Standard Specification for Precipitation-Hardening Nickel Alloy (UNS N07718) Plate, Sheet, and Strip for High-Temperature Service

This standard is issued under the fixed designation B670; 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 rolled precipitation hardenable nickel alloy (N07718)* plate, sheet, and strip in the annealed condition (temper).

1.2 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 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 become familiar with all hazards including those identified in the appropriate Material Safety Data Sheet (MSDS) for this product/material as provided by the manufacturer, to establish appropriate safety and health practices, and determine the applicability of regulatory limitations prior to use.

2. Referenced Documents

2.1 ASTM Standards:

B637 Specification for Precipitation-Hardening and Cold Worked Nickel Alloy Bars, Forgings, andForging Stock for Moderate or High Temperature Service

B906 Specification for General Requirements for Flat-Rolled Nickel and Nickel Alloys Plate, Sheet, and Strip

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

E139 Test Methods for Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials

3. Terminology

3.1 Description of Terms Specific to This Standard—The terms given in Table 1 shall apply.

4. General Requirements

4.1 Material furnished under this specification shall conform to the applicable requirements of Specification B906 unless otherwise provided herein.

5. Ordering Information

5.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered to this specification. Examples of such requirements include, but are not limited to, the following:

5.1.1 Alloy—Name or UNS number (see Table 2).

5.1.2 ASTM designation, including year of issue.

5.1.3 Condition—See 7.1 and Appendix X1.

5.1.4 Finish—Specification B906 or Appendix X1.

5.1.5 Dimensions—Thickness, width, and length.

5.1.6 Quantity:

5.1.7 Optional Requirements:

5.1.7.1 Sheet and Strip—Whether to be furnished in coil, in cut straight lengths, or in random straight lengths.

5.1.7.2 Strip—Whether to be furnished with commercial slit edge, square edge, or round edge.

5.1.7.3 Plate—Whether to be furnished specially flattened (see 8.7); also how plate is to be cut (see 8.2.1 and 8.3.2).

5.1.8 Fabrication Details—Not mandatory but helpful to the manufacturer:

5.1.8.1 Welding or Brazing—Process to be employed.

5.1.8.2 Plate—Whether material is to be hot-formed.

5.1.9 Certification—State if certification or a report of test results is required (see Specification B906).

5.1.10 Samples for Product (Check) Analysis—Whether samples should be furnished (see 6.2).

5.1.11 Purchaser Inspection—If the purchaser wishes to witness the tests or inspection of material at the place of manufacture, the purchase order must so state indicating which tests or inspections are to be witnessed (see Specification B906).
TABLE 1 Product Description

<table>
<thead>
<tr>
<th>Product</th>
<th>Thickness, in. (mm)</th>
<th>Width</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hot-rolled plate&lt;sup&gt;a&lt;/sup&gt;</td>
<td>⅛ to 2¼ (4.8 to 57.2) (B906, Table A3.1)</td>
<td>B906, Tables A3.2 and A3.5&lt;sup&gt;b&lt;/sup&gt;</td>
</tr>
<tr>
<td>Cold-rolled sheet&lt;sup&gt;c&lt;/sup&gt;</td>
<td>0.010 to 0.250 (0.25 to 6.4), incl (B906, Table A3.3)</td>
<td>B906, Table A3.6</td>
</tr>
<tr>
<td>Cold-rolled strip&lt;sup&gt;d&lt;/sup&gt;</td>
<td>...</td>
<td>B906, Table A3.6</td>
</tr>
</tbody>
</table>

<sup>a</sup> Material ⅛ to ¼ in. (4.8 to 6.4 mm), incl, in thickness may be furnished as sheet or plate provided the material meets the specification requirements for the condition ordered.

<sup>b</sup> Hot-rolled plate, in widths 10 in. (250 mm) and under, may be furnished as hot-finished rectangles with sheared or cut edges in accordance with Specification B637, UNS N07718, provided the mechanical property requirements of this specification are met.

<sup>c</sup> Material under 48 in. (1219 mm) in width may be furnished as sheet or strip provided the material meets the specification requirements for the condition ordered.

<sup>d</sup> Material 3⁄16 to 1⁄4 in. (4.8 to 6.4 mm), incl, in thickness may be furnished as sheet or plate provided the material meets the specification requirements for the condition ordered.

6. Chemical Composition

6.1 The material shall conform to the requirements as to chemical composition prescribed in Table 2.

6.2 If a product (check) analysis is performed by the purchaser, the material shall conform to the product (check) analysis variations prescribed in Specification B906.

7. Mechanical and Other Requirements

7.1 Tensile Properties—The material after precipitation hardening shall conform to the tensile properties prescribed in Table 3.

7.2 Stress-Rupture Properties—The material after precipitation hardening shall conform to the stress-rupture properties prescribed in Table 4.

8. Dimensions and Permissible Variations

8.1 Thickness and Weight:

8.1.1 Plate—The permissible variation under the specified thickness and permissible excess in overweight shall not exceed the amounts prescribed in Specification B906, Table A3.1.

8.1.2 Sheet and Strip—The permissible variations in thickness of sheet and strip shall be as prescribed in Specification B906, Table A3.3. The thickness of strip and sheet shall be measured with the micrometer spindle ⅛ in. (9.5 mm) or more from either edge for material 1 in. (25.4 mm) or over in width and at any place on the strip under 1 in. in width.

8.2 Width or Diameter:

8.2.1 Plate—The permissible variations in width of rectangular plates and diameter of circular plates shall be as prescribed in Specification B906, Table A3.4 and Table A3.5.

8.2.2 Sheet and Strip—The permissible variations in width for sheet and strip shall be as prescribed in Specification B906, Table A3.6.

8.3 Length:

8.3.1 Sheet and strip of all sizes may be ordered to cut lengths, in which case a variation of ⅛ in. (3.2 mm) over the specified length shall be permitted.

8.3.2 Permissible variations in length of rectangular plate shall be as prescribed in Specification B906, Table A3.7.

8.4 Straightness:

8.4.1 The edgewise curvature (depth of chord) of flat sheet, strip, and plate shall not exceed 0.05 in. multiplied by the...
length of the product in feet (0.04 mm multiplied by the length of the product in centimetres).

8.4.2 Straightness for coiled strip material is subject to agreement between the manufacturer and the purchaser.

8.5 Edges:

8.5.1 When finished edges of strip are specified in the contract or purchase order, the following descriptions shall apply:

8.5.1.1 Square-edge strip shall be supplied with finished edges, with sharp, square corners, and without bevel or rounding.

8.5.1.2 Round-edge strip shall be supplied with finished edges, semicircular in form, and the diameter of the circle forming the edge being equal to the strip thickness.

8.5.1.3 When no description of any required form of strip edge is given, it shall be understood that edges such as those resulting from slitting or shearing will be acceptable.

8.5.1.4 Sheet shall have sheared or slit edges.

8.5.1.5 Plate shall have sheared or cut (machined, abrasive-cut, powder-cut, or inert-arc-cut) edges, as specified.

8.6 Squareness (Sheet)—For sheets of all thicknesses, the angle between adjacent sides shall be 90° ± 0.15° (1⁄16 in. in 24 in.) (1.6 mm in 610 mm).

8.7 Flatness—Standard flatness tolerances for plate shall conform to the requirements prescribed in Table 5. “Specially flattened” plate when so specified, shall have permissible variations in flatness as agreed upon between the manufacturer and the purchaser.

9. Sampling

9.1 Lot—Definition:

<table>
<thead>
<tr>
<th>TABLE 5 Permissible Variations from Flatness of Rectangular, Circular, and Sketch Plates</th>
</tr>
</thead>
<tbody>
<tr>
<td>Specified Thickness</td>
</tr>
<tr>
<td>----------------------</td>
</tr>
<tr>
<td>Inches</td>
</tr>
<tr>
<td>1/32 to 1/8, excl</td>
</tr>
<tr>
<td>1/4 to 3/8, excl</td>
</tr>
<tr>
<td>3/8 to 1, excl</td>
</tr>
<tr>
<td>1 to 2, excl</td>
</tr>
<tr>
<td>2 to 2 1/4, excl</td>
</tr>
<tr>
<td>2 1/4 to 3, excl</td>
</tr>
<tr>
<td>3 to 4, excl</td>
</tr>
</tbody>
</table>

9.1.1 Where material cannot be identified by heat, a lot shall consist of not more than 500 lb (227 kg) of material in the same thickness and condition, except for plates weighing over 500 lb, in which case only one specimen shall be taken.

10. Number of Tests

10.1 Stress Rupture—One test per lot.

11. Specimen Preparation

11.1 Stress-rupture specimens shall be the same as tension specimens except modified as necessary for stress-rupture testing in accordance with Test Methods E139.

12. Test Methods

12.1 The stress rupture properties of the material as enumerated in this specification shall be determined, in case of disagreement, in accordance with the following methods:

<table>
<thead>
<tr>
<th>Test</th>
<th>ASTM Designation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Stress rupture</td>
<td>E139</td>
</tr>
</tbody>
</table>

12.2 For purposes of determining compliance with the specified limits for requirements of the properties listed in the following table and this specification, an observed value or a calculated value shall be rounded as indicated in accordance with the rounding method of Recommended Practice E29 referenced in Specification B906.

13. Product Marking

13.1 Each plate, sheet, or strip shall be marked on one face with the specification number, alloy, condition (temper), heat...
number, manufacturer’s identification, and size. The markings shall not have a deleterious effect on the material or its performance and shall be sufficiently stable to withstand normal handling.

13.2 When applicable, each bundle or shipping container shall be marked with the name of the material, condition (temper), this specification number, alloy, size, consignor and consignee address, contract or order number, and such other information as may be defined in the contract or order.

14. Keywords
14.1 N07718; plate; sheet; strip

APPENDIX
(Nonmandatory Information)

X1. CONDITIONS AND FINISHES NORMALLY SUPPLIED

X1.1 This appendix lists the conditions and finishes in which plate, sheet, and strip are normally supplied.

X1.2 Plate—Hot-rolled, annealed, and descaled.

X1.3 Sheet—Cold-rolled, annealed, descaled, or bright annealed.

X1.4 Strip—Cold-rolled, annealed, descaled, or bright annealed.