



AEROSPACE MATERIAL SPECIFICATION	AMS5812™	REV. G
	Issued 1961-01 Revised 2009-10 Reaffirmed 2021-05 Superseding AMS5812F	
Steel, Corrosion and Heat Resistant, Welding Wire 15Cr - 7.1Ni - 2.4Mo - 1.0Al Vacuum Induction Melted (Composition similar to UNS S15789)		

RATIONALE

AMS5812G has been reaffirmed to comply with the SAE five-year review policy.

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 bare wire filler metal for gas-tungsten-arc or gas-metal-arc welding of critical weldments of precipitation-hardenable, corrosion and heat resistant steels of similar composition where the weld area is required to have comparable strength and corrosion resistance to that of the parent 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 International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org.

AMS2248	Chemical Check Analysis Limits, Corrosion and Heat-Resistant Steels and Alloys, Maraging and Other Highly-Alloyed Steels, and Iron Alloys
AMS2371	Quality Assurance Sampling and Testing, Corrosion and Heat-Resistant Steels and Alloys, Wrought Products and Forging Stock
AMS2813	Packaging and Marking Packages of Welding Wire, Standard Method
AMS2814	Packaging and Marking Packages of Welding Wire, Premium Quality
AMS2816	Identification, Welding Wire, Tab Marking Method
AMS2819	Identification, Welding Wire, Direct Color Code System

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SAE WEB ADDRESS:

For more information on this standard, visit
<https://www.sae.org/standards/content/AMS5812G>

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 International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

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

3. TECHNICAL REQUIREMENTS

3.1 Composition

Wire 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 (3.1.1)	--	0.09
Manganese	--	1.00
Silicon	--	0.50
Phosphorus	--	0.010
Sulfur	--	0.010
Chromium	14.00	15.25
Nickel	6.50	7.75
Molybdenum	2.00	2.75
Aluminum	0.75	1.25
Oxygen (3.1.1)	--	0.005 (50 ppm)
Hydrogen (3.1.1)	--	0.0025 (25 ppm)

3.1.1 Shall be determined on finished wire.

3.1.2 Check Analysis

Composition variations shall meet the applicable requirements of AMS2248.

3.1.3 Chemical analysis of initial ingot, bar, or rod stock before drawing, other than those analyses required to be done on the finished wire, is acceptable provided the processes used for drawing or rolling, annealing, and cleaning, are controlled to ensure continued conformance to chemical composition requirements.

3.2 Melting Practice

Steel shall be produced by vacuum induction melting; it may be remelted using consumable electrode vacuum process but remelting is not required.

3.3 Condition

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

3.4 Fabrication

3.4.1 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 tolerances of 3.7.

- 3.4.2 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 in 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.
- 3.4.3 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.
- 3.4.4 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.
- 3.4.4.1 If pickling is necessary to remove surface contamination or scaling, only a light pickle shall be used followed by vacuum degassing.

3.5 Properties

Wire shall conform to the following requirements:

3.5.1 Weldability

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

3.5.2 Spooled Wire

Shall conform to 3.5.2.1 and 3.5.2.2.

3.5.2.1 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 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.

3.5.2.2 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).

3.6 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.

3.7 Sizes and Tolerances

Wire shall be supplied in the sizes and to the tolerances shown in 3.7.1 and 3.7.2.

3.7.1 Diameter

Shall be shown in Table 2.

TABLE 2A - STANDARD DIAMETERS AND TOLERANCES, INCH/POUND UNITS

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

TABLE 2B - STANDARD DIAMETERS AND TOLERANCES, SI UNITS

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

3.7.2 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 (3.7), and alloy verification (5.2.1) are acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Periodic Tests

Weldability (3.5.1), cast (3.5.2.1), and helix (3.5.2.2) 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 AMS2371 and as specified herein.