Designation: B918/B918M – 17a

Standard Practice for Heat Treatment of Wrought Aluminum Alloys[1]

This standard is issued under the fixed designation B918/B918M; 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 practice is intended for use in the heat treatment of wrought aluminum alloys for general purpose applications.

1.1.1 The heat treatment of wrought aluminum alloys used in specific aerospace applications is covered in AMS 2772.[2]

1.1.2 Heat treatment of aluminum alloy castings for general purpose applications is covered in Practice B917/B917M.

1.2 Times and temperatures appearing in the heat-treatment tables are typical for various forms, sizes, and manufacturing methods and may not provide the optimum heat treatment for a specific item.

1.3 Some alloys in the 6xxx series may achieve the T4 temper by quenching from within the solution temperature range during or immediately following a hot working process, such as upon emerging from an extrusion die. Such alternatives to furnace heating and immersion quenching are indicated in Table 2, by Footnote *L*, for heat treatment of wrought aluminum alloys. However, this practice does not cover the requirements for a controlled extrusion press or hot rolling mill solution heat treatment. (Refer to Practice B807 for extrusion press solution heat treatment of aluminum alloys and to Practice B947 for hot rolling mill solution heat treatment of aluminum alloys.)[3]

1.4 *Units*—The values stated in either Metric or US Customary 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 nonconformance with the standard.

1.5 *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.*

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 The following documents, of the issue in effect on the date of material purchase, form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards:*[3]

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

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

B881 Terminology Relating to Aluminum- and Magnesium-Alloy Products

B917/B917M Practice for Heat Treatment of Aluminum-Alloy Castings from All Processes

G69 Test Method for Measurement of Corrosion Potentials of Aluminum Alloys

2.3 *American National Standard:*

H35.1/H35.1(M) Alloy and Temper Designation Systems for Aluminum[4]

3. Terminology

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

3.2 *Definition of Pyrometry Terms Specific to This Standard:*

3.2.1 *control sensor, n*—sensor connected to the furnace temperature controller, which may or may not be recording.

[1] This practice 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] Available from SAE International, 400 Commonwealth Dr., Warrendale, PA 15096-0001, http://www.sae.org.

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

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

TABLE 1 Tests Required

Product Form	Tensile Properties[A]	Heat-treat-induced Porosity[B] [Periodic Test]	Intergranular Corrosion[C] [Periodic Test]	Diffusion (Alclad Only)[D] [Periodic Test]	Eutectic Melting [Periodic Test]
Plate and sheet	X	X	X[E]	X	X
Wire, rod, bar, and profiles	X	X	X	. . .	X
Forgings	X	X	X	. . .	X
Tubing	X	X	. . .	X	X
Rivets, fastener components	X	X	X	. . .	X

[A] Those specified in the applicable procurement material specification for lot release.
[B] Applicable only to material solution heat-treated in air furnaces.
[C] Applicable to the most quench-sensitive alloys-tempers in the following order of preference: (*1*) 2xxx in -T3 or -T4 and (*2*) 7xxx in -T6 temper. No test is required if 2xxx-T3 or -T4 or 7xxx-T6, was not solution heat-treated during the period since the prior verification test.
[D] Not applicable for thicknesses less than 0.020 in.
[E] Applicable to periodic testing of sheet product only.

3.2.2 *load sensor, n*—sensor that is attached to the production material or a representation of production material, that supplies temperature data of the production material to process instrumentation.

3.2.3 *monitoring sensor, n*—sensor connected to the monitoring instrument.

3.2.4 *test sensor, n*—sensor used in conjunction with a test instrument to perform a system accuracy test or temperature uniformity survey.

4. Equipment

4.1 *Heating Media*—Aluminum alloys are typically heat-treated in air chamber furnaces or molten salt baths; however, lead baths, oil baths, or fluidized beds, may be used. The use of uncontrolled heating is not permitted. Whichever heating means are employed, careful evaluation is required to ensure that the alloy being heat-treated responds properly to heat-treatment and is not damaged by overheating or by the heat-treatment environment.

4.1.1 Air chamber furnaces may be oil- or gas-fired or may be electrically heated. Furnace components that are significantly hotter than the metal should be suitably shielded for metal less than 0.250 in. [6.35 mm] thick to prevent adverse radiation effects. The atmosphere in air chamber furnaces must be controlled to prevent potential porosity resulting from solution heat treatment (see Note 1). The suitability of the atmosphere in an air-chamber furnace can be demonstrated by testing, in accordance with 7.4.2.1, that products processed in that furnace are free from heat-treat induced porosity.

NOTE 1—Heat-treat induced porosity may lower mechanical properties and commonly causes blistering of the surface of the material. The condition is most likely to occur in furnaces in which the products of combustion contact the work, particularly if the gases are high in water vapor or contain compounds of sulfur. In general, the high-strength wrought alloys of the 2xxx and 7xxx series are most susceptible. Low-strength and Alclad (two sides) products are practically immune to this type of damage. Anodic films and proprietary heat-treat coatings are also useful in protecting against porosity resulting from solution heat treatment. Surface discoloration is a normal result of solution heat treatment of aluminum alloys and should not be interpreted as evidence of damage from overheating or as heat-treat induced porosity (see 7.4.2.1).

4.1.2 Salt baths heat the work rapidly and uniformly. The temperature of the bath can be closely controlled, an important consideration in solution heat treatment of wrought aluminum alloys. High-temperature oxidation of aluminum is not a problem in salt baths.

4.2 *Furnace Temperature Uniformity and Calibration Requirements:*

4.2.1 After establishment of thermal equilibrium or a recurrent temperature pattern, the temperature in the working (soaking) zone, for all furnace control and test sensors, shall maintain temperature in the working (soaking) zone within the following allowable ranges:

4.2.1.1 *Annealing:*

(1) 50°F [28°C] range for furnaces used only for full annealing at 825°F [441°C] and higher. Annealing temperatures shall be controlled so as to preclude any material exceeding the lowest solution heat treating temperature for the alloy being annealed in accordance with Table 2. In the case of a practice in accordance with Table 2 with only a specified single solution heat treat temperature, the temperature shall not exceed the single provided temperature minus 10°F/6°C.

(2) For furnaces used only for full annealing below 825°F [441°C] and for stress relieving, there are no temperature uniformity requirements.

4.2.1.2 30°F [17°C] range for furnaces used only for solution heat treatment of those 6xxx alloys for which Table 2 specifies a range from 30°F [17°C] or more.

4.2.1.3 20°F [12°C] range for furnaces used for other solution heat treatment specified in Table 2 and any aging heat treatment.

4.2.2 *Temperature-Measuring System Accuracy Test*—The accuracy of temperature-measuring system shall be checked weekly or monthly if metal load sensors are placed with the load or if sensors are located to best represent the hottest and coldest temperatures based on the most recent temperature uniformity survey under operating conditions. This check should be made by inserting a calibrated test temperature-sensing element adjacent to the furnace temperature-sensing element and reading the test temperature-sensing element with a calibrated test potentiometer. When the furnace is equipped with dual potentiometer measuring systems which are checked weekly against each other, the preceding checks may be conducted every three months rather than every week. The test temperature-sensing element, potentiometer, and cold junction compensation combination shall have been calibrated against National Institute of Standards and Technology (NIST) or equivalent national standard primary or secondary certified temperature-sensing elements, within the previous three

TABLE 2 Recommended Heat Treatment for Wrought Aluminum Alloys[A]

Product	Solution Heat Treatment			Precipitation Heat Treatment[B]		
	Metal Temperature, ±10°F [±6°C][C,D]	Quench Temperature, °F [°C][E]	Temper	Metal Temperature, ±10°F [±6°C]	Time at Temperature, h	Temper
2011 Alloy[A]						
Cold-finished wire, rod, and bar	945–995 [507–535]	110 [43] max	T3[F]	320 [160]	14	T8[F]
			T4	...	...	...
			T451[G]	...	...	...
Drawn tube	975 [524]	110 [43] max	T3[F]	320 [160]	14	T8[F]
			T4511[G]	...	...	...
2014 Alloy[A]						
Flat sheet, bare or Alclad	925–945 [496–507]	110 [43] max	T3[F]	...	...	...
	935 [502]		T42	320 [160]	18–20	T62
Coiled sheet, bare or Alclad	925–945 [496–507]	110 [43] max	T4	320 [160]	18	T6
	935 [502]		T42	320 [160]	18–20	T62
Plate, bare or Alclad	925–945 [496–507]	110 [43] max	T451[G]	320 [160]	18	T651[G]
	935 [502]		T42	350 [177]	8–9	T62
Cold-finished wire, rod, and bar	925–945 [496–507]	110 [43] max	T4	350 [177]	9	T6
			T451[H]	350 [177]	9	T651[H]
	935 [502]		T42	350 [177]	8–9	T62
Extruded wire, rod, bar, profiles, and tube	925–945 [496–507]	110 [43] max	T4	350 [177]	9	T6
			T4510[H]	350 [177]	9	T6510[H]
			T4511[H]	350 [177]	9	T6511[H]
	935 [502]		T42	350 [177]	8–9	T62
Drawn tube	925–945 [496–507]	110 [43] max	T4	350 [177]	9	T6
	935 [502]		T42	350 [177]	8–9	T62
Die forgings	925–945 [496–507]	140–180 [60–82]	T4	350 [177]	9	T6
Hand forgings and rolled rings	925–945 [496–507]	140–180 [60–82]	T4	350 [177]	9	T6
	935 [502]		T452[I]	350 [177]	10	T652[I]
2017 Alloy[A]						
Cold-finished wire, rod, and bar	925–950 [496–510]	110 [43] max	T4	...	...	...
			T451[H]	...	...	...
			T42	...	...	...
2018 Alloy[A]						
Die forgings	940–970 [504–521]	212 [100]	T4	340 [171]	10	T61
2024 Alloy[A]						
Flat sheet, bare or Alclad	910–930 [488–499]	110 [43] max	T3[F]	375 [191]	12	T81[F]
	920 [493]		T361[J]	375 [191]	8	T861[J]
			T42	375 [191]	9–10	T62
			T42	375 [191]	16–18	T72
Coiled sheet, bare or Alclad	910–930 [488–499]	110 [43] max	T4	375 [191]	9–10	T6
	920 [493]		T42	375 [191]	9	T62
			T42	375 [191]	16–18	T72
Plate, bare or Alclad	910–930 [488–499]	110 [43] max	T351[G]	375 [191]	12	T851[G]
	920 [493]		T361[J]	375 [191]	8	T861[J]
			T42	375 [191]	9–10	T62
Cold-finished wire, rod, and bar	910–930 [488–499]	110 [43] max	T351[H]	375 [191]	12	T851[H]
			T36[J]	...	...	...
			T4	375 [191]	12	T6
	920 [493]		T42	375 [191]	12–13	T62
Extruded wire, rod, bar, profiles, and tube	910–930 [488–499]	110 [43] max	T3[F]	375 [191]	12	T81[F]
			T3510[H]	375 [191]	12	T8510[H]
			T3511[H]	375 [191]	12	T8511[H]
	920 [493]		T42	375 [191]	12–13	T62
Drawn tube	910–930 [488–499]	110 [43] max	T3[F]	375 [191]	12	T8[F]
	920 [493]		T42	375 [191]	9–10	T62
Die Forgings	910–930 [488–499]	110 [43] max	T3[F]	375 [191]	11	T81[F]
2025 Alloy[A]						
Die forgings	950–970 [510–521]	140–160 [60–71]	T4	350 [177]	9	T6
2117 Alloy[A]						
Cold-finished, wire or rod	925–950 [496–510]	110 [43] max	T4	...	...	...

TABLE 2 *Continued*

Product	Solution Heat Treatment			Precipitation Heat Treatment[B]		
	Metal Temperature, ±10°F [±6°C][C,D]	Quench Temperature, °F [°C][E]	Temper	Metal Temperature, ±10°F [±6°C]	Time at Temperature, h	Temper
			2124 Alloy[A]			
Plate	910–930 [488–499]	110 [43] max	T3[F]	375 [191]	12	T8[F]
			T31[G]	370 [188]	12	T8151[G]
			T4	375 [191]	9	T6
	920 [493]		T3[F]	375 [191]	12	T82[F]
			T42	375 [191]	10	T62
			2218 Alloy[A]			
Die forgings	940–960 [504–516]	212 [100]	T4	340 [171]	10	T61
			T4	460 [238]	6	T7
	950 [510]		T4	340 [171]	10	T62
			T4	460 [238]	6	T72
			2219 Alloy[A]			
Flat sheet, bare or Alclad	985–1005 [529–541]	110 [43] max	T31[F]	350 [177]	18	T81[F]
			T37[K]	325 [163]	24	T87[K]
	995 [535]		T42	375 [191]	17–19	T62
Plate	985–1005 [529–541]	110 [43] max	T37[K]	325 [163]	17–19	T87[K]
			T351[G]	350 [177]	18	T851[G]
	995 [535]		T42	375 [191]	35–37	T62
Cold-finished wire, rod, and bar	985–1005 [529–541]	110 [43] max	T4	375 [191]	18	T6
			T351[H]	375 [191]	18	T851[H]
Extruded wire, rod, bar, profiles, and tube	985–1005 [529–541]	110 [43] max	T31[F]	375 [191]	18	T81[F]
			T3510[H]	375 [191]	18	T8510[H]
			T3511[H]	375 [191]	18	T8511[H]
	995 [535]		T42	375 [191]	35–37	T62
			T3	375 [191]	17–19	T82
Die forgings and rolled rings	985–1005 [529–541]	110 [43] max	T4	375 [191]	26	T6
	995 [335]		T42	375 [191]	25–27	T62
			T352[I]	350 [177]	17–19	T82[I]
Hand forgings	985–1005 [529–541]	110 [43] max	T4	375 [191]	26	T6
	995 [335]		T42	375 [191]	25–27	T62
			T352[I]	350 [177]	17–19	T852[I]
			2618 Alloy[A]			
Die, hand, and rolled ring forgings	975–995 [524–535]	212 [100]	T4	390 [199]	20	T61
	985 [529]		T42	390 [199]	19–21	T62
			4032 Alloy			
Die forgings	940–970 [504–521]	140–180 [60–82]	T4	340 [171]	10	T6
	955 [513]		T42	340 [171]	9–11	T62
			6005 Alloy			
Extruded rod, bar, profiles, and tube	. . .[L]	. . .	T1	350 [177]	8	T5
			6005A Alloy			
Extruded rod, bar, profiles, and tube	. . .[L]	. . .	T1	350 [177]	8	T5
			T4	350 [177]	8	T61
			6013 Alloy[A]			
Sheet, bare	1045–1065 [563–574]	110 [43] max	T4	375 [191]	4	T6
				or 345 [174]	8	
	1000 [538]		T42	375 [191]	4–5	T62
Plate, bare	1020–1050 [549–566]	110 [43] max	. . .	345 [174]	8–16	T651[G]
Cold-finished wire, rod, and bar	1040–1060 [560–571]	110 [43] max	. . .	375 [191]	4	T651[H]
			. . .	375 [191]	4	T8[F]
			6020 Alloy[A]			
Rod, bar & extrusion	1010–1050 [543–566]	110 [43] max	W[U]	355 [176]	8–10	T6511[H]
Wire, rod, & bar	1010–1050 [543–566]	110 [43] max	W[U]	355 [176]	8–10	T8[F]
			6053 Alloy[A]			
Cold-finished wire and rod	960–980 [516–527]	110 [43] max	T4	355 [179]	8	T61
Die forgings	960–980 [516–527]	110 [43] max	T4	340 [171]	10	T6
	970 [521]		T42	340 [171]	10	T62
			6061 Alloy[A]			
Sheet, bare or Alclad	960–1075 [516–579][M]	110 [43] max	T4	320 [160]	18	T6
	985 [529]		T42	350 [177]	8–10	T62
			T42[Z]	320 [160][Z]	17–19[Z]	T62[Z]

TABLE 2 *Continued*

Product	Solution Heat Treatment			Precipitation Heat Treatment[B]		
	Metal Temperature, ±10°F [±6°C][C,D]	Quench Temperature, °F [°C][E]	Temper	Metal Temperature, ±10°F [±6°C]	Time at Temperature, h	Temper
			6061 Alloy[A] *(Continued)*			
Plate	960–1075 [516–579]	110 [43] max	T451[G]	320 [160]	18	T651[G]
	985 [529]		T42	350 [177]	18	T62
Tread Sheet and Plate[N,O]	960–1075 [516–579]	110 [43] max	T4	320 [160]	18	T6
Cold-finished wire, rod, and bar	960–1075 [516–579]	110 [43] max[P]	T4	350 [177]	8	T6
				or 320 [160]	18	
			T3[F]	340 [171]	8	T89[Q,R]
				or 320 [160]	18	
			T4	350 [177]	8	T94[S]
			T451[H]	350 [177]	8	T651[H]
	985 [529]		T42	350 [177]	8–10	T62
Extruded rod, bar, profiles, and tube	. . .[L]	. . .	T1	350 [177]	8	T51
	960–1075 [516–579][L]	110 [43] max[P]	T4	350 [177]	8	T6
			T4510[H]	350 [177]	8	T6510[H]
			T4511[H]	350 [177]	8	T6511[H]
	985 [529]		T42	350 [177]	8–10	T62
Structural profiles	960–1075 [516–579][L]	110 [43] max[P]	T4	350 [177]	8	T6
Pipe	960–1075 [516–579][L]	110 [43] max[P]	T4	350 [177]	8	T6
Drawn tube	960–1075 [516–579]	110 [43] max	T4	320 [160]	18	T6
				or 340 [171]	8	
	985 [529]		T42	340 [171]	8	T62
Die and hand forgings	960–1075 [516–579]	110 [43] max	T4	350 [177]	8	T6
				or 340 [171]	10	
Rolled rings	960–1075 [516–579]	110 [43] max	T4	350 [177]	8	T6
	985 [529]		T452[T]	350 [177]	8–10	T652[T]
			6063 Alloy			
Extruded rod, bar, tube, and profiles	. . .[L]	. . .	T1	400 [204]	1–2	T5
				or 360 [182]	3	
			T1	400 [204]	1–2	T52
				or 360 [182]	3	
	960–1010 [516–543][L]	110 [43] max[P]	T4	350 [177]	8	T6
				or 360 [182]	6	
	985 [529]		T42	350 [177]	8–10	T62
Drawn tube	960–1010 [516–543]	110 [43] max	T4	350 [177]	8	T6
			T3[F]	350 [177]	8	T83[R]
			T3[F]	350 [177]	8	T831[R]
			T3[F]	350 [177]	8	T832[R]
			T31[F]	. . .	. . .	. . .
	985 [529]		T42	350 [177]	8–10	T62
Pipe	960–1010 [516–543][L]	110 [43] max[P]	T4	360 [182]	6	T6
				or 350 [177]	8	
			6066 Alloy			
Extruded rod, bar, profiles, and tube	960–1010 [516–543]	110 [43] max	T4	350 [177]	8	T6
			T4510[H]	350 [177]	8	T6510[H]
			T4511[H]	350 [177]	8	T6511[H]
	985 [529]		T42	350 [177]	8–10	T62
Die forgings	960–1010 [516–543]	110 [43] max	T4	350 [177]	8	T6
			6070 Alloy			
Extruded rod, bar, profiles, and tube	1015 [546][L]	110 [43] max	T4	320 [160]	18	T6
			T42	320 [160]	18	T62
			6082 Alloy			
Extruded rod, bar, profiles, and tube	980 [527][L]	. . .	T1	350 [177]	8	T5
			T1	350 [177]	8	T5511[H]
			6101 Alloy			
Extruded rod, bar, profiles, and tube	970 [521][L]	110 [43] max[P]	T4	390 [199]	10	T6
			T4	440 [227]	5	T61
			T4	410 [210]	9	T63
			T4	535 [279]	7	T64
			T4	430 [221]	3	T65

TABLE 2 *Continued*

Product	Solution Heat Treatment			Precipitation Heat Treatment[B]		
	Metal Temperature, ±10°F [±6°C][C,D]	Quench Temperature, °F [°C][E]	Temper	Metal Temperature, ±10°F [±6°C]	Time at Temperature, h	Temper
			6105 Alloy			
Extruded rod, bar, profiles, and tube	. . .[L]	. . .	T1	350 [177]	8	T5
			T4	350 [177]	8	T6
			6110 Alloy			
Cold-finished wire, rod, and bar	980–1050 [527–566]	110 [43] max	T4[S]	380 [193]	8	T9[S]
			6151 Alloy			
Die forgings	950–980 [510–527]	110 [43] max	T4	340 [171]	10	T6
Rolled rings	960 [516]	110 [43] max	T4	340 [171]	10	T6
			T452[I]	340 [171]	10	T652[I]
			6162 Alloy			
Extruded rod, bar, profiles, and tube	. . .[L]	. . .	T1	350 [177]	8	T5
			T1510	350 [177]	8	T5510
			T1511	350 [177]	8	T5511
	980 [527][L]	. . .	T4	350 [177]	8	T6
			T4510	350 [177]	8	T6510
			T45111	350 [177]	8	T6511
			6201 Alloy			
Wire	950 [510]	110 [43] max	T3	320 [160]	4	T81[R]
			6262 Alloy			
Cold-finished wire, rod, and bar	960–1050 [516–566]	110 [43] max	T4	340 [171]	8	T6
			T4	340 [171]	8	T9[S]
			T451[H]	340 [171]	8	T651[H]
	1005 [541]		T42	340 [171]	8	T62
Extruded rod, bar, profiles, and tube	960–1050 [516–566][L]	110 [43] max	T4	350 [177]	12	T6
			T4510[H]	350 [177]	12	T6510[H]
			T4511[H]	350 [177]	12	T6511[H]
	1005 [541]		T42	350 [177]	11–13	T62
Drawn tube	960–1050 [516–566]	110 [43] max	T4	340 [171]	8	T6
			T4[S]	340 [171]	8	T9[S]
	1005 [541]		T42	340 [171]	8	T62
			6351 Alloy			
Extruded rod, bar, profiles, and tube	. . .[L]	. . .	T1	350 [177]	8	T5
				350 [177]	8	T51
	. . .[L]	. . .	T11	250 [121]	10	T54
				or 350 [177]	8	
	960–1010 [516–543][L]	110 [43] max[P]	T4	350 [177]	8	T6
			6463 Alloy			
Extruded rod, bar, profiles, and tube	. . .[L]	. . .	T1	400 [204]	1	T5
				or 360 [182]	3	
	970 [521][L]	110 [43] max[P]	T4	350 [177]	8	T6
				or 360 [182]	6	
			7005 Alloy			
Extruded rod, bar, and profiles	. . .[L]	. . .	T1	room temperature	72 plus	T53
				225 [107]	8 plus	
				300 [149]	16	
			7049 Alloy[A]			
Extruded rod, bar, and profiles	860-900 [460-482]	110 [43] max	W511[H,U]	room temperature	48 plus	T76511[H]
				250 [121]	24 plus	
				375 [163]	13	
			W511[H,U]	room temperature	48 plus	T73511[H]
				250 [121]	24 plus	
				330 [166]	17	
Die and hand forgings	860–900 [460–482]	140–160 [60–71]	W[U]	room temperature	48 plus	T73
				250 [121]	8–24	
				340 [171]	6–16	
			W51[I,U]	room temperature	8–24 plus	T7351[I]
				250 [121]	8–24 plus	
				335 [168]	6–16	
	875 [468]		W52[I,U]	room temperature	24 plus	T7352[I]
				250 [151]	8–24 plus	
				330 [166]	6–16	
			W[U]	room temperature	48 min	T732
					24 min	
					13–14	