

**SAE** The Engineering Society  
For Advancing Mobility  
Land Sea Air and Space®  
**INTERNATIONAL**

400 Commonwealth Drive, Warrendale, PA 15096-0001

# AEROSPACE MATERIAL SPECIFICATION

**SAE**

**AMS 5749C**

Issued 1 DEC 1973  
Revised 1 JUL 1992  
Superseding AMS 5749B

Submitted for recognition as an American National Standard

STEEL, CORROSION RESISTANT, BARS, WIRE, FORGINGS, AND TUBING  
14.5Cr - 4.0Mo - 1.2V (1.10-1.20C)  
Premium Quality for Bearing Applications, Double Vacuum Melted  
UNS S42700

## 1. SCOPE:

### 1.1 Form:

This specification covers a premium aircraft-quality, corrosion-resistant steel in the form of bars, wire, forgings, mechanical tubing, and forging stock.

### 1.2 Application:

These products have been used typically for parts requiring a through-hardening, corrosion-resistant steel, operating under heavy loads at high speeds, requiring resistance to wear and softening at elevated temperatures, and subject to very rigid inspection standards, 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 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

SAE Technical Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

AMS 5749C

SAE

AMS 5749C

## 2.1 SAE Publications (Continued):

- AMS 2248 Chemical Check Analysis Limits, Wrought Corrosion and Heat Resistant Steels and Alloys, Maraging and Other Highly-Alloyed Steels, and Iron Alloys
- AMS 2300 Premium Aircraft-Quality Steel Cleanliness, Magnetic Particle Inspection Procedure
- MAM 2300 Premium Aircraft-Quality Steel Cleanliness, Magnetic Particle Inspection Procedure, Metric (SI) Measurement
- 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
- 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, 1916 Race Street, Philadelphia, PA 19103-1187.

- ASTM A 370 Mechanical Testing of Steel Products
- ASTM A 604 Macrotech Testing of Consumable Electrode Remelted Steel Bars and Billets
- ASTM E 45 Determining the Inclusion Content of Steel
- ASTM E 112 Determining Average Grain Size
- ASTM E 353 Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

## 2.3 U.S. Government Publications:

Available from Standardization Documents Order 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: (R)

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	1.10	1.20
Manganese	0.30	0.60
Silicon	0.20	0.40
Phosphorus	--	0.015
Sulfur	--	0.010
Chromium	14.00	15.00
Molybdenum	3.75	4.25
Vanadium	1.10	1.30
Nickel	--	0.40
Copper	--	0.35

3.1.1 Check Analysis: Composition variations shall meet the requirements of AMS 2248.

### 3.2 Melting Practice:

Steel shall be double vacuum melted, using vacuum induction melting practice followed by vacuum consumable electrode remelting.

### 3.3 Condition:

The product shall be supplied in the following condition; hardness and tensile strength shall be determined in accordance with ASTM A 370:

3.3.1 Bars: Annealed having hardness not higher than 269 HB, or equivalent (See 8.2).

3.3.1.1 All hexagons and other bars 2.750 inches (69.85 mm) and under in nominal diameter or distance between parallel sides shall be cold finished.

3.3.1.2 Bars, other than hexagons, over 2.750 inches (69.85 mm) in nominal diameter or distance between parallel sides shall be hot finished.

3.3.2 Wire: Cold finished and annealed having tensile strength not higher than (R) 130 ksi (896 MPa) or equivalent hardness except that for wire 0.062 inch (1.59 mm) and under in nominal diameter tensile strength shall not apply unless agreed upon by purchaser and vendor (See 8.2).

3.3.3 Forgings: As ordered.

3.3.4 Mechanical Tubing: Annealed and cold finished having hardness not higher than 293 HB, or equivalent (See 8.2).

3.3.5 Forging Stock: As ordered by the forging manufacturer.

AMS 5749C

SAE

AMS 5749C

**3.4 Properties:**

The product shall conform to the following requirements; hardness testing shall be performed in accordance with ASTM A 370:

- 3.4.1 **Macrostructure:** Visual examination of transverse sections from bars, billets, tube rounds or tubes, and forging stock, etched in hot hydrochloric acid in accordance with ASTM A 604, shall show no pipes or cracks. Except as specified in 3.4.1.1, porosity, segregation, inclusions, and other imperfections for product 36 square inches (232 cm<sup>2</sup>) and under in nominal cross-sectional area shall be no worse than the micrographs of ASTM A 604 shown in Table 2; macrostructure standards for product over 36 square inches (232 cm<sup>2</sup>) in nominal cross-sectional area shall be as agreed upon by purchaser and vendor:

TABLE 2 - Macrostructure Limits

Class	Condition	Severity
1	Freckles	A
2	White Spots	A
3	Radial Segregation	B
4	Ring Pattern	B

- 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 **Micro-Inclusion Rating:** No specimen shall exceed the limits of Table 3, determined in accordance with ASTM E 45, Method D.

TABLE 3 - Micro-Inclusion Rating Limits

Type	A	A	B	B	C	C	D	D
	Thin	Heavy	Thin	Heavy	Thin	Heavy	Thin	Heavy
Worst Field Severity	1.5	1.0	1.0	1.0	1.0	1.0	1.5	1.0
Worst Field Frequency, maximum	x	1	x	1	x	1	3	1
Total Rateable Fields, Frequency, maximum	y	1	y	1	y	1	8	1

X Combined A+B+C, not more than 3 fields  
Y Combined A+B+C, not more than 8 fields

3.4.2.1 A rateable field is defined as one which has a type A, B, C, or D inclusion rating of at least No. 1.0 thin or heavy in accordance with the Jernkontoret Chart, Plate III, ASTM E 45.

### 3.4.3 Decarburization:

3.4.3.1 Bars, wire, and mechanical tubing ordered ground, turned, or polished shall be free from decarburization on the ground, turned, or polished surfaces.

3.4.3.2 Allowable decarburization of bars, wire, billets, and tube rounds ordered for redrawing or forging or to specified microstructural requirements shall be as agreed upon by purchaser and vendor.

3.4.3.3 Decarburization of bars and wire to which 3.4.3.1 or 3.4.3.2 is not applicable shall be not greater than shown in Table 4.

TABLE 4A - Maximum Decarburization, Inch/Pound Units

Nominal Diameter or Distance Between Parallel Sides Inches	Depth of Decarburization Inch
Up to 0.500, incl	0.015
Over 0.500 to 1.000, incl	0.030
Over 1.000 to 2.000, incl	0.040
Over 2.000 to 3.000, incl	0.050
Over 3.000 to 4.000, incl	0.065
Over 4.000 to 5.000, incl	0.095

TABLE 4B - Maximum Decarburization, SI Units

Nominal Diameter or Distance Between Parallel Sides Millimeters	Depth of Decarburization Millimeters
Up to 12.70, incl	0.38
Over 12.70 to 25.40, incl	0.76
Over 25.40 to 50.80, incl	1.02
Over 50.80 to 76.20, incl	1.27
Over 76.20 to 101.60, incl	1.65
Over 101.60 to 127.00, incl	2.41

3.4.3.3.1 Limits for depth of decarburization of bars over 5.000 inches (127.00 mm) in nominal diameter or distance between parallel sides shall be as agreed upon by purchaser and vendor.

AMS 5749C

SAE

AMS 5749C

3.4.3.4 Decarburization of all tubing to which 3.4.3.1 or 3.4.3.2 is not applicable shall be not greater than shown in Table 5.

TABLE 5A - Maximum Decarburization, Inch/Pound Units

Nominal Outside Diameter Inches	Depth of Decarburization Inch
Up to 1.000, incl	0.025
Over 1.000 to 2.000, incl	0.035
Over 2.000 to 3.000, incl	0.045
Over 3.000 to 4.000, incl	0.055
Over 4.000 to 5.000, incl	0.080

TABLE 5B - Maximum Decarburization, SI Units

Nominal Outside Diameter Millimeters	Depth of Decarburization Millimeters
Up to 25.40, incl	0.64
Over 25.40 to 50.80, incl	0.89
Over 50.80 to 76.20, incl	1.14
Over 76.20 to 101.60, incl	1.40
Over 101.60 to 127.00, incl	2.03

3.4.3.5 Decarburization shall be measured by the microscopic method or by Rockwell Superficial 30-N scale or equivalent hardness testing method on hardened but untempered specimens protected during heat treatment to prevent changes in surface carbon content. Depth of decarburization, when measured by a hardness method, is defined as the perpendicular distance from the surface to the depth under that surface below which there is no further increase in hardness. Such measurements shall be far enough away from any adjacent surface to be uninfluenced by any decarburization or lack of decarburization thereon.

3.4.3.5.1 When determining the depth of decarburization, it is permissible to disregard local areas provided the decarburization of such areas does not exceed the above limits by more than 0.005 inch (0.13 mm) and the width is 0.065 inch (1.65 mm) or less.

3.4.4 Response to Heat Treatment: Specimens as in 4.3.3, taken from bars or billets and ground on both faces normal to the axis of the specimen, shall have hardness not lower than 60 HRC, or equivalent, after being heat treated as follows (See 8.2):

AMS 5749C

SAE

AMS 5749C

- 3.4.4.1 Harden by heating to  $2050\text{ }^{\circ}\text{F} \pm 25$  ( $1121\text{ }^{\circ}\text{C} \pm 14$ ), holding at heat for one hour per inch (25 mm) of maximum cross section but not less than 30 minutes, and quenching in oil or quenching for 5 to 6 minutes in a salt bath maintained at  $1050\text{ }^{\circ}\text{F} \pm 15$  ( $566\text{ }^{\circ}\text{C} \pm 8$ ), and cooling in air.
- 3.4.4.2 Stress relieve by heating to  $300\text{ }^{\circ}\text{F} \pm 15$  ( $149\text{ }^{\circ}\text{C} \pm 8$ ), holding at heat for 60 minutes  $\pm 5$ , and cooling in air.
- 3.4.4.3 Cold treat by cooling to  $-100\text{ }^{\circ}\text{F} \pm 10$  ( $-73\text{ }^{\circ}\text{C} \pm 6$ ), holding at that temperature for not less than 15 minutes, and warming in air.
- 3.4.4.4 Double temper by heating to  $975\text{ }^{\circ}\text{F} \pm 15$  ( $524\text{ }^{\circ}\text{C} \pm 8$ ), holding at heat for two hours  $\pm 0.25$ , cooling in air, reheating to  $975\text{ }^{\circ}\text{F} \pm 15$  ( $524\text{ }^{\circ}\text{C} \pm 8$ ), holding at heat for two hours  $\pm 0.25$ , and cooling in air.
- 3.4.5 Grain Size: Predominantly 7 or finer with occasional grains as large as 5 permissible, determined in accordance with ASTM E 112 after austenitizing and quenching as in 3.4.4.

### 3.5 Quality:

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.

- 3.5.1 Steel shall be premium aircraft-quality conforming to AMS 2300 or MAM 2300.
- 3.5.2 Bars and mechanical tubing ordered hot rolled or cold drawn or ground, (R) turned, or polished shall, after removal of the standard machining allowance in accordance with AS1182, be free from seams, laps, tears, and cracks exposed to the ground, turned, or polished surfaces.
- 3.5.3 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 re-entrant grain flow.

### 3.6 Tolerances:

Shall conform to all applicable requirements of the following:

- 3.6.1 Bars and Wire: AMS 2241 or MAM 2241; for sizes not covered by AMS 2241 or MAM 2241, tolerances shall be as agreed upon by purchaser and vendor.
- 3.6.2 Mechanical Tubing: AMS 2243 or MAM 2243.

## 4. QUALITY ASSURANCE PROVISIONS:

### 4.1 Responsibility for Inspection: (R)

The vendor of the product 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 product conforms to the requirements of this specification.

AMS 5749C

SAE

AMS 5749C

#### 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:

(R)

Shall be in accordance with the following;

4.3.1 Bars, Wire, Mechanical Tubing, and Forging Stock: AMS 2371.

4.3.2 Forgings: AMS 2374.

4.3.3 Samples for response to heat treatment (3.4.4) shall be taken midway between surface and center of full cross-section specimens obtained from the finished billet or suitable rerolled product.

#### 4.4 Reports:

4.4.1 The vendor of bars, wire, forgings, and mechanical tubing shall furnish with each shipment a report showing the results of tests for chemical composition, macrostructure, micro-inclusion rating, and frequency-severity cleanliness rating of each heat and for response to heat treatment and grain size of each lot. This report shall include the purchase order number, heat and lot number, AMS 5749C, size, and quantity. If forgings are supplied, the part number and the size and melt source of stock used to make the forgings shall also be included.

4.4.2 The vendor of forging stock shall furnish with each shipment a report showing the results of tests for chemical composition and frequency-severity cleanliness rating of each heat. This report shall include the purchase order number, heat number, AMS 5749C, size, and quantity.

#### 4.5 Resampling and Retesting:

Shall be in accordance with the following:

4.5.1 Bars, Wire, Mechanical Tubing, and Forging Stock: AMS 2371.

4.5.2 Forgings: AMS 2374.

#### 5. PREPARATION FOR DELIVERY:

##### 5.1 Sizes:

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

##### 5.2 Identification:

Shall be as follows: