

**AEROSPACE  
MATERIAL  
SPECIFICATION**

**AMS 5390C**  
Superseding AMS 5390B

Issued 8-15-55  
Revised 7-1-84

ALLOY CASTINGS, INVESTMENT, CORROSION AND HEAT RESISTANT  
47.5Ni - 22Cr - 1.5Co - 9Mo - 0.60W - 18.5Fe  
As Cast

UNS N06002

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 parts, such as turbine vanes and turbine shroud segments, requiring oxidation resistance up to 2200°F (1205°C) and relatively high strength up to 1500°F (815°C).

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.

2.1.1 Aerospace Material Specifications:

AMS 2350 - Standards and Test Methods  
AMS 2360 - Room Temperature Tensile Properties of Castings  
AMS 2361 - Elevated Temperature Tensile Properties of Castings  
AMS 2635 - Radiographic Inspection  
AMS 2645 - Fluorescent Penetrant Inspection  
AMS 2694 - Repair Welding of Aerospace Castings  
AMS 2804 - Identification, Castings

**REAFFIRMED** 10/91

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# AMS5390C

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 E21 - Elevated Temperature Tension 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 Federal Standards:

Federal Test Method Standard No. 151 - Metals; Test Methods

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,  $\emptyset$  determined by wet chemical methods in accordance with ASTM E354, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other analytical methods approved by purchaser:

	min	max
Carbon	--	0.10
Manganese	--	1.00
Silicon	--	1.00
Phosphorus	--	0.04
Sulfur	--	0.03
Chromium	20.50 -	23.00
Cobalt	0.50 -	2.50
Molybdenum	8.00 -	10.00
Tungsten	0.20 -	1.00
Iron	17.00 -	20.00
Boron	--	0.010 (100 ppm)
Selenium	--	0.0050 (50 ppm)
Nickel		remainder

3.2 Condition: As cast.

3.3 Casting: 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.

- 3.3.1 A master heat is refined metal of a single furnace charge or is metal blended as in 3.3.2. 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 Unless prohibited by purchaser, metal from two or more master heats may be blended provided that the 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). Ingot and pig may be blended together, shot may be blended, but shot shall not be blended with ingot or pig. 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 for vendor's tests. When chemical analysis specimens are required by purchaser, specimens shall be cast to a size, shape, and form agreed upon by purchaser and vendor.
- 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 Properties: Castings and representative tensile specimens produced in accordance with 3.4.2 shall conform to the following requirements:
- 3.5.1 Tensile Properties:
- 3.5.1.1 Separately-Cast Specimens:
- 3.5.1.1.1 At Room Temperature: Shall be as follows, determined in accordance with ASTM E8:
- |                                    |                      |
|------------------------------------|----------------------|
| Tensile Strength, min              | 55,000 psi (380 MPa) |
| Yield Strength at 0.2% Offset, min | 35,000 psi (240 MPa) |
| Elongation in 4D, min              | 8%                   |

# AMS 5390C

3.5.1.1.2 At 1500°F (815°C): Shall be as follows, determined in accordance with ASTM E21 on specimens heated to 1500°F  $\pm$  10 (815°C  $\pm$  5), held at heat for 20 to 30 min. before testing, and tested at 1500°F  $\pm$  10 (815°C  $\pm$  5):

Tensile Strength, min	35,000 psi (240 MPa)
Elongation in 4D, min	12%

3.5.1.2 Specimens Cut from Castings: 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 specified on the drawing or as agreed upon by purchaser and vendor and may be defined as specified in AMS 2360 or AMS 2361, or both.

3.5.2 Hardness of Castings: Shall be as follows, determined in accordance with ASTM E18:

3.5.2.1 As Cast: Not higher than 96 HRB or equivalent.

3.5.2.2 After Heat Treatment: Not higher than 24 HRC or equivalent after being heated to 1475°F  $\pm$  10 (800°C  $\pm$  5), held at heat for 50 hr  $\pm$  1, and cooled to room temperature.

3.6 Quality:

3.6.1 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.

3.6.1.1 Castings shall have smooth surfaces and shall be well cleaned. Metallic shot or grit shall not be used for final cleaning, unless otherwise permitted by purchaser.

3.6.2 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.

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

3.6.4 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.

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

- 3.6.5.1 When permitted in writing by purchaser, defects in castings may be  
Ø 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), elevated-temperature tensile properties of separately-cast specimens (3.5.1.1.2) or, when specified, tensile properties of specimens cut from castings (3.5.1.2), hardness of castings as cast (3.5.2.1), and quality (3.6) are classified as acceptance tests and shall be performed on each lot.
- 4.2.1.1 Tensile properties of specimens cut from castings shall be determined  
Ø only when specified by purchaser or when representative separately-cast specimens are not available. Tensile properties of separately-cast specimens need not be determined when tensile properties of specimens cut from castings are determined.
- 4.2.2 Periodic Tests: Tests to determine conformance to requirements for room-temperature tensile properties of separately-cast specimens (3.5.1.1.1) and hardness of castings after heat treatment (3.5.2.2) are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.
- 4.2.3 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 or processing, or both, requires reapproval, or when purchaser deems confirmatory testing to be required.
- 4.2.3.1 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, the contracting officer, or the request for procurement.

4.3 Sampling: Shall be in accordance with the following:

- 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 Three tensile specimens in accordance with 3.4.2 from each master heat.
- 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 master heat when properties of specimens machined from castings are required. 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 test 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 master heat.

#### 4.4 Approval:

- 4.4.1 Sample castings from new or reworked master patterns 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 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 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 test specimens and castings include, but are not limited to, the following:
    - ∅ Type of furnace and its capacity
    - Type and size of furnace charge
    - Time molten metal is in furnace
    - Furnace atmosphere
    - Fluxing or deoxidation procedure
    - Number of ladles used in pour
    - 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
    - Cleaning operations
    - Methods of inspection