



Designation: B93/B93M – 09

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 B93/B93M; 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.

Note—Table 1 was corrected editorially and the year date changed on Dec. 7, 2009.

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 B80, B94, B199 and B403.

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

B80 Specification for Magnesium-Alloy Sand Castings

B94 Specification for Magnesium-Alloy Die Castings

B199 Specification for Magnesium-Alloy Permanent Mold Castings

B403 Specification for Magnesium-Alloy Investment Castings

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.

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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.

B951 Practice for Codification of Unalloyed Magnesium and Magnesium-Alloys, Cast and Wrought

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

E35 Test Methods for Chemical Analysis of Magnesium and Magnesium Alloys (Withdrawn 2008)³

E88 Practice for Sampling Nonferrous Metals and Alloys in Cast Form for Determination of Chemical Composition

E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (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 1¼ (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

³ The last approved version of this historical standard is referenced on www.astm.org.



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	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	1.9† ^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	1.9† ^G	...	...	3.7–4.3	...	0.3–1.0	...	0.30
WE54A	M18410	remainder	...	0.03	...	...	0.20	0.15 max	1.5–2.0	0.005	2.0† ^G	0.01	...	4.75–5.5	...	0.3–1.0	...	...
ZC63A	M16331	remainder	2.4–3.00	...	...	...	...	0.25–0.75	...	0.001	...	0.20	...	...	0.20 max	0.3–1.0	...	0.30
ZE41A	M16411	remainder	...	0.03	...	...	...	0.15 max	...	0.010	1.0–1.75 ^F	0.01	...	...	5.5–6.5	...	...	0.30
ZK51A	M16511	remainder	...	0.03	...	...	...	...	...	0.010	...	0.01	...	...	3.7–4.8	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 B951. UNS designations were established in accordance with Practice E527.

^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.

^I Editorially corrected.