



Standard Specification for Copper-Beryllium Alloy Sand Castings for General Applications¹

This standard is issued under the fixed designation B770; 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 establishes requirements for copper-beryllium alloy sand castings for general applications and nominal compositions alloys defined by this specification are shown in [Table 1](#).²

1.2 *Units*—The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 The following safety hazard caveat pertains only to the test methods described in this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory requirements prior to use.*

2. Referenced Documents

2.1 The following documents in the current issue of the Book of Standards form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards*:³

[B30 Specification for Copper Alloys in Ingot Form](#)

[B208 Practice for Preparing Tension Test Specimens for Copper Alloy Sand, Permanent Mold, Centrifugal, and Continuous Castings](#)

[B601 Classification for Temper Designations for Copper and](#)

[Copper Alloys—Wrought and Cast](#)

[B824 Specification for General Requirements for Copper Alloy Castings](#)

[B846 Terminology for Copper and Copper Alloys](#)

[E527 Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)

3. General Requirements

3.1 The following sections of Specification [B824](#) constitute a part of this specification:

- 3.1.1 Terminology,
- 3.1.2 Material and Manufacture,
- 3.1.3 Chemical Composition,
- 3.1.4 Dimensions and Permissible Variations,
- 3.1.5 Workmanship, Finish and Appearance,
- 3.1.6 Sampling,
- 3.1.7 Number of Tests and Retests,
- 3.1.8 Specimen Preparation,
- 3.1.9 Test Methods,
- 3.1.10 Significance of Numerical Limits,
- 3.1.11 Inspection,
- 3.1.12 Rejection and Rehearing,
- 3.1.13 Certification,
- 3.1.14 Mill Test Report, and
- 3.1.15 Packaging and Package Marking.

3.2 In addition, when a section with a title identical to that referenced in [3.1](#) appears in this specification, it contains additional requirements which supplement those appearing in Specification [B824](#).

4. Terminology

4.1 For definitions of terms relating to copper and copper alloys, refer to Terminology [B846](#).

5. Ordering Information

5.1 Include the following information for orders for product:

- 5.1.1 ASTM designation number, title, and year of issue,
- 5.1.2 Copper Alloy UNS Number designation,
- 5.1.3 Temper,
- 5.1.4 Quantity of castings required,

¹ This specification is under the jurisdiction of ASTM Committee [B05](#) on Copper and Copper Alloys and is the direct responsibility of Subcommittee [B05.05](#) on Castings and Ingots for Remelting.

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² The UNS system for copper and copper alloys (see Practice [E527](#)) is a simple expansion of the former standard designation system accomplished by the addition of a prefix “C” and a suffix “00”. The suffix can be used to accommodate composition variations of the base alloy.

³ 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.

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

TABLE 1 Nominal Compositions

Copper Alloy UNS No.	Previous Designation	Copper	Nickel	Silicon	Beryllium	Cobalt	Chromium	Iron	Zirconium	Tin	Manganese
C81400	70C	99.1	0.06	...	0.8
C82000	10C	97	0.5	2.5
C82200	3C, 14C	98	2.0	...	0.5
C82400 ^A	165C, 165CT ^A	97.8	1.7	0.5
C82500 ^A	20C, 20CT ^A	97.2	...	0.3	2.0	0.5
C82510	21C	96.6	...	0.3	2.0	1.1
C82600 ^A	245C, 245CT ^A	96.8	...	0.3	2.4	0.5
C82800 ^A	275C, 275CT ^A	96.6	...	0.3	2.6	0.5
C96700	72C	67.2	31.0	...	1.2	0.6	0.3	0.3	0.6

^A When fine-grained castings are specified, 0.02 to 0.12 titanium is added for grain refinement, usually in the remelt ingot. See Specification B30.

5.1.5 Pattern or drawing number, and condition (cast, machined, and so forth),

5.1.6 When material is purchased for agencies of the U.S. government, the Supplementary Requirements of Specification B824 may be specified.

5.2 The following options are available and should be specified in the contract or purchase order when required.

5.2.1 Mechanical requirements, if specified in the purchase order (Section 10),

5.2.2 Pressure test requirements, if specified in the purchase order (Specification B824),

5.2.3 Soundness requirements, if specified in the purchase order (Specification B824),

5.2.4 Repair of castings (Section 12),

5.2.5 Certification, if specified in the purchase order (Specification B824),

5.2.6 Foundry test report, if specified in the purchase order (Specification B824),

5.2.7 Witness inspection, if specified in the purchase order (Specification B824), and

5.2.8 Product marking, if specified in the purchase order (Specification B824).

6. Materials and Manufacture

6.1 *Material*—The material of manufacture shall be castings of the copper alloys listed in Table 1, as specified in the purchase order or contract, and of such purity and soundness as to be suitable for the products prescribed herein.

6.2 *Manufacture*—The product shall be manufactured by casting and thermal treatment to meet the properties specified.

7. Chemical Composition

7.1 The castings shall conform to the chemical composition requirements prescribed in Table 2 for the Copper Alloy UNS Number designations specified in the ordering information.

7.2 These composition limits do not preclude the presence of other elements. Limits may be established for unnamed elements by agreement between manufacturer or supplier and purchaser.

7.3 Copper is customarily given as remainder but may be taken as the difference between the sum of all elements analyzed and 100 %.

7.4 When all elements in Table 2 are analyzed, their sum shall be 99.5 % minimum.

8. Temper

8.1 The standard tempers are listed as follows:

8.1.1 *TF00*—Cast, solution heat treated and precipitation heat treated.

8.1.2 *MOI*—As sand cast.

8.1.3 Special or non-standard tempers are subject to negotiation between the supplier and purchaser. Standard temper designations are in accordance with Classification B601.

9. Precipitation Heat Treatment

9.1 For the purpose of determining conformance to the appropriate requirement in Table 3, the castings and test specimens shall be precipitation heat-treated at a uniform temperature from the solution heat-treated condition. Solution heat-treatment and precipitation heat-treatments are listed in Table 4. Other treatment times and temperatures may be preferable for end products made from this material.

9.2 Special combinations of properties such as increased ductility, electrical conductivity, dimensional accuracy, and endurance life may be obtained by special precipitation heat-treatments. The mechanical requirements of Table 3 do not apply to such special heat-treatments. Specific test requirements as needed shall be agreed upon between the manufacturer or supplier and purchaser of the end product.

10. Mechanical Property Requirements

10.1 When tension tests are required, separately cast test-bar specimens shall be used to determine mechanical properties and shall meet the requirements shown in Table 3 in the as cast or solution heat-treated and precipitation heat-treated condition.

11. Purchases for U. S. Government

11.1 When specified in the contract or purchase order, product purchased for an agency of the U. S. government shall conform to the special government regulations specified in the Special Requirements.

12. Casting Repair

12.1 The castings shall not be weld repaired without approval of the purchaser.

12.2 The castings shall not be impregnated without approval of the purchaser.

TABLE 2 Chemical Requirements^A

Composition, % max, except as indicated

Copper Alloy UNS No.	Copper, ^B min	Beryllium	Cobalt	Nickel	Silicon	Zirconium	Titanium	Manganese	Iron	Zinc	Chromium	Lead	Aluminum	Tin
C81400	remainder	0.02–0.10	0.10	...	0.6–1.0
C82000	remainder	0.45–0.8	2.40–2.70 ^C	0.20 ^C	0.15	0.10	0.10	0.09	0.02	0.10	0.10
C82200	remainder	0.35–0.8	0.30	1.0–3.0	0.15
C82400 ^D	remainder	1.60–1.85	0.20–0.65	0.20	0.20	0.10	0.09	0.02	0.15	0.10
C82500 ^D	remainder	1.90–2.25	0.35–0.70 ^C	0.20 ^C	0.20–0.35	0.25	0.10	0.09	0.02	0.15	0.10
C82510	remainder	1.90–2.15	1.0–1.2	0.20	0.20–0.35	0.25	0.10	0.09	0.02	0.15	0.10
C82600 ^D	remainder	2.25–2.55	0.35–0.65	0.20	0.20–0.35	0.25	0.10	0.09	0.02	0.15	0.10
C82800 ^D	remainder	2.50–2.85	0.35–0.70 ^C	0.20 ^C	0.20–0.35	0.25	0.10	0.09	0.02	0.15	0.10
C96700	remainder	1.10–1.20	...	29.0–33.0 ^C	0.15	0.15–0.35	0.15–0.35	0.40–1.0	0.40–1.0	0.01

^A Analysis shall regularly be made only for the major elements. All others are considered residual elements, and if above the noted maximums, may influence performance of the casting, particularly in conductivity, magnetic permeability, and machinability.

^B In reporting chemical analyses obtained by use of instruments such as spectrograph, X-ray, and atomic absorption, copper may be indicated as "remainder," and taken by difference.

^C Nickel + cobalt.

^D When fine grained castings are specified, 0.02–0.12 titanium is added for grain refinement, usually in the remelt ingot. See Specification B30.

TABLE 3 Mechanical Requirements

NOTE 1—"TF00" property values denote product in the standard solution heat-treated and precipitation heat-treated condition.

NOTE 2—"M01" property values denote product in the as sand cast condition.

Copper Alloy UNS No.	Temper Designation	Tensile Strength, min		Yield Strength 0.2 % Offset		Elongation % min in 4xD ^C
		ksi ^A	MPa ^B	ksi ^A	MPa ^B	
C81400	TF00	53	366	36	248	11
C81400	M01	45	311	15	104	15
C82000	TF00	90	621	70	483	3
C82000	M01	45	311	15	104	15
C82200	TF00	90	621	70	483	5
C82200	M01	55	380	25	173	15
C82400	TF00	145	1001	135	932	1
C82400	M01	70	483	35	242	15
C82500	TF00	150	1035	120	828	1
C82500	M01	75	518	40	276	15
C82510	TF00	160	1104	150	1035	1
C82510	M01	80	552	45	311	10
C82600	TF00	165	1139	155	1070	1
C82600	M01	80	552	45	311	10
C82800	TF00	165	1139	155	1070	1/2
C96700	TF00	125	863	80	552	10

^A ksi = 1000 psi.

^B See Appendix.

^C 4xD = 4 × diameter.

TABLE 4 Thermal Treatments

NOTE 1—The values given for solution heat treatment, precipitation temperature, and heat treatment time are the same for UNS Nos. C82400, C82500, C82510, C82600, and C82800.

Copper Alloy UNS No.	Solution Heat Treatment		Precipitation Temperature	Heat Treatment Time, h
	Temperature	Time, h/in.		
{ C81400 C96700	1800–1850°F (982–1010°C)	1 h/in. of cross section and water quench	900–950°F (482–510°C)	2
{ C82000 C82200	1675–1700°F (913–927°C)	1 h/in. of cross section and water quench	850–900°F (454–482°C)	3
C82400 C82500 { C82510 C82600 C82800	1400–1475°F (760–802°C)	1 h/in. of cross section and water quench	625–650°F (330–343°C)	3

13. Sampling

13.1 Lot Size:

13.1.1 A lot shall consist of all castings produced from one furnace melt or crucible melt.

13.1.2 When two or more furnace melts or crucible melts, or both, are used to charge a ladle for pouring, the castings produced therefrom shall constitute a lot.

13.1.3 A lot may consist of such groups of melts as agreed upon by the manufacturer and purchaser and in such case a lot shall consist of not more than 1000 lb (455 kg) of castings (gates and risers removed).

13.1.4 Test bar specimens for the Copper Alloy UNS Numbers in this specification shall be cast to the form and dimensions shown in Figs. 1, Figs. 2, Figs. 3, or Figs. 4 in Practice B208.

14. Keywords

14.1 copper alloy castings; copper-base alloy castings; copper beryllium castings

APPENDIX**(Nonmandatory Information)****X1. METRIC EQUIVALENTS**

X1.1 The SI unit for strength properties now shown is in accordance with the International System of Units (SI). The derived SI unit for force is the newton (N), which is defined as that force which when applied to a body having a mass of one kilogram gives it an acceleration of one metre per second squared ($N = \text{kg}\cdot\text{m}/\text{s}^2$). The derived SI unit for pressure or

stress is the newton per square metre (N/m^2), which has been named the pascal (Pa) by the General Conference on Weights and Measures. Since $1 \text{ ksi} = 6\,894\,757 \text{ Pa}$ the metric equivalents are expressed as megapascal (MPa), which is the same as MN/m^2 and N/mm^2 .

SUMMARY OF CHANGES

Committee B05 has identified the location of selected changes to this standard since the last issue (B770 – 10) that may impact the use of this standard. (Approved May 1, 2015.)

(1) **Table 2** was revised.

(2) Sections 5.2.1 and 7.5 were deleted.

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