

**STEEL BARS AND FORGINGS, LOW ALLOY, HEAT RESISTANT
0.65Si - 1.25Cr - 0.50Mn - 0.85V (0.25 - 0.30C)**

UNS K22770

1. SCOPE:

1.1 Form This specification covers an aircraft-quality, low-alloy, heat-resistant steel in the form of bars, forgings, and forging stock.

1.2 Application: Primarily for parts, such as turbine discs, compressor discs, and fasteners, for service up to 1050°F (565°C).

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.

2.1.1 Aerospace Material Specifications:

AMS 2251 - Tolerances, Low Alloy Steel Bars

MM 2251 - Tolerances, Metric, Low Alloy Steel Bars

AMS 2259 - Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels

AMS 2301 - Aircraft Quality Steel Cleanliness, Magnetic Particle Inspection Procedure

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 2806 - Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat Resistant Steels and Alloys

AMS 2808 - Identification, Forgings

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2.1.2 Aerospace Standards:

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

2.2 ASTM Publications: Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

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, Inspection, and Rating Steel Products Comprising Bars, Billets, Blooms, and Forgings

2.3 U S. Government Publications: Available from Standardization Documents Order Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.**2.3.1 Military Standards:**

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

3. TECHNICAL- REQUIREMENTS:

3.1 Composition: Shall conform to the following percentages by weight **0** determined wet chemical methods in accordance with ASTM E 350, by spectrochemical methods, or by other analytical methods acceptable to purchaser:

	min	max
Carbon	0.25	0.30
Manganese	0.60	0.90
Silicon	0.55	0.75
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	1.00	1.50
Molybdenum	0.40	0.60
Vanadium	0.75	0.95
Nickel	--	0.50
Copper	--	0.50

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 (12.50 mm) and Under in Nominal Diameter or Distance Between Parallel Sides: Cold finished having tensile strength not higher than 125.0 ksi (862 MPa) or hardness not higher than 27 HRC.

3.2.1.2 Bars Over 0.500 Inch (12.50 mm) in Nominal Diameter or Distance Between Parallel Sides: Hot finished and annealed having hardness not higher than 241 HB, or equivalent, except that bars ordered cold finished may have hardness as high as 248 HB, or equivalent,

3.2.2 Forgings: Annealed having hardness not higher than 241 HB, or equivalent.

3.2.3 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 Microstructure: Visual examination of transverse sections as in 4.3.3 from bars, billets, and forging stock, etched in accordance with ASTM E 381 in hot hydrochloric acid, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the following macrographs of ASTM E 381:

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

3.3.2 Grain Size: Predominantly 5 or finer with occasional grains as large as 3 permissible, determined in accordance with ASTM E 112.

3.3.3 Decarburization:

3.3.3.1 Bars ordered ground, turned, or polished shall be free from decarburization on the ground, turned, or polished surfaces.

3.3.3.2 Allowable decarburization of bars and billets ordered for redrawing or forging or to specified microstructural requirements shall be as agreed upon by purchaser and vendor.

3.3.3.3 Decarburization of bars to which 3.3.3.1 or 3.3.3.2 is not applicable shall be not greater than shown in Table I.

TABLE I

Nominal Diameter or Distance Between Parallel Sides Inches	Depth of Decarburization Inch
Up to 0.375, incl	0.015
Over 0.375 to 0.500, incl	0.017
Over 0.500 to 0.625, incl	0.019
Over 0.625 to 1.000, incl	0.022
Over 1.000 to 1.500, incl	0.025
Over 1.500 to 2.000, incl	0.030
Over 2.000 to 2.500, incl	0.035
Over 2.500 to 3.000, incl	0.040
Over 3.000 to 4.000, incl	0.045

TABLE I (SI)

Nominal Diameter or Distance Between Parallel Sides Millimeters	Depth of Decarburization Millimeters
Up to 9.52, incl	0.38
Over 9.52 to 12.70, incl	0.43
Over 12.70 to 15.88, incl	0.48
Over 15.88 to 25.40, incl	0.56
Over 25.40 to 38.10, incl	0.64
Over 38.10 to 50.80, incl	0.76
Over 50.80 to 63.50, incl	0.89
Over 63.50 to 76.20, incl	1.02
Over 76.20 to 101.60, incl	1.14

3.3.3.3.1 Limits for depth of decarburization of bars over 4.000 inches (101.60 mm) in nominal diameter or distance between parallel sides shall be as agreed upon by purchaser and vendor.

3.3.3.4 Decarburization shall be measured by the microscopic method or by Rockwell Superficial 30-N scale or equivalent hardness testing method on hardened but untempered specimens protected during heat treatment to prevent changes in surface carbon content. Depth of decarburization, when measured by a hardness method, is defined as the perpendicular distance from the surface to the depth under that surface below which there is no further increase in hardness. Such measurements shall be far enough away from any adjacent surface to be uninfluenced by any decarburization or lack of decarburization thereon.

3.3.3.4.1 When determining the depth of decarburization, it is permissible to disregard local areas provided the decarburization of such areas does not exceed the above limits by more than 0.005 inch (0.13 mm) and the width is 0.065 inch (1.65 mm) or less.

3.4 Quality:

3.4.1 Steel shall be aircraft-quality conforming to AMS 2301.

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 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 re-entrant grain flow.

3.5 Sizes: Except when exact lengths or multiples of exact lengths are ordered, straight bars 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: Bars shall conform to all applicable requirements of AMS 2251 or MAM 2251.

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 performing all required tests. 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: Tests for all technical requirements are acceptance tests and shall be performed on each heat or lot as applicable.

4.3 Sampling and Testing: Shall be in accordance with the following:

4.3.1 Bars: AMS 2370.

4.3.2 Forgings and Forging Stock: AMS 2372.

4.3.3 Samples for macrostructure rating (3.3.1) shall be full cross-sectional 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.