

STEEL BARS AND FORGINGS, CORROSION RESISTANT

17Cr - 5.8Mn - 5.8Ni - 2.0Cu - 0.26S

Free Machining

1. SCOPE:

- 1.1 **Form:** This specification covers a free-machining, corrosion-resistant steel in the form of bars, wire, forgings, and forging stock.
- 1.2 **Application:** Primarily for parts on which the amount of machining warrants use of a free-machining grade of steel, requiring corrosion resistance similar to the 18-8 type of steel but not subjected to temperatures exceeding 700°F (370°C) during fabrication or in service.

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

- 2.1 **SAE Publications:** Available from Society of Automotive Engineers, Inc., 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
- AMS 2248 - Chemical Check Analysis Limits, Wrought Heat and Corrosion Resistant Steels and Alloys
- 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 2806 - Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Heat and Corrosion Resistant Steels and Alloys
- AMS 2808 - Identification, Forgings

- 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 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 Federal Standards:

- Federal Test Method Standard No. 151 - Metals; Test Methods

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2.3.2 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, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other analytical methods approved by purchaser:

	min	max
Carbon	--	0.08
Manganese	5.00 -	6.50
Silicon	0.20 -	0.70
Phosphorus	--	0.04
Sulfur	0.18 -	0.35
Chromium	16.00 -	18.00
Nickel	5.00 -	6.50
Copper	1.75 -	2.25
Molybdenum	--	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, Wire, and Forgings: Solution heat treated free from continuous carbide network.

3.2.1.1 All hexagons, other bars 2.75 in. (70 mm) and under in nominal diameter or distance between parallel sides, and wire shall be cold finished.

3.2.1.2 Bars, other than hexagons, over 2.75 in. (70 mm) in nominal diameter or distance between parallel sides shall be hot finished.

3.2.2 Forging Stock: As ordered by the forging manufacturer.

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

3.3.1 Bars, Wire, and Forgings:

3.3.1.1 Tensile Properties: Wire shall have tensile strength of 85,000 - 125,000 psi (586 - 862 MPa) or equivalent hardness.

3.3.1.2 Hardness:

3.3.1.2.1 Bars: Shall be 140 - 255 HB or equivalent, determined approximately midway between surface and center.

3.3.1.2.2 Forgings: Shall be not higher than 187 HB or equivalent.

3.3.2 Forging Stock: As agreed upon by purchaser and vendor.

- 3.4 Quality: The product, as received by purchaser, shall be uniform in quality and condition, sound, and, consistent with the type of steel involved, free from foreign materials and from internal and external imperfections detrimental to usage of the product.
- 3.5 Sizes: Except when exact lengths or multiples of exact lengths are ordered, straight bars and wire will be acceptable in mill lengths of 6 - 20 ft (1.8 - 6.1 m) but not more than 10% of any shipment shall be supplied in lengths shorter than 10 ft (3 m).
- 3.6 Tolerances: Unless otherwise specified, tolerances for bars and wire shall conform to all applicable requirements of AMS 2241.

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: 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 Composition (3.1) of each heat.
 - 4.2.2 Tensile properties (3.3.1.1) of each lot of wire.
 - 4.2.3 Hardness (3.3.1.2) of each lot of bars and forgings.
 - 4.2.4 Tolerances (3.6) of bars and wire.
- 4.3 Sampling: Shall be in accordance with the following:
 - 4.3.1 Bars and Wire: AMS 2371.
 - 4.3.2 Forgings and Forging Stock: AMS 2374.
- 4.4 Reports:
 - 4.4.1 The vendor of the product shall furnish with each shipment three copies of a report showing the results of tests for chemical composition of each heat and for tensile properties or hardness of each lot. This report shall include the purchase order number, heat number, AMS 5762A, size, and quantity from each heat. 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 finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, AMS 5762A, contractor or other direct supplier of material, part number, and quantity. When material for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of material to determine conformance to the requirements of this specification, and shall include in the report a statement that the material conforms, or shall include copies of laboratory reports showing the results of tests to determine conformance.
- 4.5 Resampling and Retesting: Shall be in accordance with the following:
 - 4.5.1 Bars and Wire: AMS 2371.
 - 4.5.2 Forgings and Forging Stock: AMS 2374.