AEROSPACE MATERIAL SPECIFICATION

AMS5353	REV. E

Issued 1957-09
Revised 2014-02
Reaffirmed 2015-04

Superseding AMS5353D

Steel, Corrosion-Resistant, Investment Castings
16Cr - 1.8Ni - 0.08N
As Cast
(Composition similar to UNS J91651)

RATIONALE

AMS5353E has been reaffirmed to comply with the SAE five-year review policy.

1. SCOPE

1.1 Form

This specification covers a corrosion-resistant steel in the form of investment castings.

1.2 Application

These castings have been used typically for small parts, such as rotors, requiring moderate corrosion resistance and strength up to 800 °F (427 °C), 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 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.

AMS2175 Castings, Classification and Inspection of

AMS2248 Chemical Check Analysis Limits, Corrosion and Heat-Resistant Steels and Alloys, Maraging and Other Highly-Alloyed Steels, and Iron Alloys

AMS2360 Room Temperature Tensile Properties of Castings

AMS2694 In-Process Welding of Castings

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/AMS5353E

AMS2700 Passivation of Corrosion Resistant Steels

AMS2804 Identification, Castings

AMS-H-6875 Heat Treatment of Steel Raw Materials

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 E18 Rockwell Hardness of Metallic Materials

ASTM E353 Chemical Analysis of Stainless, Heat Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

ASTM E1417 Liquid Penetrant Testing

ASTM E1444 Magnetic Particle Testing

ASTM E1742 Radiographic Examination

3. TECHNICAL REQUIREMENTS

3.1 Composition

Shall conform to the percentages by weight shown in Table 1, determined by wet chemical methods in accordance with ASTM E353, by spectrochemical methods, or by other analytical methods acceptable to purchaser (See 8.2.1 and 8.2.2).

TABLE 1 - COMPOSITION

Element	min	max
Carbon	0.08	0.15
Manganese	--	1.00
Silicon	--	1.00
Phosphorus	--	0.04
Sulfur	--	0.04
Chromium	15.00	17.00
Nickel	1.50	2.20
Nitrogen	0.03	0.12
Carbon + Nitrogen	--	0.22
Molybdenum	--	0.50
Copper	--	0.50

3.1.1 Vendor may test for any element not otherwise listed in Table 1 and include this analysis in the report of 4.5. Limits of acceptability may be specified by purchaser (See 8.2.3).

3.1.2 Check Analysis

Composition variations shall meet the applicable requirements of AMS2248.

3.2 Melting Practice

Castings and specimens shall be poured at casting vendor's facility either from a melt (See 8.2.4) of a master heat, or directly from a master heat (See 3.4.2 and 8.2.5).

3.2.1 Revert (gates, sprues, risers, and rejected castings) may be used only in the preparation of master heats; revert shall not be remelted directly without refining for pouring of castings. Melting of revert creates a new master heat.

3.2.2 Portions of two or more qualified master heats (See 3.4.2) may be melted together and poured into castings using a procedure authorized by purchaser (See 8.2.6).

3.2.3 If melts are modified by replenishment (See 8.2.7), vendor shall have a written procedure acceptable to purchaser which defines the controls, test, and traceability criteria for both castings and separately-cast specimens. Control factors of 4.4.2.2 shall apply.

3.3 Condition

Unless other specified, castings shall be delivered in the as cast condition. Heat treatment of castings shall not be done unless purchaser specifies that castings are to be supplied in the intermediate heat treatment condition of 3.5.1 or the fully heat treated condition of 3.5.2.

3.4 Test Specimens

Specimens shall be either separately-cast, integrally-cast (See 8.2.8), or machined from a casting, and shall conform to 3.2.

3.4.1 If specimens are separately-cast, vendor shall have a written procedure acceptable to purchaser. Control factors of 4.4.2.2 shall apply.

3.4.2 Each master heat shall be qualified by evaluation of chemical, hardness, and tensile specimens.

3.4.2.1 If replenishments are made at remelt as in 3.2.3, the frequency of sampling and testing used by the vendor for qualification to 3.4.2 shall be acceptable to purchaser.

3.4.2.2 Tensile tests of 3.4.2 are not required if these tests are conducted using integrally-cast specimens (4.3.3.2) or specimens machined-from-casting (4.3.3.3).

3.4.3 Chemical Analysis Specimens

Shall be of any convenient size and shape.

3.4.4 Tensile Specimens

Shall be of standard proportions in accordance with ASTM E 8/E 8M (See 8.3) with 0.250-inch (6.35-mm) diameter at the reduced parallel gage section.

3.4.4.1 Separately-cast and integrally-cast specimens may be either cast to size, or cast oversize and subsequently machined to 0.250-inch (6.35-mm) diameter.

3.4.4.2 When integrally-cast specimens and/or specimens machined-from-casting are specified, specimen size and location shall be agreed upon by purchaser and vendor (See 8.2.9 and 8.6).

3.4.5 Hardness Specimens for Response to Heat Treatment

May be a representative specimen or a casting.

3.5 Response to Heat Treatment

Representative test specimens shall be heat treated as specified in 3.5.1 and 3.5.2. When castings are specified (see 3.3) to be delivered in the intermediate heat treat condition (3.5.1) or in the final heat treat condition (3.5.2), heat treatment shall be performed in accordance with AMS-H-6875 except as specified in 3.5.1 and 3.5.2.

3.5.1 Normalized, Sub-Zero Cooled, and Tempered

Heat to 1875 °F ± 25 (1024 °C ± 14), hold at heat for not less than 60 minutes per inch (25-mm) of maximum cross-section but not less than 30 minutes, and cool at a rate equivalent to air cool; cool to -100 °F ± 10 (-73 °C ± 6), hold at -100 °F ± 10 (-73 ± 6) for not less than 60 minutes, and warm in air to room temperature; temper by heating to 1125 °F ± 25 (607 °C ± 14), hold at heat for 2 to 4 hours, and cool to room temperature.

3.5.2 Hardened, Sub-Zero Cooled, and Double Tempered

After completion of operations in 3.5.1, heat to 1850 °F ± 25 (1010 °C ± 14), hold at heat for not less than 60 minutes per inch (25-mm) of maximum cross-section but not less than 30 minutes, and quench in oil; cool to -100 °F ± 10 (-73 °C ± 6), hold at -100 °F ± 10 (-73 °C ± 6) for not less than 60 minutes, and warm in air to room temperature; and heat to 600 to 700 °F (316 to 371 °C), hold at heat for 2 hours ± 0.25, cool to room temperature; cool to -100 °F ± 10 (-73 °C ± 6), hold at -100 °F ± 10 (-73 °C ± 6) for not less than 60 minutes, and warm in air to room temperature; reheat to 600 to 700 °F (316 to 371 °C), hold at heat for 2 hours ± 0.25, cool to room temperature. Sub-zero cooling and tempering before hardening may be omitted if approved by purchaser.

3.5.3 Tensile specimens used for master heat qualification may be heat treated separately from castings.

3.6 Properties

Conformance shall be based upon testing of separately-cast specimens unless purchaser specifies integrally-cast specimens or specimens machined-from-casting. Properties for integrally-cast specimens and specimens machined-from-casting shall be as specified by purchaser (See 8.6).

3.6.1 Room Temperature Tensile Properties

Shall be as specified in Table 2, determined in accordance with ASTM E 8/E 8M (See 8.3), after heat treatment in accordance with 3.5. Properties other than those listed may be defined as specified in AMS2360.

3.6.1.1 Separately-Cast Specimens

Shall be as shown in Table 2.

TABLE 2 - MINIMUM ROOM TEMPERATURE TENSILE PROPERTIES OF SEPARATELY-CAST SPECIMENS

Property	Value
Tensile Strength	170 ksi (1172 MPa)
Yield Strength at 0.2% Offset	130 ksi (896 MPa)
Elongation in 4D (See 8.3)	2.0%

3.6.2 Hardness as a Response to Heat Treatment

Shall be as follows, determined in accordance with ASTM E 18.

3.6.2.1 Castings and representative specimens shall have an intermediate hardness of 24 to 34 HRC, or equivalent (See 8.4), after heat treatment to 3.5.1.

3.6.2.2 Castings and representative specimens shall have a final hardness of 38 to 49 HRC, or equivalent (See 8.4), after heat treatment to 3.5.2.

3.7 Quality

3.7.1 Castings, 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 castings. Castings shall be free of cracks, laps, hot tears, and cold shuts, and free of scale and other process induced surface contamination which would obscure defects.

3.7.1.1 Unless otherwise specified, castings shall be sufficiently cleaned such that, after passivation by purchaser, the castings shall meet the corrosion test requirements of AMS2700.

3.7.2 Castings shall be produced under radiographic control. This control shall consist of radiographic examination of each casting part number until foundry manufacturing controls in accordance with 4.4.2 have been established. Additional radiography shall be conducted in accordance with the frequency of inspection specified by purchaser, or as necessary to ensure continued maintenance of internal quality.

3.7.2.1 Radiographic inspection shall be conducted in accordance with ASTM E 1742 or other method specified by purchaser.

3.7.3 When specified, additional nondestructive testing shall be performed as follows:

3.7.3.1 Fluorescent penetrant inspection in accordance with ASTM E 1417 or other method specified by purchaser.

3.7.3.2 Magnetic particle inspection in accordance with ASTM E 1444 or other method specified by purchaser.

3.7.4 Acceptance standards for radiographic, fluorescent penetrant, magnetic particle, visual, and other inspection methods shall be agreed upon by purchaser and vendor (See 8.2.9). AMS2175 may be used to specify acceptance standards (casting grade) and frequency of inspection (casting class).

3.7.4.1 When acceptance standards are not specified, Grade C of AMS2175 as applicable to steel castings shall apply for each applicable method of inspection.

3.7.5 Castings shall not be peened, plugged, impregnated, or welded unless authorized by purchaser.

3.7.5.1 When authorized by purchaser, welding in accordance with AMS2694 or another welding program acceptable to purchaser may be used.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

The vendor of castings 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 castings conform to specified requirements.

4.2 Classification of Tests

4.2.1 Acceptance Tests

Composition (3.1), tensile properties (3.6.1), intermediate hardness (3.6.2.1), final hardness (3.6.2.2) and applicable requirements of quality (3.7) are acceptance tests and shall be performed as specified in 4.3.

4.2.2 Periodic Tests

Corrosion resistance (3.7.1.1) and radiographic soundness (3.7.2) are periodic tests and shall be performed at a frequency selected by vendor, unless frequency of testing is specified by purchaser.

4.2.3 Preproduction Tests

All technical requirements are preproduction tests and shall be performed on sample castings (4.3.2), when a change in control factors occurs (4.4.2.2), or when purchaser deems confirmatory testing to be required.

4.3 Sampling and Testing

The minimum testing performed by vendor shall be in accordance with the following:

4.3.1 One chemical analysis specimen or a casting from each master heat shall be tested for conformance with Table 1. If 3.4.2.1 applies, test frequency shall be acceptable to purchaser.

4.3.2 One preproduction casting in accordance with 4.4 shall be tested to the requirements of the casting drawing and to all technical requirements.

4.3.2.1 Dimensional inspection sample quantity shall be as specified by purchaser.

4.3.3 Tensile tests shall be conducted to determine conformance with Table 2. Sampling and test frequency are dependent upon the type and origin of specimen specified by purchaser (See 3.4.4 and 3.6) or selected by vendor (See 4.3.3.4). When 3.4.2.1 applies, test frequency shall be acceptable to purchaser.

4.3.3.1 For separately-cast specimens in the fully heat treated condition (See 3.5.2), one specimen from each master heat shall be tested to 3.6.1.

4.3.3.2 For integrally-cast specimens in the fully heat treated condition (See 3.5.2), two specimens from each lot (See 8.2.10) shall be randomly selected and tested for conformance to properties specified by purchaser (See 3.6 and 8.6).

4.3.3.3 For specimens machined-from-casting, one casting shall be randomly selected from each lot and tested in the fully heat treated condition (See 3.5.2) at each location shown on the engineering drawing for conformance to the properties specified by purchaser.

4.3.3.3.1 When size and location of specimens are not shown, two test specimens shall be tested, one from the thickest section and one from the thinnest section. Once established under 4.4.2.2, test locations may be changed only as agreed upon by purchaser and vendor.

4.3.3.4 When acceptable to purchaser, specimens machined-from-casting may be used in lieu of both separately-cast and integrally-cast specimens, and integrally-cast specimens may be used in lieu of separately-cast specimens. In each case, the resultant properties must conform to requirements of 3.6.1, or to alternative requirements specified by purchaser (See 8.6).

4.3.3.4.1 When specimens are selected for test as in 4.3.3.4 from an origin other than that specified by purchaser, vendor shall include in the report of 4.5 a description of the source of the specimen that was tested.

4.3.3.5 When casting size, section thickness, gating method, or other factors do not permit conformance with 4.3.3.2 or 4.3.3.3, sampling and testing shall be agreed upon by purchaser and vendor.

4.3.4 Castings shall be inspected in accordance with 3.7 to the methods, frequency, and acceptance standards specified by purchaser (See 8.6).

4.3.5 One casting or specimen from each master heat shall be tested for intermediate (3.5.1) and final (3.5.2) hardness as a response to heat treatment to determine conformance to 3.6.2.1 and 3.6.2.2.

4.3.6 If castings are supplied in the intermediate heat treat condition (See 3.5.1), unless otherwise specified by purchaser, one casting per lot shall be hardness tested to determine conformance to 3.6.2.1.

4.3.7 If castings are supplied in the fully heat treated condition (See 3.5.2), the number of castings tested for hardness from each lot to determine conformance to 3.6.2.2 shall be in accordance with Table 3, unless otherwise specified by purchaser.

TABLE 3 - HARDNESS TEST SCHEDULE

Lot Size	Sample Size
1 to 8	All
9 to 50	8
51 to 90	13
91 to 150	20
151 to 280	32
281 to 500	50
501 to 1200	80
1201 to 3200	125
3201 and over	200

4.3.7.1 If any single casting from the inspection lot fails to meet the specified requirement, the entire lot shall be 100% hardness tested or reheat treated in accordance with 4.6.2 and retested in accordance with 4.3.7.

4.4 Approval

4.4.1 Sample casting(s) from new or reworked master patterns produced under the casting procedure of 4.4.2 shall be approved by purchaser before castings for production use are supplied, unless such approval be waived by purchaser.

4.4.2 For each casting part number, vendor shall establish parameters for process control factors that will consistently produce castings and test specimens meeting the requirements of the casting drawing and this specification. These parameters shall constitute the approved casting procedure and shall be used for production of subsequent castings and test specimens. If necessary to make any change to these parameters, vendor shall submit a statement of the proposed change for purchaser reapproval. When requested, vendor shall also submit test specimens, sample castings, or both to purchaser for reapproval.

4.4.2.1 Production castings produced prior to receipt of purchaser's approval shall be at vendor's risk.

4.4.2.2 Control factors for producing castings and separately-cast specimens include, but are not limited to, the following factors. Supplier's procedures shall identify tolerances, ranges, and/or control limits, as applicable. Control factors for separately-cast test specimens must generally represent, but need not be identical to, those factors used for castings (See 3.2.3 and 3.4.1).

Composition of ceramic cores, if used
Arrangement and number of patterns in the mold (including integrally-cast specimens if applicable)
Size, shape, and location of gates and risers
Mold refractory formulation
Grain refinement methods, if applicable
Mold back up material (weight, thickness, or number of dips)
Type of furnace, atmosphere, and charge for melting
Mold preheat and metal pouring temperatures
Fluxing or deoxidation procedure
Replenishment procedure, if applicable
Time molten metal is in furnace
Solidification and cooling procedures
Cleaning operations (mechanical and chemical)
Heat treatment for response to heat treatment
Straightening
Final inspection methods
Location and size of integrally-cast specimens and specimens machined from a casting, if applicable.

4.4.2.2.1 Any of the control factors for which parameters are considered proprietary by vendor may be assigned a code designation. Each variation in such parameters shall be assigned a modified code designation.

4.4.2.2.1.1 Unless otherwise agreed upon by purchaser and vendor, purchaser shall be entitled to review proprietary control factor details and coding at vendor's facility.

4.5 Reports

The vendor of castings shall furnish with each shipment a certification document declaring that castings have been processed, tested, and inspected as specified and that the results of the inspections and tests conform to requirements.

4.5.1 Unless otherwise specified, vendor shall furnish test report(s) showing the results of tests and inspections conducted in accordance with 4.2 and 4.3.

4.5.1.1 Chemical analysis determinations, property test data, and the results of any retests conducted shall be expressed numerically to reflect actual quantitative test values.

4.5.1.2 Hardness test readings may be expressed as single values or as a range of values exhibited by results obtained from the sample size.

4.5.1.3 Inspection and preproduction results shall be reported at the frequency specified by, and in a format acceptable to purchaser.

4.5.1.4 Objective evidence of purchaser's review and acceptance of nonconforming material shall be provided with the certification document at each shipment. (See 7.)

4.5.2 The statement of conformity and test report(s) shall be traceable to the purchase order number, master heat identification, heat treat/lot number, AMS5353E, part number, quantity, and when required (See 5.1.2) the list of individual serial numbers or serial number range.

4.5.2.1 If 4.3.3.4.1 applies, the mechanical property test report shall denote the source of the specimens that were tested.

4.5.3 Test reports for acceptance testing of 4.2 shall be as follows:

4.5.3.1 For each master heat

Composition (See 4.3.1)
Tensile properties (See 4.3.3)
Intermediate hardness (3.6.2.1)
Final hardness (3.6.2.2)

4.5.3.2 For each lot

Inspection results (See 4.3.4)
Intermediate hardness, if applicable (3.6.2.1)
Final hardness, if applicable (3.6.2.2)

4.5.4 The vendor shall retain records of processing and inspection in accordance with purchaser requirements

4.6 Resampling and Retesting

If the results of a valid test fail to meet requirements, two additional specimens in accordance with 4.3 from the same master heat, modified melt (See 3.2.3), or lot, as applicable, shall be tested for each nonconforming characteristic. The results of each additional test, and the average of the results of all tests (original and retests), shall meet the specified requirements; otherwise, the master heat or lot shall be rejected. Results of all tests shall be reported.

4.6.1 A test may be declared invalid if failure is due to specimen mispreparation, test equipment malfunction, improper test procedure, or the presence of random process defects such as inclusions or gas holes in a tensile specimen.