

AEROSPACE MATERIAL SPECIFICATION



AMS 6263J

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Superseding AMS 6263H

Steel Bars, Forgings, and Tubing
1.2Cr - 3.2Ni - 0.12Mo (0.11 - 0.17C) (SAE 9315)

UNS G93150

1. SCOPE:

1.1 Form:

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

1.2 Application:

Primarily for carburized parts which require high minimum core hardness within a narrow range.

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 canceled 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.

- AMS 2251 Tolerances, Low-Alloy Steel Bars
- MAM 2251 Tolerances, Metric, Low-Alloy Steel Bars
- AMS 2253 Tolerances, Carbon and Alloy Steel Tubing
- MAM 2253 Tolerances, Metric, Carbon and Alloy Steel Tubing
- AMS 2259 Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
- AMS 2301 Cleanliness, Aircraft Quality Steel, Magnetic Particle Inspection Procedure
- MAM 2301 Cleanliness, Aircraft Quality Steel, Magnetic Particle Inspection Procedure, Metric (SI) Measurement
- AMS 2370 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel, Wrought Products and Forging Stock
- AMS 2372 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Forgings
- AMS 2806 Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat Resistant Steels and Alloys

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2.1 (Continued):

AMS 2808 Identification, Forgings

AS1182 Standard Machining Allowance, Aircraft-Quality and Premium Aircraft-Quality Steel Bars and Mechanical Tubing

2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM A 255 End-Quench Test for Hardenability of Steel

ASTM A 370 Mechanical Testing of Steel Products

ASTM E 112 Determining the Average Grain Size

ASTM E 350 Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

ASTM E 381 Macroetch Testing Steel Bars, Billets, Blooms, and Forgings

3. TECHNICAL REQUIREMENTS:

3.1 Composition:

Shall conform to the percentages by weight shown in Table 1, determined by wet chemical methods in accordance with ASTM E 350, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - Composition

Element	min	max
Carbon	0.11	0.17
Manganese	0.40	0.70
Silicon	0.15	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	1.00	1.40
Nickel	3.00	3.50
Molybdenum	0.08	0.15
Copper	--	0.35

3.1.1 Check Analysis: Composition variations shall meet the applicable requirements of AMS 2259.

3.2 Condition:

The product shall be supplied in the following condition; hardness and tensile strength shall be determined in accordance with ASTM A 370:

3.2.1 Bars:

3.2.1.1 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 125,000 psi or equivalent hardness (See 8.2).

3.2.1.2 Bars Over 0.500 Inch (12.70 mm) in Nominal Diameter or Least Distance Between Parallel Sides: Hot finished and annealed or tempered, unless otherwise ordered, having hardness not higher than 229 HB, or equivalent. Bars ordered cold finished may have hardness as high as 248 HB, or equivalent (See 8.3).

3.2.2 Forgings: As ordered.

3.2.3 Mechanical Tubing: Cold finished, unless otherwise ordered, having hardness not higher than 25 HRC, or equivalent. Tubing ordered hot finished and annealed or tempered shall have hardness not higher than 99 HRB, or equivalent (See 8.3).

3.2.4 Forging Stock: As ordered by the forging manufacturer.

3.3 Properties:

The product shall conform to the following requirements; hardness testing shall be performed in accordance with ASTM A 370:

3.3.1 Macrostructure: Visual examination of transverse sections from bars, billets, tube rounds, and forging stock, etched in hot hydrochloric acid in accordance with ASTM E 381, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the macrographs of ASTM E 381 shown in Table 2.

TABLE 2 - Macrostructure Limits

Section Size Square Inches	Section Size Square Centimeters	Macrographs
Up to 36, incl	Up to 232, incl	S2 - R1 - C2
Over 36 to 100, incl	Over 232 to 645, incl	S2 - R2 - C3

3.3.2 Average Grain Size: Predominantly 5 or finer, determined in accordance with ASTM E 112 (See 8.4).

3.3.3 Hardenability: Shall be J1/16 inch (1.588 mm) = 44 HRC maximum and J 8/16 (12.7 mm) = 35 HRC minimum (See 8.4), determined on the standard end-quench test specimen in accordance with ASTM A 255, except that the steel shall be normalized at 1700 °F ± 10 (927 °C ± 6) and the test specimen austenitized at 1500 °F ± 10 (816 °C ± 6).

3.4 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.

3.4.1 Steel shall be aircraft quality conforming to AMS 2301 or MAM 2301.

3.4.2 Bars and mechanical tubing ordered hot rolled or cold drawn, or ground, turned, or polished shall, after removal of the standard machining allowance in accordance with AS1182, be free from seams, laps, tears, and cracks open to the ground, turned, or polished surfaces.

3.4.3 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.

3.5 Tolerances:

Shall be as follows:

3.5.1 Bars: In accordance with AMS 2251 or MAM 2251.

3.5.2 Mechanical Tubing: In accordance with AMS 2253 or MAM 2253.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of the product 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 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 (3.2), macrostructure (3.3.1), average grain size (3.3.2), hardenability (3.3.3), frequency-severity cleanliness rating (3.4.1) and tolerances (3.5) are acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Periodic Tests: Grain flow of die forgings (3.4.3) is a periodic test 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 as follows:

4.3.1 Bars, Mechanical Tubing, and Forging Stock: In accordance with AMS 2370.

4.3.2 Forgings: In accordance with AMS 2372.

4.4 Reports:

The vendor of the product shall furnish with each shipment a report showing the results of tests for chemical composition, macrostructure, hardenability, and frequency-severity cleanliness rating of each heat, and for condition and 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, AMS 6263J, size and quantity. If forgings are supplied, the size and melt source of stock used to make the forgings shall also be included.

4.5 Resampling and Retesting:

Shall be as follows:

4.5.1 Bars, Mechanical Tubing, and Forging Stock: In accordance with AMS 2370.

4.5.2 Forgings: In accordance with AMS 2372.

5. PREPARATION FOR DELIVERY:

5.1 Sizes:

Except when exact lengths or multiples of exact lengths are ordered, straight bars and tubing will be acceptable in mill lengths of 6 to 20 feet (1.8 to 6.1 m), but not more than 10% of any shipment shall be supplied in lengths shorter than 10 feet (3 m).

5.2 Identification:

Shall be as follows:

5.2.1 Bars and Mechanical Tubing: In accordance with AMS 2806.

5.2.2 Forgings: In accordance with AMS 2808.

5.2.3 Forging Stock: As agreed upon by purchaser and vendor.

5.3 Protective Treatment:

Bars and mechanical tubing ordered cold drawn, cold rolled, ground, turned, or polished shall be protected from corrosion prior to shipment. For bars not ordered turned or ground, and for forgings, the product may be protected from corrosion prior to shipment.

5.4 Packaging:

The product shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the product to ensure carrier acceptance and safe delivery.