



Standard Specification for Castings, Iron-Nickel-Chromium and Nickel Alloys, Specially Controlled for Pressure Retaining Parts for Corrosive Service¹

This standard is issued under the fixed designation A990/A990M; 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.

1. Scope*

1.1 This specification covers iron-nickel-chromium and nickel alloy castings specially processed with restricted melt practices, weldability testing, and nondestructive examination (NDE) requirements.

1.2 A number of grades of iron-nickel-chromium and nickel alloy castings are included in this specification. Since these grades possess varying degrees of suitability for service in corrosive environments, it is the responsibility of the purchaser to determine which grade shall be furnished. Selection will depend on design and service conditions, mechanical properties, and corrosion-resistant characteristics.

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.3.1 This specification is expressed in both inch-pound units and in SI units; however, unless the purchase order or contract specifies the applicable M specification designation (SI units), the inch-pound units shall apply. Within the text, the SI units are shown in brackets or parentheses.

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 establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.18 on Castings.

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2. Referenced Documents

2.1 ASTM Standards:²

- A351/A351M Specification for Castings, Austenitic, for Pressure-Containing Parts
- A488/A488M Practice for Steel Castings, Welding, Qualifications of Procedures and Personnel
- A494/A494M Specification for Castings, Nickel and Nickel Alloy
- A703/A703M Specification for Steel Castings, General Requirements, for Pressure-Containing Parts
- A743/A743M Specification for Castings, Iron-Chromium, Iron-Chromium-Nickel, Corrosion Resistant, for General Application
- A744/A744M Specification for Castings, Iron-Chromium-Nickel, Corrosion Resistant, for Severe Service
- A802/A802M Practice for Steel Castings, Surface Acceptance Standards, Visual Examination
- A903/A903M Specification for Steel Castings, Surface Acceptance Standards, Magnetic Particle and Liquid Penetrant Inspection
- A985/A985M Specification for Steel Investment Castings General Requirements, for Pressure-Containing Parts
- E94 Guide for Radiographic Examination
- E165 Practice for Liquid Penetrant Examination for General Industry
- E186 Reference Radiographs for Heavy-Walled (2 to 4½-in. (50.8 to 114-mm)) Steel Castings
- E272 Reference Radiographs for High-Strength Copper-Base and Nickel-Copper Alloy Castings
- E280 Reference Radiographs for Heavy-Walled (4½ to 12-in. (114 to 305-mm)) Steel Castings

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.



E446 Reference Radiographs for Steel Castings Up to 2 in. (50.8 mm) in Thickness

2.2 AWS Standards:³

AWS A5.4, Specification for Stainless Steel Electrodes for Shielded Metal Arc Welding

AWS A5.9, Specification for Bare Stainless Steel Welding Electrodes and Rods

AWS A5.11/A5.11M, Specification for Nickel and Nickel Alloy Welding Electrodes for Shielded Metal Arc Welding

AWS A5.14/A5.14M, Specification for Nickel and Nickel-Alloy Bare Welding Electrodes and Rods

2.3 ASME/ANSI Standard:⁴

ASME/ANSI B16.34, Valves-Flanged, Threaded, and Welding End

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *accessible surface, n*—surface that can be welded on without cutting access holes in the casting.

3.1.2 *refined ingot, n*—metal processed by argon-oxygen-decarburization (AOD) or vacuum-oxygen-decarburization (VOD) and cast to a size and shape suitable for remelting.

3.1.3 *revert, n*—gates, risers, and castings. Also includes scrapped machinery and fabricated items, chips, and turnings.

4. General Conditions for Delivery

4.1 Other than investment castings, material furnished to this specification shall conform to the requirements of Specification A703/A703M, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A703/A703M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A703/A703M, this specification shall prevail.

³ Available from American Welding Society (AWS), 8669 NW 36 Street, #130, Miami, FL 33166-6672, <http://www.aws.org>.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

4.2 Investment Castings – Material furnished to this specification shall conform to the requirements of Specification A985/A985M, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A985/A985M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A985/A985M, Specification A985/A985M shall prevail.

5. Ordering Information

5.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered to this specification. Such requirements may include, but are not limited to, the following:

5.1.1 Quantity.

5.1.2 Grade designation (Table 1).

5.1.3 Description of the casting by pattern number or drawing. Dimensional tolerances should be included on the casting drawing.

5.1.4 Nondestructive inspection class required (Table 2). Class D will be supplied unless otherwise specified.

5.1.5 Wetted surfaces (Table 2).

5.2 The purchaser shall specify any supplementary requirements desired, including standards of acceptance, required to describe adequately the desired material.

6. Process and Manufacture

6.1 Alloys, except for nickel base, 25 to 35 % Cu alloys, shall be made by one of the two following processes:

6.1.1 Electric arc or induction furnace melting followed by AOD or VOD refining, or

6.1.2 Electric induction furnace melting of refined ingot.

6.2 Nickel base alloys with 25 to 35 % Cu shall be made by 6.1.1 or 6.1.2 or by electric furnace.

6.3 Additions of up to 5 % are permitted for compositional adjustments and deoxidation.

6.4 Revert shall not be used.

TABLE 1 Chemical Requirements

Element, % (max, except where range is given)	Grade					
	CK3MCuN	CW-2M	CN3MCu	M35-1	CW2MC	N2M
C	0.025	0.020	0.030	0.35	0.020	0.020
Mn	1.20	1.00	1.50	1.50	1.00	1.00
Si	0.75	0.80	1.00	1.25	0.45	0.80
P	0.020	0.030	0.030	0.030	0.015	0.030
S	0.010	0.015	0.015	0.015	0.015	0.015
Mo	6.0-7.0	15.0-17.5	2.0-3.0	...	8.0-10.0	30.0-33.0
Fe	balance	2.00	balance	3.5	5.0	3.00
Ni	17.5-19.5	balance	27.5-30.5	Balance	Balance	Balance
Cr	19.5-20.5	15.0-17.5	19.0-22.0	...	20.0-23.0	1.00
N	0.18-0.24					
Cu	0.50-1.00	...	3.0-3.5	26.0-33.0	0.50	0.20
W		1.00	0.50	0.20
V		0.20	0.20
Cb		3.1-4.5	...



TABLE 2 Nondestructive Examination Requirements

Maximum Casting Thickness	Class	Visual Examination, Practice A802/A802M Minimum Ac- ceptance Level	Radiographic Examination, Guide E94 Number of Castings Severity Level per Table 6	Liquid Penetrant Examination, Test Method E165	
				Coverage	Minimum Acceptance Level per Specification A903/A903M
less than 5/8 in. (15.9 mm)	A	Level I	100 %	All accessible surfaces	Level II
	B	Level II	100 %	All accessible wetted sur- faces	Level II
	C	Level II	Initial casting off pattern	Weld repairs	Level II
	D	Level II	Initial casting off pattern	NA	NA
5/8 to 1 in. (15.9 to 25.4 mm)	A	Level I	100 %	All accessible surfaces	Level III
	B	Level II	100 %	All accessible wetted sur- faces	Level III
	C	Level II	Initial casting off pattern	Weld repairs	Level III
	D	Level II	Initial casting off pattern	NA	NA
Over 1 to 2 in. (25.4 to 50.8 mm)	A	Level I	100 %	All accessible surfaces	Level IV
	B	Level II	100 %	All accessible wetted sur- faces	Level IV
	C	Level II	Initial casting off pattern	Weld repairs	Level IV
	D	Level II	Initial casting off pattern	NA	NA
Over 2 to 4 1/2 in. (50.8 to 114 mm)	A	Level II	100 %	All accessible surfaces	Level IV
	B	Level II	100 %	All accessible wetted sur- faces	Level IV
	C	Level III	Initial casting off pattern	Weld repairs	Level V
	D	Level III	Initial casting off pattern	NA	NA
Over 4 1/2 in. (114 mm)	A	Level III	100 %	All accessible surfaces	Level V
	B	Level III	100 %	All accessible wetted sur- faces	Level V
	C	Level IV	Initial casting off pattern	Weld repairs	Level V
	D	Level IV	Initial casting off pattern	NA	NA

7. Chemical Composition

7.1 These alloys shall conform to the chemical composition requirements prescribed in Table 1. An analysis of every heat is required.

8. Tensile Properties

8.1 One tension test shall be made from each heat. Test results shall conform to the tensile requirements specified in Table 3. The bar shall be solution heat treated per the requirements of Table 4 in production furnaces to the same procedure as the castings it represents. If the casting grade does not require heat treatment, the bar used for the test specimen shall not be heat treated.

9. Weldability Qualification

9.1 Each heat shall be qualified by weldability testing.

9.2 Sampling:

9.2.1 The weldability test plate shall be cast in accordance with Fig. 1.

TABLE 4 Heat Treat Requirements

Grade	Heat Treatment
CK3MCuN	Heat to 2200 to 2265°F (1205 to 1240°C) for one hour at temperature/1 in. (25 mm) of thickness with a minimum of 4 hours. Quench in water. ^A
CW-2M	Heat to 2225 to 2300°F [1220 to 1260°C] for a minimum of 1 h at temperature/1 in. [25 mm] of thickness. Quench in water. ^A
CN3MCu	Heat to 2050°F [1120°C] min for a min of 1 h at temperature/1 in. [25 mm] of thickness. Quench in water. ^A
M35-1	As-cast
CW2MC	Heat to 2175°F [1190°C] min for a min of 2 h at temperature or a min of 1 h/1 in. [25 mm] of thickness whichever is greater. Quench in water. ^A
N2M	Heat to 2080°F [1140°C] min for a min of 2 h at temperature + 1 h/1 in. [25 mm] of thickness. Quench in water. ^A

^A Quench in water or rapid cool by other means as agreed upon by the manufacturer and purchaser.

9.2.2 For heats produced under 6.1.1, at least one weldability test plate shall be cast from each heat.

9.2.3 For heats produced under 6.1.2, at least one weldability test plate shall be cast from the first heat in an uninterrupted

TABLE 3 Tensile Requirements

	Grade					
	CK3MCuN	CW-2M	CN3MCu	M35-1	CW2MC	N2M
Tensile strength, min, ksi [MPa]	80 [550]	72 [495]	62 [425]	65 [450]	70 [485]	76 [525]
0.2 % offset yield strength, min, ksi [MPa]	38 [260]	40 [275]	25 [170]	25 [170]	40 [275]	40 [275]
Elongation in 2 in. [50 mm], min, % ^A	35	20	35	25	25	20

^A When ICI test bars are used in tensile testing as provided for in Specification A985/A985M, the gage length to reduced section diameter ratio shall be 4 to 1.

series of heats, made in the same furnace from the same heat of refined ingot using the same melting procedure, and shall qualify all of the subsequent heats in that series made in the same shift.

9.3 Procedure:

9.3.1 The test plates required under 9.2 shall be processed and tested as follows:

9.3.1.1 Prior to welding, the test plate shall be solution heat treated according to the requirements of Table 4 in production furnaces to the same procedure as the castings it represents.

9.3.1.2 All forms of cold working, mechanical deformation, hammering, or peening, in excess of that required for normal cleaning is prohibited.

9.3.1.3 Fill the groove in the plate with weld deposit according to the procedure used in Section 11 and the filler material grade specified in Table 5.

9.3.1.4 For the purposes of the weldability test only, post weld heat treatment of the test plate is prohibited even if part of the procedure. Remove one 3/8-in. (10-mm) min thick bend coupon longitudinally from the center of the welded plate by machining, sawing, or abrasive cutting. Make a transverse side bend test of the welded joint in accordance with Practice A488/A488M.

9.4 Acceptance:

9.4.1 On the bent specimen, cracks or other open defects exceeding 1/8 in. (3.2 mm), measured in any direction on the convex surface shall be cause for rejection, except that cracks occurring on and limited to the corners while testing shall not be considered.

10. Nondestructive Examination

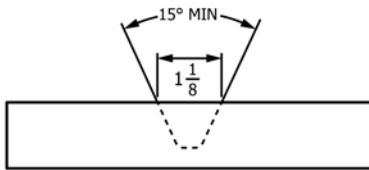
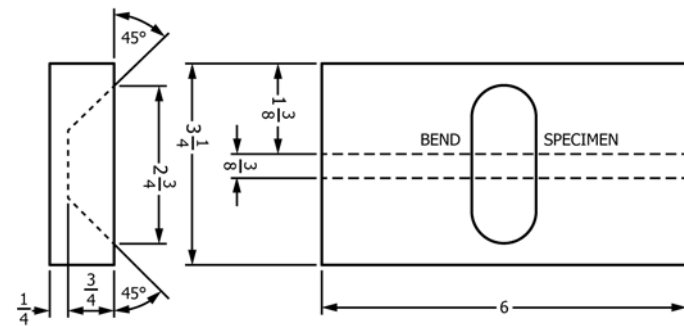
10.1 One of four different classes of nondestructive examination shall be imposed on castings ordered to this specification. Classes A, B, C, and D are defined in Table 2. Each class imposes specific requirements for three different NDE methods. Class D will be supplied unless otherwise specified.

10.2 *Visual Examination*—Each casting shall be examined visually in accordance with Practice A802/A802M. Fusion discontinuities, expansion discontinuities, and inserts are unacceptable. All other surface features must meet the acceptance criteria class in Table 2.

10.3 Radiographic Examination:

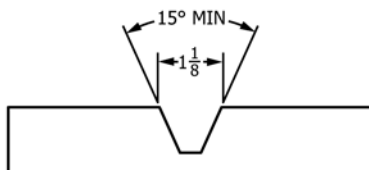
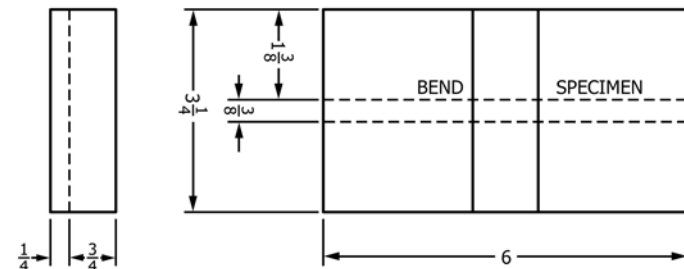
10.3.1 The number of castings to be examined radiographically and the acceptance criteria shall be in accordance with the specified class in Table 2 and Table 6.

10.3.2 The extent of coverage shall be agreed upon between the manufacturer and purchaser. Where applicable, the minimum coverage shall comply with ASME/ANSI B 16.34.



(a)

Metric Equivalents							
in.	1/4	3/8	3/4	1 1/8	2 3/4	3 1/4	6
[mm]	[5]	[10]	[20]	[30]	[70]	[85]	[155]



(b)

Metric Equivalents							
in.	1/4	3/8	3/4	1 1/8	3 1/4	6	
[mm]	[5]	[10]	[20]	[30]	[85]	[155]	

FIG. 1 (a) Weldability Test Plate (b) Optional Weldability Test Plate With a Machined Groove

TABLE 5 Weld Filler Materials

Cast Grade	AWS A5.11/A5.11M and AWS A5.14/A5.14M Weld Filler Material
CK3MCuN	AWS A5.4 and AWS A5.9 NiCrMo-3
CW-2M	NiCrMo-7 or NiCrMo-10
CN3MCu	AWS A5.4 and AWS A5.9 320LR
M35-1	NiCu-7
CW2MC	NiCrMo-3
N2M	NiMo-7 or NiMo-10



TABLE 6 Radiographic Severity Level Requirements

Nickel Copper				Severity Level, Min Acceptance Level Reference Radiographs E272							Reference Radiographs E186 Chaplets	
Casting Thick- ness in Area of interest	Class	Type	Shrinkage		Dross		Porosity		Inclusions		Reference Radiograph	Source
			Reference Radiograph	Source	Reference Radiograph	Source	Reference Radiograph	Source	Reference Radiograph	Source		
1 in. (25 mm) and less	Class A	Feathery Spongy Linear	Cd 2	X-ray	Bb 1	X-ray	A3	X-ray	Ba 3	X-ray	None Accept- able	
			Ca 2	Gamma								
	Class B, C and D	Feathery Spongy Linear	Cd 3	X-ray	Bb 2	X-ray	A4	X-ray	Ba 4	X-ray	None Accept- able	
			Cd 3	Gamma								
			Ca 3	Gamma								
Over 1 in. (25 mm)	Class A	Feathery Spongy Linear	Cd 3	X-ray	Bb 2	Gamma	A3	Gamma	Ba 3	Gamma	None Accept- able	
			Cd 3	Gamma								
	Class B, C and D	Feathery Spongy Linear	Cd 4	X-ray	Bb 3	Gamma	A4	Gamma	Ba 4	Gamma	None Accept- able	
			Cd 4	Gamma								
			Ca 4	Gamma								
Iron-Nickel-Chromium and Nickel-Chromium												
Casting Thick- ness	Class		ASTM Stan- dard	Shrinkage		Porosity		Inclusion		Hot Tear, Crack		Insert, Chaplet
Less than 1 in. (25 mm)	Class A		E446	CA 2, CB 2, CC 2, CD 2		A2		B2		None		None
	Class B, C and D		E446	CA 3, CB 3, CC 3, CD 3		A3		B3		None		None
1 to 2 in. (25 to 51 mm)	Class A		E446	CA 2, CB 2, CC 2, CD 2		A2		B2		None		None
	Class B, C and D		E446	CA 3, CB 3, CC 3, CD 3		A3		B3		None		None
Over 2 to 4½ in. (251 to 114 mm)	Class A		E186	CA 3, CB 3, CC 3		A3		B3		None		None
	Class B, C and D		E186	CA 4, CB 4, CC 4		A4		B4		None		None
Over 4½ in. (114 mm)	Class A		E280	CA 3, CB 3, CC 3		A3		B3		None		None
	Class B, C and D		E280	CA 4, CB 4, CC 4		A4		B4		None		None

10.3.3 Personnel performing the examination shall be qualified in accordance with an acceptable written practice.

10.3.4 All castings that are radiographed and found acceptable shall be marked permanently RT.

10.3.5 For Classes C and D, if a rejectable indication is found, that first casting shall be scrapped or repaired and the second casting radiographed. If the second casting passes, then no additional radiography beyond the normal amount is required. If that second casting fails, all remaining castings shall be radiographed in only the rejectable areas found on the first and second castings. After changes are made to the gating or risering of a pattern, and the subsequent castings produce no rejectable radiographic indications, then no additional radiography beyond the sampling rate agreed upon by the purchaser and the producer shall be required.

10.4 Liquid Penetrant Examination :

10.4.1 All Class A, B, and C castings shall be liquid penetrant (LP) tested in accordance with **Table 2** after the final specified heat treatment.

10.4.2 Personnel performing the examination shall be qualified in accordance with an acceptable written practice.

10.4.3 When welding is performed after the liquid penetrant examination, the repair weld and at least ¼ in. (6 mm) of the surrounding material shall be LP tested in accordance with **Table 2**.

11. Repair by Welding

11.1 All weld repairs shall be made with welders and procedures qualified in accordance with Practice **A488/A488M**. Only the filler material grades specified in **Table 5** shall be used.

11.2 Major weld repairs are repairs required when a casting has leaked on hydrostatic test or when the depth of the cavity after preparation for repair exceeds 20 % of the actual wall thickness or 1 in. (25 mm), whichever is smaller, or when the extent of the welding exceeds approximately 10 in.² (65 cm²) or 5 % of the total surface area, whichever is smaller.

11.3 All weld repairs shall be subject to the same quality standards as are used to inspect the castings. Initial excavation of defects may be accomplished by any method including air-arc gouging, grinding, or machining; however, all visible

traces of the air-arc process shall be removed by grinding or machining. All surfaces to be welded and at least 1 in. (25 mm) beyond shall be smooth and free of sand, scale, paint, oil, or other foreign matter. The cleaning may be accomplished by grinding or by machining followed by solvent washing.

11.4 All forms of cold working, mechanical deformation, hammering, or peening in excess of that required for normal cleaning is prohibited.

12. Heat Treatment

12.1 All castings shall be solution heat treated as specified in **Table 4**.

12.2 Post-weld solution heat treatment is required for all major weld repairs, except on M35-1, which is used in the as-cast condition. Post-weld solution heat treatment of other weld repairs is not required provided an interpass temperature of 250°F (121°C) is not exceeded.

12.3 For grade CK3MCuN post weld heat treatment shall be performed at a minimum of 2100°F (1150°C) for a minimum of 1 hour per inch (25 mm) of thickness and water quenched or rapidly cooled by other means as agreed upon by the manufacturer and purchaser.

13. Workmanship, Finish, and Appearance

13.1 All surfaces shall be cleaned and free of scale. Final cleaning shall be accomplished by blasting with clean nonmetallic media not previously used on steel or iron parts, pickling, machining, or other approved methods approved by the purchaser.

13.2 The castings shall not be peened, plugged, or impregnated.

14. Product Marking

14.1 Castings shall be marked with the ASTM specification designation and grade symbol, for example, CW-2M. The manufacturer's name or identification mark, the pattern number or part number, and the heat number shall be cast or stamped on all castings except those of such small size as to make such marking impractical.

14.2 When the castings are too small to mark individually, a symbol traceable to the heat shall be placed on the castings and the required identification then placed on a tag affixed to the container in which these castings are shipped.

15. Keywords

15.1 casting; iron-nickel-chromium; nickel alloy; pressure retaining

ANNEX

(Mandatory Information)

A1. ACCEPTANCE CRITERIA FOR INCLUSION OF NEW IRON-NICKEL-CHROMIUM AND NICKEL ALLOYS IN THIS SPECIFICATION

A1.1 Specifications **A351/A351M**, **A494/A494M**, **A743/A743M**, and **A744/A744M** contain alloys similar to those listed in this specification. The distinguishing requirements of this specification are as follows.

A1.1.1 One of four classes of alloys all with 0.015 % S max.

A1.1.1.1 Nickel base with 15 % Cr min, 8 % Mo min, and 0.020 % C max.

A1.1.1.2 Nickel base with 25–35 % Cu and 0.020 % C min.

A1.1.1.3 Nickel base with 25–35 % Mo and 0.020 % C max.

A1.1.1.4 Iron base, fully-austenitic, with 18 % Cr min, 17 % Ni min, 2–8 % Mo, and 0.030 % C max.

A1.1.2 AOD or VOD refined material, no revert except nickel base with 25 to 35 % Cu and 0.020 % C min.

A1.1.3 Weld bend test every heat in the as-welded condition.

A1.1.4 Levels of NDE with combinations of visual, LP, and radiography with acceptance criteria.

A1.1.5 Restricted heat treat requirements for improved corrosion resistance, solution heat treat after all major weld repairs. With 250°F (121°C) max interpass temperature, solution heat treat is not required for minor repairs.

A1.1.6 Specified weld filler material.

A1.2 To be considered for inclusion in this specification, the following data must be presented to Subcommittee A01.18.

A1.2.1 Demonstrate that all heats in the data package passed the weld bend test in the as-welded condition as directed in **Section 9**.

A1.2.2 The alloy shall fall within one of the four classes of materials listed in **A1.1.1.1 – A1.1.1.4** and meet the restricted compositional limits.



SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this standard since the last issue (A990 – 14) that may impact the use of this standard. (Approved Oct. 1, 2014.)

(1) Changed the elongation significant digit values from 0.1 % to 1 % in Table 3.

Committee A01 has identified the location of selected changes to this standard since the last issue (A990 – 11) that may impact the use of this standard. (Approved May 1, 2014.)

(1) Removed A370 and A941 from Paragraph 2, Referenced Documents.

(2) Deleted Paragraph 3.1 and renumbered the following Paragraphs.

(3) Changed the tensile strength units in Table 3 from psi to ksi.

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