



# AEROSPACE MATERIAL

## Society of Automotive Engineers, Inc. SPECIFICATION

400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

# AMS 4068

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Revised

UNS A92219

ALUMINUM ALLOY TUBING, SEAMLESS, DRAWN  
6.3Cu - 0.30Mn - 0.18Zr - 0.10V - 0.06Ti (2219-T351)

### 1. SCOPE:

- 1.1 Form: This specification covers an aluminum alloy in the form of seamless, drawn, round tubing 0.500 in. (12.70 mm) and over in OD with wall thickness of 0.029 - 0.500 in. (0.74 - 12.70 mm).
- 1.2 Application: Primarily for structures requiring good fusion weldability and a combination of good strength and resistance to stress-corrosion cracking after precipitation heat treatment.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

- 2.1 SAE Publications: Available from Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2203 - Tolerances, Aluminum Alloy Drawn Tubing

AMS 2350 - Standards and Test Methods

AMS 2355 - Quality Assurance Sampling and Testing of Aluminum-Base and Magnesium-Base Alloys, Wrought Products (Except Forgings and Forging Stock) and Flash Welded Rings

- 2.2 Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.2.1 Military Specifications:

MIL-H-6088 - Heat Treatment of Aluminum Alloys

2.2.2 Military Standards:

MIL-STD-649 - Aluminum and Magnesium Products, Preparation for Shipment and Storage

### 3. TECHNICAL REQUIREMENTS:

SAE Technical Board rules provide that: "All technical reports, including standards and practices recommended, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no agreement to adhere to any SAE standard or recommended practice, and no commitment to conform to or be guided by any technical report. In formulating and approving technical reports, the Board and its Committees will not investigate or consider patents which may apply to the subject matter. Prospective users of the report are responsible for protecting themselves against liability for infringement of patents."

3.1 Composition: Shall conform to the following percentages by weight, determined in accordance with AMS 2355:

	min	max
Copper	5.8	6.8
Manganese	0.20	0.40
Zirconium	0.10	0.25
Vanadium	0.05	0.15
Titanium	0.02	0.10
Iron	--	0.30
Silicon	--	0.20
Zinc	--	0.10
Magnesium	--	0.02
Other Impurities, each	--	0.05
Other Impurities, total	--	0.15
Aluminum	remainder	

3.2 Condition: Solution heat treated and stress relieved by stretching to produce a permanent set of 1/2 - 3%; solution heat treatment shall be performed in accordance with MIL-H-6088.

3.3 Properties: Tubing shall conform to the following requirements, determined in accordance with AMS 2355:

3.3.1 Tensile Properties:

3.3.1.1 As Solution Heat Treated and Stress-Relieved: Shall be as specified in Table I:

**TABLE I**

Nominal Wall Thickness Inch	Tensile Strength psi, min	Yield Strength at 0.2% Offset psi, min	Elongation in 2 in. %, min	
			Strip	Full Section
0.029 to 0.049, incl	45,000	26,000	--	12
Over 0.049 to 0.500, incl	45,000	26,000	12	14

**TABLE I (SI)**

Nominal Wall Thickness Millimetres	Tensile Strength MPa, min	Yield Strength at 0.2% Offset MPa, min	Elongation in 50.8 mm %, min	
			Strip	Full Section
0.74 to 1.24, incl	310	179	--	12
Over 1.24 to 12.70, incl	310	179	12	14

3.3.2 After Precipitation Heat Treatment: Tubing precipitation heat treated in accordance with MIL-H-6088 shall have properties as specified in Table II:

TABLE II

Nominal Wall Thickness Inch	Tensile Strength psi, min	Yield Strength at 0.2% Offset psi, min	Elongation in 2 in. %, min	
			Strip	Full Section
0.029 to 0.049, incl	60,000	42,000	--	6
Over 0.049 to 0.500, incl	60,000	42,000	6	8

TABLE II (SI)

Nominal Wall Thickness Millimetres	Tensile Strength MPa, min	Yield Strength at 0.2% Offset MPa, min	Elongation in 50.8 mm %, min	
			Strip	Full Section
0.74 to 1.24, incl	414	290	--	6
Over 1.24 to 12.70, incl	414	290	6	8

3.4 Quality: Tubing, as received by the purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from internal and external imperfections detrimental to usage of the tubing.

3.5 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of AMS 2203.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of tubing shall supply all samples and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.4. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to ensure that the tubing conforms to the requirements of this specification.

4.2 Classification of Tests: Tests to determine conformance to all technical requirements of this specification are classified as acceptance tests.

4.3 Sampling: Shall be in accordance with AMS 2355.

4.4 Reports:

4.4.1 The vendor of tubing shall furnish with each shipment three copies of a report stating that the tubing conforms to the chemical composition and other technical requirements of this specification. This report shall include the purchase order number, material specification number, size, and quantity.

4.4.2 The vendor of finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, material specification number, contractor or other direct supplier of tubing, part number, and quantity. When tubing for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of tubing to determine conformance to the requirements of this specification, and shall include in the report a statement that the tubing conforms, or shall include copies of laboratory reports showing the results of tests to determine conformance.

4.5 Resampling and Retesting: Shall be in accordance with AMS 2355.