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AEROSPACE MATERIAL SPECIFICATION

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AMS 5824C

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Submitted for recognition as an American National Standard

STEEL, CORROSION RESISTANT, WELDING WIRE 17Cr - 7.1Ni - 1.0Al

UNS S17780

1. SCOPE:

1.1 Form:

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

1.2 Application:

Primarily for use as bare wire filler metal for gas-tungsten-arc or gas-metal-arc welding of steels of similar composition requiring joints with strength and corrosion resistance comparable to those of the basis metal.

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 2813 Packaging of Welding Wire, Standard Method

AMS 2814 Packaging of Welding Wire, Premium Quality

AMS 2816 Identification, Welding Wire, Color Code System

ARP1876 Weldability Test for Weld Filler Metal Wire

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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 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	--	0.09
Manganese	--	1.00
Silicon	--	0.50
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	16.00	17.25
Nickel	6.50	7.75
Aluminum	0.75	1.25

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

3.2 Condition:

(R)

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

3.2.1 Wire shall be furnished on disposable spools for machine welding or in cut lengths for manual welding, as ordered.

3.2.2 Drawing compounds, oxides, dirt, and oil 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.

3.2.2.1 If pickling is necessary to remove surface contamination or scaling, only a light pickle shall be used.

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3.2.3 In-process annealing between cold rolling or drawing operations shall be performed in a suitable protective atmosphere.

3.3 Properties:

Wire shall conform to the following requirements:

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

3.3.2 Spooled Wire: Shall conform to 3.3.2.1 and 3.3.2.2.

3.3.2.1 Cast: Wire, wound on standard 12-inch (305-mm) diameter spools, shall (R) have imparted to it a curvature such that a specimen sufficient in length, 4 to 14 feet (1.2 to 4.3 m), to form one loop, 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.

3.3.2.2 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).

3.4 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 material.

3.5 Sizes and Tolerances:

Wire shall be supplied in the sizes and to the tolerances shown in 3.5.1 and 3.5.2.

3.5.1 Diameter: (R)

TABLE 2A - Standard Diameters and Tolerances, Inch-Pound Units

Form	Nominal Diameter Inch	Tolerance, Inch	
		Plus	Minus
Cut Lengths	0.030, 0.035, 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

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TABLE 2B - Standard Diameters and Tolerances, SI Units

Form	Nominal Diameter Inch	Tolerance, Millimeter	
		Plus	Minus
Cut Lengths	0.76, 0.89, 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

3.5.2 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: (R)

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: Tests for composition (3.1) and tolerances (3.5) are acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Periodic Tests: Tests for weldability (3.3.1), cast (3.3.2.1), and helix (3.3.2.2) 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: (R)

Shall be in accordance with AMS 2371 and as specified herein.

4.4 Reports:

The vendor of wire shall furnish with each shipment a report showing the results of tests for chemical composition of each heat and stating that the wire conforms to the other technical requirements. This report shall include the purchase order number, lot number, AMS 5824C, nominal size, and quantity.

4.5 Resampling and Retesting:

Shall be in accordance with AMS 2371.