



# AEROSPACE MATERIAL SPECIFICATION

AMS5385

REV. H

Issued 1947-09  
Revised 2008-03  
Reaffirmed 2013-11

Superseding AMS5385G

Cobalt Alloy, Corrosion and Heat-Resistant, Investment Castings  
62Co - 27Cr - 2.8Ni - 5.5Mo  
As-Cast  
(Composition similar to UNS R30021)

## RATIONALE

AMS5385H 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 cobalt alloy in the form of investment castings.

#### 1.2 Application

These castings have been used typically for parts such as turbine vanes requiring high strength up to 1500 °F (816 °C), and oxidation resistance up to 2000 °F (1095 °C), but usage is not limited to such applications.

1.2.1 Exposure to elevated temperatures may cause hardening of these castings; e.g., exposure at approximately 1475 °F (800 °C) for 50 hours may result in hardness as high as 45 HRC.

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

AMS2175	Castings, Classification and Inspection of
AMS2269	Chemical Check Analysis Limits, Nickel, Nickel Alloys, and Cobalt Alloys
AMS2360	Room Temperature Tensile Properties of Castings
AMS2361	Elevated Temperature Tensile Properties of Castings
AMS2694	In-Process Welding of Castings
AMS2804	Identification, Castings

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## 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 E 8	Tension Testing of Metallic Materials
ASTM E 21	Elevated Temperature Tension 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 Testing
ASTM E 1742	Radiographic Examination

## 3. TECHNICAL REQUIREMENTS

### 3.1 Composition

Shall conform to the percentages by weight as 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 purchase (See 8.3.1 and 8.3.2).

TABLE 1 - COMPOSITION

Element	min	max
Carbon	0.20	0.30
Manganese	--	1.00
Silicon	--	1.00
Phosphorus	--	0.04
Sulfur	--	0.04
Chromium	25.00	29.00
Nickel	1.75	3.75
Molybdenum	5.00	6.00
Boron	--	0.007
Iron	--	3.00
Other elements (3.1.1)	--	--
Cobalt	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 8.3.3).

### 3.1.2 Check Analysis

Composition variations shall meet the applicable requirements of AMS2269.

### 3.2 Melting Practice

Castings and specimens shall be poured at casting vendor's facility either from a melt (See 8.3.4) of a master heat, or directly from a master heat (See 3.4.2 and 8.3.5).

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.

3.2.2 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 (See 8.3.6).

3.2.3 If melts (See 8.3.4) are modified by replenishment (See 8.3.7), 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 as-cast condition.

### 3.4 Test Specimens

Specimens shall be either separately-cast, integrally-cast (See 8.3.8), 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 and elevated temperature tensile 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 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 Specimens

Shall be of standard proportions in accordance with ASTM E 8 with 0.250-inch (6.35-mm) diameter at the reduced parallel gage section.

3.4.4.1 Separately-cast and integrally-cast 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 8.3.9 and 8.5).

### 3.5 Heat Treatment

Not applicable.

### 3.6 Properties

Conformance shall be based upon testing of separately-cast specimens unless purchaser specifies integrally-cast specimens or specimens machined-from-casting. Properties for integrally-cast specimens or specimens machined-from-casting shall be as specified by purchaser (See 8.5).

#### 3.6.1 Room Temperature Tensile Properties

Tensile properties may be specified by purchaser, in accordance with AMS2360.

#### 3.6.2 Elevated Temperature Tensile Properties at 1500 °F (816 °C)

Shall be as shown in Table 2, determined in accordance with ASTM E 21 on separately-cast specimens heated to 1500 °F  $\pm$  10 (816 °C  $\pm$  6), held at heat for not less than 10 minutes before testing, and tested at 1500 °F  $\pm$  10 (816 °C  $\pm$  6). Properties other than those in Table 2 may be defined as specified in AMS2361.

TABLE 2 - MINIMUM ELEVATED TEMPERATURE TENSILE PROPERTIES  
OF SEPARATELY-CAST SPECIMENS

Property	Value
Tensile strength	52.0 ksi (360 MPa)
Elongation in 4D	10%

### 3.6.3 Hardness

As-Cast; Not higher than 34 HRC, or equivalent, determined in accordance with ASTM E 18.

### 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. 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.

3.7.2 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.

3.7.2.1 Radiographic inspection shall be conducted in accordance with ASTM E 1742 or other method specified by purchaser.

3.7.3 When specified, castings shall be subjected to fluorescent penetrant inspection in accordance with ASTM E 1417 or other method specified by purchaser.

3.7.4 Acceptance standards for radiographic, fluorescent penetrant, visual, and other inspection methods shall be agreed upon by purchaser and vendor (See 8.3.9). AMS2175 may be used to specify acceptance standards (casting grade) and frequency of inspection (casting class).

3.7.4.1 When acceptance standards are not specified, Grade C of AMS2175 as applicable to steel castings shall apply for each specified method of inspection.

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

3.7.5.1 When authorized by purchaser, welding in accordance with AMS2694 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 properties if specified (3.6.1), elevated temperature tensile properties (3.6.2), as-cast hardness (3.6.3), 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 (3.7.2) is a periodic test and shall be performed at a frequency selected by vendor, unless 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 with 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 Elevated temperature tensile tests shall be conducted to determine conformance with 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 as-cast condition, one specimen from each master heat shall be tested to 3.6.2.
    - 4.3.3.2 For integrally-cast specimens in the as-cast condition, two specimens shall be randomly selected from each lot (See 8.3.10) and tested for conformance with properties specified by purchaser (See 8.5).
    - 4.3.3.3 For specimens machined-from-casting, one casting shall be randomly selected from each lot and tested in the as-cast condition, at each location shown on the engineering drawing for conformance with properties specified by purchaser (See 8.5).
      - 4.3.3.3.1 When size and location of specimens are not shown, two test specimens shall be tested, one from the thickest section and one 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 or to alternative requirements specified by purchaser (See 8.5).
        - 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 with 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 One casting or representative specimen from each master heat shall be tested for hardness to determine conformance with 3.6.3.

#### 4.4 Approval

4.4.1 Sample casting(s) from new or reworked tooling (i.e., patterns, molds, dies, etc.) and 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 test 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, if applicable

Mold back up material (weight, thickness, or number of dips)

Type of furnace, atmosphere, and charge for melting

Mold preheat and metal pouring temperatures

Fluxing or deoxidation procedure

Replenishment procedure, if applicable

Time molten metal is in furnace

Solidification and cooling procedures

Cleaning operations (mechanical and chemical)

Straightening

Final inspection methods

Location and size of integrally-cast specimens and specimens machined-from-casting, if applicable

4.4.2.2.1 Any of the control factors for which parameters are considered proprietary by 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 Inspection and preproduction results shall be reported at the frequency specified by, and in a format acceptable to purchaser.

4.5.1.3 Objective evidence of purchaser's review and acceptance of nonconforming material shall be provided with the certification document at each shipment. (See 7).

4.5.2 The statement of conformity and test report(s) shall include or be traceable to the purchase order number, master heat identification, lot number (if 4.5.3.2 applies), AMS5385H, part number, quantity, and when required (See 5.1.1) 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.

4.5.3 Test reports for acceptance testing of 4.2 shall be as follows:

4.5.3.1 For each master heat:

Composition (See 4.3.1)

Room temperature tensile properties, if specified (See 3.6.1)

Elevated temperature tensile properties (See 4.3.3.1)

Hardness (See 4.3.5)

4.5.3.2 For each lot:

Inspection results (See 4.3.4)

Integrally-cast or machined-from-casting room temperature and/or elevated temperature properties, when specified (See 3.6, 4.3.3.2 and 4.3.3.3)

4.5.4 The vendor shall retain records of processing and inspection in accordance with purchaser requirements.

4.6 Resampling and Retesting

If the results of a valid test fail to meet specified requirements, two additional specimens in accordance with 4.3 from the same master heat, modified melt (See 3.2.3), or lot, as applicable, shall be tested for each nonconforming characteristic. Results of each additional test, and the average of the results of all tests (original and retests) shall meet the specified requirements; otherwise, the master heat or lot shall be rejected. Results of all tests shall be reported.

4.6.1 A test may be declared invalid in accordance with the applicable testing standard, including when failure is due to specimen mispreparation, test equipment malfunction, improper test procedure, or the presence of random process defects such as inclusions or gas holes in a tensile specimen.

## 5. PREPARATION FOR DELIVERY

### 5.1 Identification

Unless otherwise specified by purchaser, individual castings shall be identified in accordance with AMS2804.

#### 5.1.1 Traceability

Individual castings shall be traceable to their conditions of manufacture and inspection up to and including the point of acceptance by purchaser.

#### 5.1.2 Serialization

When specified (See 4.5.2 and 8.5) each casting shall be serialized with a unique non-repeating serial number.

### 5.2 Packaging

Castings shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the castings to ensure carrier acceptance and safe delivery.