

# AEROSPACE MATERIAL SPECIFICATION

Submitted for recognition as an American National Standard

## Plating, Brush, Nickel Low Stress, Low-Hardness Deposit

### 1. SCOPE:

#### 1.1 Purpose:

This specification covers the engineering requirements and process controls for selective plating of low-hardness, low-stress nickel by electrodeposition. It should be used, in conjunction with AMS 2451, for heat-resistant and corrosion-resistant nickel deposits.

#### 1.2 Application:

This process has been used typically to provide moderate corrosion and oxidation resistance and to repair damaged, worn, or mismachined parts requiring low residual surface stress, and service at temperatures up to 700 °F (371 °C) but is not limited to such applications.

#### 1.3 Safety - Hazardous Materials:

See AMS 2451.

### 2. APPLICABLE DOCUMENTS:

See AMS 2451.

### 3. TECHNICAL REQUIREMENTS:

The requirements of AMS 2451 shall apply as herein amended.

#### 3.1 Procedure:

3.1.1 Nickel shall be electrodeposited from a sulfamate nickel brush plating solution containing no addition or stress-reducing agents in accordance with instructions from the solution manufacturer.

#### 3.2 Properties:

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