

ALUMINUM ALLOY EXTRUSIONS AND RINGS
1.0Mg - 0.60Si - 0.28Cu - 0.20Cr (6061-T6)
Solution and Precipitation Heat Treated

UNS A96061

1. SCOPE:

1.1 Form: This specification covers an aluminum alloy in the form of extruded bars, rods, wire, shapes, and tubing, flash welded rings fabricated from extruded stock, and stock for flash welded rings.

1.2 Application: Primarily for parts requiring moderate strength, especially where such parts require brazing or welding during fabrication.

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

2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2205 - Tolerances, Aluminum Alloy and Magnesium Alloy Extrusions

MAM 2205 - Tolerances, Metric, Aluminum Alloy and Magnesium Alloy Extrusions

AMS 2350 - Standards and Test Methods

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

MAM 2355 - Quality Assurance Sampling and Testing of Aluminum Alloys and Magnesium Alloys, Wrought Products (Except Forging Stock) and Flash Welded Rings, Metric (SI) Units

AMS 2770 - Heat Treatment of Aluminum Alloy Parts

AMS 7488 - Rings, Flash Welded, Aluminum and Aluminum Alloys

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

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

	min	max
Magnesium	0.8	1.2
Silicon	0.40	0.8
Copper	0.15	0.40
Chromium	0.04	0.35
Iron	--	0.7
Zinc	--	0.25
Manganese	--	0.15
Titanium	--	0.15
Other Impurities, each	--	0.05
Other Impurities, total	--	0.15
Aluminum	remainder	

3.2 Condition: The product shall be supplied in the following condition:3.2.1 Bars, Rods, Wire, Shapes, and Tubing: Extruded and solution and precipitation heat treated in accordance with MIL-H-6088.

3.2.1.1 Extrusions shall be supplied with an as-extruded surface finish; light polishing to remove minor surface imperfections is permissible provided such imperfections can be removed within the dimensional tolerances.

3.2.2 Flash Welded Rings: Manufactured in accordance with AMS 7488 from extruded stock and solution and precipitation heat treated in accordance with AMS 2770.3.2.3 Stock for Flash Welded Rings: As ordered by the flash welded ring manufacturer.3.3 Properties: The product shall conform to the following requirements, determined in accordance with AMS 2355 or MAM 2355:3.3.1 Bars, Rods, Wire, Shapes, Tubing, and Flash Welded Rings:

3.3.1.1 Tensile Properties: Shall be as specified in Table I.

TABLE I

Nominal Diameter or Least Thickness (See 8.2) (bars, rods, wire, shapes, and flash welded rings) or Nominal Wall Thickness (tubing) Inches	Tensile Strength psi, min	Yield Strength at 0.2% Offset psi, min	Elongation in 2 in. or 4D %, min
Up to 0.250, excl	38,000	35,000	8
0.250 and over	38,000	35,000	10

TABLE I (SI)

Nominal Diameter or Least Thickness (See 8.2) (bars, rods, wire, shapes, and flash welded rings) or Nominal Wall Thickness (tubing) Millimetres	Tensile Strength MPa, min	Yield Strength at 0.2% Offset MPa, min	Elongation in 50 mm or 4D %, min
Up to 6.25, excl	260	240	8
6.25 and over	260	240	10

3.3.1.2 Hardness: Should be not lower than 80 HB/10/500 or 85 HB/10/1000 but the product shall not be rejected on the basis of hardness if the tensile property requirements are met.

3.3.2 Stock for Flash Welded Rings: Specimens taken from the stock after solution and precipitation heat treatment in accordance with AMS 2770 shall conform to the requirements of 3.3.1.1 and 3.3.1.2.

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

3.5 Tolerances: Bars, rods, wire, shapes, and tubing shall conform to all applicable requirements of AMS 2205 or MAM 2205.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of the product shall supply all samples for vendor's tests 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 sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to the requirements of this specification.

4.2 Classification of Tests:

- 4.2.1 Acceptance Tests: Tests to determine conformance to requirements for composition (3.1) and tensile properties (3.3.1.1) and of bars, rods, wire, shapes, and tubing to determine conformance to tolerance (3.5) requirements are classified as acceptance tests and shall be performed on each lot.
- 4.2.2 Periodic Tests: Tests to determine conformance to requirements for hardness (3.3.1.2) are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

4.3 Sampling: Shall be in accordance with AMS 2355 or MAM 2355.

4.4 Reports:

- 4.4.1 The vendor of extruded bars, rods, wire, shapes, and tubing shall furnish with each shipment a report stating that the extrusions conform to the chemical composition and other technical requirements of this specification. This report shall include the purchase order number, AMS 4150H, size or section identification number, and quantity.
- 4.4.2 The vendor of flash welded rings and other finished or semi-finished parts shall furnish with each shipment a report showing the purchase order number, AMS 4150H, contractor or other direct supplier of extrusions, part number, and quantity. When extrusions for making parts are produced or purchased by the parts vendor, that vendor shall inspect each lot of extrusions to determine conformance to the requirements of this specification and shall include in the report either a statement that the extrusions conform or copies of laboratory reports showing the results of tests to determine conformance.

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

5. PREPARATION FOR DELIVERY:

5.1 Identification: The product shall be identified as follows:

- 5.1.1 Each straight extruded bar, rod, and tube 0.500 in. (12.50 mm) and over in nominal OD or least width of flat surface and each straight shape with configuration allowing access to a flat surface at least 0.500 in. (12.50 mm) wide recessed not more than 1/8 in. (3 mm) below the outline of the shape shall be marked in a row of characters recurring at intervals not greater than 3 ft (900 mm) with the alloy number and temper, AMS 4150 or applicable Federal specification designation, and manufacturer's identification. The characters shall be of such size as to be legible, shall be applied using a suitable marking fluid, and shall be sufficiently stable to withstand normal handling. The markings shall have no deleterious effect on the extrusions or their performance.