



AEROSPACE MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

AMS 6395B

Superseding AMS 6395A

Issued 9-30-66

Revised 10-15-79

UNS G41400

STEEL SHEET, STRIP, AND PLATE
0.95Cr - 0.20Mo (0.38 - 0.43C) (SAE 4140)

1. SCOPE:

1.1 Form: This specification covers an aircraft-quality, low-alloy steel in the form of sheet, strip, and plate.

1.2 Application: Primarily for heat treated parts requiring through-hardening to minimum tensile strength of 180,000 psi (1241 MPa) in nominal section thicknesses up to 0.875 in. (22.22 mm) and proportionately lower strength in heavier thicknesses.

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

2.1 SAE Publications: Available from Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2252 - Tolerances, Low-Alloy Steel Sheet, Strip, and Plate

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

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

AMS 2350 - Standards and Test Methods

AMS 2370 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Wrought Products
Except Forgings and Forging Stock

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

ASTM A370 - Mechanical Testing of Steel Products

ASTM E112 - Estimating the Average Grain Size of Metals

ASTM E350 - Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel,
Ingot Iron, and Wrought Iron

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

2.3.1 Federal Standards:

Federal Test Method Standard No. 151 - Metals; Test Methods

2.3.2 Military Standards:

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

SAE Technical Board rules provide that: "All technical reports, including standards approved and practice recommended, are advisory only. Their use by anyone engaged in industry or trade or by governmental agencies is entirely voluntary. There is no agreement to adhere to or be guided by any technical report. In formulating and approving technical reports, the Board and its Committees will not investigate or consider patents which may apply to the subject matter. Prospective users of the report are responsible for protecting themselves against infringement of patents."

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E350, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other analytical methods approved by 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: The product shall be supplied in the following condition; hardness shall be determined in accordance with ASTM A370:

3.2.1 Sheet and Strip: Cold finished, bright or atmosphere annealed, and descaled if necessary, or hot rolled, annealed if necessary, and descaled, having hardness not higher than 98 HRB or equivalent.

3.2.2 Plate: Hot rolled, annealed if necessary, and descaled, having hardness not higher than 25 HRC or equivalent.

3.3 Properties: The product shall conform to the following requirements; hardness and bend testing shall be performed in accordance with ASTM A370.

3.3.1 Response to Heat Treatment: Product 0.875 in. (22.22 mm) and under in nominal thickness and thicker product reduced to 0.875 in. \pm 0.010 (22.22 mm \pm 0.25) in thickness shall have tensile strength not lower than 180,000 psi (1241 MPa) or hardness not lower than 40 HRC after being hardened by quenching in oil from 1550°F \pm 10 (845°C \pm 5) and tempered for not less than 30 min. at not lower than 900°F (480°C).

3.3.2 Grain Size: Predominantly 5 or finer with occasional grains as large as 3 permissible, determined in accordance with ASTM E112.

3.3.3 Decarburization:

3.3.3.1 Product Under 0.045 In. (1.14 mm) in Nominal Thickness: The method of test and the allowance shall be as agreed upon by purchaser and vendor.

3.3.3.2 Product 0.045 to 0.375 In. (1.14 to 9.52 mm) Excl. in Nominal Thickness:

3.3.3.2.1 Specimens: Shall be the full thickness of the product except that specimens from plate over 0.249 in. (6.32 mm) thick shall be slices approximately 0.250 in. (6.35 mm) thick cut parallel to and preserving one original surface of the plate. Recommended specimen size is 1 x 4 in. (25 x 100 mm).

3.3.3.2.2 Procedure: Specimens shall be hardened by austenitizing and quenching; preferably they shall not be tempered but, if tempered, the tempering temperature shall be not higher than 300° F (150° C). During heat treatment, specimens shall be protected by suitable atmosphere or medium or by suitable plating to prevent carburization or further decarburization. Protective plating, if used, shall then be removed from specimens of product 0.045 to 0.250 in. (1.14 to 6.35 mm), excl, in nominal thickness and a portion of the specimen shall be ground to a depth of 0.050 in. (1.27 mm) or one-half thickness, whichever is less. Specimens from product 0.250 to 0.375 in. (6.35 to 9.52 mm), excl, in nominal thickness shall be ground to remove 0.020 in. (0.51 mm) of metal from the original surface of the plate and a portion of the specimen shall be further ground to a depth of at least one-third the original thickness of the specimen. At least three Rockwell hardness readings shall be taken on each prepared step and each group of readings averaged.

3.3.3.2.3 Allowance:

3.3.3.2.3.1 Product 0.045 to 0.250 In. (1.14 to 6.35 mm), Excl, in Nominal Thickness: The product shall show no layer of complete decarburization, determined microscopically at a magnification not exceeding 100X. It shall also be free from partial decarburization to the extent that the difference in hardness between the original surface and the portion ground as in 3.3.3.2.2 shall be not greater than 2 units on the Rockwell "A" scale.

3.3.3.2.3.2 Product 0.250 to 0.375 In. (6.35 to 9.52 mm), Excl, in Nominal Thickness: Shall be free from decarburization to the extent that the difference in hardness between the two prepared steps shall be not greater than 3 units on the Rockwell "A" scale.

3.3.3.3 Product 0.375 In. (9.52 mm) and Over in Nominal Thickness: The total decarburization, determined microscopically at a magnification not exceeding 100X on the as-supplied plate, shall be not greater than shown in Table I.

TABLE I

Nominal Thickness Inches	Depth of Decarburization Inch
0.375 to 0.500, incl	0.015
Over 0.500 to 1.000, incl	0.025
Over 1.000 to 2.000, incl	0.035
Over 2.000	As agreed upon

TABLE I (SI)

Nominal Thickness Millimetres	Depth of Decarburization Millimetre
9.52 to 12.70, incl	0.38
Over 12.70 to 25.40, incl	0.64
Over 25.40 to 50.80, incl	0.89
Over 50.80	As agreed upon

3.3.4 Bending: Product 0.749 in. (19.02 mm) and under in nominal thickness shall withstand, without cracking, free bending through the angle indicated below around a diameter equal to the nominal thickness of the product with axis of bend parallel to the direction of rolling:

Nominal Thickness		Bend Angle deg
Inch	(Millimetres)	
Up to 0.249	(Up to 6.32, incl)	180
Over 0.249 to 0.749, incl	(Over 6.32 to 9.02, incl)	90

3.3.4.1 Bending requirements for plate over 0.749 in. (19.02 mm) in nominal thickness shall be as agreed upon by purchaser and vendor.

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 internal and external imperfections detrimental to usage of the product.

3.5 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of AMS 2252.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of the product shall supply all samples and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.4. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to ensure that the product conforms to the requirements of this specification.

4.2 Classification of Tests: Tests to determine conformance to all technical requirements of this specification are classified as acceptance tests and shall be performed on each lot.

4.3 Sampling: Shall be in accordance with AMS 2370.

4.4 Reports:

4.4.1 The vendor of the product shall furnish with each shipment three copies of a report showing the results of tests for chemical composition, grain size, and AMS 2301 frequency-severity rating of each heat and the results of tests on each size from each heat to determine conformance to the other technical requirements of this specification. This report shall include the purchase order number, heat number, material specification number and its revision letter, size, and quantity from each heat.

4.4.2 The vendor of finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, material specification number and its revision letter, contractor or other direct supplier of material, part number, and quantity. When material for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of material to determine conformance to the requirements of this specification, and shall include in the report a statement that the material conforms, or shall include copies of laboratory reports showing the results of tests to determine conformance.

∅ 4.5 Resampling and Retesting: Shall be accordance with AMS 2370.