SAE Aerospace
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AEROSPACE MATERIAL SPECIFICATION

SAE AMS5035 REV. B

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Superseding AMS5035A

Steel, Welding Wire
0.65Si - 1.25Cr - 0.50Mo - 0.30V (0.28 - 0.33C)

(Composition similar to UNS K23015)

RATIONALE

AMS5035B results from a Five Year Review and update of this specification that corrects the SI units in 3.4.2.1.

1. SCOPE

1.1 Form

This specification covers a low-alloy steel in the form of welding wire.

1.2 Application

This wire has been used typically as filler metal for gas-tungsten-arc and gas-metal-arc welding of low-alloy steels of similar composition where the weld area is required to have strength comparable to that of the parent metal, but usage is not limited to such applications.

1.3 Classification

Wire shall be classified as follows:

Type 1 - Bare Wire
Type 2 - Copper Coated

Type 1 shall be supplied unless Type 2 is specified.

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.

TO PLACE A DOCUMENT ORDER:
Tel: 877-606-7323 (inside USA and Canada)
Tel: +1 724-776-4970 (outside USA)
Fax: 724-776-0790
Email: CustomerService@sae.org
SAE WEB ADDRESS: http://www.sae.org

SAE values your input. To provide feedback on this Technical Report, please visit
http://www.sae.org/technical/standards/AMS5035B

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), or www.sae.org.

AMS2259	Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
AMS2370	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Wrought Products and Forging Stock
AMS2813	Packaging and Marking of Packages of Welding Wire, Standard Method
AMS2814	Packaging and Marking of Packages of Welding Wire, Premium Quality
AMS2816	Identification, Welding Wire, Tab Marking Method
AMS2819	Identification, Welding Wire, Direct Color Code System
ARP1876	Weldability Test for Weld Filler Metal Wire
ARP4926	Alloy Verification and Chemical Composition Inspection of Welding Wire

2.2 ASTM Publications

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19248-2959, Tel: 610-832-9585, or www.astm.org.

ASTM E 350	Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

3. TECHNICAL REQUIREMENTS

3.1 Composition

Wire shall conform to the percentages by weight shown in Table 1, determined by wet chemical methods in accordance with ASTM E 350, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - COMPOSITION

Element	min	max
Carbon (3.1.2)	0.28	0.33
Manganese	0.45	0.65
Silicon	0.55	0.75
Phosphorus	--	0.008
Sulfur	--	0.008
Chromium	1.15	1.35
Molybdenum	0.40	0.60
Vanadium	0.20	0.40
Nickel	--	0.25
Copper (3.1.2)	--	0.35

3.1.1 Check Analysis

Composition variations shall meet the applicable requirements of AMS2259.

3.1.2 Shall be determined on finished wire for carbon, and on finished wire for copper if wire is supplied copper clad.

3.1.3 Chemical analysis of initial ingot, bar, or rod stock before drawing, other than those analyses required to be done on the finished wire, is acceptable provided the processes used for drawing or rolling, annealing, and cleaning are controlled to ensure continued conformance to requirements.

3.2 Condition

Cold worked, bright finish, in a temper and with a surface finish that will provide proper feeding of the wire in machine welding equipment.

3.3 Fabrication

3.3.1 Wire shall be formed from rod or bar descaled by a process that does not affect the composition of the wire.

3.3.2 Drawing compounds, oxides, dirt, oil, and other foreign materials shall be removed by cleaning processes that will neither result in pitting nor cause gas absorption by the wire or deposition of substances harmful to welding operations.

3.3.3 In-process annealing, if required, between cold rolling or drawing operations, shall be performed in vacuum or protective atmosphere to avoid surface oxidation and absorption of other extraneous elements.

3.3.4 Butt welding is permissible provided both ends to be joined are either alloy verified using a method or methods capable of distinguishing the alloy from all others processed in the facility, or the repair is made at the wire processing station. The butt weld shall not interfere with uniform, uninterrupted feeding of the wire in machine welding equipment.

3.3.5 Residual elements and dissolved gases picked up during wire processing that can adversely affect the welding characteristics, the operation of the equipment, or the properties of the weld metal, shall be removed.

3.3.6 When Type 2 copper coated wire is specified, the copper coating shall be clean, bright, and uniform in appearance. A maximum of four discontinuities in the coating in any 36-inch (914-mm) length are acceptable provided the exposed wire is clean and bright. The maximum allowable discontinuity size shall be 0.25 inch (6.25 mm) in length. The thickness of the copper coating shall not exceed 0.0005 inch (0.0127 mm) on the diameter.

3.4 Properties

Wire shall conform to the following requirements:

3.4.1 Weldability

Melted wire shall flow smoothly and evenly during welding and shall produce acceptable welds. ARP1876 may be used to resolve disputes.

3.4.2 Spooled Wire

Shall conform to 3.4.2.1 and 3.4.2.2.

3.4.2.1 Cast

Wire, wound on standard 12-inch (305-mm) diameter spools, shall have imparted to it a curvature such that a specimen sufficient in length to form one loop with a 1-inch (25-mm) overlap, when cut from the spool and laid on a flat surface, shall form a circle 15 to 50 inches (381 to 1270 mm) in diameter.

3.4.2.2 Helix

The specimen on which cast was determined, when laid on a flat surface and measured between adjacent turns, shall show a vertical separation not greater than 1 inch (25 mm).

3.5 Quality

Wire, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to welding operations, operation of welding equipment, or properties of the deposited weld metal.

3.6 Sizes and Tolerances

Wire shall be supplied in the standard sizes and to the tolerances shown in 3.6.1 and 3.6.2.

3.6.1 Diameter

Shall be as shown in Table 2.

TABLE 2A - SIZES AND DIAMETER TOLERANCES, INCH/POUND UNITS

Form	Nominal Diameter Inch	Tolerance Inch plus/minus
Cut Lengths	0.030, 0.045	0.001
Cut Lengths	0.062, 0.078, 0.094, 0.125, 0.156, 0.188	0.002
Spools	0.007, 0.010, 0.015,	0.0005
Spools	0.020, 0.030, 0.035, 0.045	0.001
Spools	0.062, 0.078, 0.094	0.002

TABLE 2B - SIZES AND DIAMETER TOLERANCES, SI UNITS

Form	Nominal Diameter Millimeters	Tolerance Millimeter plus/minus
Cut Lengths	0.76, 1.14	0.025
Cut Lengths	1.57, 1.98, 2.39, 3.18, 3.96, 4.78	0.05
Spools	0.18, 0.25, 0.38,	0.013
Spools	0.51, 0.76, 0.89, 1.14	0.025
Spools	1.57, 1.98, 2.39	0.05

3.6.2 Length

Cut lengths shall be furnished in 18, 27, or 36-inch (457, 686, or 914-mm) lengths, as ordered, and shall not vary more than +0, -0.5 inch (+0, -13 mm) from the length ordered.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

The vendor of wire 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 wire conforms to specified requirements.

4.2 Classification of Tests

4.2.1 Acceptance Tests

Composition (3.1), sizes and tolerances (3.6), and alloy verification (5.2) are acceptance tests and shall be performed on each heat or lot as applicable.