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Superseding AMS5635E	

Steel, Corrosion-Resistant, Bars, Wire, and Forgings  
18Cr - 9Ni - 0.21Pb (303Pb)  
Free-Machining, Solution Heat Treated  
(Composition similar to UNS S30360)

RATIONALE

AMS5635F 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 bars, wire, forgings, and forging stock.

1.2 Application

These products have been used typically for parts on which the amount of machining warrants the use of a free-machining grade of steel, requiring corrosion resistance similar to 18-8 type steel, and not subjected to temperatures exceeding 700 °F (371 °C) during fabrication or in service, 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 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](http://www.sae.org).

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

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AMS 2808 Identification, Forgings

AS1182 Standard Machining Allowance, Aircraft-Quality and Premium Aircraft-Quality Steel Bars and Mechanical Tubing

## 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 A 370 Mechanical Testing of Steel Products

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	--	0.15
Manganese	--	2.00
Silicon	--	1.00
Phosphorus	--	0.040
Sulfur	0.12	0.30
Chromium	17.00	19.00
Nickel	8.00	10.00
Lead	0.12	0.30
Molybdenum	--	0.75
Copper	--	0.75

#### 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:

#### 3.2.1 Bars, Wire, and Forgings

Solution heat treated.

3.2.1.1 All hexagons regardless of size, and other bars 2.75 inches (69.85 mm) and under in nominal diameter or least distance between parallel sides, and wire shall be cold finished.

3.2.1.2 Bars, other than hexagons, over 2.75 inches (69.85 mm) in nominal diameter or least distance between parallel sides shall be hot finished.

#### 3.2.2 Forging Stock

As ordered by the forging manufacturer.

### 3.3 Properties

Properties of forging stock shall be as agreed upon by purchaser and vendor. Bars, wire, and forgings shall conform to the following requirements; hardness and tensile testing shall be performed in accordance with ASTM A 370:

#### 3.3.1 Tensile Properties

##### 3.3.1.1 Hot Finished Bars

Shall be as shown in Table 2.

TABLE 2 - MINIMUM TENSILE PROPERTIES

Property	Value
Tensile Strength	75 ksi (517 MPa)
Yield Strength at 0.2% Offset	30.0 ksi (207 MPa)
Elongation in 4D	40%
Reduction of Area	50%

##### 3.3.1.2 Cold Finished Bars and Wire

Shall be as shown in Table 3.

TABLE 3A - MINIMUM TENSILE PROPERTIES, INCH/POUND UNITS

Nominal Diameter or Least Distance Between Parallel Sides Inches	Tensile Strength ksi	Yield Strength at 0.2% Offset ksi	Elongation in 2 Inches or 4D %	Reduction of Area %
Up to 0.500, incl	90	45.0	35	45
Over 0.500	75	30.0	40	50

TABLE 3B - MINIMUM TENSILE PROPERTIES, SI UNITS

Nominal Diameter or Least Distance Between Parallel Sides Millimeters	Tensile Strength MPa	Yield Strength at 0.2% Offset MPa	Elongation in 50.8 mm or 4D %	Reduction of Area %
Up to 12.70, incl	621	310	35	45
Over 12.70	517	207	40	50

#### 3.3.2 Hardness

##### 3.3.2.1 Bars

Shall be as shown in Table 4, or equivalent (See 8.2), determined approximately at midradius.

TABLE 4 - HARDNESS

Nominal Diameter or Least Distance Between Parallel Sides Inch	Nominal Diameter or Least Distance Between Parallel Sides Millimeters	Hardness HB
Up to 0.75, incl	Up to 19.0, incl	170 to 255
Over 0.75	Over 19.0	140 to 241

##### 3.3.2.2 Forgings

Shall be not higher than 187 HB, or equivalent (See 8.2).

### 3.4 Quality

The product, as received by purchaser, shall be uniform in quality and condition, sound, and, consistent with the type of steel involved, free from foreign materials and from imperfections detrimental to usage of the product.

- 3.4.1 Bars and wire ordered hot rolled or cold drawn, or ground, turned, or polished, shall, after removal of the standard machining allowance in accordance with AS1182, be free from seams, laps, tears, and cracks open to the ground, turned, or polished surface.
- 3.4.2 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

Bars and wire shall conform to all applicable requirements of AMS 2241.

## 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

Composition (3.1), tensile properties (3.3.1), hardness (3.3.2), quality (3.4), and tolerances (3.5) are acceptance tests and shall be performed on each heat or lot as applicable.

#### 4.2.2 Periodic Tests

Grain flow of die forgings (3.4.2) is a periodic test 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 as follows:

#### 4.3.1 Bars, Wire, and Forging Stock

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 tensile properties and hardness 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 5635F, size, and quantity. If forgings are supplied, the size and melt source of stock used to make the forgings shall also be included.