

AEROSPACE MATERIAL SPECIFICATION



AMS 5755E

Issued JAN 1957
Revised APR 1993
Reaffirmed SEP 2000

Superseding AMS 5755D

Nickel Alloy, Corrosion and Heat Resistant, Bars, Forgings, and Rings
64Ni - 5.0Cr - 24.5Mo - 5.5Fe
Solution Heat Treated

UNS N10004

1. SCOPE:

1.1 Form:

This specification covers a corrosion and heat resistant nickel alloy in the form of bars, forgings, flash welded rings, and stock for forging or flash welded rings.

1.2 Application:

These products have been used typically for parts requiring oxidation resistance up to 1600 °F (871 °C), good strength up to 1200 °F (649 °C), and low coefficient of expansion, 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 2261	Tolerances, Nickel, Nickel Alloy, and Cobalt Alloy Bars, Rods, and Wire
MAM 2261	Tolerances, Metric, Nickel, Nickel Alloy, and Cobalt Alloy Bars, Rods, and Wire
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
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

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2.1 (Continued):

AMS 2808 Identification, Forgings
 AMS 7490 Rings, Flash Welded, Corrosion and Heat Resistant Austenitic Steels and Austenitic-Type Alloys or Precipitation Hardenable Alloys

2.2 ASTM Publications:

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

ASTM E 10 Brinell Hardness of Metallic Materials
 ASTM E 21 Elevated Temperature Tension Tests of Metallic Materials
 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 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:

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	--	0.12
Manganese	--	1.00
Silicon	--	1.00
Phosphorus	--	0.040
Sulfur	--	0.030
Chromium	4.00	6.00
Molybdenum	23.00	26.00
Iron	4.00	7.00
Vanadium	--	0.60
Cobalt (3.1.1)	--	2.50
Nickel + Cobalt	remainder	

3.1.1 Determination not required for routine acceptance.

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

3.2 Condition:

The product shall be supplied in the following condition:

3.2.1 Bars: Hot rolled, solution heat treated, and descaled. Rounds 0.75 inch (19.0 mm) and over in nominal diameter shall be ground.

3.2.2 Forgings: Solution heat treated and descaled.

3.2.3 Flash Welded Rings: Solution heat treated.

3.2.3.1 Flash welded rings shall not be supplied unless specified or permitted on purchaser's part drawing. When supplied, rings shall be manufactured in accordance with AMS 7490.

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

3.3 Heat Treatment:

Bars, forgings, and flash welded rings shall be solution heat treated by heating to 2150 °F ± 25 (1177 °C ± 14), holding at heat for a time commensurate with section thickness but not less than 20 minutes, and cooling at a rate equivalent to a rapid air cool or faster.

3.4 Properties:

The product shall conform to the following requirements:

3.4.1 Bars, Forgings, and Flash Welded Rings:

3.4.1.1 Tensile Properties at 1500 °F (816 °C): Shall be as shown in Table 2, determined in accordance with ASTM E 21 on specimens heated to 1500 °F ± 5 (816 °C ± 3), held at heat for 20 to 30 minutes before testing, and tested at 1500 °F ± 5 (816 °C ± 3):

TABLE 2 - Minimum Tensile Properties

Property	Value
Tensile Strength	55.0 ksi (379 MPa)
Elongation in 4D	10%

3.4.1.2 Hardness: Shall be 170 to 241 HB, or equivalent, determined in accordance with ASTM E 10 (See 8.2).

3.4.2 Stock for Forging or Flash Welded Rings: As agreed upon by purchaser and vendor.

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 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:

Bars shall conform to all applicable requirements of AMS 2261 or MAM 2261.

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. 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 for the following requirements are acceptance tests and shall be performed on each heat or lot as applicable.

4.2.1.1 Composition (3.1) of each heat.

4.2.1.2 Elevated temperature tensile properties (3.4.1.1) and hardness (3.4.1.2) of each lot of bars, forgings, and flash welded rings.

4.2.1.3 Tolerances (3.6) of bars.

4.2.2 Periodic Tests: Tests to determine ability of stock for forging or flash welded rings to develop required properties (3.4.2) and tests for grain flow of die forgings (3.5.1) are periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

4.3 Sampling and Testing:

Shall be in accordance with the following:

4.3.1 Bars, Flash Welded Rings, and Stock for Forging or Flash Welded Rings: AMS 2371.

4.3.2 Forgings: AMS 2374.