

NOTICE OF  
ADOPTION

ADOPTION NOTICE  
20 December 1991  
AMS 6381E  
1 October 1990  
SUPERSEDING  
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Title of Document: Steel Tubing, Mechanical  
0.95Cr - 0.20Mo (0.38 - 0.43C) (SAE 4140)

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400 Commonwealth Drive, Warrendale, PA 15096-0001

# AEROSPACE MATERIAL SPECIFICATION

**SAE** AMS-6381

REV

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Issued 1942-12-01

Revised 1990-10-01

Superseding AMS-6381D

Submitted for recognition as an American National Standard

STEEL TUBING, MECHANICAL  
0.95Cr - 0.20Mo (0.38 - 0.43C) (SAE 4140)

UNS G41400

## 1. SCOPE:

1.1 Form: This specification covers an aircraft-quality, low-alloy steel in the form of mechanical tubing.

1.2 Application: Primarily for parts, 0.500 inch (12.70 mm) and under in section thickness at time of heat treatment, requiring a through-hardening steel capable of developing hardness as high as 50 HRC when properly hardened and tempered and also parts of greater thickness but requiring proportionately lower hardness.

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-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 Steel

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

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2.1.2 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 255 - End-Quench Test for 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, 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:

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 E 350, by spectrochemical methods, or by other analytical methods acceptable to purchaser:

	min	max
Carbon	0.38	0.43
Manganese	0.75	1.00
Silicon	0.15	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	0.80	1.10
Molybdenum	0.15	0.25
Nickel	--	0.25
Copper	--	0.35

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

3.2 Condition: Cold finished having hardness not higher than 25 HRC, or  $\emptyset$  equivalent, except that tubing ordered hot finished and annealed or tempered shall have hardness not higher than 99 HRB, or equivalent; hardness shall be determined in accordance with ASTM A 370.

3.3 Properties: Tubing shall conform to the following requirements; hardness testing shall be performed in accordance with ASTM A 370:

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3.3.1 Macrostructure: Visual examination of transverse sections as in 4.3.1 from blooms or tube rounds, etched in accordance with ASTM E 381 in hot hydrochloric acid, shall show no pipe or cracks. Except as specified in 3.3.1.1, porosity, segregation, inclusions, and other imperfections shall be no worse than the following macrographs of ASTM E 381:

Section Size		Macrographs
Square Inches	Square Centimetres	
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

3.3.1.1 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.

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

3.3.3 Hardenability: Shall be J50=6 minimum, determined on the standard end-quench test specimen in accordance with ASTM A 255 except that the steel shall be normalized at  $1700^{\circ}\text{F} \pm 10$  ( $927^{\circ}\text{C} \pm 6$ ) and the test specimen austenitized at  $1550^{\circ}\text{F} \pm 10$  ( $843^{\circ}\text{C} \pm 6$ ). The hardenability test is not required on tubing which will not yield a suitable specimen but the steel from which the tubing is made shall conform to the hardenability specified.

3.3.4 Decarburization:

3.3.4.1 Tubing ordered ground, turned, or polished shall be free from decarburization on the ground, turned, or polished surfaces. Decarburization on tubing ID shall not exceed the maximum depth specified in Table I.

3.3.4.2 Allowable decarburization of pierced billets, of tube rounds and tubing for redrawing or forging, or of tubing ordered to specified microstructural requirements shall be as agreed upon by purchaser and vendor.

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- 3.3.4.3 Decarburization of tubing to which 3.3.4.1 or 3.3.4.2 is not applicable shall be not greater than shown in Table I:

TABLE I

Nominal Wall Thickness Inch	Depth of Decarburization, Inch	
	ID	OD
Up to 0.109, incl	0.008	0.015
Over 0.109 to 0.203, incl	0.010	0.020
Over 0.203 to 0.400, incl	0.012	0.025
Over 0.400 to 0.600, incl	0.015	0.030
Over 0.600 to 1.000, incl	0.017	0.035
Over 1.000	0.020	0.040

TABLE I (SI)

Nominal Wall Thickness Millimetres	Depth of Decarburization, Millimetres	
	ID	OD
Up to 2.77, incl	0.20	0.38
Over 2.77 to 5.16, incl	0.25	0.51
Over 5.16 to 10.16, incl	0.30	0.64
Over 10.16 to 15.24, incl	0.38	0.76
Over 15.24 to 25.40, incl	0.43	0.89
Over 25.40	0.51	1.02

- 3.3.4.4 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.
- 3.3.4.4.1 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 Tubing, 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 tubing.