

AEROSPACE
MATERIAL
SPECIFICATION

AMS 5394B
Superseding AMS 5394A

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ALLOY IRON CASTINGS, DUCTILE, SAND, CORROSION AND HEAT RESISTANT
2.0Cr - 20Ni (2.4 - 3.0C)
Stress Relieved

UNS F47006

1. SCOPE:

1.1 Form: This specification covers a corrosion and heat resistant alloy ductile iron in the form of sand castings.

1.2 Application: Primarily for parts, such as valve and compressor housings, subject to moderate stresses and requiring moderate corrosion and heat resistance up to 1200°F (650°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 SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2350 - Standards and Test Methods
AMS 2635 - Radiographic Inspection
AMS 2645 - Fluorescent Penetrant Inspection
AMS 2694 - Repair Welding of Aerospace Castings
AMS 2804 - Identification, Castings

2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM A370 - Mechanical Testing of Steel Products
ASTM E351 - Chemical Analysis of Cast Iron - All Types
ASTM E446 - Reference Radiographs for Steel Castings up to 2 in. (51 mm)
in Thickness

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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

2.3.3 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, determined by wet chemical methods in accordance with ASTM E351, 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	2.40	3.00
Manganese	0.80	1.60
Silicon	2.00	3.20
Phosphorus	--	0.25
Sulfur	--	0.15
Chromium	1.70	2.40
Nickel	18.00	22.00
Copper	--	0.50
Lead	--	0.003

3.2 Condition: Stress relieved.

3.3 Castings: A melt shall be the metal poured from a single magnesium-treated ladle of 10,000 lb (4500 kg) or less. A lot shall be all castings poured from a single melt in not more than eight consecutive hours and heat treated together as a batch and presented for vendor's inspection at one time.

3.4 Test Specimens:

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 Coupons: Shall be standard keel blocks conforming to ASTM A370 unless purchaser permits use of "Y" blocks as shown in Fig. 1. Coupons shall be cast with each melt of metal for castings, shall be cast in open molds made of suitable core sand, shall be poured directly after pouring the castings, and shall be kept in the mold until black. Metal for coupons shall be part of the melt which is used for the castings. Molding practice and the coupon size, when use of "Y" blocks is permitted, shall, insofar as practicable, be such that cooling rates of castings and coupons are substantially the same. Tensile specimens in accordance with ASTM A370 shall be machined from the coupons after heat treatment as in 3.5.

3.5 Heat Treatment: Castings and representative tensile coupons shall be heated to a temperature not lower than 1400°F (760°C) which will produce substantially the same hardness in castings and tensile coupons, held at heat for not less than 60 min. per inch (25 mm) of nominal cross-section, and cooled in air. When section size of castings and coupons are such that the same stress-relieving temperature is used for both, at least one set of tensile coupons shall be placed in a batch-type furnace with each load of castings or in a continuous-type furnace at intervals of not longer than 3 hours.

3.6 Properties: Castings and representative tensile coupons produced in accordance with 3.4.2 shall conform to the following requirements; hardness and tensile testing shall be performed in accordance with ASTM A370:

3.6.1 Separately-Cast Coupons:

3.6.1.1 Tensile Properties: Shall be as follows:

Tensile Strength, min	55,000 psi (380 MPa)
Yield Strength at 0.2% Offset, min	32,000 psi (220 MPa)
Elongation in 4D, min	7%

3.6.2 Castings:

3.6.2.1 Microstructure: Shall consist of spheroidal graphite with small amounts of carbide in matrix of austenite, essentially free from flake graphite.

3.6.2.2 Tensile Properties: Shall be as follows, determined on specimens cut from castings:

Tensile Strength, min	55,000 psi (380 MPa)
Yield Strength at 0.2% Offset, min	32,000 psi (220 MPa)
Elongation in 4D, min	5%

3.6.2.2.1 Specimens cut from castings are not required for acceptance of castings; however, properties obtained from such specimens may be the basis for acceptance of castings.

3.6.2.3 Hardness: Should be 75 - 88 HRB or equivalent but castings shall not be rejected on the basis of hardness if the tensile property requirements of 3.6.2.2 are met.

3.6.2.4 Effect of Sub-Zero Cooling: Castings shall withstand, without the austenite transforming to martensite, being cooled to $-75^{\circ}\text{F} \pm 5$ ($-60^{\circ}\text{C} \pm 3$), holding at $-75^{\circ}\text{F} \pm 5$ ($-60^{\circ}\text{C} \pm 3$) for sufficient time to equalize, and warming to room temperature. Castings so treated shall be sufficiently nonmagnetic to prevent a small steel magnet from adhering to the casting.

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 internal and external imperfections detrimental to usage of the castings.

3.7.1.1 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.

3.7.2 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.

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

3.7.4 Radiographic, fluorescent penetrant, and other quality standards shall be as agreed upon by purchaser and vendor. ASTM E446 may be used to define radiographic acceptance standards.

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

3.7.5.1 When permitted in writing by purchaser, defects in castings may be 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
Ø conformance to all technical requirements of this specification are classified as acceptance tests and shall be performed on each melt or lot as applicable.
- 4.2.1.1 Tensile properties of specimens cut from castings shall be determined
Ø only when specified by purchaser or when separately-cast coupons are not available. Tensile properties of separately-cast 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
Ø 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 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, 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 or a casting from each melt.
- 4.3.2 Three tensile coupons in accordance with 3.4.2 from each melt.
- 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 lot 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 specimens are not specified, not less than two tensile specimens, one from the thickest section and one from the thinnest section, shall be cut from a casting or castings from each lot.

4.4 Approval:

- 4.4.1 Sample castings from new or reworked 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 for production of sample castings of each part number parameters for the process control factors which will produce acceptable castings; these shall constitute the approved casting procedure and shall be used for producing production castings. If necessary to make any change in parameters for the process control factors, vendor shall submit for reapproval a statement of the proposed changes in processing and, when requested, sample test coupons, 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 castings include, but are not limited to, the following:

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Type of furnace
Furnace atmosphere
Fluxing or deoxidation procedure
Gating and risering practices
Pouring temperature (variation of $\pm 50^{\circ}\text{F}$ ($\pm 30^{\circ}\text{C}$) from the established limit is permissible)
Solidification and cooling procedures
Heat treatment procedure
Cooling operations
Methods of inspection

4.4.2.1.1 Any of the above process control factors 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.

4.5 Reports:

4.5.1 The vendor of castings shall furnish with each shipment three copies of a report showing the results of tests for chemical composition of at least one casting, or of specimens as in 3.4.1, from each melt represented and the results of tests on castings or separately-cast coupons to determine conformance to the other technical requirements of this specification. This report shall include the purchase order number, melt number, AMS 5394B, part number, and quantity from each melt.

4.5.2 The vendor of finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, AMS 5394B, contractor or other direct supplier of castings, part number, and quantity. When castings for making parts are produced or purchased by the parts vendor, that vendor shall inspect castings from each melt represented to determine conformance to the requirements of this specification and shall include in the report either a statement that the castings conform or copies of laboratory reports showing the results of tests to determine conformance.

- 4.6 Resampling and Retesting: If any specimen used in the above tests fails to meet the specified requirements, disposition of the castings may be based on the results of testing three additional specimens for each original nonconforming specimen. Failure of any retest specimen to meet the specified requirements shall be cause for rejection of the castings represented and no additional testing shall be permitted. Results of all tests shall be reported.

5. PREPARATION FOR DELIVERY:

- 5.1 Identification: Castings shall be identified in accordance with AMS 2804.

5.2 Packaging:

- 5.2.1 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. Packaging shall conform to carrier rules and regulations applicable to the mode of transportation.

- 5.2.2 For direct U.S. Military procurement, packaging shall be in accordance with MIL-STD-794, Level A or Level C, as specified in the request for procurement. Commercial packaging as in 5.2.1 will be acceptable if it meets the requirements of Level C.

6. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

7. REJECTIONS: Castings not conforming to this specification or to modifications authorized by purchaser will be subject to rejection.

8. NOTES:

- 8.1 Marginal Indicia: The phi (Ø) symbol is used to indicate technical changes from the previous issue of this specification.

- 8.2 Dimensions and properties in inch/pound units are standard; dimensions and properties in SI units are shown as the approximate equivalents of the inch/pound units and are presented only for informational purposes.

- 8.3 For direct U.S. Military procurement, purchase documents should specify not less than the following:

Title, number, and date of this specification
Part number or pattern number of castings desired
Quantity of castings desired
Size, location, and number of specimens for tensile testing when specimens cut from castings are required
Applicable level of packaging (See 5.2.2)