



AEROSPACE MATERIAL SPECIFICATION

AMS5627

REV. G

Issued 1952-02
Revised 2003-01
Reaffirmed 2013-07

Superseding AMS5627F

Steel, Corrosion and Heat-Resistant, Bars, Wire,
Forgins, Tubing, and Rings
17Cr (SAE 51430)
Annealed
(Composition similar to UNS S43000)

RATIONALE

AMS5627G has been reaffirmed to comply with the SAE five-year review policy.

1. SCOPE:

1.1 Form:

This specification covers a corrosion and heat-resistant steel in the form of bars, wire, forgings, mechanical tubing, flash welded rings, and stock for forging or flash welded rings.

1.2 Application:

These products have been used typically for parts requiring oxidation resistance up to 1600 °F (871 °C) but useful at the higher temperatures only when strength requirements are moderately low, 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 cancelled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001 or www.sae.org.

AMS 2241 Tolerances, Corrosion and Heat-Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Bars and Wire

AMS 2243 Tolerances, Corrosion and Heat-Resistant Steel Tubing

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SAE WEB ADDRESS:

2.1 (Continued):

AMS 2248	Chemical Check Analysis Limits, 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 2374	Quality Assurance Sampling and Testing, Corrosion and Heat-Resistant Steel and Alloy Forgings
AMS 2806	Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys
AMS 2808	Identification, Forgings
AMS 7493	Rings, Flash Welded, Ferritic and Martensitic Corrosion-Resistant Steels

2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or www.astm.org.

ASTM A 370	Mechanical Testing of Steel Products
ASTM E 112	Determining Average Grain Size
ASTM E 353	Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

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	-	0.12
Manganese	-	1.00
Silicon	-	1.00
Phosphorus	-	0.040
Sulfur	-	0.030
Chromium	16.00	18.00
Nickel	-	0.75
Molybdenum	-	0.50
Copper	-	0.50
Aluminum	-	0.05
Tin	-	0.05

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

3.2 Condition:

The product shall be supplied in the following condition; hardness and tensile strength shall be determined in accordance with ASTM A 370:

3.2.1 Bars: Annealed having hardness not higher than 202 HB, or equivalent (See 8.2).

3.2.1.1 All hexagons regardless of size, and other bars 0.500 to 2.750 inches (12.70 to 69.85 mm), inclusive, in nominal diameter or least distance between parallel sides shall be cold finished.

3.2.1.2 Bars, other than hexagons, over 2.750 inches (69.85 mm) in nominal diameter or least distance between parallel sides shall be hot finished and descaled.

3.2.2 Wire: Cold drawn and annealed, or annealed and cold finished, having tensile strength not higher than 100 ksi (689 MPa) or equivalent hardness (See 8.3).

3.2.3 Forgings and Flash Welded Rings: Annealed having hardness not higher than 183 HB, or equivalent (See 8.2).

3.2.3.1 Flash welded rings shall not be supplied unless specified or permitted on purchaser's part drawing. When supplied, rings shall be manufactured in accordance with AMS 7493.

3.2.4 Mechanical Tubing: Annealed and cold finished having hardness not higher than 202 HB, or equivalent (See 8.2).

3.2.5 Stock for Forging or Flash Welded Rings: As ordered by the forging or flash welded ring manufacturer.

3.3 Properties:

The product shall conform to the following requirements:

3.3.1 Average Grain Size: Bars, wire, forgings, tubing, and stock for flash welded rings shall have average grain size not larger than ASTM No. 0, determined in accordance with ASTM E 112. Grain size of flash welded rings shall be as agreed upon by 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 imperfections detrimental to usage of the product.

3.4.1 Grain flow of die forgings, except in areas which contain flash-line end grain, shall follow the general contour of the forgings showing no evidence of reentrant grain flow.

3.5 Tolerances:

Shall conform to all applicable requirements of the following:

3.5.1 Bars and Wire: AMS 2241.

3.5.2 Mechanical Tubing: AMS 2243.

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 the performance of all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to specified requirements.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: All technical requirements except grain flow of die forgings, are acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Periodic Tests: Grain flow of die forgings (3.4.1) is a periodic test and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by the purchaser.

4.3 Sampling and Testing:

Shall be in accordance with the following:

4.3.1 Bars, Wire, Mechanical Tubing, Flash Welded Rings, and Stock for Forging or Flash Welded Rings:

In accordance with AMS 2371.

4.3.2 Forgings: In accordance with AMS 2374.

4.4 Reports:

The vendor of the product shall furnish with each shipment a report showing the results of tests for composition of each heat and for hardness or tensile strength, as applicable, and average grain size of each lot, and stating that the product conforms to the other technical requirements. This report shall include the purchase order number, heat and lot numbers, AMS 5627G, size, and quantity. If forgings are supplied, the size and melt source of stock used to make the forgings shall also be included.