

ISO 16468:2015-10 (E)

Investment castings (steel, nickel alloys and cobalt alloys) - General technical requirements

Contents	Page
Foreword	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Materials and manufacture	2
4.1 Melting process	2
4.2 Remelting process	2
5 Inspection and testing	2
5.1 General requirements	2
5.2 Sampling	2
6 Retests	8
7 Cleaning and dressing	8
8 Quality	8
9 Production welds	8
10 Supplementary requirements	8
10.1 General	8
10.2 Agreed manufacturing procedure	8
10.3 Magnetic particle inspection	8
10.4 Radiographic inspection	8
10.5 Liquid penetrant inspection	9
10.6 Ultrasonic inspection	9
10.7 Inspection of weld preparation	9
10.8 Prior agreement relating to major finishing welds	9
10.9 Impact test at low temperatures	9
10.10 Hardness test	9
10.10.1 Brinell	9
10.10.2 Rockwell	9
10.10.3 Vickers	9
10.11 Specified ferrite range in austenitic and austenitic ferritic stainless steels	9
10.12 Unspecified elements	10
10.13 Test material removed from castings	10
10.14 Tensile test blocks and specimen locations for castings	10
10.15 Weld maps (sketches)	10
10.16 Chemical analysis -- Testing frequency	10
10.17 Tensile test -- Testing frequency	10
10.18 Inspection documents	10
10.19 Marking	10
10.20 Decarburization	10
10.21 Metallurgical cleanliness	10
Bibliography	12