

AEROSPACE MATERIAL SPECIFICATION

SAE AMS4985

REV. D

Issued 1983-07
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Superseding AMS4985C

Titanium Alloy, Investment Castings
6Al - 4V
130 UTS, 120 YS, 6% EL
Hot Isostatically Pressed
Anneal Optional or When Specified

(Composition similar to UNS R56401)

RATIONALE

AMS4985D results from a Five Year Review and update of this specification.

1. SCOPE

1.1 Form

This specification covers a titanium alloy in the form of investment castings.

1.2 Application

These castings have been used typically for parts of intricate design requiring a combination of good strength-to-weight rate and corrosion resistance, but usage is not limited to such applications.

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.

AMS2175	Castings, Classification and Inspection of
AMS2249	Chemical Check Analysis Limits, Titanium and Titanium Alloys
AMS2694	Repair Welding of Aerospace Castings
AMS2750	Pyrometry
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 B 600	Descaling and Cleaning Titanium and Titanium Alloy Surfaces
ASTM E 8 / E 8M	Tension Testing of Metallic Materials
ASTM E 539	X-Ray Emission Spectrometric Analysis of 6Al-4V Titanium Alloy
ASTM E 1320	Standard Reference Radiographs for Titanium Castings
ASTM E 1409	Determination of Oxygen and Nitrogen in Titanium and Titanium Alloys by the Inert Gas Fusion Technique
ASTM E 1417	Liquid Penetrant Testing
ASTM E 1447	Determination of Hydrogen in Titanium and Titanium Alloys by the Inert Gas Fusion Thermal Conductivity/Infrared Detection Method
ASTM E 1742	Radiographic Examination
ASTM E 1941	Determination of Carbon in Refractory and Reactive Metals and Their Alloys
ASTM E 2371	Analysis of Titanium and Titanium Alloys by Atomic Emission Plasma Spectrometry

3. TECHNICAL REQUIREMENTS

3.1 Composition

Shall conform to the percentages by weight shown in Table 1; carbon shall be determined in accordance with ASTM E 1941, hydrogen in accordance with ASTM E 1447, oxygen and nitrogen in accordance with ASTM E 1409, and other elements in accordance with ASTM E 539 and ASTM E 2371. Other analytical methods may be used if acceptable to the purchaser (See 8.2.1 and 8.2.2).

TABLE 1 - COMPOSITION

Element	min	max
Aluminum	5.50	6.75
Vanadium	3.50	4.50
Iron	--	0.30
Oxygen	--	0.20
Carbon	--	0.10
Nitrogen	--	0.05 (500 ppm)
Hydrogen (3.1.2)	--	0.015 (150 ppm)
Yttrium (3.1.1)	--	0.005 (50 ppm)
Other Elements, each (3.1.1)	--	0.10
Other Elements, total (3.1.1)	--	0.40
Titanium	remainder	

3.1.1 Determination not required for routine acceptance.

3.1.2 For hydrogen analysis conducted in accordance with ASTM E 1447, sample size may be as large as 0.35 gram.

3.1.3 Check Analysis

Composition variations shall meet the applicable requirements of AMS2249.

3.2 Melting Practice

3.2.1 Castings and specimens shall be poured at casting vendor's facility either from a melt (See 8.2.3) of a master heat, or directly from a master heat (See 3.2.3).

3.2.1.1 Remelt for Casting

Castings and specimens shall be remelted and poured under inert gas pressure in accordance with 3.2.2.1, or under vacuum without loss of vacuum between melting and pouring.

3.2.1.2 If authorized by purchaser (See 8.2.4), portions of two or more qualified master heats of 3.2.3 may be remelted together and poured into castings using a procedure acceptable to purchaser.

3.2.1.3 Remelt for casting shall be performed using consumable electrode-practice or other method authorized by purchaser.

3.2.2 Master Heat Preparation

A master heat shall be prepared from any combination of elemental and revert materials that are melted and refined as necessary in a single furnace charge. Single or multiple melting shall be accomplished using consumable electrode, nonconsumable electrode, electron beam cold hearth, or plasma cold hearth practice(s).

3.2.2.1 The atmosphere for melting shall be vacuum or shall be argon and/or helium at an absolute pressure not higher than 1000 millimeters of mercury.

3.2.2.2 Revert (gates, sprues, risers, and rejected castings) may be used in the preparation of master heats.

3.2.2.3 Solidification of the master heat into pigs or ingots before remelting and pouring of castings is permitted.

3.2.2.4 The master heat source shall establish effective control procedures, including parameters for the critical variables that will consistently produce material suitable for remelting of castings meeting the requirements of this specification. Control procedures shall be acceptable to purchaser and casting vendor.

3.2.3 Master Heat Qualification

Each master heat shall be qualified by evaluation of chemical and tensile specimens.

3.2.3.1 Specimens shall be either separately-cast, integrally-cast (See 8.2.5), or machined-from-casting, and shall conform to 3.2.1.

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

3.2.3.3 Specimens used for master heat tensile qualification tests shall be hot isostatically pressed, and annealed (See 3.3.2), as specified in the written procedure of 3.2.3.2.

3.2.3.4 Specimens used for master heat tensile qualification test may be hot isostatically pressed and annealed separately from castings.

3.2.3.5 The acceptance tests of 4.2.1 may be used to satisfy the qualification requirements of 3.2.3.

3.3 Condition

3.3.1 Castings shall be hot isostatically pressed.

3.3.2 A separate annealing operation may be performed, but it is not required.

3.3.3 The vendor shall record the type of thermal processing performed as a control factor of 4.4.2.2.

3.4 Test Specimens

3.4.1 Chemical Analysis Specimens

Shall be of any convenient size and shape.

3.4.2 Tensile Specimens

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

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

3.4.2.1.1 After machining or chemical cleaning, tensile specimens shall be free of oxygen-rich layer, such as alpha case, or other surface contamination.

3.4.2.2 When integrally-cast specimens and specimens machined-from-castings are specified (See 8.2.6), specimen size and location shall be agreed upon by purchaser and vendor (See 8.2.7 and 8.4).

3.5 Thermal Processing

Castings and representative tensile specimens shall be hot isostatically pressed in accordance with 3.5.1. When performed, annealing shall be in accordance with 3.5.2.

3.5.1 Hot Isostatic Press

Process in inert atmosphere at not less than 14.5 ksi (100 MPa) within the range 1650 to 1750 °F (899 to 954 °C), hold at the selected temperature within ± 25 °F (± 14 °C) degrees for 2 to 4 hours, and cool under inert atmosphere in the autoclave to below 800 °F (427 °C).

3.5.2 Anneal

Process in vacuum or inert atmosphere (See 4.3.1.1) at a temperature within the range 1300 to 1550 °F (704 to 843 °C) hold at the selected temperature within ± 25 °F (± 14 °C) for 2 to 4 hours, and cool in the furnace to below 1000 °F (538 °C). Pyrometry shall be in accordance with AMS2750.

3.6 Properties

Castings and separately-cast tensile specimens shall conform to the following requirements; conformance to the requirements of 3.6.1.1 shall be used for acceptance of castings unless purchaser specifies that requirements of 3.6.1.2 apply.

3.6.1 Room Temperature Tensile Properties

Shall be as specified in 3.6.1.1 or 3.6.1.2 determined in accordance with ASTM E 8 / E 8M with the rate of strain set at 0.005 inch/inch/minute (0.005 mm/mm/minute) and maintained within a tolerance of ± 0.002 inch/inch/minute (0.002 mm/mm/minute) through the 0.2% offset yield strain.

3.6.1.1 Separately-Cast Specimens

Shall be as shown in Table 2.

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

Property	Value
Tensile Strength	130 ksi (896 MPa)
Yield Strength at 0.2% Offset	120 ksi (827 MPa)
Elongation in 4D	6%

3.6.1.2 Integrally-Cast Specimens and Specimens Machined-From-Casting

Shall be as shown in Table 3 for designated areas and Table 4 for nondesignated areas.

3.6.1.2.1 Designated Areas

Shall be as shown in Table 3.

TABLE 3 - MINIMUM ROOM TEMPERATURE TENSILE PROPERTIES
INTEGRALLY-CAST SPECIMENS AND SPECIMENS
MACHINED-FROM-CASTING
DESIGNATED AREAS

Property	Value
Tensile Strength	130 ksi (896 MPa)
Yield Strength at 0.2% Offset	120 ksi (827 MPa)
Elongation in 4D	6%

3.6.1.2.2 Nondesignated Areas

Shall be as shown in Table 4.

TABLE 4 - MINIMUM ROOM TEMPERATURE TENSILE PROPERTIES
INTEGRALLY-CAST SPECIMENS AND SPECIMENS
MACHINED-FROM-CASTING
NONDESIGNATED AREAS

Property	Value
Tensile Strength	125 ksi (862 MPa)
Yield Strength at 0.2% Offset	108 ksi (745 MPa)
Elongation in 4D	4.5%

3.6.2 Surface Contamination

Castings shall be free of any oxygen-rich layer such as alpha case, compounds such as residue from halogenated solvents and quenchants, or other surface contamination.

3.6.2.1 Cleaning shall be performed in accordance with ASTM B 600 or other method(s) acceptable to purchaser.

3.6.2.2 After cleaning and prior to any subsequent processing involving temperature over 500 °F (260 °C), castings shall be handled in a manner to preclude surface contamination. Handling with clean, dry, white cotton gloves is recommended.

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.
- 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 testing in accordance with ASTM E 1417 or other method specified by purchaser.
- 3.7.4 Acceptance standards for radiographic, fluorescent penetrant, visual, surface contamination and other inspections shall be as agreed upon by purchaser and vendor.
- 3.7.4.1 AMS2175 may be used to specify frequency of inspection (casting class).
- 3.7.4.2 ASTM E 1320 may be used to specify radiographic standards (casting grade).
- 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.
- 3.7.5.2 Unless otherwise specified by purchaser, castings shall be hot isostatically pressed, or annealed, and/or hot isostatically pressed and annealed after welding.
- 3.7.5.2.1 Castings which are hot isostatically pressed before welding need not be hot isostatically pressed after welding.

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), tensile properties (3.6.1), surface contamination (3.6.2), 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 (3.7.2) is a periodic test and shall be performed at a frequency selected by the 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 in accordance with 3.4.1 from each master heat or a casting from each master heat shall be tested for conformance with Table 1.
 - 4.3.1.1 Except as specified in 4.3.1.2, hydrogen determination shall be on each lot (See 8.2.8) if chemical cleaning (See 8.2.9) is performed after thermal processing, if final anneal heat treatment is performed under inert atmosphere, or if castings are delivered in the hot isostatically pressed condition without subsequent vacuum anneal heat treatment.
 - 4.3.1.2 Hydrogen determination is permitted on each master heat if final anneal heat treatment is performed in vacuum, and if no further chemical cleaning is performed after vacuum anneal heat treatment.
- 4.3.2 One preproduction casting in accordance with 4.4 shall be tested to 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 Tensile property tests shall be conducted to determine conformance with 3.6.1. Sampling and test frequency is dependent upon the type and origin of the specimen specified by purchaser (See 3.4.2 and 3.6) or selected by vendor (See 4.3.3.4).
 - 4.3.3.1 For separately-cast specimens in the representative condition of 3.5, one specimen from each master heat shall be tested for conformance to 3.6.1.1 and Table 2.
 - 4.3.3.2 For integrally-cast specimens in the representative condition of 3.5, two specimens from each lot (See 8.2.8) shall be randomly selected and tested for conformance with 3.6.1.2.1 and Table 3 for designated areas and/or 3.6.1.2.2 and Table 4 for nondesignated areas.
 - 4.3.3.3 For specimens machined from a casting, one casting in the representative condition of 3.5 shall be randomly selected from each lot (See 8.2.8) and tested at each location shown on the engineering drawing for conformance with 3.6.1.2.1 and Table 3 for designated areas and/or 3.6.1.2.2 and Table 4 for nondesignated areas.
 - 4.3.3.3.1 If designated areas are evaluated, the nondesignated areas need not be tested.
 - 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. Integrally-cast specimens may be used in lieu of separately-cast specimens. In each case, the resultant properties must conform to the requirements of 3.6.1.2 for that origin and 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 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 Freedom from surface contamination shall be evaluated on a casting or representative specimen from each lot after completion of all thermal treatments, or by evaluation of castings or representative specimens taken individually from each hot isostatic press, and anneal if applicable, process batch.

4.3.5.1 Techniques used for metallographic examination shall be acceptable to purchaser.

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 is 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).

Master heat metal source

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, including prime and backup materials

Grain refinement methods, if applicable

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

Type of furnace, atmosphere control, and charging and melting practices

Mold preheat and metal pouring temperatures

Solidification and cooling procedures

Cleaning operations (mechanical and chemical/electrochemical)

Hot isostatic processing (HIP) cycles

Annealing heat treatment cycle(s), if applicable

Straightening procedures, if applicable

Final inspection methods

Location of specimens machined-from-casting, if applicable

4.4.2.2.1 Any of the control factors that 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 Inspection and preproduction results shall be reported at the frequency specified by, and in a format acceptable to purchaser.
- 4.5.1.3 Nonconformances shall be documented and approved by purchaser in accordance with purchaser's material review requirements.
- 4.5.1.4 The vendor of castings shall provide a copy of the original material manufacturer's report (material certification), including: producer name, product form, mill produced size, and country where the metal was melted (i.e., final melt in the case of metal processed by multiple melting operations).
- 4.5.2 The certification document and test report(s) shall include or be traceable to the purchase order number, master heat identification, HIP/lot number, heat treat/lot number, AMS4985D, 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.
- 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)
Hydrogen determination, when allowed (See 4.3.1.2)
Room temperature tensile properties (See 4.3.3.1)
- 4.5.3.2 For each lot
- Hydrogen determination, when required (See 4.3.1.1)
Integrally-cast or machined-from-casting room temperature properties, when specified (See 3.6, 4.3.3.2 and 4.3.3.3)
Inspection results (See 4.3.4)
Surface contamination (See 4.3.5)
- 4.5.4 The vendor shall retain records of processing and inspection in accordance with purchaser requirements.
- 4.6 Resampling and Retesting
- If 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 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 if failure is due to specimen mispreparation, test equipment malfunction, improper test procedure, or the presence of random process defects, such as an inclusion, in a tensile specimen (See ASTM E 8 / E 8M).

5. PREPARATION FOR DELIVERY

5.1 Identification

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