

AEROSPACE MATERIAL SPECIFICATION



AMS 5521G

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Superseding AMS 5521F

Steel, Corrosion and Heat Resistant, Sheet, Strip, and Plate 25Cr - 20Ni (SAE 30310S) Solution Heat Treated

UNS S31008

1. SCOPE:

1.1 Form:

This specification covers a corrosion and heat resistant steel in the form of sheet, strip, and plate.

1.2 Application:

These products have been used typically for parts requiring both corrosion and heat resistance, especially where such parts may require welding during fabrication, and for parts requiring oxidation resistance up to 2000 °F (1093 °C) but useful at the higher temperatures only when stresses are very low, but usage is not limited to such applications.

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

- | | |
|----------|---|
| AMS 2242 | Tolerances, Corrosion and Heat Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Sheet, Strip, and Plate |
| MAM 2242 | Tolerances, Metric, Corrosion and Heat Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Sheet, Strip, and Plate |
| AMS 2248 | Chemical Check Analysis Limits, Wrought Corrosion and Heat Resistant Steels and Alloys, Maraging and Other Highly-Alloyed Steels, and Iron Alloys |
| AMS 2371 | Quality Assurance Sampling and Testing, Corrosion and Heat Resistant Steels and Alloys, Wrought Products and Forging Stock |
| AMS 2807 | Identification, Carbon and Low-Alloy Steels, Corrosion and Heat Resistant Steels and Alloys, Sheet, Strip, Plate, and Aircraft Tubing |

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2.2 ASTM Publications:

Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

ASTM A 370 Mechanical Testing of Steel Products

ASTM E 353 Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

2.3 U.S. Government Publications:

Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

MIL-STD-163 Steel Mill Products, Preparation for Shipment and Storage

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 E 353, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - Composition

Element	min	max
Carbon	--	0.08
Manganese	--	2.00
Silicon	--	1.00
Phosphorus	--	0.040
Sulfur	--	0.030
Chromium	24.00	26.00
Nickel	19.00	22.00
Molybdenum	--	0.75
Copper	--	0.75

3.1.1 Check Analysis: Composition variations shall meet the requirements of AMS 2248.

3.2 Condition:

The product shall be supplied in the following condition:

3.2.1 Sheet and Strip: Cold rolled, solution heat treated free from continuous carbide network, and, unless solution heat treatment is performed in an atmosphere yielding a bright finish, descaled having a surface appearance comparable to 3.2.1.1 or 3.2.1.2 as applicable (See 8.2).

3.2.1.1 Sheet: No. 2D finish.

3.2.1.2 Strip: No. 1 strip finish.

3.2.2 Plate: Hot rolled, solution heat treated free from continuous carbide network, and descaled.

3.3 Properties:

The product shall conform to the following requirements; tensile, hardness, and bend testing shall be performed in accordance with ASTM A 370:

3.3.1 Tensile Properties: Shall be as shown in Table 2:

TABLE 2A - Tensile Properties, Inch/Pound Units

Nominal Thickness Inches	Tensile Strength ksi	Yield Strength at 0.2% Offset ksi, min	Elongation in 2 Inches or 4D %, min
Over 0.002 to 0.003, incl	110 max	--	20
Over 0.003 to 0.004, incl	105 max	--	30
Over 0.004	75.0 to 100	30.0	40

TABLE 2B - Tensile Properties, SI Units

Nominal Thickness Millimeters	Tensile Strength MPa	Yield Strength at 0.2% Offset MPa, min	Elongation in 50.8 mm or 4D %, min
Over 0.051 to 0.076, incl	758 max	--	20
Over 0.076 to 0.102, incl	724 max	--	30
Over 0.102	517 to 689	207	40

3.3.2 Hardness: Shall be not higher than 95 HRB, or equivalent (See 8.3).

3.3.3 Bending: Product 0.749 inch (19.02 mm) and under in nominal thickness shall withstand, without cracking, bending through the angle indicated in Table 3 around a diameter equal to the bend factor times the nominal thickness of the product with axis of bend parallel to the direction of rolling. Only one type of test will be required in routine inspection; in case of dispute, results of tests using the V-block procedure shall govern.

TABLE 3 - Bending Parameters

Nominal Thickness Inch	Nominal Thickness Millimeters	Type of Bend	Angle Degree min	Bend Factor
Up to 0.249, incl	Up to 6.32, incl	Free Bend	180	1
Up to 0.249, incl	Up to 6.32, incl	V-Block	135	1
Over 0.249 to 0.749, incl	Over 6.32 to 19.02, incl	Free Bend	90	1
Over 0.249 to 0.749, incl	Over 6.32 to 19.02, incl	V-Block	135	2

3.4 Quality:

The product, 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 product.

3.5 Tolerances:

Shall conform to all applicable requirements of AMS 2242 or MAM 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 performing 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 requirement of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests for composition (3.1), tensile properties (3.3.1), hardness (3.3.2), bending for product 0.1874 inch (4.76 mm) and under in nominal thickness (3.3.3), and tolerances (3.5) are acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Periodic tests: Tests for bending for product over 0.1874 to 0.749 inch (4.76 to 19.02 mm) in nominal thickness (3.3.3) are periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

4.3 Sampling and Testing:

Shall be in accordance with AMS 2371.