

**AEROSPACE  
MATERIAL  
SPECIFICATION**



**AMS 5776F**

Issued JAN 1957  
Revised AUG 2002  
Cancelled OCT 2007

Superseded by AWS A5.9

**Steel, Corrosion and Heat-Resistant, Welding Wire  
12.5Cr (SAE 51410)**

(Composition similar to UNS S41001)

**RATIONALE**

AMS 5776E has been designated Cancelled and Superseded because equivalent technical requirements are provided by AWS A5.9, Class ER410.

**CANCELLATION NOTICE**

This specification has been declared "CANCELLED" by the Aerospace Materials Division, SAE, as of October, 2007, and has been superseded by AWS A5.9, Class ER410. The requirements of the latest issue of AWS A5.9, Class ER410 shall be fulfilled whenever reference is made to the cancelled AMS 5776E. By this action, this document will remain listed in the Numerical Section of the Index of Aerospace Material Specifications, noting that it has been superseded by AWS A5.9, Class ER410.

Cancelled specifications are available from SAE.

SAENORM.COM : Click to view the PDF of AMS 5776F

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**1. SCOPE:****1.1 Form:**

This specification covers a corrosion and heat-resistant steel in the form of welding wire.

**1.2 Application:**

This wire has been used typically as filler metal for gas-metal-arc or gas-tungsten-arc welding of steels of similar composition requiring joints with strength and corrosion resistance comparable to those of the basis metal, but usage is not limited to such applications.

**2. APPLICABLE DOCUMENTS:**

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

**2.1 SAE Publications:**

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001 or [www.sae.org](http://www.sae.org).

AMS 2248 Chemical Check Analysis Limits, Corrosion and Heat-Resistant Steels and Alloys, Maraging and Other Highly-Alloyed Steels, and Iron Alloys

AMS 2371 Quality Assurance Sampling and Testing, Corrosion and Heat-Resistant Steels and Alloys, Wrought Products and Forging Stock

AMS 2813 Packaging and Marking of Packages of Welding Wire, Standard Method

AMS 2814 Packaging and Marking of Packages of Welding Wire, Premium Quality

AMS 2816 Identification, Welding Wire, Tab Marking Method

AMS 2819 Identification, Welding Wire, Direct Color Code System

AMS 5504 Steel Sheet, Strip, and Plate, Corrosion and Heat-Resistant, 12.5Cr (SAE 51410), Annealed

ARP1876 Weldability Test for Weld Filler Metal Wire

ARP4926 Alloy Verification and Chemical Composition Inspection of Welding Wire

**2.2 ASTM Publications:**

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or [www.astm.org](http://www.astm.org).

ASTM E 18 Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials

ASTM E 353 Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

### 3. TECHNICAL REQUIREMENTS:

#### 3.1 Wire Composition:

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	0.10	0.15
Manganese	--	1.00
Silicon	--	1.00
Phosphorus	--	0.025
Sulfur	--	0.015
Phosphorus + Sulfur	--	0.030
Chromium	11.50	13.50
Nickel	--	0.75
Molybdenum	--	0.50
Aluminum	--	0.05
Copper	--	0.50
Tin	--	0.05
Nitrogen	--	0.08

3.1.1 Chemical analysis of initial ingot, bar, or rod stock before drawing is acceptable provided processes used for drawing or rolling, annealing, and cleaning are controlled to ensure continued conformance to composition requirements.

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

#### 3.2 Condition:

Cold worked, bright finish, in a temper and with a surface finish which will provide proper feeding of the wire in machine welding equipment.

#### 3.3 Fabrication:

3.3.1 Wire shall be formed from rod or bar descaled by a process which does not affect the composition of the wire. Surface irregularities inherent with a forming process that does not tear the wire surfaces are acceptable provided the wire conforms to the tolerance of 3.6.

3.3.2 Butt welding is permissible provided both ends to be joined are alloy verified using a method capable of distinguishing the alloy from all other alloys processed within the facility or the repair is made at the wire processing station. The butt weld shall not interfere with uniform, uninterrupted feeding of the wire in machine welding.

3.3.3 In-process annealing, if required, between cold rolling or drawing operations, shall be performed in vacuum or protective atmospheres to ensure freedom from surface oxidation and absorption of other extraneous elements.

3.3.4 Residual elements, drawing compounds, oxides, dirt, oil, dissolved gasses and other foreign materials picked up during wire processing that can adversely affect the welding characteristics, the operation of the equipment, or the properties of the weld metal, shall be removed by cleaning processes that will neither result in pitting nor cause gas absorption by the wire or deposition of substances harmful to welding operations.

#### 3.4 Properties:

Wire shall conform to the following requirements:

3.4.1 Weldability: Melted wire shall flow smoothly and evenly during welding and shall produce acceptable welds. ARP1876 may be used to resolve disputes.

3.4.2 Response to Heat Treatment: Weld metal deposits approximately 1/4 inch (6.4 mm) in thickness, deposited on AMS 5504 steel, shall attain hardness of 35 to 45 HRC, or equivalent (See 8.2), determined in accordance with ASTM E 18, after being heated to 1750 °F ± 10 (954 °C ± 6), held at heat for 30 minutes ± 3, and cooled at a rate equivalent to cooling in still air.

3.4.3 Spooled Wire: Shall conform to 3.4.3.1 and 3.4.3.2.

3.4.3.1 Cast: Wire, wound on standard 12-inch (305-mm) diameter spools, shall have imparted to it a curvature such that a specimen sufficient in length to form one loop with a 1-inch (25-mm) overlap, when cut from the spool and laid on a flat surface, shall form a circle 15 to 50 inches (381 to 1270 mm) in diameter.

3.4.3.2 Helix: The specimen on which cast was determined, when laid on a flat surface and measured between adjacent turns, shall show a vertical separation not greater than 1 inch (25 mm).

#### 3.5 Quality:

Wire, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to welding operations, operation of welding equipment, or properties of the deposited weld metal.

#### 3.6 Sizes and Tolerances:

Wire shall be supplied in the sizes and to the tolerances shown in 3.6.1 and 3.6.2.

3.6.1 Diameter: Shall be as shown in Table 2.

TABLE 2A - Sizes and Diameter Tolerances, Inch/Pound Units

Form	Nominal Diameter Inch	Tolerance Inch Plus and Minus
Cut Lengths	0.030, 0.035, 0.045	0.001
Cut Lengths	0.062, 0.078, 0.094, 0.125, 0.156, 0.187	0.002
Spools	0.007, 0.010, 0.015	0.0005
Spools	0.020, 0.030, 0.035, 0.045	0.001
Spools	0.062, 0.078, 0.094	0.002

TABLE 2B - Sizes and Diameter Tolerances, SI Units

Form	Nominal Diameter Millimeters	Tolerance Millimeter Plus and Minus
Cut Lengths	0.76, 0.89, 1.14	0.025
Cut Lengths	1.57, 1.98, 2.39, 3.18, 3.96, 4.75	0.05
Spools	0.18, 0.25, 0.38	0.013
Spools	0.51, 0.76, 0.89, 1.14	0.025
Spools	1.57, 1.98, 2.39	0.05

3.6.2 Length: Cut lengths shall be furnished in 18, 27, or 36-inch (457, 686, or 914-mm) lengths as ordered, and shall not vary more than +0, -0.5 inch (-13 mm) from the length ordered.

#### 4. QUALITY ASSURANCE PROVISIONS:

##### 4.1 Responsibility for Inspection:

The vendor of wire 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 wire conforms to specified requirements.

##### 4.2 Classification of Tests:

4.2.1 Acceptance Tests: Composition (3.1), sizes and tolerances (3.6), and alloy verification (5.2) are acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Periodic Tests: Weldability (3.4.1), response to heat treatment (3.4.2), cast (3.4.3.1), and helix (3.4.3.2) 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 AMS 2371 and as specified herein.