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400 Commonwealth Drive, Warrendale, PA 15096-0001

# AEROSPACE MATERIAL SPECIFICATION

**SAE**

AMS 5695G

Issued	JUL 1958
Revised	APR 1988
Noncurrent	APR 1994
Cancelled	JUN 2000
Superseded by AWS A5.4 Class E310-XX	

Steel, Corrosion and Heat Resistant, Covered Welding Electrodes  
25Cr - 20Ni (SAE 30310)

UNS W31010

## CANCELLATION NOTICE

This specification has been declared "CANCELLED" by the Aerospace Materials Division, SAE, as of June 2000 and has been superseded by AWS A5.4 Class E310-XX. The requirements of the latest issue of AWS A5.4 Class E310-XX shall be fulfilled whenever reference is made to the cancelled AMS 5695. By this action, this document will remain listed in the Numerical Section of the Index of Aerospace Materials Specifications noting that it is superseded by AWS A5.4 Class E310-XX.

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# AEROSPACE MATERIAL SPECIFICATION

**SAE**

**AMS 5695F**

Issued JUL 1958  
Revised APR 1994  
Superseding AMS 5695E

Submitted for recognition as an American National Standard

**STEEL, CORROSION AND HEAT RESISTANT, COVERED WELDING ELECTRODES  
25Cr - 20Ni (SAE 30310)**

**UNS W31010**

This specification has been declared "NONCURRENT" by the Aerospace Materials Division, SAE, as of April 1994. It is recommended, therefore, that this specification not be specified for new designs.

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

"NONCURRENT" refers to those materials which have previously been widely used and which may be required on some existing designs in the future. The Aerospace Materials Division, however, does not recommend these as standard materials for future use in new designs. Each of these "NONCURRENT" specifications is available from SAE upon request.

PREPARED UNDER THE JURISDICTION OF AMS COMMITTEE "F"

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400 COMMONWEALTH DRIVE, WARRENDALE, PA 15096

**AEROSPACE  
MATERIAL  
SPECIFICATION**

Submitted for recognition as an American National Standard

AMS 5695E

Issued 7-1-58  
Revised 4-1-88

Superseding AMS 5695D

STEEL WELDING ELECTRODES, COVERED, CORROSION AND HEAT RESISTANT  
25Cr - 20Ni (SAE 30310)

UNS W31010

THIS REVISION CONTAINS ONLY EDITORIAL CHANGES.

1. SCOPE:

- 1.1 Form: This specification covers a corrosion and heat resistant steel in the form of covered welding electrodes.
- 1.2 Application: Primarily for shielded-metal-arc welding of parts fabricated from steels of similar composition and particularly when the weld zone is required to have corrosion and heat resistance comparable to that of the parent metal.
- 1.3 Classification: Electrodes covered by this specification are classified as follows and shall be suitable for the following usability characteristics:

Type Designation	AWS Designation	Weld Position	Current
A	-15	Flat, Vertical, Overhead, and Horizontal	DC
B	-16	Flat, Vertical, Overhead, and Horizontal	DC - AC
C	-15	Horizontal Fillets, Flat	DC
D	-16	Horizontal Fillets, Flat	DC - AC

- 1.3.1 When DC is specified, reverse polarity (electrode positive) is required.
- 1.3.2 Lime type coverings are required for Types A and C electrodes.
- 1.3.3 Type "A" electrodes shall be supplied unless another type is ordered.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

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AMS 5695G

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**2. APPLICABLE DOCUMENTS:**

The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

**2.1 SAE Publications:**

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

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2.1.1 Aerospace Material Specifications:

AMS 2350 - Standards and Test Methods

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

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

2.3 U.S. Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.3.1 Military Standards:

MIL-W-10430 - Welding Rods and Electrodes, Preparation for Delivery of

2.4 AWS Publications: Available from American Welding Society, Inc., P.O. Box 351040, Miami, FL 33135.

AWS A5.4 - Corrosion-Resisting Chromium and Chromium-Nickel Steel Covered Welding Electrodes

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Weld metal deposited from electrodes shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E353, by spectrochemical methods, or other analytical methods acceptable to purchaser:

	min	max
Carbon	0.09 -	0.20
Manganese	1.25 -	2.50
Silicon	--	0.75
Phosphorus	--	0.04
Sulfur	--	0.03
Chromium	25.00 -	27.00
Nickel	20.00 -	22.00
Molybdenum	--	0.75
Copper	--	0.75

3.1.1 Weld Pads for Chemical Analysis: The referee procedure for making pads of weld metal and removing samples for chemical analysis shall be in accordance with AWS A5.4.

AMS 5695G

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AMS 5695G

**2.1.1 Aerospace Material Specifications:****AMS 2350 Standards and Test Methods****2.2 ASTM Publications:**

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Weld metal deposited from electrodes shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E353, by spectrochemical methods, or by other analytical methods acceptable to purchaser:

3.2 Properties: Electrodes shall conform to the following requirements:

3.2.1 Weldability: Electrodes shall demonstrate good weldability and shall flow smoothly and evenly when used under the conditions specified in 1.3 and shall produce acceptable welds, determined by a procedure agreed upon by purchaser and vendor.

3.2.2 Burn-Off: The covering shall be consumed uniformly all around and shall not burn back from the core wire under proper welding conditions. Heating of the electrode during welding shall not cause injurious blistering of the covering within the ranges of current values recommended by the manufacturer.

3.2.3 Grip Portion and Arc Ends: A portion of the electrode 0.75 - 1.25 inches (20 - 30 mm) long shall be bare to permit good electrical contact with the electrode holder. The arc end of the electrodes shall be sufficiently bare to permit easy striking of the arc but the length of this bare section, measured from the end of the electrode to the point where the full cross-section of the covering begins, shall not exceed the diameter of the bare wire and in no case shall it exceed 1/8 inch (3 mm).

3.2.4 Cleaning: Slag produced during welding shall be readily removable with hand tools.

3.3 Quality:

3.3.1 Core Wire: Shall be uniform in quality and condition, cylindrical, sound, and free from foreign materials and from imperfections detrimental to weld quality.

3.3.2 Covering: Shall be concentric, uniform in quality, tightly adherent, and free from abnormal scabs, blisters, pockmarks, bruises, and other surface defects and shall withstand normal handling without damage. It shall not be harmfully hygroscopic and shall not adversely affect weld quality.

3.4 Standard Sizes and Lengths: Shall be as follows:

TABLE I

Nominal Diameter of Core Wire Inch	Length Inches
5/64	9
3/32	9 and 12
1/8, 5/32, 3/16, 1/4	14

AMS 5695G

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AMS 5695G

	min	max
Carbon	0.09	0.20
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- 3.2.4 **Cleaning:** Slag produced during welding shall be readily removable with hand tools.
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- 3.3.1 **Core Wire:** Shall be uniform in quality and condition, cylindrical, sound, and free from foreign materials and from imperfections detrimental to weld quality.

TABLE I(SI)

Nominal Diameter of Core Wire Millimetres	Length Millimetres
2.0	225
2.5	225 and 300
3.0, 4.0, 5.0, 6.5	350

3.4.1 End-grip electrodes shall be supplied in all lengths.

3.5 Tolerances: Shall be as follows:

3.5.1 Electrodes shall not vary in length more than  $\pm 1/4$  inch ( $\pm 6$  mm) from the length ordered.

3.5.2 Electrode core wire shall not vary in diameter more than  $\pm 0.002$  inch ( $\pm 0.05$  mm) from the size ordered.

3.5.3 Overall diameter of the covered electrodes shall not vary more than 4% from that of the sample approved as in 4.4.1.

3.5.4 Covering shall be concentric with the core wire to the extent that the maximum core-plus-one-covering dimension shall not exceed the minimum core-plus-one-covering dimension by more than 5% of the minimum core-plus-one-covering dimension.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of electrodes shall supply all samples for vendor's tests 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 sample and to perform any confirmatory testing deemed necessary to ensure that the electrodes conform to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests to determine conformance to requirements for composition (3.1), grip portion and arc ends (3.2.3), sizes (3.4), and tolerances (3.5) are classified as acceptance tests and shall be performed to represent each control number of electrodes.

4.2.2 Periodic Tests: Tests to determine conformance to requirements for weldability (3.2.1), burn-off (3.2.2), and cleaning (3.2.4) are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

3.3.2 Covering: Shall be concentric, uniform in quality, tightly adherent, and free from abnormal scabs, blisters, pockmarks, bruises, and other surface defects and shall withstand normal handling without damage. It shall not be harmfully hygroscopic and shall not adversely affect weld quality.

3.4 Standard Sizes and Lengths:

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- 4.2.3 Preproduction Tests: Tests to determine conformance to all technical requirements of this specification are classified as preproduction tests and shall be performed prior to or on the first-article shipment of electrodes to a purchaser, when a change in material, processing, or both requires reapproval as in 4.4.2, and when purchaser deems confirmatory testing to be required.
- 4.2.3.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material shall be submitted to the cognizant agency as directed by the procuring activity, contracting officer, or request for procurement.
- 4.3 Sampling: Shall be as agreed upon by purchaser and vendor; the control number shall be a designation indicating batch processing and core wire heat number.
- 4.4 Approval:
- 4.4.1 Sample electrodes shall be approved by purchaser before electrodes for production use are supplied, unless such approval be waived by purchaser.
- 4.4.2 Vendor shall use materials, manufacturing procedures, processes, and methods of inspection on production electrodes which are essentially the same as those used on the approved sample electrodes. If necessary to make any change in covering formulation or in manufacturing procedures, processes, or methods of inspection, vendor shall submit for reapproval a statement of the proposed changes in material, processing, or both and, when requested, sample electrodes. Production electrodes incorporating the revised procedures shall not be shipped prior to receipt of reapproval.
- 4.5 Reports:
- 4.5.1 The vendor of electrodes shall furnish with each shipment a report stating that the electrodes conform to the technical requirements of this specification. This report shall include the purchase order number, AMS 5695E, control number, size, and quantity. When requested by purchaser, the vendor shall also include in the report the composition of the deposited weld metal for each heat in the shipment.
- 4.5.2 When assemblies requiring use of these electrodes are supplied, the assembly manufacturer shall inspect each lot of electrodes to determine conformance to the technical requirements of this specification and shall furnish with each shipment a report stating that the electrodes conform. This report shall include the purchase order number, AMS 5695E, assembly number, and quantity.
- 4.6 Resampling and Retesting: If any specimen used in the above tests fails to meet the specified requirements, disposition of the electrodes 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 electrodes represented and no additional testing shall be permitted. Results of all tests shall be reported.

AMS 5695G

SAE

AMS 5695G

**4. QUALITY ASSURANCE PROVISIONS:****4.1 Responsibility for Inspection:**

The vendor of electrodes shall supply all samples for vendor's tests 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 sample and to perform any confirmatory testing deemed necessary to ensure that the electrodes conform to the requirements of this specification.

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**4.2.1 Acceptance Tests:** Tests to determine conformance to requirements for composition (3.1), grip portion and arc ends (3.2.3), sizes (3.4), and tolerances (3.5) are classified as acceptance tests and shall be performed to represent each control number of electrodes.

**4.2.2 Periodic Tests:** Tests to determine conformance to requirements for weldability (3.2.1), burn-off (3.2.2), and cleaning (3.2.4) are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

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**4.2.3.1** For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material shall be submitted to the cognizant agency as directed by the procuring activity, contracting officer, or request for procurement.

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**5. PREPARATION FOR DELIVERY:****5.1 Identification:****5.1.1 Individual Electrodes:**

5.1.1.1 At least one legible imprint of the AWS classification (E310) shall be applied to the electrode covering as near as practical to the grip end of the core wire and within 2-1/2 inches (63.5 mm) of the grip end. The prefix letter "E" in the electrode classification may be omitted from the imprint on the electrode covering.

5.1.1.2 The numbers of the imprinted electrode classification shall be of bold block type and of sufficient size and color contrast to be legible before and after normal welding applications.

5.1.2 Electrode Packages: Each package or container shall be legibly marked with not less than the purchase order number, AMS 5695E, control number, size, quantity, type designation, recommended current value, and manufacturer's designation.

**5.2 Packaging:**

5.2.1 Packaging shall be accomplished in such a manner as to ensure that the electrodes, during shipment and storage, will be protected against mechanical injury and exposure to moisture. Such packaging shall protect the covering from changes in moisture content to the extent that use of the electrodes may be impaired.

5.2.2 The weight of the package shall be as agreed upon by purchaser and vendor.

5.2.3 Packages of electrodes shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the electrodes to ensure carrier acceptance and safe delivery. Packaging shall conform to carrier rules and regulations applicable to the mode of transportation.

5.2.4 For direct U.S. Military procurement, packaging shall be in accordance with MIL-W-10430, Level A or Level C, as specified in the request for procurement. Commercial packaging as in 5.2.1 and 5.2.3 will be acceptable if it meets the requirements of Level C.

6. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

7. REJECTIONS: Electrodes not conforming to this specification, or to modifications authorized by purchaser, will be subject to rejection.