

# AEROSPACE MATERIAL SPECIFICATION



AMS 5698F

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Superseding AMS 5698E

Nickel Alloy, Corrosion and Heat Resistant, Wire  
72Ni - 15.5Cr - 0.95Cb - 2.5Ti - 0.70Al - 7.0Fe  
No. 1 Temper, Precipitation Hardenable

UNS N07750

## 1. SCOPE:

### 1.1 Form:

This specification covers a corrosion and heat resistant nickel alloy in the form of round, square, and flat wire 0.500 inch (12.70 mm) and under in nominal diameter or thickness.

### 1.2 Application:

This wire has been used typically for helical springs requiring optimum resistance to relaxation up to 1000 °F (538 °C) with moderate or relatively low stresses, but usage is not limited to such applications.

## 2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

### 2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2269 Chemical Check Analysis Limits, Wrought Nickel Alloys and Cobalt Alloys  
AMS 2371 Quality Assurance Sampling and Testing, Corrosion and Heat Resistant Steels and Alloys, Wrought Products and Forging Stock

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## 2.2 ASTM Publications:

Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

ASTM E 8      Tension Testing of Metallic Materials  
 ASTM E 8M    Tension Testing of Metallic Materials (Metric)  
 ASTM E 354    Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar  
 Iron, Nickel, and Cobalt Alloys

## 2.3 U.S. Government Publications:

Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue,  
 Philadelphia, PA 19111-5094.

MIL-STD-163    Steel Mill Products, Preparation for Shipment and Storage

## 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 354, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - Composition

Element	min	max
Carbon	--	0.08
Manganese	--	1.00
Silicon	--	0.50
Sulfur	--	0.010
Chromium	14.00	17.00
Nickel	70.00	--
Columbium	0.70	1.20
Titanium	2.25	2.75
Aluminum	0.40	1.00
Iron	5.00	9.00
Cobalt	--	1.00
Tantalum	--	0.05
Copper	--	0.50

3.1.1 Check Analysis: Composition variations shall meet the requirements of AMS 2269.

## 3.2 Condition:

Cold drawn from hot finished wire or rod which has had suitable surface preparation for removal of scale, seams, and other injurious surface imperfections. Wire shall be solution heat treated by heating within the range 2000 to 2200 °F (1093 to 1204 °C), and then suitably lubricated before reducing to the size ordered.

3.2.1 Wire over 0.025 to 0.500 inch (0.64 to 12.70 mm) in nominal diameter or thickness shall be cold reduced approximately 15% following solution heat treatment.

3.2.2 All traces of lubricant shall be removed after cold reduction.

## 3.3 Properties:

Wire shall conform to the following requirements; tensile testing shall be performed in accordance with ASTM E 8 or ASTM E 8M:

## 3.3.1 As Received:

3.3.1.1 Tensile Properties: Shall be as shown in Table 2.

TABLE 2A - Tensile Strength, Inch/Pound Units

Nominal Diameter or Thickness Inch	Tensile Strength ksi, min	Tensile Strength ksi, max
Up to 0.025, incl	--	150
Over 0.025 to 0.500, incl	130	165

TABLE 2B - Tensile Strength, SI Units

Nominal Diameter or Thickness Millimeters	Tensile Strength MPa, min	Tensile Strength MPa, max
Up to 0.64, incl	--	1034
Over 0.64 to 12.70, incl	896	1138

3.3.1.2 Wrapping: Wire shall withstand, without cracking, wrapping at room temperature five full, closely-spaced turns around a diameter as shown in Table 3.

TABLE 3 - Wrapping Parameters

Wire Shape	Wrapping Diameter
Round	Nominal diameter of wire
Square	Nominal diagonal of wire
Flat	Nominal width of wire

3.3.2 After Precipitation Heat Treatment: Wire shall have tensile properties as shown in Table 4 after being precipitation heat treated by heating to 1350 °F ± 25 (732 °C ± 14), holding at heat for 16 hours ± 0.5, and cooling in air.

TABLE 4A - Minimum Tensile Strength, Inch/Pound Units

Nominal Diameter or Thickness Inch	Tensile Strength ksi
Up to 0.025, incl	155
Over 0.025 to 0.500, incl	165

TABLE 4B - Minimum Tensile Strength, SI Units

Nominal Diameter or Thickness Millimeters	Tensile Strength MPa
Up to 0.64, incl	1069
Over 0.64 to 12.70, incl	1138

#### 3.4 Quality:

Wire, as received by purchaser, shall be uniform in quality and condition and free from kinks, twists, scrapes, splits, cold shuts, and other imperfections detrimental to usage of the wire. The surface of the wire shall be free from lubricant and have a bright, smooth finish free from pits, abrasions, and other defects.

## 3.5 Tolerances:

Shall be as follows:

## 3.5.1 Round Wire and Square Wire: Shall be as shown in Table 5.

TABLE 5A - Round and Square Wire Tolerance, Inch/Pound Units

Nominal Diameter or Thickness Inch	Tolerance Inch Plus and Minus
0.003 to 0.005, excl	0.0001
0.005 to 0.008, excl	0.0002
0.008 to 0.012, excl	0.0003
0.012 to 0.024, excl	0.0004
0.024 to 0.033, excl	0.0005
0.033 to 0.044, excl	0.0008
0.044 to 0.312, excl	0.0010
0.312 to 0.500, incl	0.0015

TABLE 5B - Round and Square Wire Tolerance, SI Units

Nominal Diameter or Thickness Millimeters	Tolerance Millimeters Plus and Minus
0.08 to 0.13, excl	0.003
0.13 to 0.20, excl	0.005
0.20 to 0.30, excl	0.008
0.30 to 0.61, excl	0.010
0.61 to 0.84, excl	0.013
0.84 to 1.12, excl	0.020
1.12 to 7.92, excl	0.025
7.92 to 12.70, incl	0.038

## 3.5.2 Out-of-Roundness: Round wire shall not be out-of-round by more than one-half the total permissible tolerance in 3.5.1.

## 3.5.3 Flat Wire 0.062 to 0.375 inch (1.57 to 9.52 mm), Inclusive, in Nominal Width: Shall be as shown in Table 6.

TABLE 6A - Flat Wire Tolerances, Inch/Pound Units

Nominal Thickness Inch	Tolerance Inch	Tolerance Inch
	Plus and Minus Thickness	Plus and Minus Width
Up to 0.029, excl	0.0010	0.005
0.029 to 0.035, excl	0.0015	0.005
0.035 to 0.3125, incl	0.0020	0.005

TABLE 6B - Flat Wire Tolerances, SI Units

Nominal Thickness Millimeters	Tolerance Millimeter	Tolerance Millimeter
	Plus and Minus Thickness	Plus and Minus Width
Up to 0.74, excl	0.025	0.13
0.74 to 0.89, excl	0.038	0.13
0.89 to 7.938, incl	0.051	0.13

#### 4. QUALITY ASSURANCE PROVISIONS:

##### 4.1 Responsibility for Inspection:

The vendor of wire shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the wire conforms to the requirements of this specification.

##### 4.2 Classification of Tests:

Tests for all technical requirements are acceptance tests and shall be performed on each heat or lot as applicable.

##### 4.3 Sampling and Testing:

Shall be in accordance with AMS 2371.

##### 4.4 Reports:

The vendor of wire shall furnish with each shipment a report showing the results of tests for chemical composition of each heat and for tensile properties and wrapping requirements of each lot. This report shall include the purchase order number, heat and lot number, AMS 5698F, size, and quantity.