

TITANIUM ALLOY, BLENDED POWDER COMPACTS, SINTERED
6A1 - 4V

UNS R56400

1. SCOPE:

1.1 Form:

This specification covers a titanium alloy in the form of compacts produced by pressing and sintering a blend of elemental titanium powder and aluminum-vanadium alloy powder.

1.2 Application:

These compacts have been used typically for light weight nuts ("B-nuts") used for connecting fluid lines to fittings and to equipment, but usage is not limited to such applications.

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2635 Radiographic Inspection

AMS 2645 Fluorescent Penetrant Inspection

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2.2 ASTM Publications:

Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

ASTM B 311 Density of Cemented Carbides
ASTM E 8 Tension Testing of Metallic Materials
ASTM E 8M Tension Testing of Metallic Materials (Metric)
ASTM E 120 Chemical Analysis of Titanium and Titanium Alloys
ASTM E 365 Chemical Analysis of Ferrovandium and Vanadium Alloying Additives

2.3 U.S. Government Publications:

Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

MIL-I-25135 Inspection Material, Penetrant

MIL-STD-2073-1 DOD Materiel, Procedures for Development and Application of Packaging Requirements

2.4 ANSI Publications:

Available from American National Standards Institute, Inc., 11 West 42nd Street, New York, NY 10036.

ANSI B46.1 Surface Texture

3. TECHNICAL REQUIREMENTS:

3.1 Composition: (R)

Shall be that resulting from blending elemental titanium powder as in 3.1.2 and aluminum-vanadium alloy powder as in 3.1.3 and shall conform to the percentages by weight shown in Table 1, after pressing and sintering, determined by wet chemical methods in accordance with ASTM E 120, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - Composition

Elements	Min	Max
Aluminum (3.1.1)	5.50	6.75
Vanadium (3.1.1)	3.50	4.50
Iron	--	0.30
Oxygen	--	0.30
Sodium	--	0.15
Chlorine	--	0.15
Carbon	--	0.10
Silicon	--	0.05
Nitrogen	--	0.05 (500 ppm)
Hydrogen	--	0.010 (100 ppm)
Residual Elements, each	--	0.10
Residual Elements, total	--	0.40
Titanium	remainder	

3.1.1 The difference in aluminum concentration and vanadium concentration among three different locations in a lot of blended powder shall be not greater than 0.4%.

3.1.2 Titanium Powder: Shall conform to the percentages by weight shown in (R) Table 2, determined as in 3.1.

TABLE 2 - Titanium Powder Composition

Element	Min	Max
Iron	--	0.20
Oxygen	--	0.20
Sodium	--	0.20
Chlorine	--	0.20
Carbon	--	0.06
Silicon	--	0.05
Nitrogen	--	0.03 (300 ppm)
Hydrogen	--	0.015 (150 ppm)
Residual Elements, each	--	0.10
Residual Elements, total	--	0.40
Titanium	remainder	

3.1.3 Alloying Powder Composition: Shall conform to the percentages by weight (R) shown in Table 3, determined by wet chemical methods in accordance with ASTM E 365, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 3 - Alloy Powder Composition

Element	Min	Max
Aluminum	56	64
Vanadium	38	42
Other Elements, by difference, total	--	3.0

3.2 Condition:

As sintered at not lower than 2100 °F (1149 °C). After sintering, compacts shall not be exposed to temperatures higher than 600 °F (316 °C).

3.3 Powder Lot Control:

The titanium 6Al - 4V powder shall be blended in lots by a suitable process in a noncontaminating facility. A powder lot shall be all powder produced as a single mixture in one production blend of titanium powder and aluminum-vanadium alloy powder.

3.3.1 Whenever a production run of sintered compacts does not require an entire lot of blended powder, the powder used shall be identified as a subplot. The identity of sublots in a basic powder lot shall be maintained.

3.3.2 Unused portions of qualified powder lots not of sufficient size for a production run of sintered compacts may be added to, and blended with, titanium and aluminum-vanadium alloy powders in the production of a new powder lot.

3.4 Properties:

Sintered compacts shall conform to the following requirements:

3.4.1 Tensile Properties: Shall be as shown in Table 4, determined in accordance with ASTM E 8 or ASTM E 8M on specimens, of the same powder lot, sintered with the parts represented.

TABLE 4 - Minimum Tensile Properties

Property	Value
Tensile Strength	130 ksi (896 MPa)
Yield Strength at 0.2 % Offset	120 ksi (827 MPa)
Elongation in 4D	10%
Reduction in Area	10%

- 3.4.2 Proof Test: Sintered compacts shall pass a proof or failure test conducted by a procedure developed by the manufacturer and for which a correlation with the tensile properties of 3.4.1 has been established for each size of sintered compact.
- 3.4.3 Density: Shall be not lower than 0.157 pounds per cubic inch (4346 kg/m³), determined in accordance with ASTM B 311 or other method agreed upon by purchaser and vendor.
- 3.4.4 Microstructure: Shall be homogeneous and free from inclusions, alloy segregation, laminations, and alpha case. Compacts shall also be free from interconnecting voids, porosity in excess of 0.010 inch (0.25 mm) in maximum dimension, and linear porosity in excess of 0.006 inch (0.15 mm) in maximum dimension.
- 3.4.4.1 Microstructure and porosity shall be determined by metallographic examination at 100 to 500X magnification after suitably polishing, or polishing and etching, as appropriate. Adjacent pores shall be treated as a single pore if they are closer to each other than the largest pore maximum dimension. Porosity whose length is more than three times its width shall be considered linear porosity.

3.5 Quality:

Sintered compacts, as received by purchaser, shall be uniform in quality and condition, clean, and free of defects such as cracks, seams, grooves, laminations, pits, inclusions, and surface oxidation and from other imperfections detrimental to their usage.

- 3.5.1 Sintered compacts shall be free from cracks, porosity, and other surface imperfections, determined by fluorescent penetrant inspection in accordance with AMS 2645 using MIL-H-25135, Group IV, Type I, penetrant.
- 3.5.2 Sintered compacts shall be free from low- and high-density inclusions and inhomogeneity, determined by radiographic inspection in accordance with AMS 2635.
- 3.5.3 Surface texture of sintered compacts shall not exceed 125 microinches (3.2 μm), determined in accordance with ANSI B46.1.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: (R)

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

4.2 Classification of Tests:

- 4.2.1 Acceptance Tests: Tests for the following requirements are acceptance tests and shall be performed as specified in 4.2.1.1 and 4.2.1.2:

4.2.1.1 Powder Lot: On each powder lot prior to use for production of sintered compacts:

4.2.1.1.1 Composition (3.1).

4.2.1.1.2 Blend uniformity check analysis on aluminum and vanadium contents (3.1.1).

4.2.1.1.3 Tensile properties (3.4.1).

4.2.1.1.4 Density (3.4.3).

4.2.1.1.5 Microstructure (3.4.4).

4.2.1.2 Part Lot: On each lot of sintered compacts from each sinter run:

4.2.1.2.1 Composition (3.1).

4.2.1.2.2 Tensile properties (3.4.1).

4.2.1.2.3 Proof test (3.4.2), density (3.4.3), and quality (3.5).

4.2.1.2.4 Microstructure (3.4.4).

4.2.2 Preproduction Tests: Tests for all technical requirements are preproduction tests and shall be performed prior to or on the first-article shipment of sintered compacts to a purchaser, when a change in ingredients and/or processing requires approval by the cognizant engineering organization (see 4.4.2), and when purchaser deems confirmatory testing to be required.

4.2.2.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material shall be submitted to the cognizant agency as directed by the procuring activity, contracting officer, or request for procurement.

4.3 Sampling and Testing:

(R)

Shall be in accordance with 4.3.1 and 4.3.2. A powder lot shall be all powder blended from the same batches of titanium and aluminum-vanadium powders in a single blending operation; a lot of sintered compacts shall be all sintered compacts of the same configuration produced from one powder lot in one production run using the same equipment and processing procedures in one sinter furnace load and presented for vendor's inspection at one time.

4.3.1 For Acceptance Tests:

4.3.1.1 Powder Lot:

4.3.1.1.1 One pressed and sintered test specimen for composition.

4.3.1.1.2 Three pressed and sintered specimens taken from three different locations in the blend for aluminum and vanadium uniformity checks.

4.3.1.1.3 Twelve pressed and sintered test specimens for tensile properties and density.

4.3.1.1.4 Two pressed and sintered test specimens for microstructure.

4.3.1.2 Part Lot:

4.3.1.2.1 One sintered compact for composition.

4.3.1.2.2 One pressed and sintered test specimen for tensile properties.

4.3.1.2.3 Sintered compacts as specified in Table 5, selected at random from the lot, for proof tests, density, and quality.

TABLE 5 - Sampling for Proof Test, Density, and Quality

Number of Inspection Units In the Lot		Proof Test (3.4.2) and Density (3.4.3)	Quality 3.5
Up to	99	2	4
100 to	299	3	6
300 to	599	4	8
600 to	999	5	10
1,000 to	1,499	6	12
1,500 to	1,999	7	14
2,000 to	2,999	8	16
3,000 to	3,999	9	18
4,000 to	5,999	10	20
6,000 to	10,000	12	24
Over	10,000	15	30

4.3.1.2.4 One sintered compact for microstructure.

4.3.2 For Preproduction Tests: As agreed upon by purchaser and vendor.

4.4 Approval:

4.4.1 The producer of compacts shall establish a written process description of (R) manufacture and inspection for each product number prior to and during preproduction. The description shall include control factors and parameters that provide products meeting the requirements of this specification. Control factors considered proprietary by vendor may be assigned codes within the process description. Each variation in such control factors shall be assigned a modified code designation. The vendor shall maintain a complete record of all proprietary factors and codes. These control factors shall include, but are not limited to, the following:

- Powder source(s)
- Blending method
- Powder storage, identification, and handling procedures
- Compaction sequence and parameters, including atmosphere, time, temperature, and pressure
- Type of sintering furnace
- Furnace calibration and leak-up rate
- Size of furnace charge
- Sintering sequence and parameters, including atmosphere, time, and temperature
- Material on which the pressed compacts rest during sintering
- Cleaning procedures and parameters
- Inspection procedures, parameters, and standards

4.4.2 Prior to the initial shipment of compacts of a particular design, the (R) supplier shall submit results of preproduction tests and, when requested, a copy of the process description for approval. Proof or failure test procedure (see 3.4.2), correlation with tensile properties, and acceptance limits shall be approved by the cognizant engineering organization.

4.4.3 The supplier shall not change the process description and shall make no (R) significant change to materials, processes, or controls referenced in the process description, unless the change is approved by the cognizant engineering organization. A significant change is one which, in the judgment of the cognizant engineering organization, could affect the properties or performance of the compacts.

4.5 Reports:

4.5.1 The vendor of sintered blanks shall furnish with each shipment a report showing the results of tests to determine conformance to the quality assurance provisions and stating that the sintered blanks conform to the other technical requirements. This report shall include the purchase order number, powder lot number, part lot number, AMS 4993B, size or part number, and quantity.