



Designation: A494/A494M – 17

Standard Specification for Castings, Nickel and Nickel Alloy¹

This standard is issued under the fixed designation A494/A494M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This specification covers nickel, nickel-copper, nickel-copper-silicon, nickel-molybdenum, nickel-chromium, and nickel-molybdenum-chromium alloy castings for corrosion-resistant service.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in nonconformance with the standard.

2. Referenced Documents

2.1 ASTM Standards:²

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A488/A488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel

A732/A732M Specification for Castings, Investment, Carbon and Low Alloy Steel for General Application, and Cobalt Alloy for High Strength at Elevated Temperatures

A781/A781M Specification for Castings, Steel and Alloy, Common Requirements, for General Industrial Use

A957/A957M Specification for Investment Castings, Steel and Alloy, Common Requirements, for General Industrial Use

E8 Test Methods for Tension Testing of Metallic Materials

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E30 Test Methods for Chemical Analysis of Steel, Cast Iron, Open-Hearth Iron, and Wrought Iron (Withdrawn 1995)³

E38 Methods for Chemical Analysis of Nickel-Chromium and Nickel-Chromium-Iron Alloys (Withdrawn 1989)³

E76 Test Methods for Chemical Analysis of Nickel-Copper Alloys (Withdrawn 2003)³

E354 Test Methods for Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys

3. Terminology

3.1 Definitions:

3.1.1 *master heat*—a single furnace charge of refined alloy, which may either be poured directly into castings or into remelt alloy for individual melts.

3.1.2 *melts*—a single furnace charge poured into castings. When master heats are used to prepare melts, a melt analysis shall be reported.

4. General Conditions for Delivery

4.1 Except for investment castings, castings furnished to this specification shall conform to the requirements of Specification A781/A781M, including any supplementary requirements that are indicated on the purchase order. Failure to comply with the general requirements of Specification A781/A781M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A781/A781M, this specification shall prevail.

4.2 Investment castings furnished to this specification shall conform to the requirements of Specification A957/A957M, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A957/A957M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A957/A957M, Specification A957/A957M shall prevail.

5. Ordering Information

5.1 Orders for castings to this specification should include the following information:

5.1.1 Quantity, in pieces, and

5.1.2 Grade designation (Table 1) and class (Table 2).

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.18 on Castings.

Current edition approved March 15, 2017. Published March 2017. Originally approved in 1963. Last previous edition approved in 2015 as A494/A494M – 15. DOI: 10.1520/A0494_A0494M-17.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

*A Summary of Changes section appears at the end of this standard