

**STEEL, CORROSION AND HEAT RESISTANT, WELDING WIRE**  
15Cr - 30Ni - 1.2Mo - 2.2Ti - 0.25Al - 0.001 B - 0.030V (0.01 - 0.03C)  
Vacuum Induction Melted, Environment Controlled Packaging

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 welding or gas-tungsten-arc of critical weldments of precipitation-hardenable, corrosion and heat resistant steels of similar composition where the weld area is required to have strength and corrosion resistance comparable to those of the parent metal, but usage is not limited to such applications. This filler metal provides joints with increased crack resistance over those using AMS 5805 wire when welding similar steels.

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 2248 Chemical Check Analysis Limits, Wrought 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 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 5805 Steel Welding Wire, Corrosion and Heat Resistant, 15Cr - 25.5Ni - 1.20Mo - 2.1Ti - 0.004B - 0.30V, Vacuum Induction Melted, Environment Controlled Packaging

ARP1876 Weldability Test for Weld Filler Metal Wire

ARP4926 Alloy Verification and Chemical Composition Inspection of Welding Wire

SAE Technical Standards 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.

## 2.2 ASTM Publications:

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

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

## 3. TECHNICAL REQUIREMENTS:

### 3.1 Wire 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     | 0.01   | 0.03           |
| Manganese  | --     | 0.20           |
| Silicon    | --     | 0.10           |
| Phosphorus | --     | 0.006          |
| Sulfur     | --     | 0.005          |
| Chromium   | 13.50  | 16.00          |
| Nickel     | 29.00  | 31.00          |
| Molybdenum | 1.00   | 1.50           |
| Titanium   | 2.00   | 2.30           |
| Aluminum   | 0.15   | 0.35           |
| Boron      | 0.0005 | 0.002          |
| Vanadium   | 0.10   | 0.50           |
| Oxygen     | --     | 0.005 (50 ppm) |
| Nitrogen   | --     | 0.005 (50 ppm) |
| Hydrogen   | --     | 0.0005 (5 ppm) |

3.1.1 Except for hydrogen, nitrogen, and oxygen, chemical analysis of initial ingot, bar, or rod stock (R) before drawing is acceptable provided the processes used for drawing or rolling, annealing, and cleaning are controlled to ensure continued conformance to composition requirements. Hydrogen, nitrogen, and oxygen shall be determined at finished diameter.

3.1.2 Check Analysis: Composition variations shall meet the requirements of AMS 2248. No variation over maximum is permitted for oxygen, nitrogen, or hydrogen.

### 3.2 Melting Practice:

Alloy shall be vacuum induction melted; it may be remelted using vacuum consumable electrode process, but remelting is not required.

### 3.3 Condition:

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

- 3.3.1 In-process annealing, between cold rolling or drawing operations, shall be performed in a protective atmosphere to avoid surface oxidation and absorption of other extraneous elements.
- 3.3.2 Drawing compounds, oxides, dirt, oil, and other foreign materials shall be removed by cleaning processes which will neither result in pitting nor cause gas absorption by the wire or deposition of substances harmful to welding operations.
- 3.3.3 Residual elements and dissolved gases deposited on, or absorbed by, the welding wire as a result of cleaning or drawing operations shall be removed.

### 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 Spooled Wire: Shall conform to 3.4.2.1 and 3.4.2.2.
  - 3.4.2.1 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 nominal 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.
  - 3.4.2.2 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 furnished 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<br>Inch   | Tolerance    | Tolerance     |
|-------------|----------------------------|--------------|---------------|
|             |                            | Inch<br>Plus | Inch<br>Minus |
| Cut Lengths | 0.030, 0.045, 0.062, 0.078 | 0.002        | 0.002         |
| Cut Lengths | 0.094, 0.125, 0.156, 0.188 | 0.003        | 0.003         |
| Spools      | 0.007, 0.010, 0.015, 0.020 | 0.0005       | 0.0005        |
| Spools      | 0.030, 0.035, 0.045        | 0.001        | 0.002         |
| Spools      | 0.062, 0.078, 0.094        | 0.002        | 0.002         |

TABLE 2B - Sizes and Diameter Tolerances, SI Units

| Form        | Nominal Diameter<br>Millimeters | Tolerance          | Tolerance           |
|-------------|---------------------------------|--------------------|---------------------|
|             |                                 | Millimeter<br>Plus | Millimeter<br>Minus |
| Cut Lengths | 0.76, 1.14, 1.57, 1.98          | 0.05               | 0.05                |
| Cut Lengths | 2.39, 3.18, 3.96, 4.78          | 0.08               | 0.08                |
| Spools      | 0.18, 0.25, 0.38, 0.51          | 0.013              | 0.013               |
| Spools      | 0.76, 0.89, 1.14                | 0.025              | 0.05                |
| Spools      | 1.57, 1.98, 2.39                | 0.05               | 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 performing all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the wire conforms to the requirements of this specification.

##### 4.2 Classification of Tests:

4.2.1 Acceptance Tests: Composition (3.1), sizes and tolerances (3.6), and alloy verification (5.3) are acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Periodic Tests: Weldability (3.4.1), cast (3.4.2.1), and helix (3.4.2.2) 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.