



International Standard

ISO 16468

Investment castings (steel, nickel alloys and cobalt alloys) — General technical requirements

*Pièces moulées en cire perdue (acier, alliages de nickel et alliages
de cobalt) — Exigences techniques générales*

**Third edition
2025-05**

iteh Standards
(<https://standards.iteh.ai>)
Document Preview

ISO 16468:2025

<https://standards.iteh.ai/catalog/standards/iso/ed07aa6d-37da-4cfe-805f-aa43073c33b2/iso-16468-2025>

iTeh Standards
(<https://standards.itih.ai>)
Document Preview

ISO 16468:2025

<https://standards.itih.ai/catalog/standards/iso/ed07aa6d-37da-4cfe-805f-aa43073c33b2/iso-16468-2025>



COPYRIGHT PROTECTED DOCUMENT

© ISO 2025

All rights reserved. Unless otherwise specified, or required in the context of its implementation, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

Contents

Page

Foreword	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Materials and manufacture	2
4.1 Melting process	2
4.2 Remelting process	2
5 Inspection and testing	2
5.1 General requirements	2
5.2 Sampling	2
6 Retests	7
7 Cleaning and dressing	8
8 Quality	8
9 Production welds	8
10 Supplementary requirements	8
10.1 General	8
10.2 Agreed manufacturing procedure	8
10.3 Magnetic particle inspection	8
10.4 Radiographic inspection	8
10.5 Liquid penetrant inspection	8
10.6 Ultrasonic inspection	9
10.7 Inspection of weld preparation	9
10.8 Prior agreement relating to major finishing welds	9
10.9 Impact test at low temperatures	9
10.10 Hardness test	9
10.10.1 Brinell	9
10.10.2 Rockwell	9
10.10.3 Vickers	9
10.11 Specified ferrite range in austenitic and austenitic ferritic stainless steels	9
10.12 Unspecified elements	9
10.13 Test material removed from castings	10
10.14 Tensile test blocks and specimen locations for castings	10
10.15 Weld maps (sketches)	10
10.16 Chemical analysis — Testing frequency	10
10.17 Tensile test — Testing frequency	10
10.18 Inspection documents	10
10.19 Marking	10
10.20 Decarburization	10
10.21 Metallurgical cleanliness	10
Bibliography	11