



Standard Specification for Magnesium-Alloy Investment Castings¹

This standard is issued under the fixed designation B403; 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 Department of Defense.

1. Scope*

1.1 This specification covers magnesium-alloy investment castings designated as shown in [Table 1](#).

1.2 Alloy designations are in accordance with Practice [E527](#); temper designations are in accordance with Practice [B296](#).

1.3 The values stated in inch-pound units are to be regarded as the standard. The SI values in parentheses are for information only.

2. Referenced Documents

2.1 The following documents of the issue in effect on the date of order acceptance form a part of this specification to the extent referenced herein:

2.2 ASTM Standards:²

- [B296 Practice for Temper Designations of Magnesium Alloys, Cast and Wrought](#)
- [B557 Test Methods for Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products](#)
- [B660 Practices for Packaging/Packing of Aluminum and Magnesium Products](#)
- [B661 Practice for Heat Treatment of Magnesium Alloys](#)
- [B666/B666M Practice for Identification Marking of Aluminum and Magnesium Products](#)
- [B951 Practice for Codification of Unalloyed Magnesium and Magnesium-Alloys, Cast and Wrought](#)
- [B953 Practice for Sampling Magnesium and Magnesium Alloys for Spectrochemical Analysis](#)
- [B954 Test Method for Analysis of Magnesium and Magnesium Alloys by Atomic Emission Spectrometry](#)
- [D3951 Practice for Commercial Packaging](#)

- [E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)
- [E88 Practice for Sampling Nonferrous Metals and Alloys in Cast Form for Determination of Chemical Composition](#)
- [E94 Guide for Radiographic Examination](#)
- [E155 Reference Radiographs for Inspection of Aluminum and Magnesium Castings](#)
- [E165 Practice for Liquid Penetrant Examination for General Industry](#)
- [E527 Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)
- 2.3 *Federal Standards:*
 - [Fed. Std. No. 123 Marking for Shipping \(Civil Agencies\)³](#)
- 2.4 *Military Standards:*
 - [MIL-STD-129 Marking for Shipment and Storage \(Military Agencies\)³](#)

3. Ordering Information

3.1 Orders for castings under this specification shall include the following information:

- 3.1.1 Quantity of each casting,
- 3.1.2 Alloy (Section [6](#) and [Table 1](#)),
- 3.1.3 Temper (see [5.1](#) and [Table 2](#)),
- 3.1.4 Casting drawing giving all necessary dimensions and showing amount of finish left for machining,
- 3.1.5 Surface treatment (see [10.1](#)),
- 3.1.6 Whether certification is required (see [11.1](#)),
- 3.1.7 Whether inspection is required at the manufacturer's works (see [12.1](#)), and
- 3.1.8 Special inspection requirements (see [12.3](#)).

4. Materials and Manufacture

4.1 The responsibility for furnishing castings that can be laid out and machined to the finished dimensions within the permissible variations specified, as shown on the drawings, shall rest with the manufacturer, except where mold equipment is furnished by the purchaser. Sufficient stock shall be allowed for shrinkage and, where required, for finishing; but castings of excessive weight shall not be furnished.

¹ This specification is under the jurisdiction of ASTM Committee [B07](#) on Light Metals and Alloys and is the direct responsibility of Subcommittee [B07.04](#) on Magnesium Alloy Cast and Wrought Products.

Current edition approved Nov. 1, 2012. Published November 2012. Originally approved in 1963. Last previous edition approved in 2007 as B403–07. DOI: 10.1520/B0403-12.

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 Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.

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

TABLE 1 Chemical Composition Limits^A

NOTE 1—Analysis shall regularly be made for the elements specifically mentioned in this table. If, however, the presence of other elements is suspected or indicated in amounts greater than the specified limits, further analysis shall be made to determine that these elements are not present in excess of the specified limits.

NOTE 2—The following applied to all specified limits in this table: For purposes of acceptance and rejection, an observed value or a calculated value obtained from analysis should be rounded off to the nearest unit in the last right-hand place of figures used in expressing the specified limit.

Alloy Number ^B		Composition, percent												
ASTM	UNS	Iron	Magne- sium	Alu- minum	Manga- nese	Zinc	Zirconium	Rare Earths	Thorium	Copper	Nickel	Silicon	Total ^C Other Impurities	Others Each
AM100A	M10100	...	remainder	9.3–10.7	0.10–0.35	0.30	0.10	0.01	0.30	0.30	...
AZ81A	M11810	...	remainder	7.0–8.1	0.13–0.35	0.40–1.0	0.10	0.01	0.30	0.30	...
AZ91C	M11914	...	remainder	8.1–9.3	0.13–0.35	0.40–1.0	0.10	0.01	0.30	0.30	...
AZ91E	M11919	0.005 ^{DE}	remainder	8.1–9.3	0.17–0.35	0.40–1.0	0.015	0.0010	0.20	0.30	0.01
AZ92A	M11920	...	remainder	8.3–9.7	0–0.35	1.6–2.4	0.10	0.01	0.30	0.30	...
EQ21A	M18330	...	remainder	0.40–1.0	1.5–3.0 ^F	...	0.05–0.10	0.01	...	0.30	...
EZ33A	M12330	...	remainder	2.0–3.1	0.50–1.0	2.5–4.0	...	0.10	0.01	...	0.30	...
K1A	M18010	...	remainder	0.40–1.0	0.30	...
QE22A ^G	M18220 ^G	...	remainder	0.40–1.0	1.8–2.5 ^F	...	0.10	0.01	...	0.30	...
ZE41A	M16410	...	remainder	...	0.15	3.5–5.0	0.40–1.0	0.75–1.75	...	0.10	0.01	...	0.30	...
ZK61A	M16610	...	remainder	5.5–6.5	0.6–1.0	0.10	0.01	...	0.30	...

^A Limits are in weight percent maximum unless shown as a range or stated otherwise.

^B These alloy designations were established in accordance with Practice B951.

^C Includes listed elements for which no specific limit is shown.

^D If iron content exceeds 0.005 %, the iron to manganese ratio shall not exceed 0.032.

^E Silver content for Alloy EQ21A shall be 1.3 to 1.7 %.

^F Rare earth elements are in the form of didymium.

^G Silver content for Alloy QE22A shall be 2.0 through 3.0 %.

5. Treatment

5.1 The castings may be subjected to such heat treatment as the manufacturer desires to produce material that will conform to the requirements specified. Heat treatment shall be performed on the whole of the casting, never on a part only, and shall be applied in a manner that will produce uniformity. Unless otherwise specified, treatment shall be in accordance with Practice B661.

6. Chemical Composition

6.1 The castings shall conform to the chemical composition limits in Table 1.

6.2 The chemical analysis shall be made in accordance with Test Method B954, or by any other approved methods agreed upon by the manufacturer and the purchaser. The analysis may be made spectrochemically provided that, in case of disagreement, the results secured by Test Method B954 shall be the basis for acceptance.

6.3 The sampling shall be in accordance with Practice B953.

7. Tensile Properties

7.1 *Limits*—The tension test specimens representing the castings shall conform to the requirements for tensile properties prescribed in Table 2.

7.2 Number of Tests:

7.2.1 At least two tension test specimens shall be cast from each melt of 2000 lb (907 kg) or fraction thereof to represent the castings poured from the same melt. If the castings are to

be heat treated, the specimens shall be heat treated with production castings of the same alloy and in the same temper as the specimens.

7.2.2 Each heat-treating furnace charge shall include at least two tension test specimens poured from a production melt. Such specimens shall be of the same alloy and in the same temper as the castings, and shall be tested to judge the quality of the heat-treating operation given the furnace charge.

7.3 Test Specimens:

7.3.1 The tension test specimens shall be separately cast in the same refractory material as the castings. The specimen should be “cast to size” according to the dimensions of the 0.250-in. (6.35-mm) diameter round specimen shown in Fig. 8 of Test Methods B557. They shall not be machined prior to test except to adapt the grip ends to the holders of the testing machine to assure axial loading.

7.3.2 If any tension test specimen is improperly machined or shows flaws upon testing, it may be discarded and another specimen from the same heat or melt used instead. If no additional specimen is available, the manufacturer and the purchaser shall agree on an alternative procedure.

7.4 *Test Methods*—The tension tests shall be made in accordance with Test Methods B557.

8. Retests

8.1 If any test specimen fails to conform to the prescribed requirements, two additional representative specimens shall be selected and tested. If either of these specimens fails to conform to the requirements, the lot may be rejected. If, however, the specimen failure is due to inadequate thermal

treatment, the material may be reheat-treated and resampled in accordance with 7.2. Castings may be reheat-treated no more than twice.

9. General Quality

9.1 The castings shall be of uniform quality and condition, free from cracks and other injurious defects, and shall be cleaned before inspection by blasting or other approved process.

9.2 Castings shall not be repaired by welding, impregnation, peening, or other method without permission of the purchaser.

10. Finish

10.1 Unless otherwise specified, the castings should be chrome pickled or coated with a corrosion inhibitive oil prior to shipment.

TABLE 2 Tensile Requirements

NOTE 1—For purposes of determining conformance with this specification, each value for tensile strength and yield strength shall be rounded off to the nearest 0.1 ksi (0.07 MPa), and each value for elongation shall be rounded off to the nearest 0.5 %, both in accordance with the rounding off method of Practice E29.

Alloy and Temper	Tensile Strength, min, ksi (MPa)	Yield Strength (0.2 % Offset), min, ksi	Elongation in 1 in. (25 mm) or 4x ia min, %
AM100A-F	20.0 (138)	10.0 (69)	^A
AM100A-T4	34.0 (234)	10.0 (69)	6
AM100A-T6	34.0 (234)	15.0 (103)	2
AM100A-T7	34.0 (234)	17.0 (117)	^A
AZ81A-T4	34.0 (234)	10.0 (69)	7
AZ91C-F	18.0 (124)	10.0 (69)	^A
AZ91C-T4	34.0 (234)	10.0 (69)	7
AZ91C-T5	20.0 (138)	11.0 (76)	2
AZ91C-T6	34.0 (234)	16.0 (110)	3
AZ91E-T6	34.0 (234)	16.0 (110)	3
AZ92A-F	20.0 (138)	10.0 (69)	^A
AZ92A-T4	34.0 (234)	10.0 (69)	6
AZ92A-T5	20.0 (138)	11.0 (76)	^A
AZ92A-T6	34.0 (234)	18.0 (124)	^A
EQ21A-T6	34.0 (234)	25.0 (172)	2
EZ33A-T5	20.0 (138)	14.0 (97)	2
K1A-F	22.0 (152)	7.0 (48)	14
QE22A-T6	35.0 (241)	25.0 (172)	2
ZE41A-T5	29.0 (200)	19.5 (133)	2.5
ZK61A-T6	40.0 (276)	25.0 (172)	5

^A Not required.

11. Certification

11.1 The supplier shall, on request, furnish to the purchaser a certificate stating that the material has been sampled, tested, and inspected in accordance with this specification, and has been found to meet the requirements.

12. Inspection

12.1 If the purchaser desires to make an inspection of the material at the manufacturer's works where the castings are made, it shall be so stated in the contract or purchase order.

12.2 If the purchaser elects to have the inspection made at the manufacturer's works, the manufacturer shall afford the inspector representing the purchaser all reasonable facilities to satisfy him that the material is being furnished in accordance with this specification. All tests and inspection shall be so conducted as not to interfere unnecessarily with the operation of the works.

12.3 Special inspection requirements such as pressure testing, X-ray, or fluorescent penetrant must be stated on the order. Unless specific reference is made to the degree of discontinuity by reference to Reference Radiographs E155, acceptance standards shall be agreed upon by the purchaser and the manufacturer. When specified, radiography shall be in accordance with Guide E94 and penetrant inspection shall be in accordance with Practice E165.

13. Rejection

13.1 Material failing to conform to the requirements of this specification, or in which defects are found during subsequent manufacturing operations may be rejected. If rejected, the manufacturer shall be responsible only for replacement of the material to the purchaser. All of the rejected original material shall be returned to the manufacturer.

14. Packaging and Marking

14.1 The material shall be packaged in such a manner as to prevent damage in ordinary handling and transportation. The type of packaging and gross weight of individual containers shall be left to the discretion of the manufacturer unless otherwise agreed upon.

14.2 Packages or containers shall be such as to ensure acceptance by common or other carriers for safe transportation to the point of delivery.

14.3 Each package or container shall be marked with the purchase order number, drawing number, and quantity. Additional information will be contained inside the package or container to identify the shipment by drawing number, quantity, alloy, and condition.

14.4 When specified in the contract or purchase order, castings shall be preserved, packaged, and packed in accordance with the requirements of Practices B660. The applicable levels shall be specified in the contract or order. Marking for shipment of such material shall be in accordance with one of the following selected standards for civil agencies: Fed. Std. No. 123, Practice B666/B666M, or Practice D3951. MIL-STD-129 is to be cited for marking supplies for military agencies only.

15. Keywords

15.1 investment castings; magnesium alloy

SUMMARY OF CHANGES

Committee B07 has identified the location of selected changes to this standard since the last issue (B403 – 07) that may impact the use of this standard. (Approved Nov. 1, 2012)

(1) Replaced withdrawn Test Methods E35 with Practice **B953** and Test Method **B954** in **6.2** and **6.3**.

ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org). Permission rights to photocopy the standard may also be secured from the ASTM website (www.astm.org/COPYRIGHT/).