

AEROSPACE MATERIAL SPECIFICATION

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Superseding AMS 6421C

Steel, Bars, Forgings, and Tubing 0.80Cr - 0.85Ni - 0.20Mo - 0.003B (0.35 - 0.40C) (Modified 98B37)

1. SCOPE:

1.1 Form:

This specification covers an aircraft-quality, low-alloy steel in the form of bars, forgings, mechanical tubing, and forging stock.

1.2 Application:

These products have been used typically for parts, 0.875 inch (22.22 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 for parts of greater thickness requiring proportionately lower hardness, 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 canceled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

- 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 2301 Steel Cleanliness, Aircraft Quality Magnetic Particle Inspection Procedure
- MAM 2301 Steel Cleanliness, Aircraft Quality Magnetic Particle Inspection Procedure, Metric (SI) Measurement
- AMS 2370 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel, Wrought Products and Forging Stock

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2.1 (Continued):

- AMS 2372 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Forgings
 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
- AS1182 Standard Machining Allowance, Aircraft Quality and Premium Aircraft-Quality Steel Bars and Mechanical Tubing

2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

- ASTM A 255 Determining 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 Steel Bars, Billets, Blooms, and Forgings
 ASTM E 384 Microindentation 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	0.35	0.40
Manganese	0.65	0.85
Silicon	0.15	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	0.70	0.90
Nickel	0.70	1.00
Molybdenum	0.15	0.25
Boron	0.0005	0.005
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 A 370:

3.2.1 Bars:

3.2.1.1 Bars 0.500 Inch (12.70 mm) and Under in Nominal Diameter or Least Distance Between Parallel Sides: Cold finished, having tensile strength not higher than 130 ksi (896 MPa) or equivalent hardness (See 8.2).

3.2.1.2 Bars Over 0.500 Inch (12.70 mm) in Nominal Diameter or Least Distance Between Parallel Sides: Hot finished and annealed, unless otherwise ordered, having hardness not higher than 229 HB, or equivalent (See 8.3). 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 unless otherwise ordered having hardness not higher than 25 HRC, or equivalent (See 8.3). Tubing ordered hot finished and annealed 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 A 370:

3.3.1 Macrostructure: Visual examination of transverse full cross-sections from bars, billets, tube rounds, and forging stock, 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

Square Inches	Square Centimeters	Macrographs
Up to 36, incl	Up to 232, incl	S2 - R1 - C2
Over 36 to 100, incl	Over 232 to 645, incl	S2 - R2 - C3

3.3.2 Average Grain Size: Shall be ASTM No. 5 or finer, determined in accordance with ASTM E 112 (See 8.4).

- 3.3.3 Hardenability: Shall be J1/16 inch (1.6 mm) = 59 HRC maximum and J10/16 inch (15.9 mm) = 50 HRC minimum (See 8.5), determined on the standard end-quench test specimen in accordance with ASTM A 255 except that the steel shall be normalized at 1700 °F ± 10 (927 °C ± 6) and the test specimen austenitized at 1550 °F ± 10 (843 °C ± 6).
- 3.3.4 Decarburization:
- 3.3.4.1 Bars and tubing ordered ground, turned, or polished shall be free from decarburization on the ground, turned, or polished surfaces. Decarburization on the tubing ID shall not exceed the maximum depth specified in Table 4.
- 3.3.4.2 Allowable decarburization of bars, billets, and tube rounds ordered for redrawing or forging or to specified microstructural requirements shall be as agreed upon by purchaser and vendor.
- 3.3.4.3 Decarburization of bars to which 3.3.4.1 or 3.3.4.2 is not applicable shall be not greater than shown in Table 3.

TABLE 3A - Maximum 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
Over 3.000 to 4.000, incl	0.045

TABLE 3B - Maximum Decarburization Limits, SI Units

Nominal Diameter or Distance Between Parallel Sides Millimeters			Total Depth of Decarburization Millimeters
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
Over	76.20 to	101.60, incl	1.14

3.3.4.4 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 4.

TABLE 4A - Maximum Decarburization Limits, Inch/Pound Units

Nominal Wall Thickness Inches	Total Depth of Decarburization	Total Depth of Decarburization
	Inch ID	Inch 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 4B - Maximum Decarburization Limits, SI Units

Nominal Wall Thickness Millimeter	Total Depth of Decarburization	Total Depth of Decarburization
	Millimeters ID	Millimeters 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

3.3.4.5 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.

3.3.4.5.1 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:

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 AMS 2301 or MAM 2301.

3.4.2 Bars and mechanical tubing 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 surface.

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:

Shall conform to all applicable requirements of the following:

3.5.1 Bars: In accordance with AMS 2251 or MAM 2251.

3.5.2 Mechanical Tubing: In accordance with AMS 2253 or MAM 2253.

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 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), condition (3.2), macrostructure (3.3.1), average grain size (3.3.2), hardenability (3.3.3), decarburization (3.3.4), frequency-severity cleanliness (3.4.1), 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:

Shall be in accordance with the following:

4.3.1 Bars, Mechanical Tubing, and Forging Stock: In accordance with AMS 2370.

4.3.2 Forgings: In accordance with AMS 2372.

4.4 Reports:

The vendor of the product shall furnish with each shipment a report showing the results of chemical composition, macrostructure, hardenability, and frequency-severity cleanliness rating for each heat, and for condition and average grain size 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, AMS 6421D, size and quantity. If forgings are supplied, the size and melt source of stock used to make the forgings shall also be included.

4.5 Resampling and Retesting:

Shall be as follows:

4.5.1 Bars, Mechanical Tubing and Forging Stock: In accordance with AMS 2370.

4.5.2 Forgings: In accordance with AMS 2372.