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Standard Specification for Titanium and Titanium Alloy Castings¹

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This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This specification covers titanium and titanium alloy castings intended for general corrosion resistant and industrial applications, as follows:

- 1.1.1 *Grade C-2*—UNS R52550. Unalloyed titanium,
- 1.1.2 *Grade C-3*—UNS R52550. Unalloyed titanium,
- 1.1.3 *Grade C-5*—UNS R56400. Titanium alloy (6 % aluminum, 4 % vanadium),
- 1.1.4 *Grade C-7*—UNS R52700. Unalloyed titanium plus 0.12 to 0.25 % palladium,
- 1.1.5 *Grade C-8*—UNS R52700. Unalloyed titanium plus 0.12 to 0.25 % palladium,
- 1.1.6 *Grade C-9*—UNS R56320. Titanium alloy (3 % aluminum, 2.5 % vanadium),
- 1.1.7 *Grade C-12*—UNS R53400. Titanium alloy (0.3 % molybdenum, 0.8 % nickel),
- 1.1.8 *Grade C-16*—UNS R52402. Unalloyed titanium plus 0.04 to 0.08 % palladium,
- 1.1.9 *Grade C-17*—UNS R52252. Unalloyed titanium plus 0.04 to 0.08 % palladium, and
- 1.1.10 *Grade C-38*—UNS R54250. Titanium alloy (4 % aluminum, 2.5 % vanadium, 1.5 % iron).

1.2 This specification is intended for use of purchasers and/or producers of reactive metal castings for defining the requirements and assuring the properties of castings for unique corrosion-resistant applications, that is, not for commodity items which must meet all potential purchasers' requirements.

1.2.1 Users are advised to use the specification as a basis for obtaining castings which will meet minimum acceptance requirements established and revised by consensus of the members of the committee.

1.2.2 User requirements considered more stringent may be met by the addition to the purchase order of one or more supplementary requirements, which may include, but are not limited to, those listed in Sections S1 through S8.

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 *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 *ASTM Standards*:²

- A802/A802M Practice for Steel Castings, Surface Acceptance Standards, Visual Examination
- E8 Test Methods for Tension Testing of Metallic Materials
- E10 Test Method for Brinell Hardness of Metallic Materials
- E18 Test Methods for Rockwell Hardness of Metallic Materials
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E94 Guide for Radiographic Examination Using Industrial Radiographic Film
- E142 Method for Controlling Quality of Radiographic Testing (Withdrawn 2000)³
- E165 Practice for Liquid Penetrant Examination for General Industry
- E446 Reference Radiographs for Steel Castings Up to 2 in. (50.8 mm) in Thickness
- E539 Test Method for Analysis of Titanium Alloys by X-Ray Fluorescence Spectrometry
- E1409 Test Method for Determination of Oxygen and Nitrogen in Titanium and Titanium Alloys by Inert Gas Fusion
- E1447 Test Method for Determination of Hydrogen in Titanium and Titanium Alloys by Inert Gas Fusion Thermal Conductivity/Infrared Detection Method

¹ This specification is under the jurisdiction of ASTM Committee B10 on Reactive and Refractory Metals and Alloys and is the direct responsibility of Subcommittee B10.01 on Titanium.

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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.

³ The last approved version of this historical standard is referenced on www.astm.org.

E1941 Test Method for Determination of Carbon in Refractory and Reactive Metals and Their Alloys by Combustion Analysis

E2371 Test Method for Analysis of Titanium and Titanium Alloys by Direct Current Plasma and Inductively Coupled Plasma Atomic Emission Spectrometry (Performance-Based Test Methodology)

E2626 Guide for Spectrometric Analysis of Reactive and Refractory Metals (Withdrawn 2017)³

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *lot, n*—shall consist of all castings of the same design produced from the same pour.

3.1.2 *pour, n*—shall consist of all material melted and cast at one time.

4. Ordering Information

4.1 Orders for castings to this specification shall include the following as required, to describe the requirements adequately:

4.1.1 Description of the castings by pattern number or drawing. Dimensional tolerances shall be included on the casting drawing,

4.1.2 Quantity,

4.1.3 Grade designation (see Table 1),

4.1.4 Options in the specification, and

4.1.5 Supplementary requirements desired, including the standards of acceptance.

5. Materials and Manufacture

5.1 Materials for this specification shall be melted by conventional processes used for reactive metals. Typical methods include the consumable electrode and induction-slag, plasma arc, induction-skull, and electron beam melting processes.

6. Chemical Composition

6.1 *Pour Analysis*—An analysis of each pour shall be made by the producer from a sample such as a casting or test bar that is representative of the pour. The chemical composition determined shall conform to the requirements specified for the relevant grade in Table 1.

6.1.1 The elements listed in Table 1 are intentional alloy additions or elements which are inherent to the manufacture of titanium sponge, ingot or mill product.

6.1.1.1 Elements other than those listed in Table 1 are deemed to be capable of occurring in the grades listed in Table 1 by and only by way of unregulated or unanalyzed scrap additions to the ingot melt. Therefore product analysis for elements not listed in Table 1 shall not be required unless specified and shall be considered to be in excess of the intent of this specification.

6.1.2 Elements intentionally added to the melt must be identified, analyzed, and reported in the chemical analysis.

6.2 When agreed upon by the producer and the purchaser and requested by the purchaser in his written purchase order, chemical analysis shall be completed for specific residual elements not listed in this specification.

6.3 *Product Analysis*—Product analysis tolerances do not broaden the specified heat analysis requirements, but cover variations between laboratories in the measurement of chemical content. The producer shall not ship material which is outside the limits specified in Table 1 for the applicable grade. Product analysis limits shall be as specified in Table 2.

6.4 *Sampling*—Samples for chemical analysis may be made by the purchaser on a representative casting from any lot. Due to the possibility of oxygen or other interstitial contamination, samples for oxygen, carbon, hydrogen, and nitrogen analysis shall be taken no closer than ¼ in. (6.3 mm) to a cast surface except that castings too thin for this shall be analyzed on representative material. The chemical composition determined shall conform to the analysis in Table 1 within the check analysis variations shown in Table 2 or shall be subject to rejection by the purchaser.

7. Heat Treatment

7.1 Unless otherwise specified in the contract, all castings will be supplied in the as-cast condition except when post-weld heat treatment is required.

7.2 If post-weld heat treatment is required, it shall consist of a stress relief performed at 1075 ± 25°F (580 ± 14°C) for Grades C-2, C-3, C-7, C-8, C-12, C-16 and C-17, and 1200 ± 25°F (650 ± 14°C) for Grades C-5, C-6, C-9, C-18, and C-38. Time at temperature shall be a minimum of ½ h plus an additional ½ h at temperature per inch of thickness for section sizes greater than 1 in. (25 mm). After heat treatment, the castings should be cooled in air or in the furnace to ambient temperature unless otherwise agreed upon between the purchaser and producer.

8. Methods of Chemical Analysis

8.1 The chemical analysis shall normally be conducted using the ASTM standard test methods referenced in 2.1. Other industry standard methods may be used where the ASTM test methods in 2.1 do not adequately cover the elements in the material or by agreement between the producer and purchaser. Alternate techniques are discussed in Guide E2626.

9. Workmanship, Finish, and Appearance

9.1 All castings shall be made in a workman-like manner and shall conform to the dimensions in drawings furnished by the purchaser before manufacturing is started. If the pattern is supplied by the purchaser, the dimensions of the casting shall be as predicted by the pattern.

9.2 The surface of the casting shall be free of adhering mold material, scale, cracks, and hot tears as determined by visual examination. Other surface discontinuities shall meet the visual acceptance standards specified in the order. Practice A802/A802M or other visual standards may be used to define acceptable surface discontinuities and finish. Unacceptable surface discontinuities shall be removed and their removal verified by visual examination of the resultant cavities.