

Steel Bars and Forgings
1.8Ni - 0.25Mo (0.38 - 0.43C) (4640)
Heat Treated, 125 ksi (862 MPa) Tensile Strength
(Composition similar to UNS K22440)

RATIONALE

AMS6317J 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 heat treated bars and forgings.

1.2 Application

These products have been used typically for parts with sections 1.0 inch (25 mm) and under in nominal thickness requiring a minimum tensile strength of 125 ksi (862 MPa), 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.

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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), www.sae.org.

AMS2251	Tolerances, Low-Alloy Steel Bars
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
AMS2806	Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys
AMS2808	Identification, Forgings
AMS6312	Steel Bars, Forgings, and Tubing 1.8Ni - 0.25Mo (0.38 - 0.43C) (4640)
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 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
ASTM E 384	Knoop and Vickers Hardness of Materials

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	0.38	0.43
Manganese	0.60	0.80
Silicon	0.15	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Nickel	1.65	2.00
Molybdenum	0.20	0.30
Chromium	--	0.20
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:

3.2.1 Bars

Bars shall not be cut from plate. (Also see 4.4.2).

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

Cold finished, hardened, and tempered.

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

Hot finished, or cold finished when so ordered, hardened, and tempered.

3.2.2 Forgings

Hardened and tempered.

3.2.2.1 Forging stock produced to AMS6312 may be used as starting material for forgings.

3.3 Properties

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

3.3.1 Macrostructure

Visual examination of transverse full cross sections from bars and billets, 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

Cross-Sectional Area Square Inches	Cross-Sectional Area Square Centimeters	Macrographs
Up to 36, incl	Up to 232, incl	S2 - R1 - C2
Over 36 to 133, incl	Over 232 to 858 incl	S2 - R2 - C3
Over 133	Over 858	Note 1

Note 1 Limits for larger sizes shall be agreed upon by purchaser and vendor. The purchaser shall have written approval of the agreement from the cognizant engineering organization.

3.3.2 Average Grain Size of Bars and Forgings

Shall be ASTM No. 5 or finer, 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 Decarburization of bars to which 3.3.3.1 is not applicable shall be not greater than shown in Table 3.

TABLE 3A - MAXIMUM DEPTH OF DECARBURIZATION LIMITS, INCH/POUND UNITS

Nominal Diameter or Distance Between Parallel Sides Inches	Total Depth of Decarburization Inch
Up to 0.375, incl	0.010
Over 0.375 to 0.500, incl	0.012
Over 0.500 to 0.625, incl	0.014
Over 0.625 to 1.000, incl	0.017
Over 1.000 to 1.500, incl	0.020
Over 1.500 to 2.000, incl	0.025
Over 2.000 to 2.500, incl	0.030
Over 2.500 to 3.000, incl	0.035

TABLE 3B - MAXIMUM DEPTH OF DECARBURIZATION LIMITS, SI UNITS

Nominal Diameter or Distance Between Parallel Sides Millimeters	Total Depth of Decarburization Millimeter
Up to 9.52, incl	0.25
Over 9.52 to 12.70, incl	0.30
Over 12.70 to 15.88, incl	0.36
Over 15.88 to 25.40, incl	0.43
Over 25.40 to 38.10, incl	0.51
Over 38.10 to 50.80, incl	0.64
Over 50.80 to 63.50, incl	0.76
Over 63.50 to 76.20, incl	0.89

3.3.3.3 Decarburization shall be measured by the metallographic method, by the HR30N scale hardness testing method, or by a traverse method using microhardness testing in accordance with ASTM E 384. The hardness method(s) shall be conducted on a hardened but untempered specimen 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 influenced by any decarburization on the adjacent surface. In case of dispute, the depth of decarburization determined using the microhardness traverse method shall govern.

3.3.3.3.1 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.

3.3.4 Tensile Properties

Specimens, cut longitudinally from bars 1.00 inch (25.4 mm) and under in nominal diameter or distance between parallel sides and from forgings 1.00 inch (25.4 mm) and under in nominal cross-section with axis of specimen in area of gage length within 15 degrees of parallel to forging flow lines, shall have the properties shown in Table 4.

TABLE 4 - MINIMUM TENSILE PROPERTIES

Property	Value
Tensile Strength	125 ksi (862 MPa)
Yield Strength at 0.2% Offset	100 ksi (689 MPa)
Elongation in 4D	16%
Reduction of Area	50%

3.3.4.1 When specified, transverse tensile properties and longitudinal tensile properties of bars over 1.00 inch (25.4 mm) in nominal diameter or distance between parallel sides and of forgings over 1.00 inch (25.4 mm) in nominal cross-section shall be as agreed upon by purchaser and vendor.

3.3.5 Hardness

Shall be 262 to 311 HB, or equivalent (See 8.2), but the product shall not be rejected on the basis of hardness if the tensile property requirements of 3.3.4 are acceptable, determined on specimens taken from the same sample as that with nonconforming hardness or from another sample with similar nonconforming hardness.

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 ordered hot rolled or cold drawn, or ground, turned, or polished shall, after removal of the standard stock removal allowance in accordance with AS1182, be free from seams, laps, tears, and crack open to the machined, 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

Bars shall conform to all applicable requirements of AMS2251.

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 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), macrostructure (3.3.1), average grain size (3.3.2), decarburization (3.3.3), tensile properties (3.3.4), hardness (3.3.5), frequency-severity cleanliness (3.4), 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 a frequency of testing is specified by purchaser.

4.3 Sampling and Testing

4.3.1 Bars

In accordance with AMS2370.

4.3.2 Forgings

In accordance with AMS2372.

4.4 Reports

4.4.1 The vendor of the product shall furnish with each shipment a report showing the results of composition, macrostructure, and frequency-severity cleanliness rating for each heat and for average grain size and tensile properties 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, AMS6317J, product form, 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 (See 3.2.1).

4.5 Resampling and Retesting

4.5.1 Bars

In accordance with AMS2370.

4.5.2 Forgings

In accordance with AMS2372.