

**AEROSPACE
MATERIAL
SPECIFICATION**

SAE AMS6263

REV. L

Issued 1942-09
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Superseding AMS6263K

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

(Composition similar to UNS K44414)

RATIONALE

AMS6263L results from a Five Year Review and update of this specification.

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 that require high minimum core hardness within a narrow range, 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), or 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
- AMS2301 Steel Cleanliness, Aircraft Quality, Magnetic Particle Inspection Procedure
- 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

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SAE WEB ADDRESS:

AMS2806	Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys
AMS2808	Identification, Forgings
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.

ASTM A 255	Determining Hardenability of Steel
ASTM A 370	Mechanical Testing of Steel Products
ASTM E 112	Determining 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 AMS2259.

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

Bar shall not be cut from plate.

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 ksi 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 (See 8.3). 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 (See 8.3). 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 of Bars, Forgings, and Tubing

Shall be ASTM No. 5 or finer determined in accordance with ASTM E 112.

3.3.3 Hardenability of Each Heat

Shall be J1/16 inch (1.588 mm) = 44 HRC maximum and J 8/16 (12.7 mm) = 35 HRC minimum, 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 AMS2301.

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 surface.

3.4.3 Grain flow of die forgings, except in areas that contain flash-line end grain, shall follow the general contour of the forgings showing no evidence of reentrant grain flow.

3.5 Tolerances

3.5.1 Bars

In accordance with AMS2251.

3.5.2 Mechanical Tubing

In accordance with AMS2253.

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

4.3.1 Bars, Mechanical Tubing, and Forging Stock

In accordance with AMS2370.

4.3.2 Forgings

In accordance with AMS2372.