



Designation: B 92/B92M – 89 (Reapproved 1994)^{ε1}

Standard Specification for Magnesium Ingot and Stick For Remelting¹

This standard is issued under the fixed designation B 92/B92M; 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.

^{ε1} NOTE—Keywords were added editorially in December 1994.

1. Scope *

1.1 This specification covers magnesium in the form of ingot and stick for remelting: 9980A is available in ingot and stick form, and 9980B, 9990A, 9995A, and 9998A are generally available only in ingot form.

1.2 The values stated in SI units are to be regarded as a separate standard. The values stated in each system are not exact equivalents, therefore each system must be used independently of the other.

2. Referenced Documents

2.1 ASTM Standards:

E 35 Test Methods for Chemical Analysis of Magnesium and Magnesium Alloys²

E 88 Practice for Sampling Nonferrous Metals and Alloys in Cast Form for Determination of Chemical Composition²

3. Terminology

3.1 Definitions:

3.1.1 *ingot*—a cast form suitable for remelting.

3.1.2 *stick*—an extruded form substantially uniform in cross section cut to desired length or weight.

4. Ordering Information

4.1 Orders for ingot and stick under this specification shall include the following information:

4.1.1 Grade (Section 6 and Table 1),

4.1.2 Quantity, in pieces or pounds [kilograms], and

4.1.3 Form; by agreement between the purchaser and the manufacturer the approximate form and weight of each piece or ingot may be specified.

4.1.4 For inch-pound orders specify B92, for metric orders specify B92M. Do not mix units.

5. Materials and Manufacture

5.1 No scrap shall be used in the production of magnesium ingot and stick, except such as shall accumulate at the manufacturer's plants from material of similar composition and of his own manufacture.

6. Chemical Composition

6.1 *Limits*—The material shall conform to the requirements as to chemical composition prescribed in Table 1.

6.2 Sampling:

6.2.1 Sufficient samples shall be taken by the manufacturer to assure conformance to the chemical composition requirements of the alloy. Samples may be taken from the molten metal when the ingot is poured or from the ingot. Samples shall be representative of the material.

6.2.2 In case of dispute, the sampling for chemical analysis shall be according to the requirements of Practice E 88. If the ingots are shipped in carload lots of the same alloy, not less than four ingots shall be taken at random from the carload for sampling. If the shipment is in less than carload lots, one ingot shall be taken for sampling for each 10 000 lb [4500 kg] or fraction thereof.

6.3 *Methods of Analysis*—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 by the purchaser and vendor.

7. General Quality

7.1 Magnesium ingot and stick shall have a clean surface and shall be commercially free from dirt, slag, or other foreign material.

8. Rejection

8.1 Material that does not conform to the requirements of this specification may be rejected, and if rejected the conditions of replacement shall be as agreed upon between the purchaser and the seller. The seller's responsibility shall be limited to a period of six months from shipping date unless other agreement is made by the purchaser and seller.

¹ This specification is under the jurisdiction of the ASTM Committee B-7 on Light Metals and Alloys and is the direct responsibility of Subcommittee B07.04 on Magnesium Alloy, Cast and Wrought Products.

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² *Annual Book of ASTM Standards*, Vol 03.05.

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

TABLE 1 Chemical Requirements

NOTE 1—Analysis shall regularly be made only for the elements specifically mentioned in this table. 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 2—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 to the nearest unit in the last right-hand place of figures used in expressing the specified limit.

	Composition, %				
	Grade 9980A (UNS 19980)	Grade 9980B (UNS M 19991)	Grade 9990A (UNS 19990)	Grade 9995A (UNS 19995)	Grade 9998A (UNS 19998)
Aluminum, max	0.003	0.01	0.004
Copper, max	0.02	0.02	0.0005
Iron, max	0.04	0.003	0.002
Lead, max	0.01	0.01	0.001
Manganese, max	0.10	0.10	0.004	0.004	0.002
Nickel, max	0.001	0.005	0.001	0.001	0.0005
Silicon, max	0.005	0.005	0.003
Sodium, max	0.006
Tin, max	0.01	0.01
Titanium, max	0.01	0.001
Other impurities each, max ^{A,B}	0.05	0.05	0.01 ^C	0.005 ^C	0.005 ^C
Magnesium, by difference, min	99.80	99.80	99.90	99.95	99.98

^A For specific applications, other minor impurities may be required to be controlled to limiting maxima by agreement between the purchaser and the seller.

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

^C For nuclear applications, the cadmium and boron (high-capture cross-section elements) shall be specified as follows:

Cadmium, max, %	0.0001 or 0.00005
Boron, max, %	0.00007 or 0.00003

9. Packaging, Marking, and Shipping

9.1 The material shall be packaged in such a manner as to prevent damage in ordinary handling and transportation. The type of packaging and gross weight of individual containers shall be left to the discretion of the seller unless otherwise agreed upon. Packaging methods and containers shall be so selected as to permit maximum utility of mechanical equipment in unloading and subsequent handling. Each package or container shall contain only one size and form of material when packed for shipment unless otherwise agreed upon.

9.2 Packages or containers shall be such as to ensure

acceptance by common or other carriers for safe transportation at the lowest rate to the point of delivery.

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

10. Keywords

10.1 chemical specifications; compositional limits; contaminants; contents; grades; magnesium; pure; unalloyed

SUMMARY OF CHANGES

This section identifies the principal changes to this standard that have been incorporated since the last issue.

(1) Metric (SI) units were added, alternative use of SI system

permitted when specified by designation B92M.

(2) Maximum of 0.006 sodium set for 9980A in Table 1.

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