

Titanium Alloy Sheet, Strip, and Plate  
6Al - 6V - 2Sn  
Solution Heat Treated and Aged

(Composition Similar to UNS R56620)

**RATIONALE**

AMS4990A results from a Five Year Review and update of this specification.

**1. SCOPE**

**1.1 Form**

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

**1.2 Application**

This material is typically used for parts requiring high strength-to-weight ratio and stability up to 550 °F (288 °C), but usage is not limited to such applications.

1.2.1 Certain processing procedures and service conditions may cause these products to become subject to stress-corrosion cracking; ARP982 recommends practices to minimize such conditions.

**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 cancelled and no superseding document has been specified, the last published issue of that document shall apply.

**2.1 SAE Publications**

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), [www.sae.org](http://www.sae.org).

- AMS2242 Tolerances, Corrosion and Heat Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Sheet, Strip, and Plate
- AMS2249 Chemical Check Analysis Limits, Titanium and Titanium Alloys
- AMS2631 Ultrasonic Inspection, Titanium and Titanium Alloy Bar and Billet
- AMS2750 Pyrometry
- AMS2809 Identification, Titanium and Titanium Alloy Wrought Products
  
- ARP982 Minimizing Stress-Corrosion Cracking in Wrought Titanium Alloy Products

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## 2.2 ASTM Publications

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM E 8 / E 8M	Tension Testing of Metallic Materials
ASTM E 112	Determining Average Grain Size
ASTM E 290	Bend Testing of Material for Ductility
ASTM E 384	Microindentation Hardness of Materials
ASTM E 1409	Determination of Oxygen and Nitrogen 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/Infrared Detection Method
ASTM E 1941	Determination of Carbon in Refractory and Reactive Metals and Their Alloys
ASTM E 2371	Analysis of Titanium and Titanium Alloys by Atomic Emission Plasma Spectrometry

## 3. TECHNICAL REQUIREMENTS

### 3.1 Composition

Shall conform to the percentages by weight shown in Table 1; carbon shall be determined in accordance with ASTM E 1941, hydrogen in accordance with ASTM E 1447, oxygen and nitrogen in accordance with ASTM E 1409, and other elements in accordance with ASTM E 2371. Other analytical methods may be used if acceptable to the purchaser.

TABLE 1 - COMPOSITION

Element	min	max
Aluminum	5.00	6.00
Vanadium	5.00	6.00
Tin	1.50	2.50
Iron	0.35	1.00
Copper	0.35	1.00
Oxygen	--	0.20
Carbon	--	0.05
Nitrogen	--	0.04 (400 ppm)
Hydrogen	--	0.015 (150 ppm)
Yttrium (3.1.1)	--	0.005 ( 50 ppm)
Other Elements, each (3.1.1)	--	0.10
Other 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 applicable requirements of AMS2249.

3.1.3 Sample size, when using ASTM E 1447, 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(s). The final melting cycle shall be made under vacuum using vacuum arc remelting (VAR) practice with no alloy additions.

3.2.1.1 The atmosphere for non-consumable 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

The product shall be supplied in the following condition:

#### 3.3.1 Sheet and Strip

Hot rolled, with or without subsequent cold reduction, solution heat treated, descaled, leveled, and precipitation hardened, having a surface appearance comparable to a commercial corrosion-resistant steel No. 2D finish (See 8.3).

#### 3.3.2 Plate

Hot rolled, solution heat treated, flattened, and aged, having a surface appearance comparable to a commercial corrosion-resistant steel No. 1 finish (See 8.3). Plate product shall be produced using standard industry practices designed strictly for the production of plate stock to the procured thickness. Bar, billet, extrusions, forgings, or forging stock shall not be supplied in lieu of plate.

### 3.4 Heat Treatment

The product shall be solution heat treated by heating to a temperature 1550 to 1700 °F (843 to 927 °C) holding at the selected temperature within  $\pm 25$  °F ( $\pm 14$  °C) for 2 to 60 minutes, and cooling at a rate equivalent to an air cool or faster and aged by heating to 875 to 1150 °F  $\pm 15$  (468 to 621 °C  $\pm 8$ ), holding at heat for 2 to 10 hours, and cooling in air. Pyrometry shall be in accordance with AMS2750.

### 3.5 Properties

Product shall conform to the following requirements:

#### 3.5.1 Tensile Properties

Shall be as specified in Table 2, determined in accordance with ASTM E 8 / E 8M with the rate of strain set at 0.005 inch/inch/minute (0.005 mm/mm/minute) and maintained within a tolerance of  $\pm 0.002$  inch/inch/minute (0.002 mm/mm/minute) through the 0.2% offset yield strain

TABLE 2A MINIMUM TENSILE PROPERTIES (SEE 8.2)

Nominal Thickness Inches	Tensile Strength ksi	Yield Strength at 0.2% Offset ksi	Elongation in 2 inches or 4D %
Up to 0.1875, excl	170	160	8 (6) (3.5.1.1)
0.1875 to 1.500, excl	170	160	8
1.500 to 2.500, excl	160	150	6
2.500 to 4.000, excl	150	140	6

TABLE 2B - MINIMUM TENSILE PROPERTIES, SI UNITS (SEE 8.2)

Nominal Thickness Millimeters	Tensile Strength MPa	Yield Strength at 0.2% Offset MPa	Elongation in 50.8 mm or 4D %
Up to 4.76, excl	1172	1103	8 (6) (3.5.1.1)
4.76 to 38.10, excl	1172	1103	8
38.10 to 63.50, excl	1103	1034	6
63.50 to 101.60, excl	1034	965	6

3.5.1.1 Elongation value in parentheses is for transverse direction only.

### 3.5.2 Microstructure

Shall be that structure resulting from processing within the alpha-beta phase field. Microstructure shall conform to 3.5.2.1 or 3.5.2.2 (See 8.5).

3.5.2.1 Equiaxed and/or elongated primary alpha in a transformed beta matrix with no continuous network of alpha at prior beta grain boundaries.

3.5.2.2 Essentially complete field of equiaxed and/or elongated alpha with or without intergranular beta and with no continuous network of alpha at prior beta grain boundaries.

3.5.2.3 A microstructure showing a continuous network of alpha in prior beta grain boundaries is not acceptable.

### 3.5.3 Surface Contamination

The product shall be free of any oxygen-rich layer, such as alpha case, or other surface contamination, determined as in 3.5.3.1 or 3.5.3.2, or other method acceptable to purchaser.

3.5.3.1 Microscopic examination at 400X minimum.

3.5.3.2 Hardness difference; a surface hardness more than 40 points higher than the subsurface hardness, determined in accordance with ASTM E 384 on the Knoop scale using a 200 gram load, being evidence of unacceptable surface contamination.

### 3.5.4 Average Grain Size

Shall be ASTM No. 6 or finer 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.

#### 3.6.1 Ultrasonic Inspection

Plate 0.500 to 4.000 inch (12.70 to 101.60 mm) incl in nominal thickness shall meet Class A1 requirements of AMS2631.

### 3.7 Tolerances

Shall conform to all applicable requirements of AMS2242.

## 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 specified requirements.

### 4.2 Classification of Tests

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