



Standard Specification for Niobium-Hafnium Alloy Ingots¹

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1. Scope

1.1 This specification covers hafnium alloyed niobium ingots prepared by vacuum- or plasma- arc melting or electron-beam furnace melting, or a combination of these methods, to produce consolidated metal for processing to various mill shapes.

1.2 The material covered by this specification is Grade R04295, niobium-base alloy containing approximately 10 % hafnium and 1 % titanium.

1.3 The values stated in either inch-pound or SI units are to be regarded separately as standard. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. SI values cannot be mixed with inch-pound values.

2. Referenced Documents

2.1 *ASTM Standards*:²

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

3. Ordering Information

3.1 Orders for material under this specification shall include the following information as applicable:

3.1.1 General alloy description (see 1.2) and ASTM designation and year of issue,

3.1.2 Quantity in weight or pieces,

3.1.3 Size: diameter and length,

3.1.4 Chemistry (Section 5),

3.1.5 Quality and finish (see 7.2, 7.4, and 7.6),

3.1.6 Certifications and Reports (Section 13),

3.1.7 Packaging (Section 15), and

3.1.8 Disposition of rejected material (Section 11).

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²For 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.

4. Materials and Manufacture

4.1 The ingot metal for this material may be vacuum- or plasma-arc melted, electron-beam melted, or a combination of these methods.

5. Chemical Composition

5.1 The material shall conform to the requirements as to chemical composition prescribed in Table 1. Analysis for elements, not listed in Table 1 and not normally expected in niobium hafnium alloy, shall not be required unless specified at time of purchase.

6. Permissible Variations in Quantity

6.1 For orders requiring up to 100 lb [45 kg] of ingots, the manufacturer may overship up to a maximum of 20 %. For orders up to 1000 lb [450 kg], the manufacturer may overship up to a maximum of 10 %. The permissible overshipment shall be negotiated for orders larger than 1000 lb [450 kg].

7. Workmanship, Finish, and Appearance

7.1 The manufacturer shall use care to have each lot of ingot material as uniform in quality as possible.

7.2 When specified, the ingots shall be conditioned on the surface to standards agreed upon between the purchaser and the manufacturer.

7.3 In the conditioned ingot, no abrupt changes in diameter or local depressions that will impair subsequent fabrication will be permitted. The difference between maximum and minimum radius of the conditioned ingot shall not exceed 5 % of the maximum radius. Lands, grooves, and local depressions shall be blended to a maximum angle of 30° to the axis of the ingot.

7.4 Each ingot should be tested for soundness by nondestructive test methods, such as dye penetrant and ultrasonic tests, as mutually agreed upon between the purchaser and the manufacturer.

7.5 Defects in ingots that exceed the acceptance standards shall be removed by cropping or surface conditioning, whichever is appropriate. The manufacturer shall be permitted to remove surface imperfections provided that after such removal, the requirements of conditioning are met (7.3).

TABLE 1 Chemical Requirements (Ingot)

Niobium-Hafnium Alloy Grade R04295	
Element	Content, Maximum Weight % (Except for Hf and Ti)
Carbon	0.015
Oxygen	0.025
Nitrogen	0.010
Hydrogen	0.0015
Hafnium	9–11
Titanium	0.7–1.3
Zirconium	0.700
Tungsten	0.500
Tantalum	0.500
Niobium by difference	

7.6 The ingots shall be free of imperfections that would be deemed injurious by the standards of acceptability agreed upon between the purchaser and the manufacturer.

8. Number of Tests

8.1 Each ingot shall be tested for chemical composition in at least three positions along the length of the ingot.

9. Significance of Numerical Limits

9.1 The following applies to all specified limits in this standard for purposes of determining conformance with this specification: The observed value or a calculated value shall be rounded off to the nearest unit in the last right-hand digit used in expressing the specification limit, in accordance with the rounding-off method of Practice E 29.

10. Sampling

10.1 Care shall be exercised to ensure that the sample selected for testing is representative of the material, and that it is not contaminated by the sampling procedure. If there is any question relating to the sampling techniques or to the analysis thereof, the methods for sampling and analysis shall be as agreed upon between the purchaser and the manufacturer.

11. Rejection

11.1 Material that fails to conform to the requirements of this specification may be rejected. Rejection shall be reported

to the producer or supplier promptly and in writing. In case of dissatisfaction with the results of the tests, the producer or supplier may make claim for a rehearing.

12. Rehearing

12.1 In the event of disagreement between the manufacturer and the purchaser on the conformance of the material to the requirements of this specification or any special test specified by the purchaser, a mutually acceptable referee shall perform the tests in question. The results of the referee's testing shall be used in determining conformance of the material to this specification.

13. Certification

13.1 When specified in the purchase order or contract, a producer's or supplier's certification shall be furnished to the purchaser that the material was manufactured, sampled, tested, and inspected in accordance with this specification and has been found to meet the requirements. When specified in the purchase order or contract, a report of the results shall be furnished.

14. Product Marking

14.1 Each ingot shall be marked for identification by metal die stamping the manufacturer's ingot number on the top of the ingot. Each box or skid shall be marked or tagged legibly and conspicuously with the number, type of material, ingot number(s), manufacturer's identification, nominal size, and the gross, net, and tare weights.

15. Packaging

15.1 Unless otherwise specified, material purchased under this specification must be boxed or banded on skids in such a manner as to secure safe delivery to their destination when properly transported by any common carrier.

16. Keywords

16.1 niobium-hafnium alloy ingots

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