

Titanium Alloy Cold Rolled Sheet and Strip  
15V - 3Al - 3Cr - 3Sn  
Solution Heat Treated

1. SCOPE:

1.1 Form:

This specification covers a titanium alloy in the form of sheet and strip.

1.2 Application:

These products have been used typically for parts to be formed in the solution heat treated condition and subsequently precipitation heat treated requiring high strength-to-weight ratio and stability up to 550 °F (288 °C) in the precipitation heat treated condition, but usage is not limited to such applications.

2. APPLICABLE DOCUMENTS:

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been canceled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001 or [www.sae.org](http://www.sae.org).

AMS 2242	Tolerances, Corrosion and Heat Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Sheet, Strip, and Plate
AMS 2249	Chemical Check Analysis Limits, Titanium and Titanium Alloys
AMS 2750	Pyrometry
AMS 2801	Heat Treatment of Titanium Alloy Parts
AMS 2809	Identification, Titanium and Titanium Alloy Wrought Products

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

Copyright © 2003 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)  
Tel: 724-776-4970 (outside USA)  
Fax: 724-776-0790  
Email: [custsvc@sae.org](mailto:custsvc@sae.org)  
SAE WEB ADDRESS: <http://www.sae.org>

## 2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or [www.astm.org](http://www.astm.org).

ASTM E 8	Tension Testing of Metallic Materials
ASTM E 8M	Tension Testing of Metallic Materials (Metric)
ASTM E 112	Determining Average Grain Size
ASTM E 120	Chemical Analysis of Titanium and Titanium Alloys
ASTM E 290	Bend Testing of Material for Ductility
ASTM E 1409	Determination of Oxygen in Titanium and Titanium Alloys by the Inert Gas Fusion Technique
ASTM E 1447	Determination of Hydrogen in Titanium and Titanium Alloys by the Inert Gas Fusion Thermal Conductivity Method

## 3. TECHNICAL REQUIREMENTS:

## 3.1 Composition:

Shall conform to the percentages by weight shown in Table 1; oxygen shall be determined in accordance with ASTM E 1409, hydrogen in accordance with ASTM E 1447, and other elements in accordance with ASTM E 120, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - Composition

Element	min	max
Vanadium	14.0	16.0
Chromium	2.5	3.5
Tin	2.5	3.5
Aluminum	2.5	3.5
Iron	--	0.25
Oxygen	--	0.13
Carbon	--	0.05
Nitrogen	--	0.05 (500 ppm)
Hydrogen	--	0.015 (150 ppm)
Residual Elements, each (3.1.1)	--	0.10
Residual Elements, total (3.1.1)	--	0.40
Titanium	remainder	

3.1.1 Determination not required for routine acceptance.

3.1.2 Check Analysis: Composition variations shall meet the requirements of AMS 2249.

3.1.3 Sample size when using ASTM E 1447 for hydrogen may be as large as 0.35 gram.

## 3.2 Melting Practice:

3.2.1 Alloy shall be multiple melted. Melting cycle(s) prior to the final melting cycle shall be made using vacuum consumable electrode, nonconsumable electrode, electron beam cold hearth, or plasma arc cold hearth melting practice. The final melting cycle shall be made under vacuum using vacuum arc remelting (VAR) practice with no alloy additions permitted.

3.2.1.1 The atmosphere for nonconsumable electrode melting shall be vacuum or shall be argon and/or helium at an absolute pressure not higher than 1000 mm of mercury.

3.2.1.2 The electrode tip for nonconsumable electrode melting shall be water-cooled copper.

## 3.3 Condition:

Hot rolled with subsequent cold reduction, solution heat treated, descaled, and leveled, having a surface appearance comparable to a commercial corrosion-resistant steel No. 2D finish (See 8.2).

## 3.4 Heat Treatment:

Product shall be solution heat treated by heating to a temperature within the range 1450 to 1500 °F (788 to 816 °C), holding at the selected temperature within  $\pm 25$  °F ( $\pm 14$  °C) for 3 to 30 minutes, and cooling at a rate which will produce product meeting the requirements of 3.5 (See 8.3). Pyrometry shall be in accordance with AMS 2750.

## 3.5 Properties:

The product shall conform to the following requirements:

## 3.5.1 As Solution Heat Treated:

3.5.1.1 Tensile Properties: Shall be as shown in Table 2 for product 0.125 inch (3.18 mm) and under in nominal thickness, determined in accordance with ASTM E 8 or ASTM E 8M with the rate of strain maintained at 0.003 to 0.007 inch/inch/minute (0.003 to 0.007 mm/mm/minute) through the yield strength and then increased so as to produce failure in approximately one additional minute. When a dispute occurs between purchaser and vendor over the yield strength values, a referee test shall be performed on a machine having a strain rate pacer, using a rate of 0.005 inch/inch/minute (0.005 mm/mm/minute) through the yield strength and a minimum crosshead speed of 0.10 inch (2.5 mm) per minute above the yield strength.

TABLE 2 - Tensile Properties

Property	Value
Tensile Strength	102 to 137 ksi (703 to 945 MPa)
Yield Strength at 0.2% Offset	100 to 126 ksi (689 to 869 MPa)
Elongation in 2 Inches (50.8 mm) or 4D	12% minimum

- 3.5.1.2 Bending: Product 0.125 inch (3.18 mm) and under in nominal thickness, shall have a test sample prepared nominally 0.750 inch (19.06 mm) in width, with its axis of bending parallel to the direction of rolling. The sample shall be bend tested in accordance with the guided bend test defined in ASTM E 290 through an angle of 105 degrees. The test fixture supports shall have a contact radius 0.010 inch (0.25 mm) minimum, and the plunger shall have a radius equal to the bend factor shown in Table 3 times the nominal thickness. Examination of the bent sample shall show no evidence of cracking when examined at 15 to 25X magnification.

TABLE 3 - Bending

Nominal Thickness Inch	Nominal Thickness Millimeters	Bend Factor
Up to 0.070, incl	Up to 1.78, incl	4
Over 0.070 to 0.125, incl	Over 1.78 to 3.18, incl	5

- 3.5.1.3 Surface Contamination: The product shall be free of any oxygen-rich layer, such as alpha case, or other surface contamination, determined by the bend test of 3.5.1.2 or other method acceptable to purchaser.

- 3.5.2 After Precipitation Heat Treatment: Performed in accordance with AMS 2801.

- 3.5.2.1 Tensile Properties: Shall be as shown in Tables 4 and 5 for product 0.125 inch (0.32 mm) and under in nominal thickness, determined in accordance with ASTM E 8 or ASTM E 8M with the rate of strain maintained at 0.003 to 0.007 inch/inch/minute (0.003 to 0.007 mm/mm/minute) through the yield strength and then increased so as to produce failure in approximately one additional minute. When a dispute occurs between purchaser and vendor over the yield strength values, a referee test shall be performed on a machine having a strain rate pacer, using a rate of 0.005 inch/inch/minute (0.005 mm/mm/minute) through the yield strength and a minimum cross head speed of 0.10 inch (2.5 mm) per minute above the yield strength. Properties shall be verified for each precipitation heat treatment condition.

TABLE 4 - Minimum Tensile Properties

After precipitation heat treatment in accordance with AMS 2801.

Property	Value
Tensile Strength	145 ksi (1000 MPa)
Yield Strength at 0.2% Offset	140 ksi ( 965 MPa)
Elongation in 2 Inches (50.8 mm) or 4D	7%

TABLE 5 - Minimum Tensile Properties

After heating to 900 °F ± 10 (482 °C ± 6), holding at heat for 16 hours ± 0.5, and cooling in air:

Property	Value
Tensile Strength	180 ksi (1241 MPa)
Yield Strength at 0.2% Offset	170 ksi (1172 MPa)
Elongation in 2 Inches (50.8 mm) or 4D	5%

3.5.2.2 Grain Size: Shall be predominantly 6 or finer with occasional grains as large as 2 permissible, determined by comparison of a polished and etched specimen with the chart in ASTM E 112.

### 3.6 Quality:

The product, as received by purchaser, shall be uniform in quality and condition, sound, and free from "oil cans" (See 8.4) of depth in excess of the flatness tolerances, ripples, and foreign materials and from imperfections detrimental to usage of the product.

### 3.7 Tolerances:

Shall conform to all applicable requirements of AMS 2242.

## 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 the performance of all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to the specified requirements.

### 4.2 Classification of Tests:

All technical requirements are acceptance tests and shall be performed on each heat or lot as applicable.

### 4.3 Sampling and Testing:

Shall be in accordance with the following; a lot shall be all product of the same nominal size from the same heat processed at the same time and in the same heat treatment batch.

4.3.1 Composition: One sample from each heat, except that for hydrogen determinations one sample from each lot obtained after thermal and chemical processing is completed.