

AEROSPACE
MATERIAL
SPECIFICATION

Submitted for recognition as an American National Standard

SAE AMS 5522D

Issued 12-1-47
Revised 1-1-86

Superseding AMS 5522C

STEEL SHEET, STRIP, AND PLATE, CORROSION AND HEAT RESISTANT
25Cr - 20Ni - 2.0Si (314)
Solution Heat Treated

UNS S31400

This specification has been declared "NONCURRENT" by the Aerospace Materials Division, SAE, as of 7-15-83. It is recommended that this specification not be specified for new designs.

This cover sheet should be attached to the "D" revision of the subject specification.

This specification is under the jurisdiction of AMS Committee "F".

SAE Technical Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

AMS documents are protected under United States and international copyright laws. Reproduction of these documents by any means is strictly prohibited without the written consent of the publisher.



AEROSPACE MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

AMS 5522D
Superseding AMS 5522C

Issued 12-1-47
Revised 1-15-78

UNS S31400

STEEL SHEET, STRIP, AND PLATE, CORROSION AND HEAT RESISTANT
25Cr - 20Ni - 2.0Si (314)

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: Primarily for parts requiring both corrosion and oxidation resistance, and where such parts may require welding during fabrication. Parts and assemblies requiring oxidation resistance up to approximately 2000° F (1093° C), but useful at the higher temperatures only when stresses are low. The specified silicon content improves oxidation resistance with some sacrifice of weldability and ductility.

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 Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2242 - Tolerances, Corrosion and Heat Resistant Steel and Iron Base Alloy Sheet, Strip, and Plate and Titanium and Titanium Alloy Sheet, Strip, and Plate

AMS 2248 - Chemical Check Analysis Limits, Wrought Heat and Corrosion Resistant Steels and Alloys

AMS 2350 - Standards and Test Methods

AMS 2371 - Quality Assurance Sampling of Corrosion and Heat Resistant Alloys, Wrought Products Except Forgings

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

ASTM A370 - Mechanical Testing of Steel Products

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

2.3 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-163 - Steel Mill Products, Preparation for Shipment and Storage

SAE Technical Board rules provide that: "All technical reports, including standards approved by the Board, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no agreement to adhere to any SAE standard or to investigate or consider patents which may apply to the subject matter. Prospective users of the report are responsible for protecting themselves against liability for infringement of patents."

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 approved analytical methods:

	min	max
Carbon	--	0.12
Manganese	1.00 -	2.00
Silicon	1.70 -	2.30
Phosphorus	--	0.040
Sulfur	--	0.030
Chromium	23.00 -	25.00
Nickel	19.00 -	22.00
Molybdenum	--	0.75
Copper	--	0.50

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: Cold rolled, solution heat treated, and descaled (No. 2D Finish).

3.2.2 Strip: Cold rolled, solution heat treated, and descaled (No. 1 Strip Finish).

3.2.3 Plate: Hot rolled, solution heat treated, 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 A370:

3.3.1 Hardness: Shall be 70 - 95 HRB or equivalent.

3.3.2 Bending: Product 0.749 in. (19.02 mm) and under in nominal thickness shall withstand, without cracking, bending through the angle indicated below around a diameter equal to 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.

Nominal Thickness		Type of Bend	Angle	Bend Factor
Inch	(Millimetres)		deg, min	
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

3.3.2.1 Bending requirements for plate over 0.749 in. (19.02 mm) in nominal thickness shall be as agreed upon by the purchaser and vendor.

3.4 Quality: The product, 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 product.

3.5 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of AMS 2242.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of the product shall supply all samples and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.4. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to ensure that material conforms to the requirements of this specification.

4.2 Classification of Tests: Tests to determine conformance to all technical requirements of this specification are classified as acceptance tests.

4.3 Sampling: Shall be in accordance with AMS 2371 and the following:

4.3.1 Specimens for tensile tests of widths 9 in. (229 mm) and over shall be taken with the axis of the specimen perpendicular to the direction of rolling; for widths less than 9 in. (229 mm), specimens shall be taken with the axis parallel to the direction of rolling.

4.4 Reports:

4.4.1 The vendor of the product shall furnish with each shipment three copies of a report of the results of tests for chemical composition of each heat and for hardness and bending properties of each size from each heat. This report shall include the purchase order number, heat number, material specification number and its revision letter, size, and quantity from each heat.

4.4.2 The vendor of finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, material specification number and its revision letter, contractor or other direct supplier of material, part number, and quantity. When material for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of material to determine conformance to the requirements of this specification, and shall include in the report a statement that the material conforms, or shall include copies of laboratory reports showing the results of tests to determine conformance.

Ø 4.5 Resampling and Retesting: Shall be in accordance with AMS 2371.

5. PREPARATION FOR DELIVERY:

5.1 Identification: Each sheet, strip, and plate shall be marked on one face, in the respective location indicated below, with AMS 5522D, heat number, manufacturer's identification, and nominal thickness in inches. The characters shall be of such size as to be clearly legible, shall be applied using a suitable marking fluid, and shall be removable in hot alkaline cleaning solution without rubbing. The markings shall have no deleterious effect on the material or its performance and shall be sufficiently stable to withstand normal handling.

5.1.1 Flat Strip 6 In. (152 mm) and Under in Width: Shall be marked in one or more lengthwise rows of characters recurring at intervals not greater than 3 ft (914 mm).

5.1.2 Flat Sheet, Flat Strip Over 6 In. (152 mm) in Width, and Plate: Shall be marked in lengthwise rows of characters recurring at intervals not greater than 3 ft (914 mm), the rows being spaced not more than 6 in. (152 mm) apart and alternately staggered.

5.1.3 Coiled Sheet and Strip: Shall be marked near both the outside and inside ends of the coil; the markings shall be applied as in 5.1 or shall appear on a durable tag or label attached to the coil and marked with the information of 5.1. When the inside end of the coil is inaccessible, as when the product is wound on cores, the tag or label may be attached to the core.