

**AEROSPACE
MATERIAL
SPECIFICATION**

AMS 5718C

Issued NOV 1970
Revised JAN 1987
Noncurrent AUG 1992
Reaf. Noncur. NOV 2000
Cancelled APR 2007

Superseding AMS 5718B

Steel, Bars, Forgings, Tubing, and Rings, Corrosion-Resistant
11.8Cr - 2.5Ni - 1.8Mo - 0.33V (0.08 - 0.15C)
Annealed

(Composition similar to UNS S64152)

RATIONALE

AMS 5718C has been designated cancelled because survey of aerospace users indicated that this material is not being procured to this specification.

CANCELLATION NOTICE

This specification has been declared "CANCELLED" by the Aerospace Materials Division, SAE, as of April, 2007. By this action, this document will remain listed in the Numerical Section of the Index of Aerospace Material Specifications, indicating that it has been "CANCELLED".

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**AEROSPACE
MATERIAL
SPECIFICATION**



AMS 5718B

Issued NOV 1970
Revised JAN 1987
Noncurrent AUG 1992
Reaf. Noncur. NOV 2000

Superseding AMS 5718A

Steel, Bars, Forgings, Tubing, and Rings, Corrosion Resistant
11.8Cr - 2.5Ni - 1.8Mo - 0.33V (0.08 - 0.15C)
Annealed

UNS S64152

NONCURRENT NOTICE

This specification has been declared "NONCURRENT" by the Aerospace Materials Division, SAE, as of August, 1992. It is recommended, therefore, that this specification not be specified for new designs.

"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.

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1. SCOPE:

1.1 Form:

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

1.2 Application:

Primarily for parts, such as compressor wheels and structural members, requiring high strength and oxidation resistance up to 800°F (425°C).

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications and Aerospace Standards 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.

2.1.1 Aerospace Material Specifications:

| | |
|----------|---|
| AMS 2241 | Tolerances, Corrosion and Heat Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Bars and Wire |
| MAM 2241 | Tolerances, Metric, Corrosion and Heat Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Bars and Wire |
| AMS 2243 | Tolerances, Corrosion and Heat Resistant Steel Tubing |
| MAM 2243 | Tolerances, Metric, Corrosion and Heat Resistant Steel Tubing |
| AMS 2248 | Chemical Check Analysis Limits, Wrought Corrosion and Heat Resistant Steels and Alloys, Maraging and Other Highly-Alloyed Steels, and Iron Alloys |
| AMS 2303 | Aircraft Quality Steel Cleanliness, Martensitic Corrosion Resistant Steels, Magnetic Particle Inspection Procedure |
| MAM 2303 | Aircraft Quality Steel Cleanliness, Martensitic Corrosion Resistant Steels, Magnetic Particle Inspection Procedure, Metric (SI) Measurement |
| AMS 2350 | Standards and Test Methods |
| AMS 2371 | Quality Assurance Sampling of Corrosion and Heat Resistant Steels and Alloys, Wrought Products Except Forgings and Forging Stock |
| AMS 2374 | Quality Assurance Sampling of Corrosion and Heat Resistant Steels and Alloys, Forgings and Forging Stock |
| AMS 2375 | Control of Forgings Requiring First Article Approval |
| AMS 2806 | Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Heat and Corrosion Resistant Steels and Alloys |
| AMS 2808 | Identification, Forgings |
| AMS 7493 | Rings, Flash Welded, Non-Austenitic Corrosion Resistant Steels |

2.1.2 Aerospace Standards:

AS 1182 Standard Machining Allowance, Aircraft Quality and Premium Quality Steel Products

2.2 ASTM Publications:

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

ASTM A370 Mechanical Testing of Steel Products

ASTM E112 Determining Average Grain Size

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

ASTM E381 Macroetch Testing, Inspection, and Rating Steel Products, Comprising Bars, Billets, Blooms, and Forgings

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

3. TECHNICAL REQUIREMENTS:

3.1 Composition:

Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E353 or by spectrographic or other analytical methods approved by purchaser:

| | min | max |
|------------|-------|-------|
| Carbon | 0.08 | 0.15 |
| Manganese | 0.50 | 0.90 |
| Silicon | -- | 0.35 |
| Phosphorus | -- | 0.025 |
| Sulfur | -- | 0.025 |
| Chromium | 11.00 | 12.50 |
| Nickel | 2.00 | 3.00 |
| Molybdenum | 1.50 | 2.00 |
| Vanadium | 0.25 | 0.40 |
| Nitrogen | 0.01 | 0.05 |
| 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:

3.2.1.1 Rounds: Annealed and centerless ground, turned, or polished.

3.2.1.2 Hexagons: Annealed and cold finished.

3.2.1.3 Bars Other than Rounds or Hexagons: Annealed and descaled.

3.2.2 Wire: Annealed and cold finished.

3.2.3 Forgings, Flash Welded Rings, and Extrusions: Annealed and descaled.

3.2.3.1 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 7493.

3.2.4 Mechanical Tubing: Cold finished and annealed.

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

3.3 Heat Treatment:

Bars, wire, forgings, flash welded rings, extrusions, and mechanical tubing shall be annealed by heating to 1275°F ± 20 (690°C ± 10), holding at heat for not less than 6 hr, and cooling in air.

3.4 Properties:

The product shall conform to the following requirements; tensile and hardness testing shall be performed in accordance with ASTM A370:

3.4.1 Macrostructure: Visual examination of transverse sections as in 4.3.3 from bars, billets, tube rounds or tubes, and stock for forging or flash welded rings, etched in accordance with ASTM E381 in hot hydrochloric acid at 160° - 180°F (70° - 80°C) for sufficient time to develop a well-defined macrostructure, shall show no pipe or cracks. Except as specified in 3.4.1.1, porosity, segregation, inclusions, and other imperfections shall be no worse than standards agreed upon by purchaser and vendor.

3.4.1.1 If tubes are produced directly from ingots or large blooms, transverse sections may be taken from tubes rather than tube rounds. Macrostructure standards for such tubes shall be as agreed upon by purchaser and vendor.

- 3.4.2 Grain Size: Predominantly 5 or finer with occasional grains as large as 3 permissible, determined by comparison of a polished and etched specimen with the chart in ASTM E112.
- 3.4.3 Bars, Wire, Forgings, Flash Welded Rings, Extrusions, and Mechanical Tubing:
- 3.4.3.1 As Annealed:
- 3.4.3.1.1 Bars, Forgings, Flash Welded Rings, Extrusions and Mechanical Tubing: Shall have hardness not higher than 311 HB, or equivalent.
- 3.4.3.1.2 Wire: Shall have tensile strength not higher than 155,000 psi (1070 MPa).
- 3.4.3.2 After Hardening and Tempering: Specimens taken from bars, wire, extrusions, and tubing, from forgings with axis in the longitudinal direction, and from parent metal of flash welded rings shall have the following properties after being hardened by heating to 1925°F ± 25 (1050°C ± 15), holding at heat for not less than 30 min., and cooling as required to room temperature and tempered by heating to 1200°F ± 25 (650°C ± 15), holding at heat for not less than 2 hr, and cooling in air to room temperature:
- 3.4.3.2.1 Tensile Properties:
- | | |
|------------------------------------|-----------------------|
| Tensile Strength, min | 135,000 psi (930 MPa) |
| Yield Strength at 0.2% Offset, min | 110,000 psi (760 MPa) |
| Elongation in 4D, min | 17% |
| Reduction of Area, min | 30% |
- 3.4.3.2.2 Hardness: Should be 286 - 331 HB, or equivalent, but the product shall not be rejected on the basis of hardness if the tensile property requirements of 3.4.3.2.1 are met.
- 3.4.4 Forging Stock: When a sample of stock is forged to a test coupon and heat treated as in 3.3 and 3.4.3.2, specimens taken from the heat treated coupon shall conform to the requirements of 3.4.3.2.1 and 3.4.3.2.2. If specimens taken from the stock after heat treatment as in 3.3 and 3.4.3.2 conform to the requirements of 3.4.3.1 and 3.4.3.2.2, the tests shall be accepted as equivalent to tests of the forged coupon.
- 3.4.5 Stock for Flash Welded Rings: Specimens taken from the stock after heat treatment as in 3.3 and 3.4.3.2 shall conform to the requirements of 3.4.3.2.1 and 3.4.3.2.2.
- 3.5 Quality:
- 3.5.1 Steel shall be aircraft quality conforming to AMS 2303 or MAM 2303.
- 3.5.2 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.

- 3.5.2.1 Bars, tubing, and flash welded rings ordered ground, turned, or polished shall be free from seams, laps, tears, and cracks open to the ground, turned, or polished surfaces.
- 3.5.2.2 Product ordered to surface conditions other than ground, turned, or polished shall, after removal of the standard machining allowance, be free from seams, laps, tears, cracks, and other defects exposed to the machined surfaces. Standard machining allowance shall be in accordance with AS 1182.
- 3.5.2.3 Grain flow of die forgings, except in areas having flash-line end grain, shall follow the general contour of the forgings, showing no evidence of re-entrant flow.

3.6 Sizes:

Except when exact lengths or multiples of exact lengths are ordered, straight bars, wire, and mechanical tubing will be acceptable in mill lengths of 6 - 20 ft (2 - 6 m) but not more than 10% of any shipment shall be supplied in lengths shorter than 10 ft (3 m).

3.7 Tolerances:

Shall conform to all applicable requirements of the following:

- 3.7.1 Bars and Wire: AMS 2241 or MAM 2241.
- 3.7.2 Mechanical Tubing: AMS 2243 or MAM 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 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 product conforms to the requirements of this specification.

4.2 Classification of Tests:

- 4.2.1 Acceptance Tests: Tests to determine conformance to the following requirements are classified as acceptance tests and shall be performed on each heat or lot as applicable.
- 4.2.1.1 Composition (3.1), macrostructure (3.4.1), and grain size (3.4.2) of each heat.
- 4.2.1.2 Tensile properties (3.4.3.2.1) and hardness (3.4.3.2.2) of each lot of bars, wire, forgings, mechanical tubing, extrusions, and flash welded rings after hardening and tempering.
- 4.2.1.3 Tolerances (3.7) of bars, wire, and mechanical tubing.