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Superseding AMS5383D	

Nickel Alloy, Corrosion and Heat-Resistant, Investment Castings  
52.5Ni - 19Cr - 3.0Mo - 5.1Cb(Nb) - 0.90Ti - 0.60Al - 18Fe  
Vacuum Melted  
Homogenization and Solution Heat Treated  
(Composition similar to UNS N07718)

#### RATIONALE

AMS5383E has been reaffirmed to comply with the SAE five-year review policy.

#### 1. SCOPE

##### 1.1 Form

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

##### 1.2 Application

These castings have been used typically for structural parts requiring strength up to 1300 °F (704 °C) and oxidation resistance up to 1800 °F (982 °C), but usage is not limited to such applications.

##### 1.3 Classification

Castings conforming to this specification are classified as follows:

- Class 1 Trace element limits conforming to AMS 2280-1
- Class 2 Trace element limits conforming to AMS 2280-2
- Class 3 Trace element limits do not apply

1.3.1 Castings shall conform to Class 3 unless Class 1 or Class 2 is specified by purchaser.

#### 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.

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## 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](http://www.sae.org).

AMS 2175	Castings, Classification and Inspection of
AMS 2269	Chemical Check Analysis Limits, Nickel, Nickel Alloys, and Cobalt Alloys
AMS 2280	Trace Element Control, Nickel Alloy Castings
AMS 2360	Room Temperature Tensile Properties of Castings
AMS 2362	Stress Rupture Properties of Castings
AMS 2694	Repair Welding of Aerospace Castings
AMS 2750	Pyrometry
AMS 2804	Identification, Castings

## 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](http://www.astm.org).

ASTM E 8	Tension Testing of Metallic Materials
ASTM E 18	Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials
ASTM E 139	Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials
ASTM E 354	Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys
ASTM E 1417	Liquid Penetrant Inspection
ASTM E 1742	Radiographic Inspection

## 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 354, by spectrochemical methods, or by other analytical methods acceptable to purchaser (See 8.2.1 and 8.2.2).

TABLE 1 - COMPOSITION

Element	min	max
Carbon	--	0.08
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 (Niobium)	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 Vendor may test for any element not otherwise listed in Table 1 and include this analysis in the report of 4.5. Limits of acceptability may be specified by purchaser (See 8.2.3).

### 3.1.2 Trace Elements

Shall conform to AMS 2280, Class 1 or Class 2, when specified by purchaser.

### 3.1.3 Check Analysis

Composition variations shall meet the applicable requirements of AMS 2269.

## 3.2 Melting Practice

Castings and specimens shall be poured at casting vendor's facility either from a melt (See 8.2.4) of a master heat, or directly from a master heat (See 3.4.2 and 8.2.5).

3.2.1 Revert (gates, sprues, risers, and rejected castings) may be used only in the preparation of master heats; revert shall not be remelted directly without refining for pouring of castings. Melting of revert creates a new master heat.

3.2.1.1 The metal for castings and specimens shall be melted and poured under vacuum without loss of vacuum between melting and pouring. When authorized by purchaser (See 8.2.6), protective atmosphere may be used in lieu of vacuum for pouring of castings.

3.2.2 Portions of two or more qualified master heats (See 3.4.2) may be melted together and poured into castings using a procedure authorized by purchaser.

3.2.3 If melts (See 8.2.4) are modified by replenishment (See 8.2.7), vendor shall have a written procedure acceptable to purchaser which defines the controls, test, and traceability criteria for both castings and separately-cast specimens. Control factors of 4.4.2.2 shall apply.

## 3.3 Condition

Castings shall be delivered in the homogenization and solution heat treated condition.

## 3.4 Test Specimens

Specimens shall be either separately-cast, integrally-cast (See 8.2.8), or machined from a casting, and shall conform to 3.2.

3.4.1 If specimens are separately-cast, vendor shall have a written procedure acceptable to purchaser. Control factors of 4.4.2.2 shall apply.

3.4.2 Each master heat shall be qualified by evaluation of chemical, room temperature tensile, and stress-rupture specimens.

3.4.2.1 If replenishments are made at remelt as in 3.2.3, the frequency of sampling and testing used by the vendor for qualification to 3.4.2 shall be acceptable to purchaser.

3.4.2.2 Tensile and stress-rupture tests of 3.4.2 are not required if these tests are conducted using integrally-cast specimens (4.3.3.2) or specimens machined-from-casting (4.3.3.3).

### 3.4.3 Chemical Analysis Specimens

Shall be of any convenient size and shape.

### 3.4.4 Tensile and Stress-Rupture Specimens

Shall be of standard proportions in accordance with ASTM publications referenced in 3.6.

3.4.4.1 Separately-cast and integrally-cast tensile specimens may be either cast to size or cast oversize and subsequently machined to 0.250-inch (6.35-mm) diameter.

3.4.4.2 When integrally-cast specimens and/or specimens machined-from-casting are specified, specimen size and location shall be agreed upon by purchaser and vendor. (See 8.2.9 and 8.6.)

### 3.5 Heat Treatment

Castings and representative tensile and stress-rupture specimens shall be heat treated as specified in 3.5.1 and 3.5.2. Pyrometry shall be in accordance with AMS 2750.

#### 3.5.1 Castings and Specimens

##### 3.5.1.1 Homogenization Heat Treatment

Heat in a suitable protective atmosphere to 2000 °F ± 25 (1093 °C ± 14), hold at heat for 1 to 2 hours, and cool at a rate equivalent to an air cool or faster to 900 °F (482 °C). Any convenient rate may be used below 900 °F (482 °C).

##### 3.5.1.2 Solution Heat Treatment

Heat in a suitable protective atmosphere to a temperature within the range of 1750 to 1800 °F (954 to 982 °C), hold at the selected temperature within ± 25 °F (± 14 °C) for not less than one hour, and cool at a rate equivalent to an air cool or faster.

#### 3.5.2 Response to Heat Treatment

After homogenization and solution heat treatment to 3.5.1, specimens, and castings when required, shall be heat treated in accordance with the following for subsequent testing to determine response to heat treatment:

##### 3.5.2.1 Precipitation Heat Treatment

Heat to 1325 °F ± 15 (718 °C ± 8), hold at heat for 8 hours -0 +30 minutes, furnace cool to 1150 °F ± 15 (621 °C ± 8) at an average rate of 100 °F ± 15 (55 °C ± 8) per hour, hold at 1150 °F ± 15 (621 °C ± 8) for 8 hours -0 +30 minutes and cool at a rate equivalent to air cool.

3.5.3 Tensile and stress-rupture specimens used for master heat qualification may be heat treated separately from castings.

### 3.6 Properties

Conformance shall be based upon testing separately-cast specimens unless purchaser specifies integrally-cast specimens or specimens machined-from-casting.

#### 3.6.1 Room Temperature Tensile Properties

Shall be as specified in Table 2; determined in accordance with ASTM E 8 or ASTM E 8M (See 8.3). Properties other than those listed may be defined as specified in AMS 2360.

##### 3.6.1.1 Separately-Cast Specimens

Shall be as shown in Table 2.

TABLE 2 - MINIMUM ROOM TEMPERATURE TENSILE PROPERTIES

Property	Value
Tensile Strength	125 ksi (862 MPa)
Yield Strength at 0.2% Offset	110 ksi (758 MPa)
Elongation in 4D	5 %
Reduction of Area	10 %

### 3.6.1.2 Integrally-Cast Specimens and Specimens Machined-from-Castings

Shall be as shown in Table 3.

TABLE 3 - MINIMUM ROOM TEMPERATURE TENSILE PROPERTIES

Property	Value
Tensile Strength	120 ksi (827 MPa)
Yield Strength at 0.2% Offset	105 ksi (724 MPa)
Elongation in 4D	3 %
Reduction of Area	8 %

### 3.6.2 Stress-Rupture Properties at 1300 °F (704 °C)

Shall be as follows; determined in accordance with ASTM E 139. Properties other than those listed may be defined as specified in AMS 2362.

3.6.2.1 Specimens, maintained at 1300 °F  $\pm$  3 (704 °C  $\pm$  2) while a load sufficient to produce an initial axial stress of 65.0 ksi (448 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.

3.6.2.2 The test of 3.6.2.1 may be conducted using a load higher than required to produce an initial axial stress of 65.0 ksi (448 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.

3.6.2.3 When authorized by purchaser, the test of 3.6.2.1 may be conducted using incremental loading. In such case, the load required to produce an initial axial stress of 65.0 ksi (448 MPa) shall be used to rupture or for 23 hours, whichever occurs first. After the 23 hours and at intervals of 8 hours, minimum, thereafter, the stress shall be increased in increments of 5 ksi (34.5 MPa). Time to rupture and elongation requirements shall be as specified in 3.6.2.1.

### 3.6.3 Hardness

Shall be as follows, determined in accordance with ASTM E 18.

#### 3.6.3.1 Castings

Castings, in the homogenized and solution heat treated condition of 3.5.1, shall have hardness not higher than 25 HRC, or equivalent (See 8.4).

#### 3.6.3.2 Response to Heat Treatment

Specimens and representative castings when required, heat treated to the homogenized, solution, and precipitation heat treated condition of 3.5.2, shall have hardness of 34 to 44 HRC, or equivalent (See 8.4).

### 3.7 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. Castings shall be free of cracks, laps, hot tears, and cold shuts and free of scale and other process-induced surface contamination which would obscure defects.

3.7.1 Castings shall be produced under radiographic control. This control shall consist of radiographic examination of each casting part number until foundry manufacturing controls in accordance with 4.4.2 have been established. Additional radiography shall be conducted in accordance with the frequency of inspection specified by purchaser, or as necessary to ensure continued maintenance of internal quality.

- 3.7.1.1 Radiographic inspection shall be conducted in accordance with ASTM E 1742 or other process method specified by purchaser.
- 3.7.2 When specified, castings shall be subjected to fluorescent penetrant inspection in accordance with ASTM E 1417 or other process method specified by purchaser.
- 3.7.3 Acceptance standards for radiographic, fluorescent penetrant, visual, and other inspection methods shall be as agreed upon by purchaser and vendor. AMS 2175 may be used to specify acceptance standards (casting grade) and frequency of inspection (casting class).
- 3.7.3.1 When acceptance standards are not specified, Grade C of AMS 2175 as applicable to steel castings shall apply for each specified method of inspection.
- 3.7.4 Castings shall not be peened, plugged, impregnated, or welded unless authorized by purchaser.
- 3.7.4.1 When authorized by purchaser, welding in accordance with AMS 2694 or other welding program acceptable to 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

Composition (3.1), room temperature tensile (3.6.1), stress-rupture (3.6.2), casting hardness (3.6.3.1), response to heat treatment hardness (3.6.3.2), and the applicable requirements of quality (3.7) are acceptance tests and shall be performed as specified in 4.3.

###### 4.2.2 Periodic Tests

Radiographic soundness (3.7.1) is a periodic test and shall be performed at a frequency selected by vendor unless a frequency of testing is specified by purchaser.

###### 4.2.3 Preproduction Tests

All technical requirements are preproduction tests and shall be performed on sample castings (4.3.2), when a change in control factors occurs (4.4.2.2), and when purchaser deems confirmatory testing to be required.

##### 4.3 Sampling and Testing

The minimum testing performed by vendor shall be in accordance with the following:

- 4.3.1 One chemical analysis specimen or a casting from each master heat shall be tested for conformance to Table 1. If 3.4.2.1 applies, test frequency shall be acceptable to purchaser.
- 4.3.2 One preproduction casting in accordance with 4.4 shall be tested to the requirements of the casting drawing and to all technical requirements.
- 4.3.2.1 Dimensional inspection sample quantity shall be as specified by purchaser.

- 4.3.3 Room temperature tensile and stress-rupture tests shall be conducted to determine conformance with Table 2 or Table 3, and 3.6.2. Sampling and test frequency are dependent upon the type and origin of specimen specified by purchaser (See 3.4.4 and 3.6) or selected by vendor (See 4.3.3.4). When 3.4.2.1 applies, specimen source and test frequency shall be acceptable to purchaser.
- 4.3.3.1 For separately-cast specimens in the homogenized, solution, and precipitation heat treated condition of 3.5.2, two specimens from each master heat shall be tested for conformance; one to 3.6.1, and one to 3.6.2.
- 4.3.3.2 For integrally-cast specimens in the homogenized, solution, and precipitation heat treated condition of 3.5.2, four specimens from each lot (See 8.2.10) shall be randomly selected and tested for conformance; two to 3.6.1, and two to 3.6.2.
- 4.3.3.3 For specimens machined-from-casting, one casting shall be randomly selected from each lot and tested after homogenization, solution, and precipitation heat treatment to 3.5.2 at each location shown on the engineering drawing for conformance to 3.6.1 and 3.6.2.
- 4.3.3.3.1 When size and location of specimens are not shown, four specimens shall be tested, two from the thickest section and two from the thinnest section. Once established under 4.4.2.2, test locations may be changed only as agreed upon by purchaser and vendor.
- 4.3.3.4 When acceptable to purchaser, specimens machined-from-casting may be used in lieu of both separately-cast and integrally-cast specimens, and integrally-cast specimens may be used in lieu of separately-cast specimens. In each case, the resultant properties must conform to the requirements of 3.6 for that type of specimen.
- 4.3.3.4.1 When specimens are selected for test as in 4.3.3.4 from an origin other than that specified by purchaser, vendor shall include, in the report of 4.5, a description of the source of the specimen that was tested.
- 4.3.3.5 When casting size, section thickness, gating method, or other factors do not permit conformance to 4.3.3.2 or 4.3.3.3, sampling and testing shall be agreed upon by purchaser and vendor.
- 4.3.4 Castings shall be inspected in accordance with 3.7 to the methods, frequency, and acceptance standards specified by purchaser.
- 4.3.5 After homogenization and solution heat treatment of 3.5.1, castings shall be tested for hardness to determine conformance with 3.6.3.1. Unless otherwise specified by purchaser, one casting per lot shall be hardness tested.
- 4.3.5.1 In event of failure, the entire lot shall be 100% inspected or reheat treated in accordance with 4.6.2.
- 4.3.6 After homogenization, solution, and precipitation heat treatment to 3.5.2, one specimen from 3.4 shall be tested for hardness to determine conformance with 3.6.3.2.
- 4.3.6.1 In event of failure, specimens may be reheat treated in accordance with 4.6.2.
- 4.4 Approval
- 4.4.1 Sample casting(s) from new or reworked master patterns produced under the casting procedure of 4.4.2 shall be approved by purchaser before castings for production use are supplied, unless such approval be waived by purchaser.
- 4.4.2 For each casting part number, vendor shall establish parameters for process control factors that will consistently produce castings and test specimens meeting the requirements of the casting drawing and this specification. These parameters shall constitute the approved casting procedure and shall be used for production of subsequent castings and test specimens. If necessary to make any change to these parameters, vendor shall submit a statement of the proposed change for purchaser reapproval. When requested, vendor shall also submit test specimens, sample castings, or both to purchaser for reapproval.
- 4.4.2.1 Production castings produced prior to receipt of purchaser's approval shall be at vendor's risk.

- 4.4.2.2 Control factors for producing castings and separately-cast specimens include, but are not limited to, the following factors. Supplier's procedures shall identify tolerances, ranges, and/or control limits, as applicable. Control factors for separately-cast specimens must generally represent, but need not be identical to, those factors used for castings (See 3.2.3 and 3.4.1)

Composition of ceramic cores, if used  
Arrangement and number of patterns in the mold (including integrally-cast specimens if applicable)  
Size, shape, and location of gates and risers  
Mold refractory formulation  
Grain refinement methods  
Mold back up material (weight, thickness, or number of dips)  
Type of furnace, vacuum, and charge for melting  
Mold preheat and metal pouring temperatures  
Fluxing or deoxidation procedure  
Replenishment procedure, if applicable  
Time that molten metal is in the furnace  
Solidification and cooling procedures  
Cleaning operations (mechanical and chemical)  
Heat treatment  
Straightening  
Final inspection methods  
Location of specimens machined-from-casting (if applicable)

- 4.4.2.2.1 Any of the control factors shown above 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.

- 4.4.2.2.1.1 Unless otherwise agreed upon by purchaser and vendor, purchaser shall be entitled to review proprietary control factor details and coding at vendor's facility.

#### 4.5 Reports

The vendor of castings shall furnish with each shipment a certification document declaring that castings have been processed, tested, and inspected as specified and that the results of the inspections and tests conform to requirements.

- 4.5.1 Unless otherwise specified, vendor shall furnish test report(s) showing the results of tests and inspections conducted in accordance with 4.2 and 4.3.

- 4.5.1.1 Chemical analysis determinations, property test data, and the results of any retests conducted shall be expressed numerically to reflect actual quantitative test values.

- 4.5.1.2 Hardness test readings may be expressed as single values or as a range of values exhibited by results obtained from the sample size.

- 4.5.1.3 Inspection and preproduction results shall be reported at the frequency specified by, and in a format acceptable to purchaser.

- 4.5.1.4 Nonconformances shall be documented and approved by purchaser in accordance with purchaser's material review requirements.

- 4.5.2 The statement of conformity and test report(s) shall include or be traceable to the purchase order number, master heat identification, heat treat/lot number, AMS 5383E, part number, quantity, and when required (See 5.1.2) the list of individual serial numbers or serial number range.

- 4.5.2.1 If 4.3.3.4.1 applies, the mechanical property test report shall denote the source of the specimens that were tested.