

ALLOY CASTINGS, INVESTMENT, CORROSION AND HEAT RESISTANT  
52.5Ni - 19Cr - 3.0Mo - 5.1(Cb + Ta) - 0.90Ti - 0.60Al - 18Fe  
Vacuum Melted

Homogenization and Solution Heat Treated

UNS N07718

1. SCOPE:

1.1 Form: This specification covers a corrosion and heat resistant nickel alloy in the form of investment castings.

1.2 Application: Primarily for structural parts requiring strength up to 1300°F (700°C) and oxidation resistance up to 1800°F (980°C).

1.3 Classification: Castings conforming to this specification are classified as follows:

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Class 1 - Trace element limits conforming to AMS 2280-1.

Class 2 - Trace element limits conforming to AMS 2280-2.

1.3.1 Castings shall conform to Class 1 unless Class 2 is specified by purchaser.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

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### 2.1.1 Aerospace Material Specifications:

- AMS 2268 - Chemical Check Analysis Limits, Cast Nickel and Nickel Alloys
- AMS 2280 - Trace Element Control, Nickel Alloy Castings
- AMS 2350 - Standards and Test Methods
- AMS 2360 - Room Temperature Tensile Properties of Castings
- AMS 2362 - Stress-Rupture Properties of Castings
- AMS 2635 - Radiographic Inspection
- AMS 2645 - Fluorescent Penetrant Inspection
- AMS 2694 - Repair Welding of Aerospace Castings
- AMS 2804 - Identification, Castings

### 2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

- ASTM E8 - Tension Testing of Metallic Materials
- ASTM E18 - Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials
- ASTM E139 - Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials
- ASTM E192 - Reference Radiographs of Investment Steel Castings for Aerospace Applications
- ASTM E354 - Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys

### 2.3 U.S. Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

#### 2.3.1 Military Specifications:

- MIL-H-6875 - Heat Treatment of Steels, Process for

#### 2.3.2 Military Standards:

- MIL-STD-794 - Parts and Equipment, Procedures for Packaging and Packing of

### 3. TECHNICAL REQUIREMENTS:

- 3.1 Composition: Shall conform to the following percentages by weight,  
 Ø determined by wet chemical methods in accordance with ASTM E354 or by spectrographic or other analytical methods approved by purchaser:

	min	max
Carbon	--	0.10
Manganese	--	0.35
Silicon	--	0.35
Phosphorus	--	0.015
Sulfur	--	0.015
Chromium	17.00 - 21.00	
Nickel	50.00 - 55.00	
Molybdenum	2.80 - 3.30	
Columbium + Tantalum	4.75 - 5.50	
Titanium	0.65 - 1.15	
Aluminum	0.40 - 0.80	
Titanium + Aluminum	--	1.75
Cobalt	--	1.00
Boron	--	0.006
Copper	--	0.30
Iron	remainder	

- 3.1.1 Trace element limits shall conform to Class 1 unless Class 2 is specified  
 Ø by purchaser.

- 3.1.2 Check Analysis: Composition variations shall meet the requirements of  
 Ø AMS 2268.

- 3.2 Condition: Homogenization and solution heat treated.

- 3.3 Casting:

- 3.3.1 The metal for castings shall be melted and poured under vacuum without loss of vacuum between melting and pouring. When permitted by purchaser, protective atmosphere may be used in lieu of vacuum for pouring of castings.

- 3.3.2 Castings shall be poured either from remelted metal from a master heat or directly from a master heat. In either case, metal for casting shall be qualified as in 3.4.

- 3.3.2.1 A master heat is refined metal of a single furnace charge or is metal blended as in 3.3.2.2 and melted and cast into ingot or pig under vacuum. Gates, sprues, risers, and rejected castings shall be used only in preparation of master heats; they shall not be remelted directly, without refining, for pouring of castings.

- 3.3.2.2 Metal from two or more master heats may be blended provided that the  
 Ø composition of each master heat to be blended is within the limits of 3.1 and that the total weight of metal blended does not exceed 15,000 lb (6800 kg). When two or more master heats are blended, the resultant blend shall be considered a master heat.

3.4 Master Heat Qualification: Each master heat shall be qualified by evaluation of chemical analysis and tensile specimens conforming to 3.4.1 and 3.4.2, respectively. A master heat may be considered conditionally qualified if vendor's test results show conformance to all applicable requirements of this specification. However, except when purchaser waives confirmatory testing, final qualification shall be based on purchaser's test results. Conditional qualification of a master heat shall not be construed as a guarantee of acceptance of castings poured therefrom.

3.4.1 Chemical Analysis Specimens: Shall be of any convenient size, shape, and form.

3.4.2 Tensile Specimens: Shall be cast from remelted metal from each master heat except when castings are poured directly from a master heat, in which case the specimens shall also be poured directly from the master heat. Specimens shall be of standard proportions in accordance with ASTM E8 with 0.250 in. (6.25 mm) diameter at the reduced parallel gage section. They shall be cast to size or shall be cast oversize and subsequently machined to 0.250 in. (6.25 mm) diameter. Center gating may be used.

3.5 Heat Treatment: Castings and representative separately-cast tensile specimens shall be heat treated as follows; furnace surveys and calibration of temperature controllers and recorders shall be in accordance with MIL-H-6875. Heat treatment batch control shall be traceable from a coded ink-stamped mark on each casting.

3.5.1 Homogenization Heat Treatment: Heat in a suitable protective atmosphere to  $2000^{\circ}\text{F} + 25$  ( $1095^{\circ}\text{C} + 15$ ), hold at heat for 1 - 2 hr, and cool at a rate equivalent to air cool or faster to  $900^{\circ}\text{F}$  ( $480^{\circ}\text{C}$ ). Any convenient rate may be used below  $900^{\circ}\text{F}$  ( $480^{\circ}\text{C}$ ).

3.5.2 Solution Heat Treatment: Heat in a suitable protective atmosphere to a temperature within the range  $1750^{\circ} - 1800^{\circ}\text{F}$  ( $955^{\circ} - 980^{\circ}\text{C}$ ), hold at the selected temperature within  $+25^{\circ}\text{F}$  ( $+15^{\circ}\text{C}$ ) for not less than 1 hr, and cool at a rate equivalent to air cool or faster.

3.6 Properties: Castings and representative tensile specimens produced in accordance with 3.4.2 shall conform to the following requirements:

3.6.1 As Solution Heat Treated:

3.6.1.1 Hardness: Shall be not higher than 25 HRC, or equivalent, determined in accordance with ASTM E18.

3.6.2 After Precipitation Heat Treatment: Separately-cast tensile specimens, integrally-cast coupons, and castings shall have the following properties after being precipitation heat treated by heating to  $1325^{\circ}\text{F} + 15$  ( $720^{\circ}\text{C} + 8$ ), holding at heat for 8 hr + 0.5, furnace cooling to  $1150^{\circ}\text{F} \mp 15$  ( $620^{\circ}\text{C} + 8$ ), holding at  $1150^{\circ}\text{F} + 15$  ( $620^{\circ}\text{C} + 8$ ) for a total precipitation time of 18 hr, and cooling at a rate equivalent to an air cool or faster:

### 3.6.2.1 Separately-Cast Specimens:

3.6.2.1.1 Tensile Properties: Shall be as follows, determined in accordance with ASTM E8:

Tensile Strength, min	125,000 psi (860 MPa)
Yield Strength at 0.2% Offset, min	110,000 psi (760 MPa)
Elongation in 4D, min	5%
Reduction of Area, min	10%

3.6.2.1.2 Stress-Rupture Properties at 1300°F (705°C): Specimens, maintained at 1300°F + 3 (705°C + 2) while a load sufficient to produce an initial axial stress of 65,000 psi (450 MPa) is applied continuously, shall not rupture in less than 23 hours. The test shall be continued to rupture without change of load. Elongation after rupture, measured at room temperature, shall be not less than 3% in 4D. Test shall be performed in accordance with ASTM E139.

3.6.2.1.2.1 The test of 3.6.2.1.2 may be conducted using a load higher than required to produce an initial axial stress of 65,000 psi (450 MPa) but load shall not be changed while test is in progress. Time to rupture and elongation requirements shall be as specified in 3.6.2.1.2.

3.6.2.1.2.2 When permitted by purchaser, the test of 3.6.2.1.2 may be conducted using incremental loading. In such case, the load required to produce an initial axial stress of 65,000 psi (450 MPa) shall be used to rupture or for 23 hr, whichever occurs first. After the 23 hr and at intervals of 8 - 16 hr, preferably 8 - 10 hr, thereafter, the stress shall be increased in increments of 5,000 psi (35 MPa). Time to rupture and elongation requirements shall be as specified in 3.6.2.1.2.

### 3.6.2.2 Integrally-Cast Coupons:

3.6.2.2.1 Tensile Properties: Shall be as follows, determined in accordance with ASTM E8:

Tensile Strength, min	125,000 psi (860 MPa)
Yield Strength at 0.2% Offset, min	110,000 psi (760 MPa)
Elongation in 4D, min	3%
Reduction of Area, min	8%

### 3.6.2.3 Castings:

3.6.2.3.1 Hardness: Shall be 34 - 44 HRC, or equivalent, determined in accordance with ASTM E18.

3.6.2.3.2 Tensile and Stress-Rupture Properties: When specified on the drawing or when agreed upon by purchaser and vendor, tensile specimens as in 4.3.4 conforming to ASTM E8 shall be machined from locations indicated on the drawing from castings selected at random from each lot. Property requirements for such specimens shall be as shown on the drawing or as agreed upon by purchaser and vendor and may be defined as specified in AMS 2360 or AMS 2362.

### 3.7 Quality:

3.7.1 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.

3.7.1.1 Castings shall have smooth surfaces and shall be well cleaned. Metallic shot or grit shall not be used for final cleaning.

3.7.2 Castings shall be produced under radiographic control. This control shall consist of radiographic examination of castings in accordance with AMS 2635 until proper foundry technique, which will produce castings free from harmful internal imperfections, is established for each part number and of production castings as necessary to ensure maintenance of satisfactory quality.

3.7.3 When specified, castings shall be subjected to fluorescent penetrant inspection in accordance with AMS 2645.

3.7.4 Radiographic, fluorescent penetrant, and other quality standards shall be as agreed upon by purchaser and vendor. ASTM E192 may be used to define radiographic acceptance standards.

3.7.5 Castings shall not be repaired by peening, plugging, welding, or other methods without written permission from purchaser.

3.7.5.1 When permitted in writing by purchaser, defects in castings may be removed and the castings repaired by welding in accordance with AMS 2694.

### 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 performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.5. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the castings conform to the requirements of this specification.

### 4.2 Classification of Tests:

- 4.2.1 Acceptance Tests: Except as specified in 4.2.1.1, tests to determine conformance to requirements for composition (3.1), hardness (3.6.1.1) of castings as solution heat treated, tensile properties of separately-cast specimens (3.6.2.1.1) or of integrally-cast coupons (3.6.2.2.1), stress-rupture properties (3.6.2.1.2) of separately-cast specimens, hardness of castings (3.6.2.2.1) after precipitation heat treatment, and quality (3.7) are classified as acceptance tests and shall be performed on each master heat or lot as applicable.
- 4.2.1.1 Tensile or stress-rupture properties of specimens cut from castings shall be determined only when specified by purchaser or when separately-cast specimens are not available. Tensile or stress rupture properties of separately-cast specimens need not be determined when such properties are determined on specimens cut from castings or on integrally-cast coupons.
- 4.2.2 Preproduction Tests: Tests to determine conformance to all technical requirements of this specification are classified as 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, processing, or both requires reapproval as in 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: Shall be not less than the following; a lot shall be all castings of the same part number poured from the same master heat in eight consecutive hours, homogenization and solution heat treated in the same furnace loads, and presented for vendor's inspection at one time:
- 4.3.1 Two chemical analysis specimens in accordance with 3.4.1 from each master heat or a casting from each lot.
- 4.3.2 Six tensile specimens in accordance with 3.4.2 from each master heat, three specimens each for tensile testing and for stress-rupture testing, except when purchaser requires tensile properties of specimens cut from castings or from integrally-cast coupons.
- 4.3.3 Two preproduction castings in accordance with 4.4.1 of each part number.
- 4.3.4 One or more castings from each lot when properties of specimens machined from castings are required or, when permitted by purchaser, four or more integrally-cast coupons. Size, location, and number of specimens machined from castings shall be as specified on the drawing or as agreed upon by purchaser and vendor. When size, location, and number of specimens are not specified, not less than four tensile specimens, two from the thickest section and two from the thinnest section, shall be cut from a casting or castings from each lot.

#### 4.4 Approval:

- 4.4.1 Sample castings from new or reworked master patterns and the casting procedures 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 separately for tensile specimens used for master heat qualification and for production of sample castings of each part number parameters for the process control factors which will produce tensile specimens meeting master heat qualification requirements and acceptable castings; these shall constitute the approved casting procedure and shall be used for producing subsequent master heat qualification specimens and production castings. If necessary to make any change in parameters for the process control factors, vendor shall submit for reapproval a statement of the proposed changes in processing and, when requested, test specimens, sample castings, or both. Production castings incorporating the revised operations shall not be shipped prior to receipt of reapproval.
- 4.4.2.1 Control factors for producing tensile specimens and castings include, but are not limited to, the following:
- Type of furnace and its capacity
  - Type and size of furnace charge
  - Vacuum level
  - Mold refractory formulation
  - Mold back-up material
  - Gating practices
  - Mold preheat and metal pouring temperatures; variations of  $\pm 25^{\circ}\text{F}$  ( $\pm 15^{\circ}\text{C}$ ) from established limits are permissible
  - Solidification and cooling procedures
  - Homogenization and solution heat treating cycles
  - Cleaning operations
  - Methods of inspection
- 4.4.2.1.1 Any of the above process control factors for which parameters are considered proprietary by the vendor may be assigned a code designation. Each variation in such parameters shall be assigned a modified code designation.

#### 4.5 Reports:

- 4.5.1 The vendor of castings shall furnish with each shipment a report showing the results of tests for chemical composition of at least one casting, or of specimens as in 3.4.1 cast in a mold with parts, from each master heat represented and the results of tests on each lot to determine conformance to the other acceptance test requirements and stating that the castings conform to the other technical requirements of this specification. When properties of specimens cut from castings are specified, the report shall include the results of tests to determine conformance to such requirements. This report shall include the purchase order number, master heat number or code symbol, AMS 5383C, lot number, part number, and quantity from each lot.