SAE Aerospace
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AEROSPACE MATERIAL SPECIFICATION

SAE AMS4291 REV. H

Issued 1943-10
Revised 2010-10

Superseding AMS4291G

Aluminum Alloy, Die Castings
8.5Si - 3.5Cu (A380.0-F)
As Cast

(Composition similar to UNS A13800)

RATIONALE

AMS4291H revises permissible methods for determining composition (3.1), and results from a Five Year Review and update of this specification.

1. SCOPE

1.1 Form

This specification covers an aluminum alloy in the form of die castings.

1.2 Application

These castings have been used typically for components of intricate shape, but not having thin sections, but usage is not limited to such applications. This alloy has good casting characteristics by cold-chamber die casting and fair resistance to corrosion.

2. APPLICABLE DOCUMENTS

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org.

AMS2694 In-Process Welding of Castings

AMS2804 Identification, Castings

AS1990 Aluminum Alloy Tempers

TO PLACE A DOCUMENT ORDER: **Tel: 877-606-7323 (inside USA and Canada)**
Tel: +1 724-776-4970 (outside USA)
Fax: 724-776-0790
Email: CustomerService@sae.org
SAE WEB ADDRESS: **http://www.sae.org**

SAE values your input. To provide feedback on this Technical Report, please visit
http://www.sae.org/technical/standards/AMS4291H

2.2 ASTM Publications:

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM B 660 Packaging/Packing of Aluminum and Magnesium Products

ASTM E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

ASTM E 34 Chemical Analysis of Aluminum and Aluminum-Base Alloys

ASTM E 505 Reference Radiographs for Inspection of Aluminum and Magnesium Die Castings

ASTM E 607 Atomic Emission Spectrometric Analysis of Aluminum Alloys by the Point-to-Plane Technique, Nitrogen Atmosphere

ASTM E 716 Sampling of Aluminum and Aluminum Alloys for Spectrochemical Analysis

ASTM E 1251 Analysis of Aluminum and Aluminum Alloys by Atomic Emission Spectrometry

ASTM E 1417 Liquid Penetrant Testing

ASTM E 1742 Radiographic Examination

3. TECHNICAL REQUIREMENTS

3.1 Composition

Shall conform to the percentages by weight shown in Table 1, determined by wet chemical methods in accordance with ASTM E 34, by spectrochemical methods in accordance with ASTM E 607, or ASTM E 1251, or by other analytical methods acceptable to purchaser (See 3.4 and 8.2).

TABLE 1 - COMPOSITION

Element	min	max
Silicon	7.5	9.5
Iron	--	1.3
Copper	3.0	4.0
Manganese	--	0.50
Magnesium	--	0.10
Nickel	--	0.50
Zinc	--	3.0
Tin	--	0.35
Other Elements, total	--	0.50
Aluminum	remainder	

3.1.1 Test results may be rounded in accordance with the “rounding off” method of ASTM E 29.

3.2 Condition

As cast (F temper) as defined in AS1990.

3.3 Castings

Castings shall be produced from metal conforming to 3.1, determined by analysis of a specimen (3.4) cast after the last melt addition.

3.4 Chemical Analysis Specimen

Shall be cast after the last melt addition and shall be tested to qualify the melt lot as in 3.1. Spectrochemical sample shall be prepared in accordance with ASTM E 716.

3.5 Quality

Castings, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to usage of the castings.

3.5.1 Radiographic, liquid penetrant, and other quality standards shall be as agreed upon by purchaser and vendor. When acceptance standards are not specified for radiographic inspection, the requirements of Table 2 shall apply, utilizing the reference radiographs of ASTM E 505.

TABLE 2 - DEFAULT RADIOGRAPHIC ACCEPTANCE STANDARDS USING ASTM E 505

Category of Discontinuity	Maximum Acceptable Level of Discontinuity Section Thickness 1/8 inch (3.2 mm)	Maximum Acceptable Level of Discontinuity Section Thickness 5/8 inch (15.9 mm)
Category A (Porosity)	#2	#2
Category B (Cold Fill)	#2	#3 per 1/8 inch (3.2 mm) Reference
Category C (Shrinkage)	N/A	
Category D (Foreign Material)	Not greater than reference standard for 1/8 inch (3.2 mm) section thicknesses	Not greater than reference standard for 5/8 inch (15.9 mm) section thicknesses

3.5.2 Methods of inspection and frequency of inspection shall be as agreed upon by purchaser and vendor. A “Casting Classification” of AMS2175 may be selected to specify the method and frequency of inspection.

3.5.3 Castings shall be produced under radiographic control. This control shall consist of 100% radiographic inspection of castings until process control factors (See 4.4.2) have been established to ensure production of acceptable castings. Unless otherwise specified by purchaser, continued radiographic inspection of production castings shall be performed at a frequency determined by the vendor to ensure continued maintenance of internal quality.

3.5.3.1 Radiographic inspection shall be conducted in accordance with ASTM E 1742, unless otherwise specified by purchaser.

3.5.4 When specified by purchaser, castings shall be fluorescent penetrant tested using a method specified by purchaser, or, if not specified, a method in accordance with ASTM E 1417.

3.5.5 Castings shall not be peened, plugged, impregnated, or welded unless authorized by purchaser.

3.5.5.1 When authorized by purchaser, welding in accordance with AMS2694, or other welding program approved by purchaser, may be used.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

The vendor of castings shall supply all samples for vendor's tests and shall be responsible for the performance of all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the castings conform to specified requirements.

4.2 Classification of Tests

4.2.1 Acceptance Tests

All technical requirements except radiographic inspection (3.5.3) are acceptance tests and shall be performed on each lot (See 4.2.2).

4.2.2 Periodic Tests

Radiographic inspection (3.5.3) following establishment of process control (See 4.4.2) is a periodic test and shall be performed at a frequency determined by the vendor to ensure continued maintenance of internal quality, unless frequency is specified by purchaser.

4.2.3 Preproduction Tests

All technical requirements are preproduction tests and shall be performed prior to or on the first-article shipment of a casting to a purchaser, when a change in material and/or processing requires reapproval as in 4.4.2, and when purchaser deems confirmatory testing to be required.

4.3 Sampling and Testing

Shall be in accordance with the following:

4.3.1 At least one chemical analysis specimen from each melt for conformance to 3.1 unless another sampling frequency is agreed upon by purchaser and vendor.

4.3.2 One or more preproduction castings of each casting part number in accordance with 4.4.1.

4.4 Approval

4.4.1 Sample castings from new or reworked dies and the casting procedure shall be approved by purchaser before castings for production use are supplied, unless such approval be waived by purchaser.

4.4.2 Vendor shall establish, for production of sample castings of each part number, parameters for process control factors which will produce acceptable castings and, when requested, sample castings and/or radiographic results; these shall constitute the approved casting procedure and shall be used for producing production castings. If necessary to make any change in parameters for process control factors, vendor shall submit for reapproval, a statement of the proposed change in processing and, when requested, sample casting. Production castings incorporating the revised operations shall not be shipped prior to receipt of reapproval.