



Standard Specification for General Requirements for Wrought Precious Metal Electrical Contact Materials¹

This standard is issued under the fixed designation B476; 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 general requirements common to wrought precious metal electrical contact alloy products in the form of sheet, strip, wire, and rod. Unless otherwise specified in the purchase order or in an individual specification, these general requirements shall apply to wrought electrical contact materials where indicated in the applicable product specifications issued by ASTM.

1.2 In case of conflict, the requirements on the purchase order, the individual specification, and this general specification shall prevail in the sequence named.

1.3 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.

1.4 *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 The following documents of the issue in effect, on the date of material purchase, form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards*:²

B63 Test Method for Resistivity of Metallically Conducting

Resistance and Contact Materials

B772 Guide for Specifying the Chemical Compositions for Electrical Contact Materials (Arcing and Nonarcing)

E3 Guide for Preparation of Metallographic Specimens

E8 Test Methods for Tension Testing of Metallic Materials

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

E55 Practice for Sampling Wrought Nonferrous Metals and Alloys for Determination of Chemical Composition

E112 Test Methods for Determining Average Grain Size

E384 Test Method for Knoop and Vickers Hardness of Materials

3. Terminology

3.1 *Definitions*:

3.1.1 *lot, n*—the quantity of material of the same type, size, and finish produced at one time from the same cast or heat, and heat treated in the same heat-treatment cycle.

4. Ordering Information

4.1 Orders for material to this specification shall include the following information:

4.1.1 Designation and revision date of this specification.

4.1.1.1 If a revision date is not designated, the latest revision should be used.

4.1.2 Designation and revision date of the applicable product specification.

4.1.2.1 If a revision date is not designated, the latest revision of the product specification should be used.

4.1.3 Description of material form,

4.1.4 Dimensions of the material,

4.1.5 Total quantity of each size,

4.1.6 Temper of the material (annealed, cold worked, etc.),

4.1.7 Temper test (hardness or tensile) (Section 10),

4.1.8 Special requirements (if any), and

4.1.9 Certification (Section 14).

4.2 Specify the following, if required:

4.2.1 Certificate of compliance of physical and chemical requirement.

4.2.2 *Test Data*—Specify tests and analyses to be performed and reported.

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.05 on Precious Metals and Electrical Contact Materials.

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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.

4.2.3 Special packaging, if required.

5. Materials and Manufacture

5.1 The raw material shall be of such quality and purity that the finished product shall have the properties and characteristics prescribed in the applicable product specification issued by ASTM.

5.2 The product shall be produced by a combination of hot or cold working operations. It shall be finished, unless otherwise specified, by such cold working, annealing, or heat treatment as may be necessary to meet the specified properties.

6. Dimensions and Permissible Variations

6.1 *General*—For the purpose of determining conformance with the dimensional requirements prescribed in this specification, any measured value outside the specified limiting values for any dimension may be cause for rejection.

6.2 Tolerance tables to cover all forms of products can become quite voluminous. For this reason, it is recommended that tolerances be established and agreed upon between the producer and user at the time of placing an order or an inquiry for quotation of price and delivery. Refer to Section 16 (Supplementary Requirements). Details of form and tolerances for products not covered by this specification, such as, the types of materials listed below, and means of measurement, should be established between producer and user.

6.2.1 Sawed products,

6.2.2 Square sheared products,

6.2.3 Flat wire, thickness, width and edge radius tolerances,

6.2.4 Edge rolled flat wire, thickness, width and corner radius tolerances.

6.3 *Wire and Rod*:

6.3.1 The standard tolerances applied to the diameter of wire and rod shall be as prescribed in Table 1.

6.3.2 The rod straightness and length tolerance shall be those prescribed in Table 2.

6.4 *Strip and Sheet*—Supplied in the form of coils, flat lengths or on spools.

6.4.1 The thickness tolerances shall be those prescribed in Table 3.

6.4.2 The width standard tolerance for slit products shall be those prescribed in Table 4.

6.4.3 The straightness (camber or edgewise curvature) tolerance for slit strip is prescribed in Table 4 also.

6.5 *Flatness*—The flatness of blanks, shims, circles, or other forms should be negotiated between the manufacturer and the

purchaser. The following suggestion is to be used for guidance only when the manufacturer and the purchaser discuss flatness requirements. It is not a requirement of this specification, unless agreed upon and made part of the purchase order or request for quotation. The flatness of a flat form shall be that the maximum deviation from the flat surface shall be less than 1 % of the measurement distance specified for the product, such as diameter for circles, length or width of blanks, or any specific measurement length; that is, maximum of 0.20 in. (5.08 mm) deviation in any 20 in. (508 mm) length in any direction.

7. Workmanship

7.1 Surfaces of all material furnished to this specification shall be smooth, clean, and free from scratches, stains, rough spots, slivers, laps, scale, pits, and any other injurious defects within limits consistent with the best possible practice.

8. Sampling

8.1 *Sampling*—The portion size and selection of pieces shall be as follows:

8.1.1 *Chemical Analysis*—Samples for chemical analysis shall be taken and prepared in accordance with Practice E55. The minimum weight of the composite sample that is to be divided into three equal parts shall be 6 g.

8.1.2 *Physical Tests*—For physical tests, a test specimen shall be taken from each of four randomly selected individual units of finished product from a lot. If the lot consists of less than four units, a piece shall be taken from each individual unit.

9. Number of Tests and Retests

9.1 If any specimen tested shows a defective test method or extraneous flaws, it may be discarded and another specimen substituted.

9.2 If the chemical analysis fails to conform to the specified limits, analysis shall be made on a new composite sample, prepared from samples selected in accordance with Practice E55 or 8.1.2 after the physical tests have been performed. The results of this retest shall comply with the specified requirements.

9.3 The required physical tests shall be performed on 2 of 4 of the pieces selected in accordance with 8.1.2.

9.3.1 If one of the two tests made to determine any of the physical properties fails to meet a specified limit, this test shall be repeated on each of the two remaining pieces selected in accordance with 8.1.2 and the results of both of these tests shall comply with the specified requirements.

9.4 In the case of micro hardness, the number of readings shall not be less than 5 on each test specimen.

10. Test Methods

10.1 The properties enumerated in the applicable product specification shall be determined in accordance with the following: Test Methods B63 and E384, Methods E3, E8, and E112, and Practice E55.

TABLE 1 Round Wire and Rod Diameter Tolerance

Diameter, in. (mm)	Tolerance, $\pm$, in. (mm)
Up to 0.010 (0.25), incl	0.0001 (0.002)
Over 0.010 to 0.020 (0.25 to 0.51), incl	0.0002 (0.005)
Over 0.020 to 0.030 (0.51 to 0.76), incl	0.0003 (0.008)
Over 0.030 to 0.040 (0.76 to 1.02), incl	0.0004 (0.010)
Over 0.040 to 0.187 (1.02 to 4.75), incl	0.0005 (0.013)
Over 0.187 to 0.250 (4.75 to 6.35), incl	0.001 (0.03)
Over 0.250 to 0.375 (6.35 to 9.52), incl	0.0015 (0.04)
Over 0.375 to 0.750 (9.52 to 19.0), incl	0.002 (0.05)



TABLE 2 Round Rod Straightness and Length Tolerance

Length, ft (m)	Straightness Tolerances		Length Tolerances	
	Applicable to any longitudinal edge		Applicable only to full length pieces	
	Maximum Curvature (Depth of Arc; in. (mm))		Length Tolerances in. (mm)	
Under 2 (0.6)	0.031 (0.78)		±0.125 (3.18)	
2 (0.6) and under 5 (1.5)	0.031 (0.78) in any 2-ft (0.6-m) portion of the total length.		±0.125 (3.18)	
5 (1.5) and under 10 (3.0)	0.125 (3.18) in any 5-ft (1.5-m) portion of the total length.		±0.375 (9.52)	
10 (3.0) and over	0.50 (12.7) in any 10-ft (3.0-m) portion of the total length.		±0.500 (12.7)	

TABLE 3 Strip and Sheet Thickness Tolerance for Widths to 8.00 in. (203 mm) Inclusive

Thickness, in (mm)	Thickness	
	Tolerance, ±, in. (mm)	
Up to 0.004 (0.10), incl	0.0003 (0.008)	
Over 0.004 to 0.006 (0.10 to 0.15), incl	0.0004 (0.010)	
Over 0.006 to 0.009 (0.15 to 0.23), incl	0.0006 (0.015)	
Over 0.009 to 0.013 (0.23 to 0.33), incl	0.0008 (0.020)	
Over 0.013 to 0.017 (0.33 to 0.43), incl	0.0010 (0.025)	
Over 0.017 to 0.021 (0.43 to 0.53), incl	0.0013 (0.033)	
Over 0.021 to 0.026 (0.53 to 0.66), incl	0.0015 (0.038)	
Over 0.026 to 0.050 (0.66 to 1.27), incl	0.002 (0.051)	
Over 0.050 to 0.073 (1.27 to 1.85), incl	0.0025 (0.064)	
Over 0.073 to 0.130 (1.85 to 3.30), incl	0.003 (0.076)	
Over 0.130 to 0.188 (3.30 to 4.77), incl	0.0035 (0.089)	

10.2 The contract or order may specify ultimate tensile strength, elongation, microhardness (Knoop or Vickers), hardness (Rockwell or Rockwell Superficial), or a combination of these mechanical properties as temper criterion. If the contract or order does not specify a temper criterion, then the criterion for temper designation will be ultimate tensile strength and elongation.

11. Significance of Numerical Limits

11.1 For purpose of determining compliance with the specified limits for requirements of the properties listed in the following table, an observed value or a calculated value shall be rounded as indicated in accordance with Practice E29.

Property	Unit	Rounded Unit for Observed or Calculated Value
Chemical composition	percent	
Hardness		
Knoop (100-g load unless otherwise specified)		
Vicker (specify load)		
Rockwell (all scales, specify which)		nearest unit on the last right hand place of figure of specified limit
Rockwell superficial (all scales, specify which)		
Resistivity	μΩ·cm	
Tensile strength	psi (MPa)	nearest 1000 psi (nearest 10 MPa)
Yield Strength	psi (MPa)	nearest 1000 psi (nearest 10 MPa)
Elongation		
Below 5 %	percent	nearest multiple of 0.5 %
5 % and over	percent	nearest 1 %
Grain size		
Up to 0.055 mm incl.	mm	nearest multiple of 0.005 mm
Over 0.055 to 0.160, mm, incl.	mm	nearest 0.01 mm

12. Inspection

12.1 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.

12.2 The manufacturer shall perform or have performed at least these minimum tests to ensure conformance to this specification:

12.2.1 Visual inspection at 1× for surface defects. All material shall be visually free from structural defects, cracks, seams, porosity, inclusions, segregation, and other defects described in 7.1.

12.2.1.1 If during 1× visual inspection an area of injurious defects is suspected, further inspection at 10× to 20× magnification is recommended to try to ascertain if the area in question is definitely defective as described in 7.1 and 12.2.1.

12.2.1.2 Although not required by the manufacturer, the purchaser may inspect the four randomly selected individual units chosen for physical tests in 8.1.2 for surface defects prior to performing the physical tests. An inspection at 10× to 20× magnification can be performed to look for defects described in 7.1 and 12.2.1.

12.2.1.3 If during visual inspection an injurious defect is suspected, a sample containing the defect may be mounted and suitably polished and etched. The sample may then be examined at 50× magnification to determine if it meets the requirements listed in 7.1 and in 12.2.1. In no case shall any defect exceed 0.0005 in. (0.01 mm) in depth.

12.2.2 Hardness test or tension test can be applied, but not both unless specified by user.

12.2.3 Dimensional inspections shall be made as required to ensure conformance to tolerances specified.

12.2.4 Spectrographic or chemical analysis when required by order

13. Rejection

13.1 Material that fails to conform to this specification will be rejected, and the manufacturer shall be notified within 30 days after receipt of the material.

13.2 In the event of rejection, manufacturer and purchaser shall maintain test data and samples for not less than 6 weeks from the date of the test reports to resolve any disputed test results.

14. Certification

14.1 When specified in the purchase order or contract, the manufacturer's or supplier's certification shall be furnished to the purchaser stating that samples representing each lot have been manufactured, tested, and inspected in accordance with this specification and the requirements have been met. When specified in the purchase order or contract, a report of the test results shall be furnished.



TABLE 4 Width and Edgewise Curvature Tolerances for Sheet and Strip, With Slit Edges

Width Range	Width Tolerances in Inches (mm)				Edgewise Curvature	
	Slit Metal Thickness Range				Maximum Edgewise Curvature (depth of arc in any 6-ft (1.8-m) portion of the total length)	
					Shipped in Rolls in. (mm)	Shipped Flat in. (mm)
	over 0.002 to 0.016 (0.051 to 0.406) incl	over 0.016 to 0.062 (0.406 to 1.57) incl	over 0.062 to 0.125 (1.57 to 3.18) incl	over 0.125 to 0.188 (3.18 to 4.78) incl		
0.060 to 1.000 (1.52 to 25.4) incl	±0.003 (0.076)	±0.003 (0.076)	±0.005 (0.127)	±0.008 (0.203)	1.0 (25)	0.75 (19)
over 1.000 to 2.000 (25.4 to 50.8) incl	±0.003 (0.076)	±0.003 (0.076)	±0.008 (0.203)	±0.012 (0.305)	0.6 (15)	0.50 (13)
over 2.000 to 6.000 (50.8 to 152.4) incl	±0.003 (0.076)	±0.005 (0.127)	±0.010 (0.254)	±0.015 (0.381)	0.50 (13)	0.50 (13)
over 6.000 to 8.000 (152.4 to 203) incl	±0.005 (0.127)	±0.008 (0.203)	±0.013 (0.330)	±0.015 (0.381)	0.38 (9.7)	0.38 (9.7)

15. Packaging and Package Marking

15.1 The material shall be separated by size, composition, and temper, and prepared for shipment in such a manner as to ensure acceptance by common carrier for transportation and to afford protection from the normal hazards of transportation.

15.2 Each shipping unit shall be legibly marked with the purchase order number, metal or alloy designation, temper, size, shape, gross and net weight, and name of supplier. The specification number shall be shown when specified.

16. Supplementary Requirements

16.1 Special tolerances other than those specified herein shall be as agreed upon by the manufacturer and purchaser.

16.2 Special requirements in analysis test procedures, tolerances, properties, and quality shall be as agreed upon between manufacturer and purchaser.

17. Keywords

17.1 contacts; electrical contact materials; wrought precious metal

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