

STEEL BARS, FORGINGS, AND TUBING
1.2Cr - 3.25Ni - 0.12Mo (0.07 - 0.13C) (SAE 9310)

UNS G93106

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: Primarily for carburized parts requiring high minimum core hardness with narrow range and subject to stringent magnetic particle inspection standards.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications and Aerospace Standards shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

- 2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

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2.1.1 Aerospace Material Specifications:

- 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 2300 - Premium Aircraft-Quality Steel Cleanliness, Magnetic Particle Inspection Procedure
- MAM 2300 - Premium Aircraft-Quality Steel Cleanliness, Magnetic Particle Inspection Procedure, Metric (SI) Measurement
- AMS 2350 - Standards and Test Methods
- AMS 2370 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Wrought Products Except Forgings and Forging Stock
- AMS 2372 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Forgings and Forging Stock
- AMS 2375 - Control of Forgings Requiring First Article Approval
- AMS 2806 - Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat Resistant Steels and Alloys
- AMS 2808 - Identification, Forgings

2.1.2 Aerospace Standards:

- AS 1182 - Standard Machining Allowance, Aircraft Quality and Premium Quality Steel Products

2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

- ASTM A255 - End-Quench Test for Hardenability of Steel
- ASTM A370 - Mechanical Testing of Steel Products
- ASTM A604 - Macroetch Testing of Consumable Electrode Remelted Steel Bars and Billets
- ASTM E112 - Determining Average Grain Size
- ASTM E350 - Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

2.3 U.S. Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.3.1 Military Standards:

- MIL-STD-163 - Steel Mill Products, Preparation for Shipment and Storage

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Shall conform to the following percentages by weight, \emptyset determined by wet chemical methods in accordance with ASTM E350, by spectrochemical methods, or by other analytical methods acceptable to purchaser:

	min	max
Carbon	0.07	0.13
Manganese	0.40	0.70
Silicon	0.15	0.35
Phosphorus	--	0.015
Sulfur	--	0.015
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 A370:

3.2.1 Bars:

3.2.1.1 Bars 0.500 Inch (12.70 mm) and Under in Nominal Diameter or Distance Between Parallel Sides: Cold finished having tensile strength not higher than 125,000 psi (862 MPa) or equivalent hardness.

3.2.1.2 Bars Over 0.500 Inch (12.70 mm) in Nominal Diameter or Distance Between \emptyset Parallel Sides: Hot finished and annealed having hardness not higher than 229 HB, or equivalent, except that bars ordered cold finished may have hardness as high as 248 HB, or equivalent.

3.2.2 Forgings: As ordered.

3.2.3 Mechanical Tubing: Cold finished having hardness not higher than 25 HRC, \emptyset or equivalent, except that tubing ordered hot finished and annealed or tempered shall have hardness not higher than 99 HRB, or equivalent.

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 A370:

3.3.1 Hardenability: Shall be J41=1 maximum and J32=6 minimum, determined on the \emptyset standard end-quench test specimen in accordance with ASTM A255.

- 3.3.2 Grain Size: Predominantly 5 or finer, with occasional grains as large as \emptyset 3 permissible, determined in accordance with ASTM E112.
- 3.3.3 Macrostructure: Visual examination of transverse sections as in 4.3.3 from bars, billets, tube rounds or tubes, and forging stock etched in accordance with ASTM A604 in hot hydrochloric acid (1:1) at 160° - 180°F (71° - 82°C) for sufficient time to develop a well-defined macrostructure, shall show no pipe or cracks. Except as specified in 3.3.3.1, porosity, segregation, inclusions, and other imperfections for product 36 square inches (232 cm²) and under in nominal cross-sectional area shall be no worse than the following macrographs of ASTM A604; macrostructure standards for product over 36 square inches (232 cm²) in nominal cross-sectional area shall be as agreed upon by purchaser and vendor:

Class	Condition	Severity
1	Freckles	A
2	White spots	A
3	Radial segregation	B
4	Ring pattern	B

- 3.3.3.1 If tubes are produced directly from ingots or large blooms, transverse sections may be taken from tubes rather than tube rounds. Macrostructure standards for such tubes shall be as agreed upon by purchaser and vendor.

3.4 Quality:

- 3.4.1 Steel shall conform to the cleanliness requirements of AMS 2300 or MAM 2300. It shall be multiple melted using either ESR or VAR consumable electrode practice in the remelt cycle.
- 3.4.2 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.
- 3.4.2.1 Bars and tubing ordered ground, turned, or polished shall be free from seams, laps, tears, and cracks open to the ground, turned, or polished surfaces.
- 3.4.2.2 Product ordered to surface conditions other than ground, turned, or polished shall, after removal of the standard machining allowance, be free from seams, laps, tears, cracks, and other defects exposed to the machined surfaces. Standard machining allowance shall be in accordance with AS 1182.
- 3.4.2.3 Forgings shall have substantially uniform macrostructure. Standards for acceptance shall be as agreed upon between purchaser and vendor.
- 3.4.2.4 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 re-entrant grain flow.

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

3.6 Tolerances: Shall conform to all applicable requirements of the following:

3.6.1 Bars: AMS 2251 or MAM 2251.

3.6.2 Mechanical Tubing: AMS 2253 or MAM 2253.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of the product shall supply all \emptyset samples for vendor's tests and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.5. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests to determine conformance to all technical \emptyset requirements of this specification are classified as acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Preproduction Tests: Tests of forgings to determine conformance to all \emptyset applicable technical requirements of this specification when AMS 2375 is specified are classified as preproduction tests and shall be performed prior to or on the first-article shipment of a forging to a purchaser, when a change in material, processing, or both requires reapproval as in 4.4, and when purchaser deems confirmatory testing to be required.

4.2.2.1 For direct U.S. Military procurement of forgings, substantiating test \emptyset data and, when requested, preproduction forgings shall be submitted to the cognizant agency as directed by the procuring activity, contracting officer, or request for procurement.

4.3 Sampling: Shall be in accordance with the following:

4.3.1 Bars and Mechanical Tubing: AMS 2370.

4.3.2 Forgings and Forging Stock: AMS 2372.

4.3.3 Samples for macrostructure rating (3.3.3) shall be full cross-sectional \emptyset specimens obtained from the finished billet or suitable rerolled product representing the top and bottom of at least the first, middle, and last usable ingot of each heat.