



Designation: **B 283 – 99a04**

Standard Specification for Copper and Copper-Alloy Die Forgings (Hot-Pressed)¹

This standard is issued under the fixed designation B 283; 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 establishes the requirements for copper and copper alloy die forgings produced by the hot pressing method. The following copper and copper alloys are included:

Copper or Copper Alloy	UNS No.	Name
	C44000	
	C11000	copper
	C14500	copper-tellurium
	C14700	copper-sulfur
	C36500	leaded Muntz metal
	C37000	free-cutting Muntz metal
	C37700	forging brass
	C46400	naval brass
	C48200	medium leaded naval brass
	C48500	leaded naval brass
	C61900	aluminum bronze
	C62300	aluminum bronze, 9 %
	C63000	aluminum-nickel bronze
	C63200	aluminum-nickel bronze
	C64200	aluminum-silicon bronze
	C64210	aluminum-silicon bronze, 6.7 %
	C65500	high-silicon bronze (A)
	C67500	manganese bronze (A)
	C67600	...
	C70620	copper-nickel 90-10
	C71520	copper-nickel 70-30
	C77400	nickel silver, 45-10

1.2 ~~The values~~

1.2 Units—Values stated in inch-pound units are ~~the to be~~ regarded as standard. The ~~SI~~ values given in parentheses are mathematical conversions to SI units, which are provided for information only.

1.3 ~~The following safety caveat pertains only to Section 10 of 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 limitations prior to use.*~~ are not considered standard.

NOTE 1—Nominal composition and relative forgeability ratings are given in Appendix X1. Copper-nickel alloys C70620 and C71520 are intended for welded applications with seawater exposure.

NOTE 2—Wrought product intended for hot forging is described in Specification B 124/B 124M.

1.3 The following safety caveat pertains only to Section 10 of 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 limitations prior to use.*

¹ This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.02 on Rod, Bar, Wire, Shapes, and Forgings.

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

2. Referenced Documents

2.1 ASTM Standards:²

~~B 1249/B 124M Specification for General Requirements for Wrought Copper and Copper Alloy Forging Rod, Bar, Shapes and Forgings Shapes~~

~~B 601 Practice 249/B 249M Specification for Temper Designations General Requirements for Wrought Copper and Copper Alloys—Wrought Alloy Rod, Bar, Shapes and Cast² Forgings~~

B 846 Terminology for Copper and Copper Alloys

E 8 Test Methods for Tension Testing of Metallic Materials

~~E 5462 Test Methods for Chemical Analysis of Special Brasses Copper and Bronzes Copper Alloys (Photometric Method)~~

~~E 6275 Test Methods for Chemical Analysis of Copper-Nickel and Copper Alloys (Photometric Method)⁴ Copper-Nickel-Zinc Alloys~~

~~E 4758 Test Methods for Chemical Analysis of Copper-Nickel and Copper-Nickel-Zinc Alloys⁴~~

~~E 478 Test Methods for Chemical Analysis of Copper Alloys~~

2.2 ISO Standard:

7602 Determination of Tellurium Content (High Content)—Flame Atomic Absorption Spectrometric Method³

2.3 Military Standards:

MIL-STD-792 Identification Marking Requirements for Special Purpose Components⁴

NAVSEA T9074-AS-GIB-010/271 Requirements for Nondestructive Testing Method⁴

3. General Requirements

3.1 The following sections of Specification B 249/B 249M constitute a part of this specification:

3.1.1 Terminology,

3.1.2 Materials and Manufacture,

3.1.3 Workmanship, Finish and Appearance,

3.1.4 Sampling,

3.1.5 Number of Tests and Retests,

3.1.6 Specimen Preparation,

3.1.7 Test Methods,

3.1.8 Significance of Numerical Limits,

3.1.9 Inspection,

3.1.10 Rejection and Rehearing,

3.1.11 Certification,

3.1.12 Test Reports,

3.1.13 Packaging and Package Marking, and

3.1.14 Supplementary Requirements.

3.1.15 In addition, when a section with a title identical to one of those referenced in 3.1, above, appears in this specification, it contains additional requirements that supplement those appearing in Specification B 249/B 249M.

4. Terminology

4.1 Definitions:

4.1.1 For definitions of terms used in this specification, related to copper and copper alloys, refer to Terminology B 846.

4.2 Definition of Term Specific to This Standard:

4.2.1 *hot pressed forging, n*—a product made by pressing a heated blank or section of wrought or cast copper or copper alloy in a closed impression die.

5. Ordering Information

5.1 ~~Include the following information when placing orders for product produced products to this specification shall include the following information: specification, as applicable:~~

5.1.1 ASTM designation and year of issue,

5.1.2 Copper or Copper Alloy UNS No. designation ~~(Section 1.1), (Scope),~~

5.1.3 Drawing showing the shape dimensions and tolerances ~~(Section H), (Dimensions and Permissible Variations),~~

5.1.4 Temper ~~(Section 8), (as specified herein),~~

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*, Vol 02.01, volume information, refer to the standard's Document Summary page on the ASTM website.

Annual Book of ASTM Standards, Vol 03.01.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

Annual Book of ASTM Standards, Vol 03.05.

⁴ Available from DODSSP, Bldg. 4/Sec. D, 700 Robbins Ave., Philadelphia, PA 19111-5098.

5.1.5 Quantity: total weight or number of pieces for each form, temper, and copper or copper alloy,

5.1.6 When product is purchased for agencies of the U.S. Government (Section 12), government (as specified herein), and

5.1.7 When product must adhere to the requirements of ASME Boiler and Pressure Vessel Code (Section 9) (Mechanical Property Requirements).

5.2 The following requirements are optional and shall be specified in the contract or purchase order.

5.2.1 Certification (Section 14 (as specified herein and Supplementary Requirements),

5.2.2 Mill test report (as specified in B 249/B 249M), and

5.2.3 Ultrasonic inspection report (Supplementary Requirements).

6. Material and Manufacture

6.1 Materials:

6.1.1 The starting material of manufacture shall be a form of rods, billets, or blanks cut from cast or wrought material of one of the copper or copper alloys listed in 1.1 the Scope of this specification and of purity and soundness as to be suitable for processing in to the products prescribed herein.

6.1.2 In the event heat identification or traceability is required, the purchaser shall specify the details desired.

NOTE 2—Because of 3—Due to the discontinuous nature of the processing of castings into wrought products, it is not always practical to identify specific casting analysis with a specific quantity of finished material.

6.2 Manufacture:

6.2.1 The product shall be manufactured by hot pressing material between the upper and lower sections of a set of dies conforming to the configuration defined by the purchaser's submitted drawings.

6.2.2 Product of Copper Alloy UNS No. C63000 and C63200 shall be heat treated (Section 10) (as specified herein).

7. Chemical Composition

7.1 The materials shall conform to the chemical composition requirements specified in Table 1 for the Copper or Copper Alloy UNS No. designation specified in the ordering information.

7.2 These composition limits do not preclude the presence of other elements. When limits for unnamed elements are required, they shall be established by agreement between manufacturer or supplier and the purchaser, limits may be established and analysis required for unnamed elements.

7.2.1 For copper alloys in which zinc is specified listed as a remainder, either copper or zinc is permitted to be taken as the difference between the sum of results for all the elements analyzed determined and 100 %. When copper is so determined, that difference value shall conform to the requirements given in Table 1. 100 %.

7.2.2 For copper alloys for in which copper is specified listed as the remainder, copper may be taken as is the difference between the sum of results of all the elements analyzed determined and 100 %.

7.3 When all the elements in Table 1 are determined for the individual alloy, the sum of results shall be 99.6 % min for Copper Alloy UNS No. C36500, C37000, C46400, C48200, C48500 and 99.5 % , the sum of results shall be 99.6 % min, for all other alloys the sum of results shall be 99.5 % min.

8. Temper

8.1 The standard tempers, a for products described in Practice B 601, available under this specification are M10 (as as follows:

8.1.1 As hot forged-air cooled), M11 (as forged-quenched), TQ50 (quench hardened cooled M10,

8.1.2 As forged-quenched M11,

8.1.3 Hot forged and temper annealed); annealed O20.

8.2 UNS Alloy Nos. C63000 and O20 (hot forged C63200 shall be furnished as:

8.2.1 Quench hardened and temper annealed), TQ50.

8.2.3 Alloys C70620 and C71520 shall be furnished in the M10 following tempers:

8.3.1 As hot forged-air cooled M10, unless,

8.3.2 Both forged and annealed O20 temper is specified.

8.4 Other tempers, shall be subjected to agreement between the manufacturer and the purchaser.

9. Mechanical Property Requirements

9.1 Mechanical property requirements are subject to agreement between the manufacturer and the purchaser.

9.2 Product furnished to this specification for UNS Alloys No. C70620 and C71520 and product specified to meet the requirements of the ASME Boiler and Pressure Vessel Code shall have conform to the tensile properties as requirements prescribed in Table 2, when tested in accordance with Test Methods E 8.

9.2.1 Acceptance or rejection based upon mechanical properties for UNS Alloy No. C70620 and C71520 shall depend only on tensile strength.

10. Heat Treatment

10.1 Product produced from Copper Alloy UNS No. C63200 shall be heat treated as follows:

TABLE 1 Chemical Requirements

Copper or Copper Alloy UNS No.	Composition, %												
	Copper	Lead	Tin	Iron	Nickel (incl Co)	Aluminum	Silicon	Manganese	Zinc	Sulfur	Tellurium	Phosphorus	Arsenic
C11000	99.90 ^A min
C14500 ^B	99.90 ^C min	0.004–0.012 ^D	...
C14700 ^B	99.90 ^E min	0.40–0.7	...	0.002–0.005 ^D	...
C36500	58.0–61.0	0.25–0.7	0.25 max	0.15 max	remainder
C37700	59.0–62.0	0.8–1.5	...	0.15 max	remainder
C37700	58.0–61.0	1.5–2.5	...	0.30 max	remainder
C46400	59.0–62.0	0.50–1.0	0.50–1.0	0.10 max	remainder
C48200	59.0–62.0	0.40–1.0	0.50–1.0	0.10 max	remainder
C48500	59.0–62.0	1.3–2.2	0.50–1.0	0.10 max	remainder
C61900	remainder	0.02 max	0.6 max	3.0–4.5 ^F	...	8.5–10.00	0.8 max
C62300	remainder	...	0.6 max	2.0–4.0	1.0 max	8.5–10.0	0.25 max	0.50 max
C63000	remainder	...	0.20 max	2.0–4.0	4.0–5.5	9.0–11.0	0.25 max	1.5 max	0.30 max
C63200	remainder	0.02 max	...	3.5–4.3 ^G	4.0–4.8	8.7–9.5	0.10 max	1.2–2.0
C64210	remainder	0.05 max	0.20 max	0.30 max	0.25 max	6.3–7.6	1.5–2.2	0.10 max	0.50 max	0.15 max
C65500	remainder	0.05 max	0.20 max	0.30 max	0.25 max	6.3–7.0	1.50–2.0	0.10 max	0.50 max	0.15 max
C67500	57.0–60.0	0.20 max	...	0.8 max	0.6 max	...	2.8–3.8	0.50–1.3	1.5 max
C67500	57.0–60.0	0.20 max	0.50–1.5	0.8–2.0	...	0.25 max	...	0.05–0.50	remainder
C67600	57.0–60.0	0.50–1.0	0.50–1.0	0.40–1.3	0.05–0.50	remainder
C70620 ^H	86.5 ^A min	0.50–1.0	0.50–1.5	0.40–1.3	0.05–0.50	remainder
C71520 ^H	65.0 ^A min	0.02 max	...	1.0–1.8	9.0–11.0	1.0 max	0.50 max	0.02 max	0.02 max	0.02 max	...
C77400	43.0–47.0	0.20 max	...	0.40–1.0	29.0–33.0	1.0 max	0.50 max	0.02 max	0.02 max	0.02 max	...
C77400	43.0–47.0	0.20 max	9.0–11.0	remainder

^A Silver counting as copper.

^B Includes oxygen-free or deoxidized grades with deoxidizers (such as phosphorus, boron, lithium, or others) in amount agreed upon.

^C This includes copper plus silver plus tellurium.

^D Other deoxidizers may be used as agreed upon, in which case phosphorus need not be present.

^E This includes copper plus silver plus sulfur plus phosphorus.

^F For boiler code application maximum iron content shall be 4.0 %.

^G Iron content shall not exceed nickel content.

^H Carbon shall be 0.05 % max.

TABLE 2 Tensile Requirements

Diameter or Section Thickness, in. (mm)	Temper Designation Standard Former	Tensile Strength, min		Yield Strength at 0.5 % Extension Under Load, min		Elongation in 4 × Diameter or Thickness of Specimen, min, %
		ksi	MPa ^A	ksi	MPa ^A	
Copper Alloy UNS No. C37700						
Up to 1½ (38.1), incl	M10 As Hot Forged–Air Cooled	50	345	18	124	25
Up to 1½ (38.1), incl		50	345	18	124	25
Over 1½ (38.1)	M10 As Hot Forged–Air Cooled	46	317	15	103	30
Over 1½ (38.1)		46	317	15	103	30
Copper Alloy UNS No. C64200						
Up to 1½ (38.1), incl	M10 As Hot Forged–Air Cooled	70	483	25	172	30
Up to 1½ (38.1), incl		70	483	25	172	30
Over 1½ (38.1)	M10 As Hot Forged–Air Cooled	68	469	23	156	35
Over 1½ (38.1)		68	469	23	156	35
Copper Alloy UNS Nos. C46400, C48200 and C48500						
All sizes	M10 As Hot Forged–Air Cooled	52	358	22	152	25
All sizes		52	358	22	152	25
Copper Alloy UNS No. C70620						
Up to 6 (152.3), incl	M40temper	45	310	18	124	30
Up to 6 (152.3), incl	M10 As Hot Forged–Air Cooled	45	310	18	124	30
Over 6 (152.3)	M40temper	40	276	15	103	30
Over 6 (152.3)	M10 As Hot Forged–Air Cooled	40	276	15	103	30
All sizes	O20temper	40	276	15	103	30
All sizes	O20 Hot Forged and Annealed	40	276	15	103	30
Copper Alloy UNS No. C71520						
Up to 6 (152.3), incl	M40temper	50	345	20	138	30
Up to 6 (152.3), incl	M10 As Hot Forged – Air Cooled	50	345	20	138	30
Over 6 (152.3)	M40temper	45	310	18	124	30
Over 6 (152.3)	M10 As Hot Forged – Air Cooled	45	310	18	124	30
All sizes	O20temper	45	310	18	124	30
All sizes	O20 Hot Forged and Annealed	45	310	18	124	30

^A See Appendix X34.

10.1.1 Heat to 1550°F (843°C) minimum for 1 h minimum and quench in water or other suitable medium.

10.1.2 Temper Anneal at +1300+ and –25°F (704+ and –14°C) 1300 ± 25°F (704 ± 14°C) for 3 to 9 h as required to meet mechanical properties.

11. Special Government Requirements

11.1 Product purchased for agencies of the U.S.–G government shall conform to the additional requirements prescribed in the Supplementary Requirements section of this specification.

12. Dimensions and Permissible Variations

12.1 The dimensions and tolerances for forgings shall be those agreed upon between the manufacturer and the purchaser, and such dimensions and tolerances shall be specified on the drawings which form a part of the contract or purchase order.

NOTE 34—Typical tolerances commonly used for forgings are shown in Table X2.1.

13. Test Methods

13.1 Chemical Analysis:

~~13.1.1 Chemical composition shall, in~~

13.1.1 In case of disagreement, be determined a the composition using the following methods:

Element		ASTM Test Method
Aluminum		E 478
Arsenic		E 62
Copper		E 478
Iron	<1.3 %	E 478, E 75 for CuNi
	≥1.3 %	E 54, E 75 for CuNi
	≥1.3 %	E 478, E 75 for CuNi
Lead		E 478 (AA)
Manganese		E 62, E 75 for CuNi
Nickel	<5 %	E 478 (photometric)
	>5 %	E 478 (gravimetric)
Phosphorus		E 62
Silicon		E 54 (perchloric acid)
Silicon		E 62 (perchloric acid)
Tin	<1.3 %	E 478
	≥1.3 %	E 54
	≥1.3 %	E 478
Zinc	<2 %	E 478 (AA)
	>2 %	E 478 (titrimetric)
Tellurium		ISO Test Method 7602

NOTE— < = less than; > = greater than

13.1.2 Test method(s) to be followed for the determination of element(s) ~~required by~~ resulting from contractual or purchase order agreement shall be as agreed upon between the manufacturer or supplier and ~~the purchaser~~.

Property	Rounded Unit for Observed or Calculated Value
Chemical composition	nearest unit in the last right-hand place of figures
Tensile strength } Yield strength }	nearest ksi; nearest 5 MPa for over 40 to 400 ksi; —incl
Elongation	nearest 1 %

purchaser.

14. Certification

14.1 Certification to this specification is mandatory for product purchased for *ASME Boiler and Pressure Vessel* applications.

15. Keywords

15.1 copper and copper alloy die forgings (hot pressed); die forgings (hot pressed)—; UNS No. C11000; UNS No. C14500; UNS No. C14700; UNS No. C36500; UNS No. C37000; UNS No. C37700; UNS No. C46400; UNS No. C48200; UNS No. C48500; UNS No. C61900; UNS No. C62300; UNS No. C63000; UNS No. C63200; UNS No. C64200; UNS No. C64210; UNS No. C65500; UNS No. C67500; UNS No. C67600; UNS No. C70620; UNS No. C71520; UNS No. C77400

SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall apply only when specified by the purchaser in the inquiry, contract or order, for agencies of the U.S. ~~G~~ government.

S1. Supplementary Requirements S1, S2, and S4 of ASTM B 249/B 249M shall apply.

S2. **Identification Marking**—Individual forgings shall be marked with the producer’s name or trademark, this ASTM specification number, the UNS number, and the heat number or serial number. The method and location of marking shall be in accordance with MIL-STD-792. If approved by the purchaser, the forgings may be bundled or boxed and each bundle or box provided with a metal or oil-proof tag showing the above information.

S3. **Sampling**—The lot size, portion size, and selection of sample pieces shall be as follows:

S3.1 *Lot Size*—For forgings weighing 250 lbs (114 kg) or less, a lot shall be 2000 lbs (909 kg) or less, and shall consist of forgings of the same design and alloy forged from the same material heat and heat treated at the same time. For forgings exceeding 250 lbs (114 kg), each individual forging shall constitute a lot.

S3.2 *Portion Size* —For forgings less than 250 lbs (114 kg), two forgings per lot shall be selected for tensile testing. Tensile tests shall be performed on each forging over 250 lbs (114 kg).

S3.3 *Chemical Analysis*—If heat identification is required, one sample for chemical analysis shall be taken for each heat at the

time of pouring or from semifinished or finished product.

S3.4 *Tensile Testing*—The tensile specimens shall be taken from integral forging prolongations or shall be removed from the forgings by trepanning. Alternatively, samples may be taken from separately forged test bars of the same heat as the forgings in the lot provided the wall thickness and amount of working for the test bar are equivalent to those for the forgings. The axis of the tensile specimen shall be located at any point midway between the center and the surface of solid forgings and at any point midway between the inner and outer surfaces of the wall of hollow forgings, and shall be parallel to the direction of greatest grain flow to the greatest extent possible.

S4. **Liquid Penetrant Inspection**—When specified by the purchaser, each piece of each lot shall be inspected in accordance with NAVSEA T9074-AS-GIB-101/271.

S5. **Ultrasonic Inspection**—When specified by the purchaser, each piece of each lot shall be inspected.

S5.1 *General Requirements*—Ultrasonic testing shall be performed in accordance with NAVSEA T9074-AS-GIB-101/271. Acoustic compatibility between the production material and the calibration standard material shall be within 75 %. If the acoustic compatibility is within 25 %, no gain compensation is required for the examination. If acoustic compatibility difference is between 25 and 75 %, a change in the gain or dB controls shall be accomplished to compensate for the differences in acoustic compatibility. This method cannot be used if the ultrasonic noise level exceeds 50 % of the rejection value.

S5.2 *Calibration:*

S5.2.1 *Shear Wave*—The shear wave test shall be calibrated on two notches, one notch cut into the inside and one into the outside surface. The notches shall be cut axially and shall have a depth of 5 % of the material thickness or ¼ in. (6.4 mm), whichever is less. Notch length shall not exceed 1 in. (25.4 mm). Notches shall be made either in the piece to be examined or in a separate defect-free specimen of the same size (within ± ⅛ in. (3.18 mm), shape, material, and condition, or acoustically similar material. The position and amplitude of the response from each notch shall be marked on the instrument screen or a transparent overlay, and these marks shall be used as the evaluation reference. Indications that appear between these points shall be evaluated on the basis of a straight line joining the two peak amplitudes.

S5.2.2 *Longitudinal Wave*—The longitudinal wave test shall be calibrated on a flat-bottomed reference hole of a given diameter in accordance with Table S5.1 for specified material thickness drilled either into the piece to be tested or into a separate defect-free specimen of the same size (within ± ⅛ in. (3.18 mm)), shape, material, and condition or acoustically similar material. Holes are to be drilled to midsection and the bottom of the hole shall be parallel to the entrant surface. The ultrasonic test instrument shall be adjusted so that the response from the reference hole shall not be less than 25 % and not more than 75 % of screen height.

S5.2.3 *Recalibration*—During quality conformance inspection, any realignment of the search unit that will cause a decrease in the calibrated sensitivity and resolution, or both, or any change in search unit, couplant, instrument settings, or scanning speed from that used for calibration shall require recalibration. Recalibration shall be performed at least once per 8-h shift.

S5.3 *Procedure:*

S5.3.1 *Ring and Hollow Round Products* —Rings and other hollow cylindrical products shall be tested using the shear wave method by the contact or immersion technique. The shear wave entrant angle shall be such to ensure reflection from the notch or notches used in calibration. For contact testing, the search unit shall be fitted with a wedge or shoe machined to fit the curvature of the piece being inspected. The product also shall be inspected with a longitudinal wave test from the external circumferential and end surfaces.

S5.3.2 *Disk or Pancake Forgings*—Disk or pancake forgings shall be inspected with a longitudinal wave technique from both parallel surfaces.

S5.4 *Acceptance Criteria:*

S5.4.1 *Shear Wave*—Any material that produces indications equal to or larger than the response from the reference notch or higher than the straight line joining the two peak amplitudes shall be rejected.

S5.4.2 *Longitudinal Wave* —Any material that produces indications equal to or larger than the response from the reference hole or that produces a complete loss of back reflection shall be rejected. Material shall be tested using a square, rectangular, or circular transducer having an effective area of 1 in.² or less, but no dimension shall be smaller than the diameter of the reference hole. In the event of disagreement on the degree of back reflection loss, it shall be determined by the contact method using a 1- to 1 ⅛-in. (25.4- to 28.6-mm) diameter transducer or one whose area falls within this range.

S5.4.3 *Reference Notch Removal*—If reference notches or flat-bottomed holes are made in the material to be tested, they shall be so located that their subsequent removal will not impair the suitability of the material for its intended use.

TABLE S5.1 Ultrasonic Testing Reference Hole for Rod, Bar, Disk Pancake Forgings, and Forgings

Material Thickness, in. (mm)	Hole Diameter, in. (mm)
Up to and including 6 (152)	⅛ (3.18)
Over 6 (152) and including 16 (406)	¼ (6.4)
Over 16 (406)	As agreed upon

APPENDIXES

(Nonmandatory Information)

X1. NOMINAL COMPOSITION AND RELATIVE FORGEABILITY RATINGS

X1.1 The nominal composition of the various forging materials are shown in Table X1.1.

TABLE X1.1 Nominal Compositions and Forgeability Ratings

Copper or Copper Alloy UNS No.	Nominal Composition, %											Forgeability Rating ^A
	Copper	Lead	Tin	Iron	Nickel	Aluminum	Silicon	Manganese	Zinc	Sulfur	Tellu- rium	
C11000	100	65
C14500	99.45	0.55	65
C14700	99.5	0.35	...	65
C36500	60	0.6	39.4	100
C37000	60	1	39	100
C37700	60	2	38	100
C46400	60	...	0.8	39.2	90
C48200	60	0.7	0.8	38.5
C48200	60	0.7	0.8	38.5	90
C48500	60	1.8	0.8	37.4	90
C61900	87.5	3.5	...	9	75
C62300	88	3	...	9	75
C63000	81	3	5	10	...	1	75
C63200	81	4	4.5	9	...	1.5	75
C64200	91	7	2	75
C64210	91.3	6.7	2	75
C65500	96	B	3	B	B	40
C65500	96	B	3	90	B	40
C67500	58.5	...	1	1	0.10	39.4	80
C67600	58.5	0.75	4	0.8	0.10	39.6	80
C67600	58.5	0.75	1	1	0.10	39.6	80
C70620	86.5	1.4	10.0	1	75
C71520	65.0	0.7	31.0	1	40
C77400	45	10	45	85

^A Relative forgeability rating takes into consideration such variable factors as pressure, die wear, and plasticity (hot). Since it is impracticable to reduce these variables to common units, calibration in terms of a percentage of the most generally used alloy, forging brass (100 %), is considered the most practical basis for such ratings. The values shown represent the general opinion and are intended for information to enable the designer to better understand the forging characteristics of these various alloys. Intricate parts are more likely to be available in alloys having a high rating.

^B One or more of these elements may be present as specified in Table 2.

X2. DIMENSIONAL TOLERANCES

X2.1 The data in Table X2.1 do not constitute a part of this specification. They are given merely to indicate to the purchaser the various forging types and some dimensional tolerances used on commercially designed hot-pressed forgings up to 2 lbs (0.91 kg) in weight. For tolerances applicable to heavier forgings, the manufacturers should be consulted.

TABLE X2.1 Dimensional Tolerances

	Tolerances, Plus and Minus, in. (mm) Except as Indicated ^A			
	Copper or Copper Alloy UNS Nos.			
	C11000 C14500 C14700 C61900 C62300 C64200 C64210	C36500 C37000 C37700 C46400 C48200 C48500 C67500 C67600	C77400	C63000 C63200 C65500 C70620 C71520
Forging types:				
Solid	0.010 (0.25)	0.008 (0.20)	0.008 (0.20)	0.012 (0.30)
Solid, with symmetrical cavity	0.010 (0.25)	0.008 (0.20)	0.008 (0.20)	0.012 (0.30)
Solid, with eccentric cavity	0.012 (0.30)	0.008 (0.20)	0.008 (0.20)	0.012 (0.30)
Solid, deep extrusion	0.012 (0.30)	0.010 (0.25)	0.010 (0.25)	0.014 (0.36)
Hollow, deep extrusion	0.012 (0.30)	0.010 (0.25)	0.010 (0.25)	0.014 (0.36)
Thin section, short (up to 6 in. (152 mm) incl.)	0.012 (0.30)	0.010 (0.25)	0.010 (0.25)	0.014 (0.36)
Thin section, long (over 6 in. (152 mm) to 14 in. (356 mm) incl.)	0.015 (0.38)	0.015 (0.38)	0.015 (0.38)	0.020 (0.51)
Thin section, round	0.012 (0.30)	0.010 (0.25)	0.010 (0.25)	0.014 (0.36)
Draft angles, outside and inside 1 to 5°	1/2 °	1/2 °	1/2 °	1/2 °
Machining allowance (on one surface)	1/32 (0.79)	1/32 (0.79)	1/32 (0.79)	1/32 (0.79)
Flatness (maximum deviation per inch)	0.005 (0.13)	0.005 (0.13)	0.005 (0.13)	0.005 (0.13)
Concentricity (total indicator reading)	0.030 (0.76)	0.020 (0.51)	0.030 (0.76)	0.030 (0.76)
Nominal web thickness:	5/32 (4.0)	1/8 (3.2)	1/8 (3.2)	3/16 (4.8)
Tolerance	1/64 (0.40)	1/64 (0.40)	1/64 (0.40)	1/64 (0.40)
Nominal fillet and radius:	3/32 (2.4)	1/16 (1.6)	1/16 (1.6)	1/8 (3.2)
Tolerance	1/64 (0.40)	1/64 (0.40)	1/64 (0.40)	1/64 (0.40)
Approximate flash thickness	1/16 (1.6)	3/64 (1.2)	3/64 (1.2)	5/64 (2.0)

^A If tolerances all plus or all minus are desired, double the values given.

X3. TYPICAL MECHANICAL PROPERTIES

X3.1 Mechanical properties of any forging are influenced by shape and size. Unless otherwise specified in the purchase order or specifically guaranteed by the manufacturer, acceptance of forgings under this specification shall not depend on the mechanical properties determined by tension or hardness tests. (Frequently, the design of forgings will not permit adequate test sections.) Therefore, the data in Table X3.1 do not constitute a part of this specification, and are given for general information only. They are typical of forgings up to 2 lbs (0.91 kg) in weight.

TABLE X3.1 Typical Mechanical Properties of Forgings as Hot Pressed, Temper M10, M11, or TQ50^A

Copper or Copper Alloy UNS No.	0.505-in. (128-mm) Diameter Test Section				Rockwell Hardness (Filed Surface, 1/8-in. (3.18-mm) Chord, min)		
	Tensile Strength		Yield Strength (0.5 % Extension Under Load)		Elongation in 4 × Diameter, %	F Scale	B Scale
	ksi ^B	MPa ^C	ksi ^B	MPa ^C			
C11000	33	230	11	75	40	37	...
C14500	34	235	12	85	35	40	...
C14700	34	235	12	85	35	40	...
C36500	58	400	23	160	40	...	45
C37000	58	400	23	160	40	...	45
C37700	58	400	23	160	40	...	45
C46400	64	440	26	180	40	...	55
C48200	64	440	26	180	40	...	55
C48500	62	425	24	165	40	...	55
C61900	82	565	37	255	32	...	82
C62300	82	565	37	255	32	...	82
C63000	95	655	48	330	15	...	90
C63200	92	635	45	310	18	...	88
C64200	83	570	41	285	35	...	77
C64210	83	570	41	285	35	...	77
C65500	52	360	18	125	70	...	62
C67500	72	495	34	235	33	...	69
C67600	72	495	34	235	33	...	69
C71520	55	380	20	138	45	...	35
C77400	83	570	36	250	25	...	73

^A For Copper Alloy UNS Nos. C63000 and C63200.

^Bksi = 1000-psi.

^CSee Appendix X4.

X4. METRIC EQUIVALENTS

X4.1 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 ($N = \text{kg} \cdot \text{m/s}^2$). 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 specification since the last issue (B 283 – 99a) that may impact the use of this standard. (Approved May 1, 2004.)

- (1) ~~Changed the iron content in C46400 from 0.15 max~~ A five-year review was conducted. Editorial revisions to ~~0.10 max~~; most sections were made to incorporate current form and style practice. The following were effected: Sections 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 13, and Table 2.
- (2) ~~Changed the iron content in C48200 from 0.15 max~~ UNS Alloy No. C37000 was added to ~~0.10 max~~; this specification and specifically to Sections 1.1, 7.3, Table 1, Table X1.1, Table X2.1, and Table X3.1.
- (3) ~~Changed~~ Corrected the ~~iron content~~ chemistry for UNS Alloy No. C67600 listed in ~~C48500 from 0.15 max to 0.10 max~~; Table 1 and Table X1.1.
- (4) ~~Changed~~ Corrected the ~~aluminum content~~ chemistry for UNS Alloy No. C65500 listed in ~~C62300 from 8.5–11 to 8.5–10.0~~; Table X1.1.

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