



AEROSPACE MATERIAL

Society of Automotive Engineers, Inc.
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

SPECIFICATION

AMS 5401

Issued 1-15-80

Revised

ALLOY CASTINGS, INVESTMENT, CORROSION AND HEAT RESISTANT

62Ni - 21.5Cr - 9.0Mo - 3.6(Cb+Ta)

Vacuum Melted, Vacuum Cast

1. SCOPE:

- 1.1 Form: This specification covers a corrosion and heat resistant nickel alloy in the form of vacuum-melted, vacuum-cast investment castings.
- 1.2 Application: Primarily for parts requiring moderate strength up to 1600° F (870° C) and excellent oxidation and corrosion resistance up to 1800° F (980° 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 (AMS) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

- 2.1 SAE Publications: Available from Society of Automotive Engineers, Inc., 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 2635 - Radiographic Inspection
AMS 2645 - Fluorescent Penetrant Inspection
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 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 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

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3. TECHNICAL REQUIREMENTS:

- 3.1 Composition: Shall conform to the following percentages by weight, 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	--	0.50
Silicon	--	0.50
Phosphorus	--	0.015
Sulfur	--	0.015
Chromium	20.00 - 23.00	
Molybdenum	8.00 - 10.00	
Columbium + Tantalum	3.15 - 4.15	
Titanium	Present but not exceeding	0.40
Aluminum	Present but not exceeding	0.40
Cobalt (3.1.1)	--	1.00
Iron	--	5.00
Copper	--	0.30
Nickel	remainder	

- 3.1.1 Determination not required for routine acceptance.

- 3.2 Condition: As cast.

- 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.

- 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 deoxidized and 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 When permitted 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 10,000 lb (4540 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 test 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 Test Specimens:** Integral or separately-cast tensile test 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 test specimens produced in accordance with 3.4.2 shall conform to the following requirements:

3.5.1 **Tensile Properties:** Shall be as follows, determined in accordance with ASTM E8 on integral or separately-cast tensile test specimens or, when specified by purchaser or agreed upon by purchaser and vendor, on specimens cut from castings:

Tensile Strength, min	85,000 psi (586 MPa)
Yield Strength at 0.2% Offset, min	45,000 psi (310 MPa)
Elongation in 4D, min	25%

3.5.1.1 When tensile properties other than those specified in 3.5.1 are required of specimens cut from castings, tensile test specimens conforming to ASTM E8 shall be machined from castings selected at random from each master heat. 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.

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 internal and external 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.

3.6.2 Castings shall be produced under radiographic control, unless otherwise specified. 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 written permission from purchaser.

3.6.5.1 When permitted in writing by purchaser, defects in castings may be removed and the castings repaired by welding provided the weld repair area has properties comparable to those of the parent metal. Repair welds shall be subjected to the same inspection procedures and acceptance standards required of the castings. Weld repair areas shall be suitably marked to facilitate inspection. Repair welding shall be performed prior to any nondestructive testing specified herein.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of castings shall supply all samples 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 perform such confirmatory testing as he deems 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 all technical requirements of this specification are classified as acceptance tests and shall be performed to represent each lot.

4.2.1.1 Tensile properties of specimens cut from castings shall be determined only when specified by purchaser or when representative separately-cast specimens or specimens cut from attached coupons are not available. Tensile properties of separately-cast specimens or of specimens cut from attached coupons need not be determined when tensile properties of specimens cut from castings are determined.

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 on the first-article shipment of a casting to a purchaser, when a change in material or processing 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, pre-production 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: a lot shall be all castings of the same part number poured from the same master heat in a period of 8 consecutive hours and presented for vendor's inspection at one time.

4.3.1 Two chemical analysis specimens in accordance with 3.4.1 and/or a casting from each master heat.

4.3.2 Three separately-cast tensile test specimens in accordance with 3.4.2 from each master heat except when tensile test specimens are permitted to be obtained from attached coupons as in 4.3.3.

4.3.3 One attached coupon, when specified or permitted by purchaser, obtained from each of three castings or clusters of castings selected at random from each lot. Coupons shall be of a size and shape and located on castings as specified on the part drawing or as agreed upon by purchaser and vendor. Specimens conforming to ASTM E8 with 0.250 in. (6.25 mm) diameter at the reduced parallel gage section shall be machined from each coupon.

4.3.4 Two preproduction castings in accordance with 4.4.1 of each part number.

4.3.5 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 test 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: