(2015\).htm](https://www.astm.org/standards/A891/A891M-10(2015).htm)

3.1.3 *Forging Drawing*—Each forging shall be manufactured in accordance with a drawing furnished by the purchaser showing the dimensions of the forging and the location of mechanical test specimens.

3.1.4 Include the information specified in Specification **A788/A788M**.

4. Condition and Heat Treatment

4.1 The forgings covered in this specification may be ordered in two different solution treated and aged conditions:

4.1.1 *Type 1*:

4.1.1.1 Solution anneal at $1650 \pm 25^\circ\text{F}$ [$900 \pm 14^\circ\text{C}$] for 2 to 5 h at temperature liquid quench.

4.1.1.2 Precipitation harden at $1420 \pm 15^\circ\text{F}$ [$770 \pm 8^\circ\text{C}$] for 16 h at temperature air cool; $1200 \pm 15^\circ\text{F}$ [$650 \pm 8^\circ\text{C}$] for 16 h at temperature air cool.

4.1.2 *Type 2*:

4.1.2.1 Solution anneal at $1800 \pm 25^\circ\text{F}$ [$980 \pm 14^\circ\text{C}$] for 2 to 5 h at temperature liquid quench.

4.1.2.2 Precipitation harden at $1420 \pm 15^\circ\text{F}$ [$770 \pm 8^\circ\text{C}$] for 16 h at temperature air cool; $1200 \pm 15^\circ\text{F}$ [$650 \pm 8^\circ\text{C}$] for 16 h at temperature air cool.

¹ This specification is under the jurisdiction of Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.06 on Steel Forgings and Billets.

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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.

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

5. Manufacture

5.1 The material shall be made by vacuum melting followed by consumable electrode vacuum arc or electroslag remelting as agreed upon between producer and user.

5.2 The forgings shall be upset forged so that the axis of the disk corresponds with that of the ingot.

6. Chemical Requirements

6.1 *Heat Analysis*—Each heat shall be analyzed by the manufacturer in accordance with Specification **A788/A788M**. The chemical composition shall conform to the requirements specified in **Table 1**.

6.2 *Product Analysis*—The purchaser may obtain a product analysis, representing each heat or multiple heat, in accordance with the provisions of Specification **A788/A788M**.

7. Mechanical Properties

7.1 The forgings shall conform to the mechanical property requirements specified in **Table 2** after heat treatment as prescribed in **4.1**.

7.2 *Tension and Hardness*—Tension and hardness testing shall be conducted in accordance with Specification **A788/A788M**.

7.3 *Stress Rupture*:

7.3.1 Combination smooth and notched bar specimens using 0.252 in. [6.4 mm] diameter bars shall be tested to rupture in accordance with Test Methods **E292**. Rupture must occur in the smooth section of each specimen. After 100 h, samples may be uploaded in 5-ksi [35-MPa] increments in 8 to 16 h intervals.

7.3.2 Material supplied as Type 1 shall meet the stress rupture requirements specified in **Table 3**.

7.3.3 Material supplied as Type 2 shall meet the stress rupture requirements of either Test A or Test B of **Table 3** as specified by the purchaser.

7.4 *Creep*:

7.4.1 A creep test shall be performed in accordance with Test Methods **E139** on a 0.252 in. [6.4 mm] diameter smooth bar.

7.4.2 The material shall meet the requirements specified in **Table 4** after heat treatment as prescribed in **4.1**.

7.5 *Number of Tests*—The testing frequency shall be as follows with a lot being defined as not more than 50 pieces of the same part made from the same heat of material to the same forging parameters, forged within an 8 h period, and heat treated together:

7.5.1 For forgings weighing less than 500 lb [225 kg] each, one tension, stress rupture, and creep test shall be made on one forging per lot. In addition, two hardness tests shall be made on each piece in the lot.

7.5.2 For forgings weighing 500 to 2000 lb [225 to 900 kg] one tension, stress rupture, and creep test, and two hardness tests shall be made on each forging.

7.5.3 For forgings weighing over 2000 lb [900 kg] testing shall be performed as covered in Supplementary Requirement S1. In addition, one tangential tension, stress rupture, and creep test shall be run on material taken from the forging hub.

7.6 *Test Location*:

7.6.1 The tension, stress rupture, and creep specimens covered in **7.5.1** and **7.5.2** shall be machined from tangential bars taken from the forging rim.

7.6.2 Hardness tests shall be taken on both the rim and hub.

8. Microstructure

8.1 The forgings shall have an average grain size of number 4 or finer as determined in accordance with Test Methods **E112**. The material shall be of a uniform microstructure, free of phase or compound formations such as a continuous grain boundary film.

TABLE 1 Chemical Composition

Element	Heat Analysis Range, Percentage
Carbon	0.05 max
Manganese	0.50 max
Silicon	0.50 max
Phosphorus	0.025 max
Sulfur	0.015 max
Chromium	13.50–16.00
Nickel	24.00–27.00
Molybdenum	1.00–1.50
Titanium	1.90–2.35
Boron	0.003–0.010
Vanadium	0.10–0.50
Aluminum	0.35 max
Iron	remainder