

UNS G51986

STEEL BARS, FORGINGS, AND TUBING  
1.0Cr (0.98 - 1.10C) (SAE 51100)  
Electroslag Remelted

1. SCOPE:

1.1 Form: This specification covers a premium-cleanliness, low-alloy steel in the form of bars, forgings, mechanical tubing, and forging stock.

1.2 Application: Primarily for parts of small cross section, such as bearing components, requiring a through-hardening steel, usually with hardness of approximately 60 HRC, which are subject to very rigid inspection standards.

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 SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

- AMS 2251 - Tolerances, Low-Alloy Steel Bars
- AMS 2253 - Tolerances, Carbon and Alloy Steel Tubing
- AMS 2259 - Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
- 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
- AMS 2372 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Forgings and Forging Stock
- AMS 2375 - Control of Forgings Requiring First-Article Approval
- AMS 2806 - Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Heat and Corrosion Resistant Steels and Alloys
- AMS 2808 - Identification, Forgings

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 or their use by governmental agencies 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."

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

ASTM E45 - Determining the Inclusion Content of Steels

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

2.3 U.S. 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

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Shall conform to the following percentages by weight,  $\phi$  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	0.98	1.10
Manganese	0.25	0.45
Silicon	0.15	0.35
Phosphorus	--	0.015
Sulfur	--	0.015
Chromium	0.90	1.15
Nickel	--	0.25
Molybdenum	--	0.10
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 A370:

3.2.1.1 Bars 0.500 In. (12.50 mm) and Under in Nominal Diameter or Distance Between Parallel Sides: Cold finished, with microstructure of spheroidized cementite in ferrite matrix, having tensile strength not higher than 120,000 psi (825 MPa) or equivalent hardness.

3.2.1.2 Bars Over 0.500 In. (12.50 mm) in Nominal Diameter or Distance Between Parallel Sides: Hot finished and annealed, with microstructure of spheroidized cementite in ferrite matrix, having hardness not higher than 207 HB or equivalent except that 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 with microstructure of spheroidized cementite in ferrite matrix. Tubing ordered hot finished and annealed shall have hardness not higher than 95 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 A370:

3.3.1 Inclusion Rating: Shall be as follows:

3.3.1.1 Macrostructure: Visual examination of transverse sections as in 4.3.3 from bars, billets, tube rounds or tubes, and forging stock, etched in accordance with ASTM A604 in hot hydrochloric acid (1:1) at 160° - 180°F (70° - 80°C) for sufficient time to develop a well-defined macrostructure, shall show no pipe or cracks. Except as specified in 3.3.1.1.1, porosity, segregation, inclusions, and other imperfections shall be no worse than the following macrographs of ASTM A604:

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

3.3.1.1.1 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.

3.3.1.2 Micro-Inclusion Rating: No specimen as in 4.3.4 shall exceed the following limits, determined in accordance with ASTM E45, Method D:

Type	Inclusion Rating			
	A	B	C	D
Thin	2.0	1.5	1.5	1.5
Heavy	1.0	1.0	1.0	1.0

3.3.1.2.1 For types A, B, and C, thin combined, there shall be not more than three fields of No. 2.0 A type or No. 1.5 B and C types and not more than five other lower rateable A, B, and C type thin fields per specimen. For D type thin, there shall be not more than five No. 1.5 thin fields. Any number of lower rateable D type thin fields per specimen is permitted. There shall be not more than one field each of No. 1.0 type A, B, or C or three fields of type D heavy per specimen. In addition, the thickness of the D type heavy shall not exceed 0.0005 in. (0.012 mm).

3.3.1.2.2 A rateable field is defined as one which has a type A, B, C, or D inclusion rating of at least 1.0 thin or heavy in accordance with the Jernkontoret chart, Plate III, ASTM E45.

3.3.2 Response to Heat Treatment: Specimens as in 4.3.5, protected by suitable means or treated in a neutral atmosphere to minimize scaling and prevent either carburization or decarburization, shall have substantially uniform hardness not lower than 63 HRC at any point below any permissible decarburization after being placed in a furnace which is at 1525°F + 10 (830°C + 5), allowed to heat to 1525°F + 10 (830°C + 5), held at heat for 20 min. + 2, and quenched in commercial paraffin oil (100 SUS at 100°F (38°C) at room temperature.

3.3.3 Decarburization:

3.3.3.1 Bars and 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 3.3.3.4.

3.3.3.2 Allowable decarburization of bars, billets, and tube rounds ordered for redrawing or forging or to specified microstructural requirements other than spheroidized cementite in ferrite matrix shall be as agreed upon by purchaser and vendor.

3.3.3.3 Decarburization of bars for anti-friction balls and rollers to which  $\emptyset$  3.3.3.1 or 3.3.3.2 is not applicable shall be not greater than shown in Table I.

TABLE I

Nominal Diameter or Distance Between Parallel Sides Inch	Depth of Decarburization	
	Hot Finished	Cold Finished
Up to 0.250, incl	0.005	0.003
Over 0.250 to 0.500, incl	0.006	0.004
Over 0.500 to 0.750, incl	0.008	0.006
Over 0.750 to 1.000, incl	0.010	0.008

TABLE I (SI)

Nominal Diameter or Distance Between Parallel Sides Millimetres	Depth of Decarburization Millimetres	
	Hot Finished	Cold Finished
Up to 6.25, incl	0.12	0.08
Over 6.25 to 12.50, incl	0.15	0.10
Over 12.50 to 18.75, incl	0.20	0.15
Over 18.75 to 25.00, incl	0.25	0.20

3.3.3.4 Decarburization of bars and of the ID and OD of tubes to which 3.3.3.1,  $\emptyset$  3.3.3.2, or 3.3.3.3 is not applicable shall be not greater than shown in Table II.

TABLE II

Nominal Diameter or Distance Between Parallel Sides Inches	Depth of Decarburization, Inch				
	Bars		Tubes		
	Hot Finished	Annealed	Cold Finished	Annealed	Cold Finished
Up to 1.000, incl	0.012	0.015	0.012	0.012	0.010
Over 1.000 to 2.000, incl	0.017	0.022	0.015	0.020	0.014
Over 2.000 to 3.000, incl	0.025	0.030	0.025	0.030	0.019
Over 3.000 to 4.000, incl	0.035	0.045	0.035	0.035	0.024
Over 4.000 to 5.000, incl	0.055	0.065	0.055	0.040	0.028

TABLE II (SI)

Nominal Diameter or Distance Between Parallel Sides Millimetres	Depth of Decarburization, Millimetres				
	Bars			Tubes	
	Hot Finished	Annealed	Cold Finished	Annealed	Cold Finished
Up to 25.00, incl	0.30	0.38	0.30	0.30	0.25
Over 25.00 to 50.00, incl	0.42	0.55	0.38	0.50	0.35
Over 50.00 to 75.00, incl	0.62	0.75	0.62	0.75	0.48
Over 75.00 to 100.00, incl	0.88	1.12	0.88	0.88	0.60
Over 100.00 to 125.00, incl	1.40	1.62	1.40	1.00	0.70

3.3.3.5 Limits for depth of decarburization of bars and tubes over 5.000 in. (125.00 mm) in nominal diameter or distance between parallel sides shall be as agreed upon by purchaser and vendor.

3.3.3.6 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.

3.3.3.6.1 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 in. (0.13 mm) and the width is 0.065 in. (1.65 mm) or less.

3.4 Quality:

3.4.1 Steel shall be premium-cleanliness conforming to AMS 2300; it shall be multiple melted using electroslag remelting practice in the remelt cycle.

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.

3.4.2.1 Bars and tubing ordered ground, turned, or polished shall be free from seams, laps, tears, and cracks open to the ground, turned, or polished surfaces.

- 3.4.2.2 Product 5.000 in. (125.00 mm) and under in nominal diameter or distance between parallel sides ordered to surface conditions other than ground, turned, or polished shall, after removal of the standard machining allowance, be free from seams, laps, tears, cracks, and other defects exposed to the machined surfaces. Standard machining allowance shall be equal, but not in addition, to the decarburization limits of 3.3.3 for the form and condition of the product ordered.
- 3.4.2.2.1 Standard machining allowance for product over 5.000 in. (125.00 mm) in nominal diameter or distance between parallel sides shall be as agreed upon by purchaser and vendor.
- 3.5 Sizes: Except when exact lengths or multiples of exact lengths are ordered, straight bars and tubing will be acceptable in mill lengths of 6 - 20 ft (2 - 6 m) but not more than 10% of any shipment shall be supplied in lengths shorter than 10 ft (3 m).
- 3.6 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of the following:
- 3.6.1 Bars: AMS 2251.
- 3.6.2 Mechanical Tubing: AMS 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 performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.5. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to the requirements of this specification.
- 4.2 Classification of Tests:
- 4.2.1 Acceptance Tests: Tests to determine conformance to all technical requirements of this specification are classified as acceptance tests and shall be performed on each heat or lot as applicable.
- 4.2.2 Preproduction Tests: Tests of forgings to determine conformance to all applicable technical requirements of this specification when AMS 2375 is specified are classified as preproduction tests and shall be performed on the first-article shipment of a forging to a purchaser, when a change in material and/or processing requires reapproval as in 4.4, and when purchaser deems confirmatory testing to be required.
- 4.2.2.1 For direct U.S. Military procurement of forgings, substantiating test data and, when requested, preproduction forgings shall be submitted to the cognizant agency as directed by the procuring activity, the contracting officer, or the request for procurement.

# AMS 6446B

4.3 Sampling: Shall be in accordance with the following; a heat shall be the  
∅ electroslag remelted ingots produced from steel originally melted as a single furnace charge:

4.3.1 Bars and Mechanical Tubing: AMS 2370.

4.3.2 Forgings and Forging Stock: AMS 2372.

4.3.3 Samples for macrostructure (3.3.1.1) testing shall be full cross-sectional  
∅ specimens obtained from the finished billet or suitable rerolled product representing the top and bottom of at least the first, middle, and last usable ingots of each heat.

4.3.4 Samples for micro-inclusion (3.3.1.2) rating shall consist of not less  
∅ than six specimens obtained from the full cross-section of billet stock taken from the top and bottom of at least the first, middle, and last usable ingots from each heat.

4.3.5 Samples for response to heat treatment (3.3.2) shall be as follows:

4.3.5.1 Specimens from bars shall be full cross-sections of the bar, ground on both faces normal to the axis so that length is 0.30 in.  $\pm$  0.010 (7.5 mm  $\pm$  0.25).

4.3.5.2 Specimens from mechanical tubing shall be full cross-sections of the tubing, shall have wall thickness not over 0.625 in. (16 mm), with wall  
∅ thicknesses over 0.625 in. (16 mm) being turned to 0.625 in.  $\pm$  0.010 (16 mm  $\pm$  0.25), and shall be ground on both faces so that length is 0.30 in.  $\pm$  0.010 (7.5 mm  $\pm$  0.25).

4.4 Approval: When specified, approval and control of forgings shall be in accordance with AMS 2375.

4.5 Reports:

4.5.1 The vendor of the product shall furnish with each shipment three copies of a report showing the results of tests for chemical composition, inclusion rating, and AMS 2300 frequency-severity rating of each heat and for the response to heat treatment of each lot. This report shall include the purchase order number, heat number, AMS 6446B, size, and quantity from each heat. If forgings are supplied, the part number and the size and melt source of stock used to make the forgings shall also be included.