



AEROSPACE MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
TWO PENNSYLVANIA PLAZA, NEW YORK, N.Y. 10001

AMS 5651E

Superseding AMS 5651D

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STEEL BARS, FORGINGS, TUBING, AND RINGS, CORROSION AND HEAT RESISTANT
25Cr - 20Ni (SAE 30310)

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: Primarily for parts and assemblies requiring good corrosion resistance and which will be subjected to elevated temperatures during fabrication or in service, especially 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.
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 Aerospace Material Specifications: Available from Society of Automotive Engineers, Inc., Two Pennsylvania Plaza, New York, New York 10001.

AMS 2241 - Tolerances, Corrosion and Heat Resistant Steel Bars and
Wire and Titanium and Titanium Alloy Bars and Wire
AMS 2243 - Tolerances, Corrosion and Heat Resistant Steel Tubing
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
AMS 2375 - Approval and Control of Critical Forgings
AMS 2808 - Identification, Forgings
AMS 7490 - Rings, Flash Welded, Corrosion and Heat Resistant
Austenitic Steels and Austenitic-Type Alloys

- 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, Pennsylvania 19120.

- 2.3.1 Federal Standards:

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

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:

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	min	max
Carbon	--	0.08
Manganese	--	2.00
Silicon	0.30 -	0.80
Phosphorus	--	0.040
Sulfur	--	0.030
Chromium	24.00 -	26.00
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 Bars, Wire, Forgings, Mechanical Tubing, and Flash Welded Rings: Solution heat treated free from continuous carbide network.

3.2.1.1 Bars and Wire: All hexagons, other bars 2.750 in. (69.85 mm) and under in diameter or distance between parallel sides, and wire shall be cold finished.

3.2.1.2 Mechanical Tubing: Shall be cold finished.

3.2.1.3 Flash Welded Rings: Shall not be supplied unless specified or permitted on purchaser's part drawing. When supplied, they shall be manufactured in accordance with AMS 7490.

3.2.2 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; hardness and tensile testing shall be performed in accordance with ASTM A370.

3.3.1 Hardness:

3.3.1.1 Bars: Not higher than 187 HB or equivalent, determined approximately midway between surface and center except that if supplied cold finished, hardness may be as high as 229 HB or equivalent.

3.3.1.2 Forgings and Flash Welded Rings: Not higher than 187 HB or equivalent.

3.3.1.3 Mechanical Tubing: Not higher than 90 HRB or equivalent determined approximately midway between outer and inner surfaces.

3.3.2 Tensile Properties: Wire shall have tensile strength not higher than 125,000 psi (862 MPa) or equivalent hardness.

3.4 Quality: The product shall be uniform in quality and condition, clean, sound, and free from foreign materials and from internal and external imperfections detrimental to fabrication or to performance of parts.

3.5 Sizes: Except when exact lengths or multiples of exact lengths are ordered, bars, straight wire, and mechanical tubing will be acceptable in mill lengths of 6 - 20 ft (1.8 - 6.1 m) but not more than 10% of any shipment shall be supplied in lengths shorter than 10 ft (3 m).

3.6 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of the following:

3.6.1 Bars and Wire: AMS 2241.

3.6.2 Mechanical Tubing: AMS 2243.

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 4.5. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to assure that the product 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 or routine control tests.
- 4.3 Sampling: Shall be in accordance with the following:
- 4.3.1 Bars, Wire, Mechanical Tubing, Flash Welded Rings, and Stock for Flash Welded Rings: AMS 2371.
- 4.3.2 Forgings and Forging Stock: As agreed upon by purchaser and vendor.
- 4.4 Approval: When specified, approval and control of critical forgings shall be in accordance with AMS 2375.
- 4.5 Reports:
- 4.5.1 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 in the shipment and the results of tests on each size from each heat to determine conformance to the hardness or tensile property requirements. This report shall include the purchase order number, heat number, material specification number and its revision letter, size, and quantity from each heat. If forgings are supplied, the part number and the size and melt source of stock used to make the forgings shall also be included.
- 4.5.2 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.
- 4.6 Resampling and Retesting: If any specimen used in the above tests fails to meet the specified requirements, disposition of the product may be based on the results of testing three additional specimens for each original nonconforming specimen. Failure of any retest specimen to meet the specified requirements shall be cause for rejection of the product represented and no additional testing shall be permitted. Results of all tests shall be reported.

5. PREPARATION FOR DELIVERY:

- 5.1 Identification: The product shall be identified as follows:
- 5.1.1 Bars, Wire, and Tubes:
- 5.1.1.1 Each straight bar, wire, and tube 0.500 in. (12.70 mm) and over in OD or least width of flat surface shall be marked in a row of characters recurring at intervals not greater than 3 ft (914 mm) with AMS 5651E, heat number, and manufacturer's identification. The characters shall be of such size as to be clearly legible, shall be applied using a suitable marking fluid, and shall be capable of being removed 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.