



Standard Specification for Magnesium Alloys in Ingot Form for Sand Castings, Permanent Mold Castings, and Die Castings¹

This standard is issued under the fixed designation B 93/B 93M; 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 magnesium alloys in ingot form for remelting for the manufacture of sand castings, permanent mold castings, investment castings, and die castings.

NOTE 1—Supplementary information pertaining to the alloys covered by this specification when used in the form of castings is given in Specifications B 80, B 94, B 199 and B 403.

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

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 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 date of order acceptance form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards:*²

B 80 Specification for Magnesium-Alloy Sand Castings

B 94 Specification for Magnesium-Alloy Die Castings

B 199 Specification for Magnesium-Alloy Permanent Mold Castings

B 403 Specification for Magnesium-Alloy Investment Castings

B 951 Practice for Codification of Unalloyed Magnesium and Magnesium-Alloys, Cast and Wrought

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

E 35 Test Methods for Chemical Analysis of Magnesium and Magnesium Alloys

E 88 Practice for Sampling Nonferrous Metals and Alloys in Cast Form for Determination of Chemical Composition

E 527 Practice for Numbering Metals and Alloys (UNS)

3. Ordering Information

3.1 Orders for ingot to this specification shall include the following information:

3.1.1 Quantity in pounds (kilograms)

3.1.2 Alloy (Section 4 and Table 1 or Table 2), and

3.1.3 Form: as agreed upon between the purchaser and seller. Some forms in commercial use are:

Form	Approximate Size Length by Width by Height, in. (mm)	Approximate Weight, lb (kg)
Five-segment	23 by 2¾ by 1¾ (583 by 70 by 44)	5 (2.3)
Four-segment	28 by 4½ by 4 (711 by 114 by 102)	20 (9.1)
Self-Palletizing	26½ by 6¾ by 2½ (672 by 168 by 67)	25 (11.3)

3.1.4 Inspection required at the manufacturer's works (see 8.1).

3.1.5 For inch-pound orders specify B93; for metric orders specify B93M. Do not mix units.

4. Chemical Composition

4.1 The ingots shall conform to the chemical composition limits prescribed in Table 1 for sand cast alloys and permanent mold-cast alloys and in Table 2 for die-cast alloys. Conformance shall be determined by the manufacturer by analyzing samples taken at the time the ingots are poured or samples taken from the ingots. If the manufacturer has determined the chemical composition of the material during manufacture, he shall not be required to sample and analyze the ingots.

4.2 The alloys shall conform to the chemical composition requirements prescribed in Table 1 and Table 2 (Note 2 and Note 3).

¹ This specification is under the jurisdiction of ASTM Committee B07 on Light Metals and Alloys and is the direct responsibility of Subcommittee B07.04 on Magnesium Alloy Cast and Wrought Products.

Current edition approved June 1, 2007. Published June 2007. Originally approved in 1934. Last previous edition approved in 2006 as B 93/B 93M – 06.

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.

TABLE 1 Chemical Requirements for Alloy Ingot for Remelt to Sand, Permanent, Mold and Investment Castings—Composition %

Alloy ^A ASTM	UNS	Mag- nesium	Alumi- num	Copper, max	Gadol- inium	Iron, max	Lithium, max	Manga- nese	Neody- mium	Nickel, max	Rare Earths	Silicon, max	Silver	Yttrium	Zinc	Zir- conium	Others each max ^B	Total Others, max ^B
AM100A	M10101	remainder	9.4–10.6	0.08	...	...	...	0.13–0.35	...	0.010	...	0.20	...	...	0.2 max	...	...	0.30
AZ63A	M11631	remainder	5.5–6.5	0.20	...	...	...	0.15–0.35	...	0.010	...	0.20	...	...	2.7–3.3	...	...	0.30
AZ81A	M11811	remainder	7.2–8.0	0.08	...	...	...	0.15–0.35	...	0.010	...	0.20	...	...	0.5–0.9	...	...	0.30
AZ91C	M11915	remainder	8.3–9.2	0.08	...	...	...	0.15–0.35	...	0.010	...	0.20	...	...	0.45–0.9	...	...	0.30
AZ91E	M11918	remainder	8.3–9.2	0.015	...	0.005	...	0.17–0.50	...	0.0010	...	0.20	...	...	0.45–0.9	...	0.01	0.30
AZ92A	M11921	remainder	8.5–9.5	0.20	...	...	...	0.13–0.35	...	0.010	...	0.20	...	...	1.7–2.3	...	...	0.30
EQ21A	M18330	remainder	...	0.05–0.10	...	...	...	...	...	0.01	1.5–3.0 ^C	0.01	1.3–1.7	...	...	0.3–1.0	...	0.30
EV31A ^D	M12311	remainder	...	0.01 max	1.0–1.7	0.010	...	...	2.6–3.1	0.0020	0.4 ^E	...	0.05 max	...	0.20–0.50	0.3–1.0	0.01	...
EZ33A	M12331	remainder	...	0.03	...	...	...	...	...	0.010	2.6–3.9 ^F	0.01	...	...	2.0–3.0	0.3–1.0	...	0.30
K1A	M18011	remainder	...	0.03	...	...	...	...	...	0.010	...	0.01	...	...	...	0.3–1.0	...	0.30
QE22A	M18221	remainder	...	0.03	...	...	...	0.15 max	...	0.010	1.9–2.4 ^C	0.01	2.0–3.0	...	0.2 max	0.3–1.0	...	0.30
WE43A	M18431	remainder	...	0.03	...	...	0.18	0.15 max	2.0–2.5	0.005	2.4–4.4 ^G	0.01	...	3.7–4.3	0.20 max	0.3–1.0	...	0.30
WE43B	M18433	remainder	...	0.01	...	...	0.18	0.03 max	2.0–2.5	0.004	2.4–4.4 ^G	...	...	3.7–4.3	...	0.3–1.0	0.01	...
WE54A	M18410	remainder	...	0.03	...	...	0.20	0.15 max	1.5–2.0	0.005	1.5–4.0 ^G	0.01	...	4.75–5.5	0.20 max	0.3–1.0	...	0.30
ZC63A	M16331	remainder	...	2.4–3.00	...	...	...	0.25–0.75	...	0.001	...	0.20	...	...	5.5–6.5	...	...	0.30
ZE41A	M16411	remainder	...	0.03	...	...	...	0.15 max	...	0.010	1.0–1.75 ^F	0.01	...	...	3.7–4.8	0.3–1.0	...	0.30
ZE63A	M16631	remainder	...	0.03	...	...	...	...	...	0.010	2.0–3.0	0.01	...	...	5.5–6.0	0.3–1.0	...	0.30
ZK51A	M16511	remainder	...	0.03	...	...	...	...	...	0.010	...	0.01	...	...	3.8–5.3	0.3–1.0	...	0.30
ZK61A	M16611	remainder	...	0.03	...	...	...	...	...	0.010	...	0.01	...	...	5.7–6.3	0.3–1.0	...	0.30

^A These alloy designations were established in accordance with Practice B 951. UNS designations were established in accordance with Practice E 527.

^B Includes listed elements for which no specific limit is shown.

^C Rare earth elements are in the form of Didymium, not less than 70 % Neodymium balance substantially Praseodymium.

^D Alloy EV31A is a patented composition, suitable for elevated temperature applications. Interested parties are invited to submit information regarding the identification of alternatives to these compositions to ASTM International. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this specification. Users of this specification are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

^E Other Rare Earths may also be present to a total maximum of 0.4 %. These Rare Earths shall principally be Cerium, Lanthanum, and Praseodymium.

^F Total Rare Earths (TRE) are principally a mixture of Cerium, Lanthanum, Neodymium, and Praseodymium. The Cerium content should not be less than 45% of TRE.

^G Other Rare Earths shall be principally heavy rare earths, such as, Gadolinium, Dysprosium, Erbium, and Ytterbium. Other Rare Earths are derived from the Yttrium, typically 80 %, and 20 % heavy rare earths.

^H Zinc + Silver shall be 0.15 % max.

NOTE 2—Analysis shall regularly be made only for the elements specifically mentioned in the tables. If, however, the presence of other elements is suspected or indicated in the course of routine analysis, further analysis shall be made to determine that the total of these other elements is not in excess of the limits specified in the last column of the table.

NOTE 3—The following applies to all specified limits in the tables: For purposes of acceptance and rejection, an observed value or a calculated value obtained from analysis shall be rounded off in accordance with the rounding off method of Practice E 29 to the nearest unit in the last right-hand place of figures used in expressing the specified limit.

5. Workmanship, Finish and Appearance

5.1 The ingots shall be uniform in quality and shall be commercially free of slag or other foreign material.

6. Sampling for Chemical Analysis

6.1 Sufficient samples shall be taken by the manufacturer to ensure conformance to the chemical composition requirement of the alloy.

6.1.1 Samples may be taken from the molten metal when the ingot is poured or from the ingots. Samples shall be representative of the material.

6.2 In case of dispute, the sampling for chemical analysis shall be according to the requirements of Practice E 88.

6.2.1 If the shipment is in less than carload lots and also in the case of magnesium-zirconium alloys, one ingot section shall be taken for sampling for each 2200 lb (1000 kg) or fraction thereof.

7. Methods of Chemical Analysis

7.1 Any suitable method of chemical analysis may be used. In case of dispute, the analysis shall be made by methods given in Test Methods E 35 or any other standard methods of analysis approved by ASTM unless some other method is agreed upon between the purchaser and vendor.

8. Inspection

8.1 If the purchaser desires that inspection be made at the manufacturer's works where the material is made, it shall be so stated in the contract or purchase order.

8.1.1 If the purchaser elects to have the inspection made at the manufacturer's works, 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.

8.1.2 All tests and inspection shall be so conducted as not to interfere unnecessarily with the operation of the works.

9. Rejection

9.1 Material that does not conform to the requirements of this specification may be rejected and, if rejected, the seller's responsibility shall be limited to replacing the rejected material. The full weight of the rejected material shall be returned to the manufacturer.

TABLE 2 Chemical Requirements for Alloys Used for Die Castings^A

Alloy		Composition, %											
Designation ^B	UNS Magnesium	Aluminum	Beryllium	Copper, max	Iron, max	Manganese	Nickel, max	Rare Earth	Silicon	Strontium	Zinc	Other Metallic impurities, max each ^C	Other Impurities, max
AS41A	M10411 remainder	3.7–4.8	...	0.04	...	0.22–0.48	0.01	...	0.60–1.4	...	0.10 max	...	0.30
AS41B	M10413 remainder	3.7–4.8	0.0005–0.0015	0.015	0.0035	0.35–0.6	0.001	...	0.60–1.4	...	0.10 max	0.01	...
AM50A	M10501 remainder	4.5–5.3	0.0005–0.0015	0.008	0.004	0.28–0.50	0.001	...	0.08 max	...	0.20 max	0.01	...
AM60A	M10601 remainder	5.6–6.4	...	0.25	...	0.15–0.50	0.01	...	0.20 max	...	0.20 max	...	0.30
AM60B	M10603 remainder	5.6–6.4	0.0005–0.0015	0.008	0.004	0.26–0.50	0.001	...	0.08 max	...	0.20 max	0.01	...
AZ91A	M11911 remainder	8.5–9.5	...	0.08	...	0.15–0.40	0.01	...	0.20 max	...	0.45–0.9	...	0.30
AZ91B	M11913 remainder	8.5–9.5	...	0.25	...	0.15–0.40	0.01	...	0.20 max	...	0.45–0.9	...	0.30
AZ91D	M11917 remainder	8.5–9.5	0.0005–0.0015	0.025	0.004	0.17–0.40	0.001	...	0.08 max	...	0.45–0.9	0.01	...
AJ52A ^D	M17521 remainder	4.6–5.5	0.0005–0.0015	0.008	0.004	0.26–0.5	0.001	...	0.08 max	1.8–2.3	0.20 max	0.01	...
AJ62A ^D	M17621 remainder	5.6–6.6	0.0005–0.0015	0.008	0.004	0.26–0.5	0.001	...	0.08	2.1–2.8	0.20 max	0.01	...
AS21A	M10211 remainder	1.9–2.5	0.0005–0.0015	0.008	0.004	0.2–0.6	0.001	...	0.7–1.2	...	0.20 max	0.01	...
AS21B ^D	M10213 remainder	1.9–2.5	0.0005–0.0015	0.008	0.0035	0.05–0.15	0.001	0.06–0.25	0.7–1.2	...	0.25 max	0.01	...

^A The following applies to all specified limits in this table; for purposes of acceptance and rejection, an observed value or a calculated value obtained from analysis should be rounded off to the nearest unit in the last right-hand place of figures used in expressing the specified limit in accordance with the rounding-off procedure prescribed in Practice E 29.

^B ASTM alloy designations were established in accordance with Practice B 951. UNS Numbers were established in accordance with Practice E 527.

^C Includes listed elements for which no specific limit is shown.

^D Alloys AJ52A, AJ62A, and AS21B are patented compositions for elevated temperature applications. Interested parties are invited to submit information regarding the identification of alternatives to these compositions to ASTM International. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this specification. Users of this specification are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

10. Product Marking

10.1 Identification shall be by stamping with the alloy designation in Table 1 and Table 2.

11. Packaging and Package Marking

11.1 Ingots shall be packaged in such a manner as to prevent damage in ordinary handling and transportation. The type of packing and gross weight of individual containers or bundles shall be left to the discretion of the supplier unless otherwise agreed upon. Packaging methods shall be so selected as to permit maximum utility of equipment in unloading and subsequent handling. Each container or bundle shall contain only one size and alloy when packaged for shipment unless otherwise agreed upon.

11.2 Each package shall be marked with the purchase order number, quantity, specification number, alloy, gross or net weights, and the name of the manufacturer.

11.2.1 Each package shall be color-coded on two opposite corners, visible from four sides, with the colors listed in Table 3 when stated as a purchase order requirement.

11.3 Packages shall be such as to ensure acceptance by common or other carriers for safe transportation at the lowest rate to the point of delivery.

TABLE 3 Color Code

Alloy	Color Code
AJ52A	Black and White
AJ62A	Black and Yellow
AM50A	Black
AM60A	Green and White
AM60B	White
AS21A	Blue and Green
AS21B	Blue and White
AS41A	Red
AS41B	Red and White
AZ91B	Blue and Yellow
AZ91C	Brown
AZ91D	Yellow
AZ91E	Brown and Yellow

11.4 For those alloys listed, the various national regulations concerning the transportation of these alloys will be complied with in regard to hazardous materials.

12. Keywords

12.1 composition; die casting; high pressure die cast alloy; magnesium; permanent mold casting; sand casting



SUMMARY OF CHANGES

Committee B07 has identified the location of selected changes to this standard since the last issue (B93/B93M – 06) that may impact the use of this standard. (Approved June 1, 2007)

(1) Replace the new B 951 for B 275 in 2.2, Table 1, and Table 2.

Committee B07 has identified the location of selected changes to this standard since the last issue (B 93/B 93M – 05) that may impact its use. (Approved Sept. 1, 2006.)

(1) Clarified the Rare Earths for alloys ZE41A and EZ33A. (2) Removed alloy ZE63A, which is no longer in production.

ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).