

AEROSPACE MATERIAL SPECIFICATION

SAE® AMS 5771D

Issued MAY 1971
Revised APR 1996

Submitted for recognition as an American National Standard

Superseding AMS 5771C

NICKEL ALLOY, CORROSION AND HEAT RESISTANT, BARS, FORGINGS, AND RINGS
74Ni - 7.0Cr - 16.5Mo
Solution Heat Treated

UNS N10003

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, such as turbine air-sealing components, requiring moderate strength up to 1400 °F (760 °C) and oxidation resistance up to 1600 °F (871 °C), particularly where a low coefficient of expansion is desirable, 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, Nickel, 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 2750	Pyrometry

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2.1 (Continued):

- 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
 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, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

- ASTM E 10 Brinell Hardness of Metallic Materials
 ASTM E 139 Conducting Creep, Creep-Rupture, and Stress-Rupture 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 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	
Carbon	0.04	0.08
Manganese	--	1.00
Silicon	--	1.00
Phosphorus	--	0.015
Sulfur	--	0.020
Chromium	6.00	8.00
Molybdenum	15.75	17.25
Cobalt	--	0.20
Tungsten	--	0.50
Aluminum + Titanium	--	0.50
Boron	--	0.01
Iron	--	5.00
Copper	--	0.35
Nickel	remainder	

3.1.1 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, Forgings, and Flash Welded Rings: Solution heat treated and descaled.

3.2.1.1 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.

3.2.2 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 an air cool or faster. Pyrometry shall be in accordance with AMS 2750.

3.4 Properties:

The product shall conform to the following requirements:

3.4.1 Bars, Forgings, and Flash Welded Rings:

3.4.1.1 Hardness: Shall be not higher than 255 HB, or equivalent (See 8.2), determined in accordance with ASTM E 10. (R)

3.4.1.2 Stress-Rupture Properties at 1500 °F (816 °C): A tensile specimen, maintained at 1500 °F ± 3 (816 °C ± 2) while a load sufficient to produce an initial axial stress of 13.5 ksi (93 MPa) or higher is applied continuously, shall not rupture in less than 23 hours. The test shall be continued to rupture without change of load. Elongation after rupture, measured at room temperature, shall be not less than 10% in 4D. Test shall be conducted in accordance with ASTM E 139.

3.4.1.2.1 The test of 3.4.1.2 may be conducted using incremental loading. In such case, the load required to produce an initial axial stress of 13.5 ksi (93 MPa) or higher shall be used to rupture or for 23 hours, whichever occurs first. After the 23 hours and at intervals of 8 to 16 hours thereafter, the stress shall be increased in increments of 2.0 ksi (14 MPa). Time to rupture and elongation requirements shall be as specified in 3.4.1.2. (R)

3.4.2 Forging Stock: When a sample of stock is forged to a test coupon and heat treated as in 3.3, specimens taken from the heat treated coupon shall conform to the requirements of 3.4.1.1 and 3.4.1.2. If specimens taken from the stock after heat treatment as in 3.3 conform to the requirements of 3.4.1.1 and 3.4.1.2, the tests shall be accepted as equivalent to tests of a forged coupon.

3.4.3 Stock for Flash Welded Rings: Specimens taken from stock after heat treatment as in 3.3 shall conform to the requirements of 3.4.1 .1 and 3.4.1.2.

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 the performance of all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to specified requirements.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: 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 Hardness (3.4.1.1) and stress-rupture properties (3.4.1.2) of bars, forgings, and flash welded rings.

4.2.1.3 Tolerances (3.6) of bars.

4.2.2 Periodic Tests: Tests of forging stock (3.4.2) and of stock for flash welded rings (3.4.3) to demonstrate ability to develop required properties and 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:

(R)

Shall be as follows:

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