

# AEROSPACE MATERIAL SPECIFICATION

**SAE** AMS6476

REV. D

Issued 1988-04  
Revised 2011-05

Superseding AMS6476C

Steel, Bars, Forgings, and Tubing  
0.50Cr - 0.12Mo (0.89 - 1.01C)

(Composition similar to UNS K19526)

## RATIONALE

.AMS6476D results from a Five Year Review and update of this specification.

### 1. SCOPE

#### 1.1 Form

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

#### 1.2 Application

These products have been used typically for bearing components requiring a through-hardening steel usually with hardness of approximately 60 HRC and section thickness under 0.50 inch (12.7 mm), 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 cancelled and no superseding document has been specified, the last published issue of that document shall apply.

#### 2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), or [www.sae.org](http://www.sae.org).

AMS2251 Tolerances, Low-Alloy Steel Bars

AMS2253 Tolerances, Carbon and Alloy Steel Tubing

AMS2259 Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels

AMS2370 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Wrought Products and Forging Stock

AMS2372 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Forgings

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**SAE WEB ADDRESS:**

AMS2806	Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys
AMS2808	Identification, Forgings
AS1182	Standard Stock Removal Allowance, Aircraft-Quality and Premium Aircraft-Quality Steel Bars and Mechanical Tubing

## 2.2 ASTM Publications

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, or [www.astm.org](http://www.astm.org).

ASTM A 370	Mechanical Testing of Steel Products
ASTM E 45	Determining the Inclusion Content of Steel
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	Knoop and Vickers Hardness Testing 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	0.89	1.01
Manganese	0.50	0.80
Silicon	0.15	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	0.40	0.60
Molybdenum	0.08	0.15
Nickel	--	0.25
Copper	--	0.35

#### 3.1.1 Check Analysis

Composition variations shall meet the applicable requirements of AMS2259.

### 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

Bar shall not be cut from plate.

### 3.2.1.1 Bars 0.500 Inch (12.70 mm) and Under in Nominal Diameter or Least Distance Between Parallel Sides

Cold finished, with microstructure of spheroidized cementite in a ferrite matrix, having tensile strength not higher than 120 ksi (827 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

Unless otherwise ordered, hot finished and annealed, with microstructure of spheroidized cementite in a ferrite matrix, having hardness not higher than 207 HB, or equivalent (See 8.3). Bars ordered cold finished may have hardness as high as 248 HB, or equivalent (See 8.3).

### 3.2.2 Forgings

As ordered.

### 3.2.3 Mechanical Tubing

Unless otherwise ordered, 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 (See 8.3).

### 3.2.4 Forging or Tubing Stock

As ordered by the forging or tubing 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 - MAXIMUM MACROSTRUCTURE RATINGS

Section Size Square Inches	Section Size 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 Micro-Inclusion Rating of Each Heat

One or more specimens from each ingot tested, as well as two-thirds of the total number of specimens and the average of all specimens, shall not exceed the limits shown in Table 3, determined in accordance with ASTM E 45, Method A.

TABLE 3 - MICRO-INCLUSION RATING

Type	A	B	C	D
Thin	2.5	2.0	0.5	1.0
Heavy	1.5	1.0	0.5	1.0

### 3.3.3 Response to Heat Treatment for Bars, Forgings, and Tubing

Specimens as in 4.3.3, 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  $1525\text{ }^{\circ}\text{F} \pm 10$  ( $829\text{ }^{\circ}\text{C} \pm 6$ ), allowed to heat to  $1525\text{ }^{\circ}\text{F} \pm 10$  ( $829\text{ }^{\circ}\text{C} \pm 6$ ), held at heat for 20 minutes  $\pm 2$ , and quenched in commercial paraffin oil (90 to 110 SUS at  $100\text{ }^{\circ}\text{F}$  ( $38\text{ }^{\circ}\text{C}$ )) at room temperature.

### 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 other than spheroidized cementite in a ferrite matrix shall be as agreed upon by purchaser and vendor.

3.3.4.3 Decarburization of bars and of the ID and OD of tubes 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 Diameter or Distance Between Parallel Sides Inches	Total Depth of Decarburization				
	Bars, Hot	Bars	Bars, Cold	Tubes	Tubes, Cold
	Finished Inch	Annealed Inch	Finished Inch	Annealed Inch	Finished Inch
Up to 0.250, incl	0.005	0.015	0.003	0.012	0.010
Over 0.250 to 0.500, incl	0.006	0.015	0.004	0.012	0.010
Over 0.500 to 0.750, incl	0.008	0.015	0.006	0.012	0.010
Over 0.750 to 1.000, incl	0.010	0.015	0.008	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 4B - MAXIMUM DECARBURIZATION LIMITS, SI UNITS

Nominal Diameter or Distance Between Parallel Sides Millimeters	Total Depth of Decarburization				
	Bars, Hot	Bars	Bars, Cold	Tubes	Tubes, Cold
	Finished Millimeters	Annealed Millimeters	Finished Millimeters	Annealed Millimeters	Finished Millimeter
Up to 6.35, incl	0.13	0.38	0.08	0.30	0.25
Over 6.35 to 12.70, incl	0.15	0.38	0.10	0.30	0.25
Over 12.70 to 19.05, incl	0.20	0.38	0.15	0.30	0.25
Over 19.05 to 25.40, incl	0.25	0.38	0.20	0.30	0.25
Over 25.40 to 50.80, incl	0.43	0.56	0.38	0.51	0.36
Over 50.80 to 76.20, incl	0.64	0.76	0.64	0.76	0.48
Over 76.20 to 101.60, incl	0.89	1.14	0.89	0.89	0.61
Over 101.60 to 127.00, incl	1.40	1.65	1.40	1.02	0.71

3.3.4.4 Decarburization shall be measured by the metallographic method, by HR 30N 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.

3.3.4.4.1 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

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 Bars and tubing ordered hot rolled or cold drawn, or ground, turned, or polished, shall, after removal of the standard stock removal allowance in accordance with AS1182, be free from seams, laps, tears, and cracks open to the ground, turned, or polished surface.

3.4.2 Grain flow of die forgings, except in areas that contain flash-line end grain, shall follow the general contour of the forgings showing no evidence of reentrant grain flow.

### 3.5 Tolerances

Shall be as follows:

#### 3.5.1 Bars

In accordance with AMS2251.

#### 3.5.2 Mechanical Tubing

In accordance with AMS2253.

## 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 to 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), micro-inclusion rating (3.3.2), response to heat treatment (3.3.3), decarburization (3.3.4), and tolerance (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 (3.4.2) is a periodic test and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

#### 4.3 Sampling and Testing

##### 4.3.1 Bars, Mechanical Tubing, and Forging or Tubing Stock

In accordance with AMS2370.

##### 4.3.2 Forgings

In accordance with AMS2372.

##### 4.3.3 Samples for response to heat treatment (3.3.3) shall be as follows:

4.3.3.1 Specimens from bars shall be full cross-sections of the bar machined on both faces normal to the axis so that length is 0.50 inch  $\pm$  0.010 (12.7 mm  $\pm$  0.25).

4.3.3.2 Specimens from mechanical tubing shall be full cross-sections of the tubing, shall have wall thickness not over 0.625 inch (15.88 mm), with wall thicknesses over 0.625 inch (15.88 mm) being turned to 0.625 inch  $\pm$  0.010 (15.88 mm  $\pm$  0.25), and shall be machined on both faces so that length is 0.50 inch  $\pm$  0.010 (12.7 mm  $\pm$  0.25).

#### 4.4 Reports

4.4.1 The vendor of the bars, forgings, and tubing shall furnish with each shipment a report showing the results of tests for composition, macrostructure and micro-inclusion rating of each heat, and for response to heat treatment 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, AMS6476D, product form and size (and/or part number, if applicable), and quantity. If forgings are supplied, the size and melt source of stock used to make the forgings shall also be included.

4.4.2 Report the nominal metallurgically worked cross sectional size and the cut size, if different (See 3.2.1).

4.4.3 The vendor of forging or tubing stock shall furnish with each shipment a report showing the results of tests for composition, macrostructure, and micro-inclusion rating of each heat and the results of any additional property requirements imposed by 8.6. This report shall include the purchase order number, heat number, AMS6476D, size and quantity

#### 4.5 Resampling and Retesting

##### 4.5.1 Bars, Mechanical Tubing, and Forging or Tubing Stock

In accordance with AMS2370.

##### 4.5.2 Forgings

In accordance with AMS2372.