Designation: B247 – 15

Standard Specification for Aluminum and Aluminum-Alloy Die Forgings, Hand Forgings, and Rolled Ring Forgings[1]

This standard is issued under the fixed designation B247; 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 U.S. Department of Defense.

1. Scope*

1.1 This specification[2] covers aluminum-alloy (Note 1) die forgings, hand forgings, and rolled ring forgings as shown in Table 2, Table 3 and Table 4 in Section 10 for heat-treatable alloy forgings supplied in the F and 01 tempers. The maximum thicknesses for forgings within the scope of this specification are as indicated in those tables.

NOTE 1—Throughout this specification use of the term *alloy* in the general sense includes aluminum as well as aluminum alloy.

NOTE 2—For forging stock supplied as rolled or cold-finished bar or rod see Specification B211. For forging stock supplied as extruded bar or rod see Specification B221.

1.2 Alloy and temper designations are in accordance with ANSI H35.1/H35.1(M). The equivalent Unified Numbering System alloy designations are those of Table 1 preceded by A9, for example, A91100 for aluminum 1100 in accordance with Practice E527.

1.3 For acceptance criteria for inclusion of new aluminum and aluminum alloys in this specification, see Annex A2.

1.4 This specification is the inch-pound companion to Specification B247M; therefore, no SI equivalents are presented in the specification.

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]

B211 Specification for Aluminum and Aluminum-Alloy Rolled or Cold Finished Bar, Rod, and Wire

B221 Specification for Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes

B557 Test Methods for Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products

B594 Practice for Ultrasonic Inspection of Aluminum-Alloy Wrought Products

B660 Practices for Packaging/Packing of Aluminum and Magnesium Products

B881 Terminology Relating to Aluminum- and Magnesium-Alloy Products

B918 Practice for Heat Treatment of Wrought Aluminum Alloys

B985 Practice for Sampling Aluminum Ingots, Billets, Castings and Finished or Semi-Finished Wrought Aluminum Products for Compositional Analysis

E10 Test Method for Brinell Hardness of Metallic Materials

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

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 (Withdrawn 2011)[4]

E716 Practices for Sampling and Sample Preparation of Aluminum and Aluminum Alloys for Determination of Chemical Composition by Spectrochemical Analysis

E1004 Test Method for Determining Electrical Conductivity Using the Electromagnetic (Eddy-Current) Method

E1251 Test Method for Analysis of Aluminum and Aluminum Alloys by Spark Atomic Emission Spectrometry

[1] This specification is under the jurisdiction of ASTM Committee B07 on Light Metals and Alloys and is the direct responsibility of Subcommittee B07.03 on Aluminum Alloy Wrought Products.

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[2] For ASME Boiler and Pressure Vessel Code applications see related Specification SB-247 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.

[4] The last approved version of this historical standard is referenced on www.astm.org.

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

TABLE 1 Chemical Composition Limits[A,B,C,J]

Alloy	Silicon	Iron	Copper	Manganese	Magnesium	Chromium	Nickel	Zinc	Titanium	Zirconium		Other Elements[D] Each	Other Elements[D] Total[E]	Aluminum
1100	0.95 Si + Fe		0.05–0.20	0.05	...	...	...	0.10	...	...		0.05	0.15	99.00 min[F]
2014	0.50–1.2	0.7	3.9–5.0	0.40–1.2	0.20–0.8	0.10	...	0.25	0.15	...	[G]	0.05	0.15	rem
2018	0.9	1.0	3.5–4.5	0.20	0.45–0.9	0.10	1.7–2.3	0.25	...	...		0.05	0.15	rem
2025	0.50–1.2	1.0	3.9–5.0	0.40–1.2	0.05	0.10	...	0.25	0.15	...		0.05	0.15	rem
2218	0.9	1.0	3.5–4.5	0.20	1.2–1.8	0.10	1.7–2.3	0.25	...	...		0.05	0.15	rem
2219	0.20	0.30	5.8–6.8	0.20–0.40	0.02	...	...	0.10	0.02–0.10	0.10–0.25	[H]	0.05	0.15	rem
2618	0.10–0.25	0.9–1.3	1.9–2.7	...	1.3–1.8	...	0.9–1.2	0.10	0.04–0.10	...		0.05	0.15	rem
3003	0.6	0.7	0.05–0.20	1.0–1.5	...	...	...	0.10	...	...		0.05	0.15	rem
4032	11.0–13.5	1.0	0.50–1.3	...	0.8–1.3	0.10	0.50–1.3	0.25	...	...		0.05	0.15	rem
5083	0.40	0.40	0.10	0.40–1.0	4.0–4.9	0.05–0.25	...	0.25	0.15	...		0.05	0.15	rem
6061	0.40–0.8	0.7	0.15–0.40	0.15	0.8–1.2	0.04–0.35	...	0.25	0.15	...		0.05	0.15	rem
6066	0.9–1.8	0.50	0.7–1.2	0.6–1.1	0.8–1.4	0.40	...	0.25	0.20	...		0.05	0.15	rem
6151	0.6–1.2	1.0	0.35	0.20	0.45–0.8	0.15–0.35	...	0.25	0.15	...		0.05	0.15	rem
7049	0.25	0.35	1.2–1.9	0.20	2.0–2.9	0.10–0.22	...	7.2–8.2	0.10	...		0.05	0.15	rem
7050	0.12	0.15	2.0–2.6	0.10	1.9–2.6	0.04	...	5.7–6.7	0.06	0.08–0.15		0.05	0.15	rem
7075	0.40	0.50	1.2–2.0	0.30	2.1–2.9	0.18–0.28	...	5.1–6.1	0.20[I]	...		0.05	0.15	rem
7076	0.40	0.6	0.30–1.0	0.30–0.8	1.2–2.0	...	...	7.0–8.0	0.20	...		0.05	0.15	rem
7175	0.15	0.20	1.2–2.0	0.10	2.1–2.9	0.18–0.28	...	5.1–6.1	0.10	...		0.05	0.15	rem

[A] Limits are in weight percent maximum unless shown as a range or stated otherwise.
[B] Analysis shall be made for the elements for which limits are shown in this table.
[C] 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-off method of Practice E29.
[D] *Others* includes listed elements for which no specific limit is shown as well as unlisted metallic elements. The producer may analyze samples for trace elements not specified in the specification. However, such analysis is not required and may not cover all metallic *Others* elements. Should any analysis by the producer or the purchaser establish that an *Others* element exceeds the limit of *Each* or that the aggregate of several *Others* elements exceeds the limit of *Total*, the material shall be considered nonconforming.
[E] *Other Elements*—Total shall be the sum of unspecified metallic elements 0.010 % or more, rounded to the second decimal before determining the sum.
[F] The aluminum content shall be calculated by subtracting from 100.00 % the sum of all metallic elements present in amounts of 0.010 % or more each, rounded to the second decimal before determining the sum.
[G] Upon agreement between purchaser and producer or supplier, a zirconium-plus-titanium limit of 0.20 % maximum is permitted.
[H] Vanadium, 0.05–0.15 %. The total for other elements does not include Vanadium.
[I] Upon agreement between purchaser and producer or supplier, a zirconium-plus-titanium limit of 0.25 % maximum is permitted.
[J] In case there is a discrepancy in the values listed in Table 1 with those listed in the "International Alloy Designations and Chemical Composition Limits for Wrought Aluminum and Wrought Aluminum Alloys" (known as the "Teal Sheets"), the composition limits registered with the Aluminum Association and published in the "Teal Sheets" shall be considered the controlling composition. The "Teal Sheets" are available at http://www.aluminum.org/tealsheets.

G47 Test Method for Determining Susceptibility to Stress-Corrosion Cracking of 2XXX and 7XXX Aluminum Alloy Products

2.3 *ANSI Standard:*

H35.1/H35.1(M) Alloy and Temper Designation Systems[5]

2.4 *Military Standards:*

MIL-STD-129 Marking for Shipment and Storage[6] (referenced in MIL-STD-649 and applies only to direct shipments to Department of Defense agencies).

2.5 *SAE:*

AMS 2772 Heat Treatment of Aluminum Alloys Raw Materials[7]

2.6 *Federal Standard:*

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)[6]

2.7 *National Aerospace Standard:*

NAS 410 Certification and Qualification of Nondestructive Test Personnel[8]

2.8 *Other Standards:*

CEN EN 14242 Aluminum and aluminum alloys. Chemical Analysis. Inductively coupled plasma optical emission spectral analysis[9]

3. Terminology

3.1 *Definitions:*

3.1.1 Refer to Terminology B881 for definitions of product terms used in this specification.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *capable of*—The term *capable of* as used in this specification means that the test need not be performed by the producer of the material. However, should subsequent testing by the purchaser establish that the material does not meet the requirements, the material shall be subject to rejection.

4. Ordering Information

4.1 Orders for material to this specification shall include the following information:

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

4.1.2 Quantity in pieces or pounds,

4.1.3 Alloy (Section 7),

[5] Available from Aluminum Association, Inc., 1400 Crystal Dr. Blvd., Suite 430, Arlington, VA 22202, http://www.aluminum.org.
[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 Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, http://www.sae.org.
[8] Available from Aerospace Industries Association of America, Inc. (AIA), 1000 Wilson Blvd., Suite 1700, Arlington, VA 22209-3928, http://www.aia-aerospace.org.
[9] Available from European Committee for Standardization, Central Secretariat (CEN), rue de Stassart 36, B1050 Brussels, Belgium, http://www.cen.eu/esearch.

TABLE 2 Mechanical Property Limits for Die Forgings[A,B]

Alloy and Temper	Specified Thickness, in.	Specimen Axis Parallel to Direction of Grain Flow[C]				Specimen Axis Not Parallel to Direction of Grain Flow[C]			Brinell Hardness[D], min
		Tensile Strength[E], min, ksi	Yield Strength[E] (0.2 % Offset), min, ksi	Elongation[E] in 2 in. or 4 × Dia, min, %		Tensile Strength[E], min, ksi	Yield Strength[E] (0.2 % Offset), min, ksi	Elongation[E] in 2 in. or 4 × Dia., min, % Forgings	
				Forgings	Separate Test Coupon (from stock or forged)[F]				
1100-H112	up through 4.000	11.0	4.0	18	25	...	...	...	20
2014-T4	up through 4.000	55.0	30.0	11	16	...	...	...	100
2014-T6	up through 1.000	65.0	56.0	6	8	64.0	55.0	3	125
	1.001–2.000	65.0	56.0	6	...	64.0	55.0	2	125
	2.001–3.000	65.0	55.0	6	...	63.0	54.0	2	125
	3.001–4.000	63.0	55.0	6	...	63.0	54.0	2	125
2018-T61	up through 4.000	55.0	40.0	7	10	...	...	...	100
2025-T6	up through 4.000	52.0	33.0	11	16	...	...	...	100
2218-T61	up through 4.000	55.0	40.0	7	10	...	...	...	100
2219-T6	up through 4.000	58.0	38.0	8	10	56.0	36.0	4	100
2618-T61	up through 4.000	58.0	45.0	4	6	55.0	42.0	4	115
3003-H112	up through 4.000	14.0	5.0	18	25	...	...	...	25
4032-T6	up through 4.000	52.0	42.0	3	5	...	...	...	115
5083-H111	up through 4.000	42.0	22.0	14	14	39.0	20.0	12	...
5083-H112	up through 4.000	40.0	18.0	16	16	39.0	16.0	14	...
6061-T6	up through 4.000	38.0	35.0	7	10	38.0	35.0	5	80
6066-T6	up through 4.000	50.0	45.0	8	12	...	...	...	100
6151-T6	up through 4.000	44.0	37.0	10	14	44.0	37.0	6	90
7049-T73	up through 1.000	72.0	62.0	7	10	71.0	61.0	3	135
	1.001–2.000	72.0	62.0	7	10	70.0	60.0	3	135
	2.001–3.000	71.0	61.0	7	10	70.0	60.0	3	135
	3.001–4.000	71.0	61.0	7	10	70.0	60.0	2	135
	4.001–5.000	70.0	60.0	7	10	68.0	58.0	2	135
7050-T74[G]	up through 2.000	72.0	62.0	7	10	68.0	56.0	5	135
	2.001–4.000	71.0	61.0	7	10	67.0	55.0	4	135
	4.001–5.000	70.0	60.0	7	10	66.0	54.0	3	135
	5.001–6.000	70.0	59.0	7	10	66.0	54.0	3	135
7075-T6	up through 1.000	75.0	64.0	7	10	71.0	61.0	3	135
	1.001–2.000	74.0	63.0	7	...	71.0	61.0	3	135
	2.001–3.000	74.0	63.0	7	...	70.0	60.0	3	135
	3.001–4.000	73.0	62.0	7	...	70.0	60.0	2	135
7075-T73	up through 3.000	66.0	56.0	7	...	62.0	53.0	3	125
	3.001–4.000	64.0	55.0	7	...	61.0	52.0	2	125
7075-T7352	up through 3.000	66.0	56.0	7	...	62.0	51.0	3	125
	3.001–4.000	64.0	53.0	7	...	61.0	49.0	2	125
7076-T61	up through 4.000	70.0	60.0	10	14	67.0	58.0	3	140
7175-T74[G]	up through 3.000	76.0	66.0	7	10	71.0	62.0	4	...
7175-T7452[G]	up through 3.000	73.0	63.0	7	10	68.0	55.0	4	...

TABLE 2 *Continued*

Alloy and Temper	Specified Thickness, in.	Specimen Axis Parallel to Direction of Grain Flow[C]				Specimen Axis Not Parallel to Direction of Grain Flow[C]			Brinell Hardness[D], min
		Tensile Strength[E], min, ksi	Yield Strength[E] (0.2 % Offset), min, ksi	Elongation[E] in 2 in. or 4 × Dia, min, %		Tensile Strength[E], min, ksi	Yield Strength[E] (0.2 % Offset), min, ksi	Elongation[E] in 2 in. or 4 × Dia., min, % Forgings	
				Forgings	Separate Test Coupon (from stock or forged)[F]				
7175-T7454[G]	up through 3.000	75.0	65.0	7	10	70.0	61.0	4	...

[A] To determine conformance to this specification, each value for tensile strength and yield strength shall be rounded to the nearest 0.1 ksi and each value for elongation to the nearest 0.5 % (or the nearest 0.1 % if measured in accordance with 7.8.4 of Test Methods B557), in accordance with the rounding-off method of Practice E29.
[B] For the basis for establishment of strength property limits, see Annex A1.
[C] These values apply to standard specimens. For the heat-treatable alloys the thicknesses shown are the maximum thickness at time of heat treatment for which the indicated properties apply. Forgings machined prior to heat treatment shall develop the properties applicable to the heat-treated thickness provided the as-forged thickness is not more than twice the heat-treated thickness.
[D] For information only. The hardness is usually measured on the surface of a forging using a 500-kgf load and 10-mm ball.
[E] Tensile property test requirements in any direction are limited to a minimum material dimension of 2.000 in. because of the difficulty to obtain a tension test specimen suitable for routine control testing.
[F] These values apply to standard ½-in. diameter test specimens machined from the stock used in making the forgings, or from separately forged coupons representative of the forgings.
[G] Beginning with the 1985 issue the T736, T73652, and T73654 tempers were replaced by the T74, T7452, and T7454 tempers respectively as applicable to alloys 7050 and 7175.

4.1.4 Temper (Section 8),

4.1.5 Dimensions (Section 13). A drawing is required for die forgings and for hand forgings whose shapes are not simple rectangles,

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

4.2.1 For die forgings, whether tensile property and grain flow survey shall be made (8.2.1.1),

4.2.2 For die forgings, whether tension tests are required using specimens not parallel to the direction of grain flow and whether such test specimens shall be prepared by a specific method (8.3.1),

4.2.3 For hand forgings, whether tension tests shall be made in other than the long transverse and short transverse directions (8.3.3),

4.2.4 For rolled ring forgings, whether tension tests shall be made in the radial direction (8.3.4),

4.2.5 Whether it is required in tension tests that small elongations shall be measured by a special procedure (8.4.2),

4.2.6 Whether heat treatment in accordance with Practice B918 is required (9.2),

4.2.7 Whether 7075-F material shall meet the requirements for T73 temper (10.3),

4.2.8 Whether ultrasonic inspection is required (Section 14 and Table 4),

4.2.9 Whether liquid-penetrant inspection is required (15.3),

4.2.10 Whether inspection or witness of inspection and tests by the purchaser's representative is required prior to material shipment (Section 16),

4.2.11 Whether certification is required (Section 18),

4.2.12 Whether hand forgings shall be marked for identification (Section 19), and

4.2.13 Whether Practices B660 applies and, if so, the levels of preservation, packaging, and packing required (Section 20).

5. Materials and Manufacture

5.1 The forgings may be manufactured by pressing, hammering, or rolling at the option of the producer.

6. Responsibility for Quality Assurance

6.1 *Responsibility for Inspection and Tests*—Unless otherwise specified in the contract or purchase order, the producer is responsible for the performance of all inspection and test requirements specified herein. The producer may use their own or any other suitable facilities for the performance of the inspection and test requirements specified herein, unless disapproved by the purchaser in the order or at the time of contract signing. The purchaser shall have the right to perform any of the inspection and tests set forth in this specification where such inspections are deemed necessary to ensure that material conforms to prescribed requirements.

6.2 *Lot Definition*—An inspection lot shall be defined as follows:

6.2.1 For heat-treated tempers, an inspection lot shall consist of forgings of the same shape, or a group of forgings of similar size and shape, of the same alloy and heat-treated in the same furnace charge. If forgings are heat-treated in a continuous furnace, forgings charged consecutively during continuous operation of the furnace shall be considered a furnace charge;

TABLE 3 Mechanical Property Limits for Rolled Ring Forgings[A,B,C]

Alloy and Temper	Maximum Heat Treat Section Thickness, in.	Direction	Tensile Strength, min, ksi[D]	Yield Strength (0.2 % Offset), min, ksi[D]	Elongation in 2 in. or 4 × Diameter, min, %
2014-T6 and 2014-T652[E]	up through 2.500	tangential	65.0	55.0	7
		axial	62.0	55.0	3
		radial[F]	60.0	52.0	2
	2.501 to 3.000	tangential	65.0	55.0	6
		axial	62.0	52.0	2
		radial[F]	...	...	...
2219-T6	up through 2.500	tangential	56.0	40.0	6
		axial	55.0	37.0	4
		radial[F]	53.0	35.0	2
2618-T61	up through 2.500	tangential	55.0	41.0	6
		axial	55.0	41.0	5
		radial[F]	...	...	...
6061-T6 and 6061-T652[E]	up through 2.500	tangential	38.0	35.0	10
		axial	38.0	35.0	8
		radial[F]	37.0	33.0	5
	2.501 to 3.500	tangential	38.0	35.0	8
		axial	38.0	35.0	6
		radial[F]	37.0	33.0	4
6151-T6 and 6151-T652[E]	up through 2.500	tangential	44.0	37.0	5
		axial	44.0	35.0	4
		radial[F]	42.0	35.0	2
7075-T6 and 7075-T652[E]	up through 2.000	tangential	73.0	62.0	7
		axial	72.0	61.0	3
		radial[F]	68.0	58.0	2
	2.001 to 3.500	tangential	71.0	60.0	6
		axial	70.0	59.0	3
		radial[F]	...	...	...

[A] To determine conformance to this specification each value for tensile strength and yield strength shall be rounded to the nearest 0.1 ksi and each value for elongation to the nearest 0.5 % (or the nearest 0.1 % if measured in accordance with 7.8.4 of Test Methods B557), in accordance with the rounding-off method of Practice E29.
[B] Tensile property test requirements in any direction are limited to a minimum material dimension of 2.000 in. because of the difficulty to obtain a tension test specimen suitable for routine control testing.
[C] Applicable only to rings which have an OD-to-wall thickness ratio of 10/1 or greater. Those having a smaller ratio shall be the subject of agreement between the purchaser and producer.
[D] The basis for establishment of mechanical property limits is shown in Annex A1.
[E] Forgings may be available in the T651 temper but shall be the subject of agreement between the purchaser and producer.
[F] Radial properties are not specified requirements. For wall thicknesses 2 in. and greater, they will be determined when specifically requested for informational purposes only.

TABLE 4 Ultrasonic Discontinuity Limits for Die and Hand Forgings[A]

Alloy	Thickness, in.	Product	Maximum Weight per Piece, lb	Discontinuity Class[B]
2014	0.500–4.000	die forgings	300	B
2219	0.500–4.000			
7049	0.500–4.000			
7050	0.500–4.000			
7075	0.500–4.000			
7175	0.500–4.000			
2014	1.000–8.000	hand forgings	600	A
2219	1.000–8.000			
7049	1.000–8.000			
7050	1.000–8.000			
7075	1.000–8.000			
7175	1.000–8.000			

[A] Discontinuities in excess of those listed in this table shall be allowed if it is established that they will be removed by machining or that they are in noncritical areas.
[B] The discontinuity class limits are defined in Section 11 of Practice B594.

for such forgings weighing 5 lb or less the maximum weight of a lot shall be 2000 lb, and for heavier forgings it shall be 6000 lb.

6.2.2 For nonheat-treated tempers, an inspection lot shall consist of an identifiable quantity of forgings of similar size and shape of the same alloy and temper subjected to inspection at one time.

7. Chemical Composition

7.1 *Limits*—The forgings shall conform to the chemical composition limits specified in Table 1. Conformance shall be determined by the producer by taking samples in accordance with E716 when the ingots are poured and analyzing those samples in accordance with Test Methods E607, E1251, E34, or EN 14242. At least one sample shall be taken for each group of ingots poured simultaneously from the same source of molten metal. If the producer has determined the chemical composition during pouring of the ingots, they shall not be required to sample and analyze the finished product.

7.2 If it becomes necessary to analyze forgings for conformance to chemical composition limits, the methods of sampling and methods of analysis shall be as provided in the following:

7.2.1 *Methods of Sampling*—Samples for chemical analysis shall be taken in accordance with B985.

7.2.2 *Methods of Analysis*—Analysis shall be performed in accordance with Test Methods E607, E1251, E34, or EN 14242.

NOTE 3—It is standard practice in the United States aluminum industry to determine conformance to the chemical composition limits prior to further processing of ingots into wrought products. Due to the continuous nature of the process, it is not practical to keep a specific ingot analysis identified with a specific quantity of finished material.

8. Mechanical Properties of Material as Supplied

8.1 *Limits:*

8.1.1 Die forgings shall conform to the tensile requirements in Table 2.

8.1.1.1 Die forgings shall be capable of conforming to the Brinell hardness requirements in Table 2 when measured at or near the surface, except that in case of question the basis for acceptance shall be conformance with the specified minimum tensile requirements of Table 2.

8.1.2 Hand forgings shall conform to the tensile requirements in Table 5.

8.1.3 Rolled ring forgings shall conform to the tensile property requirements in Table 3.

8.2 *Number of Specimens:*

8.2.1 For die forgings, hand forgings, and rolled ring forgings, there shall be at least one tension specimen taken from each lot (see 6.2).

8.2.1.1 For die forgings, when specified, a grain-flow pattern and tensile-property survey shall be made on a forging representative of the first production parts (see 8.3.2). It shall be repeated after any major change in forging technique.

8.3 *Test Specimen:*

8.3.1 For die forgings, unless otherwise specified by the purchaser at the time of placing the order, test specimens shall be prepared with the axis of the specimen as nearly parallel to the direction of maximum metal flow as possible, and, at the option of the forging producer, by one of the following methods:

8.3.1.1 *Method 1*—Machined from a section of the stock used in making the forgings.

8.3.1.2 *Method 2*—Machined from a coupon forged from the stock.

8.3.1.3 *Method 3*—Machined from a prolongation of the forging.

8.3.1.4 *Method 4*—Machined from one of the forgings in the lot.

NOTE 4—Test specimens obtained by Method 1, 2, or 3 will usually have different properties from those obtained by Method 4. Samples obtained by Methods 1, 2, or 3 indicate only the general strength level of the forging that would be obtained with proper heat treatment.

8.3.1.5 Specimens representing heat-treated forgings shall be heat-treated with the forgings they represent or shall be machined from coupons that have been so treated.

8.3.2 If required, a die forging representative of the first production parts shall be selected after forging techniques have been established, and shall be tested as follows:

8.3.2.1 Tension test specimens shall be taken in two directions: (*1*) substantially parallel to, and (*2*) not parallel to the forging flow lines. The locations shall be as indicated on the forging engineering drawing or, if not indicated, from generally representative areas.

8.3.2.2 A sample forging shall be sectioned at the locations of the specimens, to show the grain flow.

8.3.3 For hand forgings, the specimens shall be taken from a prolongation of the forgings or from a forging chosen to represent the lot. Tests will regularly be made only in the long transverse and short transverse directions, but when required by the purchaser tests shall also be made in the longitudinal direction.

8.3.4 For rolled ring forgings, the specimens shall be taken from a prolongation of the forging or from a forging chosen to represent the lot. Unless otherwise specified, rolled ring forging sections shall be taken from an area representative of the center of mass where size permits. Tests will regularly be made only in the tangential and axial directions, but when required by the purchaser tests shall also be made in the radial direction for informational purposes.

8.4 *Test Methods:*

8.4.1 The tension tests shall be made in accordance with Test Method B557.

8.4.2 If required when the specified elongation is less than 3 % and the elongation measured in the usual manner is less than 4 %, the elongation of round tension specimens shall be measured in accordance with 7.8.4 of Test Methods B557.

8.4.3 Brinell hardness tests shall be made in accordance with Test Method E10, by applying a 500-kgf load on a 10-mm ball for 10 to 15 s. Other equivalent combinations of load and ball or alternative methods of testing may be used if desired provided that, in case of dispute, the results secured with the 500-kgf load and 10-mm ball shall be the basis of acceptance.