

**AEROSPACE
MATERIAL
SPECIFICATION**

AMS 5368B
Superseding AMS 5368A

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**STEEL CASTINGS, INVESTMENT, CORROSION RESISTANT
15Cr - 4.0Ni - 2.3Mo - 0.09N
Solution Heat Treated**

1. SCOPE:

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

1.2 Application: Primarily for small structural parts requiring good corrosion resistance up to 850°F (455°C).

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) 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 2350 - Standards and Test Methods
AMS 2360 - Room Temperature Tensile Properties of Castings
AMS 2635 - Radiographic Inspection
AMS 2640 - Magnetic Particle Inspection
AMS 2645 - Fluorescent Penetrant Inspection
AMS 2694 - Repair Welding of Aerospace Castings
AMS 2804 - Identification, Castings

2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM A370 - Mechanical Testing of Steel Products
ASTM E192 - Reference Radiographs of Investment Steel Castings
for Aerospace Applications
ASTM E353 - Chemical Analysis of Stainless, Heat-Resisting, Maraging,
and Other Similar Chromium-Nickel-Iron Alloys

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

2.3.1 Federal Standards:

Federal Test Method Standard No. 151 - Metals; Test Methods

2.3.2 Military Standards:

MIL-STD-794 - Parts and Equipment, Procedures for Packaging and Packing of

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E353, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other analytical methods approved by purchaser:

	min	max
Carbon	0.08	0.15
Manganese	0.40	1.10
Silicon	--	0.75
Phosphorus	--	0.04
Sulfur	--	0.03
Chromium	14.50	15.50
Nickel	3.50	4.50
Molybdenum	2.00	2.60
Nitrogen	0.05	0.13
Carbon + Nitrogen	0.15	0.25

3.2 Condition: Solution heat treated.

3.3 Casting: Castings shall be poured either from remelted metal from a master heat or directly from a master heat. In either case, metal for casting shall be qualified as in 3.4.

3.3.1 A master heat is refined metal of a single furnace charge or is metal blended as in 3.3.2. Gates, sprues, risers, and rejected castings shall be used only in preparation of master heats; they shall not be remelted directly, without refining, for pouring of castings.

3.3.2 Unless prohibited by purchaser, metal from two or more master heats may be blended provided that the composition of each master heat to be blended is within the limits of 3.1 and that the total weight of metal in the blend does not exceed 10,000 lb (4500 kg). Ingot and pig may be blended together, shot may be blended, but shot shall not be blended with ingot or pig. When two or more master heats are blended, the resultant blend shall be considered a master heat.

- 3.4 Master Heat Qualification: Each master heat shall be qualified by evaluation of chemical analysis and tensile specimens conforming to 3.4.1 and 3.4.2, respectively. A master heat may be considered conditionally qualified if vendor's test results show conformance to all applicable requirements of this specification. However, except when purchaser waives confirmatory testing, final qualification shall be based on purchaser's test results. Conditional qualification of a master heat shall not be construed as a guarantee of acceptance of castings poured therefrom.
- 3.4.1 Chemical Analysis Specimens: Shall be of any convenient size, shape, and form for vendor's tests. When chemical analysis specimens are required by purchaser, specimens shall be cast to a size, shape, and form agreed upon by purchaser and vendor.
- 3.4.2 Tensile Specimens: Shall be cast from remelted metal from each master heat except when castings are poured directly from a master heat, in which case the tensile specimens shall also be poured directly from the master heat. Specimens shall be of standard proportions in accordance with ASTM A370 with 0.250 in. (6.25 mm) diameter at the reduced parallel gage section. They shall be cast to size or shall be cast oversize and subsequently machined to 0.250 in. (6.25 mm) diameter. Center gating may be used.
- 3.5 Heat Treatment: Castings and representative tensile specimens shall be solution heat treated by heating to a temperature within the range 1875° - 1925°F (1025° - 1050°C), holding at the selected temperature within $\pm 25^\circ\text{F}$ ($\pm 15^\circ\text{C}$) for not less than 1 hr per inch (25 mm) of section thickness, and cooling rapidly in air for castings with all sections 1 in. (25 mm) and under in thickness and in water or oil for castings with any section over 1 in. (25 mm) in thickness.
- 3.6 Properties: Castings and representative tensile specimens shall conform to the following requirements; hardness and tensile testing shall be performed in accordance with ASTM A370:
- 3.6.1 Castings As Solution Heat Treated:
- 3.6.1.1 Hardness: Not higher than 39 HRC or equivalent.
- 3.6.2 After Austenite Conditioning, Sub-Zero Cooling, and Tempering: Specimens produced in accordance with 3.4.2 and castings, solution heat treated as in 3.5, shall conform to the requirements of 3.6.2.1 and 3.6.2.2 after being austenite conditioned by heating to a temperature within the range 1750° - 1825°F (955° - 995°C), holding at the selected temperature within $\pm 25^\circ\text{F}$ ($\pm 15^\circ\text{C}$) for not less than 1 hr per inch (25 mm) of cross-sectional thickness, and quenching in water or otherwise cooling as rapidly as possible to room temperature, cooling to -100°F (-75°C) or lower, holding at this temperature for not less than 3 hr, warming in air to room temperature, and tempered by heating to $850^\circ\text{F} \pm 25$ ($455^\circ\text{C} \pm 15$), holding at heat for not less than 3 hr, and cooling in air.

3.6.2.1 Separately-Cast Specimens:**3.6.2.1.1 Tensile Properties:**

Tensile Strength, min	200,000 psi (1380 MPa)
Yield Strength at 0.2% Offset, min	150,000 psi (1035 MPa)
Elongation in 4D, min	8%

3.6.2.1.2 Hardness: Not lower than 40 HRC or equivalent.

3.6.2.2 Castings:

3.6.2.2.1 Hardness: Not lower than 40 HRC or equivalent.

3.6.2.2.2 Tensile Properties: When specified on the drawing or when agreed upon by purchaser and vendor, tensile specimens conforming to ASTM A370 shall be machined from locations indicated on the drawing from castings selected at random from each master heat. Size, number, and location of such specimens and required properties shall be as shown on the drawing or as agreed upon by purchaser and vendor. Property requirements may be defined as specified in AMS 2360.

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 internal and external imperfections detrimental to usage of the castings.

3.7.1.1 Castings shall have smooth surfaces and shall be well cleaned. Metallic shot or grit shall not be used for final cleaning, unless otherwise permitted.

3.7.2 Castings shall be produced under radiographic control, unless otherwise specified. This control shall consist of radiographic examination of castings in accordance with AMS 2635 until proper foundry technique, which will produce castings free from harmful internal imperfections, is established for each part number and of production castings as necessary to ensure maintenance of satisfactory quality.

3.7.3 When specified, castings shall be subjected to magnetic particle inspection in accordance with AMS 2640 and/or to fluorescent penetrant inspection in accordance with AMS 2645.

3.7.4 Radiographic, magnetic particle, fluorescent penetrant, and other quality standards shall be as agreed upon by purchaser and vendor. ASTM E192 may be used to define radiographic acceptance standards.

3.7.5 Castings shall not be repaired by peening, plugging, welding, or other methods without written permission from purchaser.

- 3.7.5.1 When permitted in writing by purchaser, defects in castings may be
Ø removed and the castings repaired by welding in accordance with AMS 2694.

4. QUALITY ASSURANCE PROVISIONS:

- 4.1 Responsibility for Inspection: The vendor of castings shall supply all
Ø 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 4.5. Purchaser reserves the right to sample and to perform any
confirmatory testing deemed necessary to ensure that the castings conform to
the requirements of this specification.
- 4.2 Classification of Tests: Tests to determine conformance to all technical
Ø requirements of this specification are classified as acceptance tests and
as preproduction tests and shall be performed on each master heat or lot as
applicable, prior to or on the first-article shipment of a casting to a
purchaser, when a change in material and/or processing requires reapproval
as in 4.4.2, and when purchaser deems confirmatory testing to be required.
- 4.2.1 For direct U.S. Military procurement, substantiating test data and, when
Ø requested, preproduction test material shall be submitted to the cognizant
agency as directed by the procuring activity, the contracting officer, or
the request for procurement.
- 4.3 Sampling: Shall be in accordance with the following; a lot shall be all
Ø castings from a single master heat, solution heat treated as a batch, and
presented for vendor's inspection at one time:
- 4.3.1 Two chemical analysis specimens in accordance with 3.4.1 and/or a casting
from each master heat.
- 4.3.2 Three tensile specimens in accordance with 3.4.2 from each master heat,
when requested.
- 4.3.3 Two preproduction castings in accordance with 4.4.1 of each part number.
- 4.3.4 One or more castings from each master heat when tensile properties of
Ø specimens machined from castings are specified. Size, location, and
number of specimens machined from castings shall be as specified on the
drawing or as agreed upon by purchaser and vendor. When size, location,
and number of specimens are not specified, not less than two tensile
specimens, one from the thickest section and one from the thinnest
section, shall be cut from a casting or castings from each master heat.
- 4.4 Approval:
- 4.4.1 Sample castings from new or reworked master patterns and the casting
procedure shall be approved by purchaser before castings for production
use are supplied, unless such approval be waived by purchaser.

4.4.2 Vendor shall establish separately for tensile specimens used for master heat qualification and for production of sample castings of each part number parameters for the control factors of processing which will produce tensile specimens meeting master heat qualification requirements and acceptable castings; these shall constitute the approved casting procedures and shall be used for producing subsequent master heat qualification specimens and production castings. If necessary to make any change in parameters for the control factors of processing, vendor shall submit for reapproval a statement of the proposed changes in processing and, when requested, sample test specimens, castings, or both. Production castings incorporating the revised operations shall not be shipped prior to receipt of reapproval.

4.4.2.1 Control factors for producing test specimens and castings include, but are not limited to, the following:

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Type of furnace and its capacity
Type and size of furnace charge
Time molten metal is in furnace
Furnace atmosphere
Fluxing or deoxidation procedure
Number of ladles used in pour
Mold refractory formulation
Mold back-up material
Gating practices
Mold pre-heat and pouring temperatures, (variations of $\pm 25^{\circ}\text{F}$ ($\pm 15^{\circ}\text{C}$) from established limits are permissible)
Solidification and cooling procedures
Solution, austenite conditioning, sub-zero cooling, and tempering heat treatments
Cleaning operations
Methods of inspection

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

4.5 Reports:

4.5.1 The vendor of castings shall furnish with each shipment three copies of a report showing the results of tests for chemical composition of at least one casting, or of specimens as in 3.4.1 cast in a mold with parts, from each master heat represented and the results of tests on each master heat to determine conformance to the other technical requirements of this specification. When properties of test specimens cut from castings are specified, the report shall include the results of tests to determine conformance to such requirements. This report shall include the purchase order number, master heat number and/or code symbol, AMS 5368B, part number, and quantity from each master heat.