



AEROSPACE MATERIAL SPECIFICATION

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

AMS 6438B

Superseding AMS 6438A

Issued 6-30-64
Revised 12-15-74

STEEL SHEET, STRIP, AND PLATE
1.05Cr - 0.55Ni - 1.0Mo - 0.12V (0.45 - 0.50C)
Premium Quality, Consumable Electrode Melted

1. SCOPE:

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

1.2 Application: Primarily for heat treated parts which may be welded during fabrication and which require through-hardening to high strength levels, for use at temperatures up to 600° F (316° C).

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, Pennsylvania 15096.

2.1.1 Aerospace Material Specifications:

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

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

AMS 2300 - Premium 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, Pennsylvania 19103.

ASTM A370 - Mechanical Testing of Steel Products

ASTM A604 - Macroetch Testing of Consumable Electrode Vacuum Arc Remelted
Steel Bars and Billets

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, Pennsylvania 19120.

2.3.1 Federal Standards:

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

3. TECHNICAL REQUIREMENTS:

SAE Technical Board rules provide that: "All technical reports, including standards approved and practices recommended, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no agreement to adhere to any SAE standard or recommended practice, and no commitment to conform 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 liability for infringement of patents."

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 approved analytical methods:

	min	max
Carbon	0.45	0.50
Manganese	0.60	0.90
Silicon	0.15	0.30
Phosphorus	--	0.015
Sulfur	--	0.015
Chromium	0.90	1.20
Nickel	0.40	0.70
Molybdenum	0.90	1.10
Vanadium	0.08	0.15
Copper	--	0.35

Ø 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 tests shall be conducted in accordance with ASTM A370:

Ø 3.2.1 Sheet and Strip: Cold finished, bright or atmosphere annealed, and descaled if necessary; or hot rolled, annealed or normalized and tempered, and descaled; having hardness not higher than 30 HRC or equivalent. When spheroidize anneal is specified, hardness shall be not higher than 100 HRB or equivalent.

Ø 3.2.2 Plate: Hot rolled, annealed or normalized and tempered, and descaled, having hardness not higher than 30 HRC or equivalent. When spheroidize anneal is specified, hardness shall be not higher than 100 HRB or equivalent.

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

Ø 3.3.1 Grain Size: Predominantly 5 or finer with occasional grains as large as 3 permissible, ASTM E112, McQuaid-Ehn test.

Ø 3.3.2 Macrostructure: Visual examination of transverse sections from slabs, billets, or suitable rerolled product, etched in accordance with ASTM A604 in hot hydrochloric acid (1:1) at 160° - 180° F (71.1° - 82.2° C) for sufficient time to develop a well-defined macrostructure, shall show no injurious imperfections such as pipe, cracks, porosity, segregation, and inclusions detrimental to fabrication or to performance of parts. Macrostructure shall be equal to or better than the following macrographs of ASTM A604:

Class	Condition	Severity
1	Freckles	B
2	White Spots	C
3	Radial Segregation	C
4	Ring Pattern	As agreed upon

Ø 3.3.3 Decarburization:

Ø 3.3.3.1 Product Under 0.045 In. (1.14 mm) in 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 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. or 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 (149° 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 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 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 Thickness: The product shall show no layer of complete decarburization as 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 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 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 Millimetres
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 Response to Heat Treatment: Product hardened by heating in a protective atmosphere to a temperature within the range 1600° - 1650° F (871.1° - 898.9° C), holding at the selected temperature within $\pm 10^\circ$ F ($\pm 5.6^\circ$ C) for a time commensurate with section thickness but not less than 20 min., and quenched in oil, stress relieved at 400° F ± 10 (204.4° C ± 5.6) for 60 min. ± 5 , cooled in air, and tempered at not lower than 1000° F (538° C) for not less than 4 hr, and cooled in air shall conform to the following requirements:

3.3.4.1 Tensile Properties:

Tensile Strength, min	224,000 psi (1544 MPa)
Yield Strength at 0.2% Offset, min	195,000 psi (1345 MPa)
Elongation in 2 in. (50.8 mm) or 4D, min	7%

3.3.4.2 Hardness: Product should have hardness not lower than 47 HRC or equivalent but the product shall not be rejected on the basis of hardness if the tensile property requirements are met.

3.4 Quality:

3.4.1 Steel shall be premium quality conforming to AMS 2300; it shall be multiple melted using vacuum consumable electrode process in the remelt cycle.

3.4.2 The product shall be uniform in quality and condition, clean, sound, and free from foreign materials and from internal and external imperfections detrimental to fabrication or to performance of parts.

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 assure 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 or routine control tests.

4.3 Sampling: Shall be in accordance with AMS 2370 and the following; a heat shall be the consumable electrode remelted ingots produced from steel originally melted as a single furnace charge:

4.3.1 Tensile test specimens from widths 9 in. (229 mm) and over shall be taken with the axis of the specimen perpendicular to the direction of rolling; for widths less than 9 in. (229 mm), tensile test specimens shall be taken with the axis parallel to the direction of rolling.

4.4 Reports:

4.4.1 The vendor of the product shall furnish with each shipment three copies of a report of the results of tests for chemical composition, grain size, macrostructure, and AMS 2300 frequency-severity rating for each heat in the shipment and the results of tests on each size from each heat to determine conformance to the tensile property and hardness requirements after heat treatment. This report shall include the purchase order number, heat number, material specification number and its revision letter, size, and quantity from each heat.