



<b>AEROSPACE MATERIAL SPECIFICATION</b>	<b>AMS6255™</b>	<b>REV. G</b>
	Issued	1984-07
	Revised	2021-08
Superseding AMS6255F		
Steel Bars, Forgings, and Mechanical Tubing and Forging Stock 1.1Si - 1.45Cr - 1.0Mo - 0.08Al (0.16 - 0.22C) Double Vacuum Melted (Composition similar to UNS K21940)		

RATIONALE

AMS6255G updates title, prohibits unauthorized exceptions (3.7, 4.4.4, 5.2.1.1, 8.7), updates composition test (3.1), updates macrostructure requirements (3.4.1.1, 3.4.1.2, 8.9), adds condition for Jominy specimens (3.4.4), provides note on stock removal (8.6), allows prior revisions (8.8), and is the result of a Five-Year Review and update of the specification.

1. SCOPE

1.1 Form

This specification covers a premium aircraft quality, low-alloy steel in the form of bars, forgings, mechanical tubing, and forging stock.

1.2 Application

These products have been used typically for critical carburized parts, such as bearings, gears, and shafts, requiring high minimum core hardness within a narrow range, good resistance to elevated temperature up to 600 °F (316 °C), and subject to rigid magnetic particle inspection standards, 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 +1 724-776-4970 (outside USA), [www.sae.org](http://www.sae.org).

- AMS2251 Tolerances, Low-Alloy Steel Bars
- AMS2253 Tolerances, Carbon and Alloy Steel Tubing
- AMS2259 Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
- AMS2300 Steel Cleanliness, Premium Aircraft-Quality Magnetic Particle Inspection Procedure

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SAE WEB ADDRESS:

For more information on this standard, visit  
<https://www.sae.org/standards/content/AMS6255G>

AMS2370	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Wrought Products and Forging Stock
AMS2372	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Forgings
AMS2806	Identification Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys
AMS2808	Identification, Forgings
ARP1917	Clarification of Terms Used in Aerospace Metals Specifications
AS1182	Standard Stock Removal Allowance, Aircraft-Quality and Premium Aircraft-Quality Steel, Bars, and Mechanical Tubing

## 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](http://www.astm.org).

ASTM A255	Determining Hardenability of Steel
ASTM A370	Mechanical Testing of Steel Products
ASTM A604	Macroetch Testing of Consumable Electrode Remelted Steel Bars and Billets
ASTM A751	Chemical Analysis of Steel Products
ASTM E45	Determining the Inclusion Content of Steel
ASTM E112	Determining Average Grain Size
ASTM E140	Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness

## 3. TECHNICAL REQUIREMENTS

### 3.1 Composition

Shall conform to the percentages by weight shown in Table 1, determined in accordance with ASTM A751 or by other analytical methods acceptable to purchaser.

**Table 1 - Composition**

Element	Min	Max
Carbon	0.16	0.22
Manganese	0.45	0.75
Silicon	0.90	1.25
Phosphorus	--	0.010
Sulfur	--	0.010
Chromium	1.25	1.65
Molybdenum	0.90	1.10
Aluminum	0.03	0.12
Nickel	--	0.25
Copper	--	0.35

#### 3.1.1 Check Analysis

Composition variations shall meet the applicable requirements of AMS2259.

### 3.2 Melting Practice

Steel shall be multiple melted using vacuum induction melting plus consumable electrode vacuum remelting.

### 3.3 Condition

The product shall be supplied in the following condition; hardness and tensile strength shall be determined in accordance with ASTM A370:

#### 3.3.1 Bars

Bar shall not be cut from plate (also see 4.4.2).

##### 3.3.1.1 Bars 0.500 Inch (12.70 mm) and Under in Nominal Diameter or Least Distance Between Parallel Sides

Cold finished having tensile strength not higher than 125 ksi (862 MPa), or equivalent hardness (see 8.2).

##### 3.3.1.2 Bars Over 0.500 Inch (12.70 mm) in Nominal Diameter or Least Distance Between Parallel Sides

Hot finished and annealed unless otherwise ordered, having hardness not higher than 229 HBW, or equivalent (see 8.3). Bars ordered cold finished may have hardness as high as 248 HBW, or equivalent (see 8.3).

#### 3.3.2 Forgings

As ordered.

#### 3.3.3 Mechanical Tubing

Cold finished unless otherwise ordered, having hardness not higher than 25 HRC, or equivalent (see 8.3). Tubing ordered hot finished and annealed shall have hardness not higher than 229 HBW, or equivalent (see 8.3).

#### 3.3.4 Forging Stock

As ordered by the forging manufacturer.

### 3.4 Properties

The product shall conform to the following requirements; hardness testing shall be performed in accordance with ASTM A370:

#### 3.4.1 Macrostructure Rating

Visual examination of transverse full cross-sections from bars, billets, tube rounds (solid, not hollow), and forging stock, etched in hot hydrochloric acid in accordance with ASTM A604, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the macrographs of ASTM A604 shown in Table 2.

**Table 2 - Macrostructure limits**

Class	Condition	Severity
1	Freckles	A
2	White Spots	A
3	Radial Segregation	B
4	Ring Pattern	B

3.4.1.1 Macrostructure examination is not required for bored/hollow forgings (including ring forgings) and mechanical tubing that is produced directly from ingots or large blooms unless otherwise agreed upon by purchaser and producer (see 8.9).

3.4.1.2 If mechanical tubing is produced directly from ingots or large blooms, transverse sections may be taken from the tubing. Macrostructure standards for tubes shall be as agreed by purchaser and producer (see 8.9).

### 3.4.2 Micro-Inclusion Rating of Each Heat

No specimen shall exceed the limits of Table 3, determined in accordance with ASTM E45, Method D:

**Table 3 - Micro-inclusion rating limits**

Type	A	A	B	B	C	C	D	D
	Thin	Heavy	Thin	Heavy	Thin	Heavy	Thin	Heavy
Worst field severity	1.5	1.0	1.5	1.0	1.5	1.0	1.5	1.0
Worst field frequency, maximum	a	1	a	1	a	1	3	1
Total rateable fields, frequency, maximum	b	1	b	1	b	1	8	1

a - Combined A+B+C, not more than three fields.

b - Combined A+B+C, not more than eight fields.

3.4.2.1 A rateable field is defined as one that has a Type A, B, C, or D inclusion rating of at least No. 1.0 thin or heavy in accordance with ASTM E45.

### 3.4.3 Average Grain Size of Bars, Forgings, and Tubing

Shall be ASTM No. 4 or finer, determined in accordance with ASTM E112.

### 3.4.4 Hardenability of Each Heat

Shall be J1/16 inch (1.6 mm) = 47 HRC maximum and J6/16 inch (9.5 mm) = 30 HRC minimum, determined on the standard end-quench specimen in accordance with ASTM A255 except that the steel shall be normalized at 1700 °F ± 10 °F (927 °C ± 6 °C) and the specimen austenitized at 1650 °F ± 10 °F (899 °C ± 6 °C). Cast specimens do not need to be normalized.

## 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 Steel shall be premium aircraft-quality conforming to AMS2300.

3.5.2 Bars and mechanical tubing shall be free from seams, laps, tears, and cracks after removal of the standard stock removal allowance in accordance with AS1182.

3.5.3 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 reentrant grain flow.

## 3.6 Tolerances

### 3.6.1 Bars

In accordance with AMS2251.

### 3.6.2 Mechanical Tubing

In accordance with AMS2253.

## 3.7 Exceptions

Any exceptions shall be authorized by the purchaser and reported as in 4.4.4.

## 4. QUALITY ASSURANCE PROVISIONS

### 4.1 Responsibility for Inspection

The producer of the product shall supply all samples for producer'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

Composition (3.1), condition (3.3), macrostructure (3.4.1), micro-inclusion rating (3.4.2), average grain size (3.4.3), hardenability (3.4.4), quality (3.5), and tolerances (3.6) are acceptance tests and shall be performed on each heat or lot as applicable.

#### 4.2.2 Periodic Tests

Frequency-severity cleanliness rating (3.5.1) and grain flow of die forgings (3.5.3) are periodic tests and shall be performed at a frequency selected by the producer unless frequency of testing is specified by purchaser.

### 4.3 Sampling and Testing

#### 4.3.1 Bars, Mechanical Tubing, and Forging Stock

In accordance with AMS2370.

#### 4.3.2 Forgings

In accordance with AMS2372.

### 4.4 Reports

4.4.1 The producer of bars, forgings, and tubing shall furnish with each shipment a report showing the producer identity, country where the metal was melted (e.g., final melt in the case of metal processed by multiple melting operations), the results of tests for composition, macrostructure, micro-inclusion rating and hardenability of each heat and for average grain size of each lot, and stating that the product conforms to the other technical requirements. This report shall include the purchase order number, heat and lot numbers, AMS6255G, product form and size (and/or part number, if applicable), and quantity. If forgings are supplied, the size and melt source of stock used to make the forgings shall also be included.

4.4.2 If the ship size/shape is cut from a larger cross section, report the nominal metallurgically worked size (also see 3.3.1).

4.4.3 The producer of forging stock shall furnish with each shipment a report showing the producer identity, country where the metal was melted (e.g., final melt in the case of metal processed by multiple melting operations), the results of tests for composition, macrostructure, micro-inclusion rating and hardenability of each heat, and the results of any additional property requirements imposed by the purchase order (see 8.7). This report shall include the purchase order number, heat number, AMS6255G, size, and quantity.