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

AEROSPACE MATERIAL SPECIFICATION

AMS 2808B
Superseding AMS 2808A
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IDENTIFICATION
Forgings

1. SCOPE: This specification covers requirements for identification of forgings of all types, including rolled rings.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Standards (AS) shall apply.

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

2.1.1 Aerospace Standards:

AS 478 - Identification Marking Methods

3. REQUIREMENTS: Identification marking methods shall conform to AS 478, unless otherwise specified. The required information and the type and location of identification marking shall be as specified on the forging drawing or purchase order. When specific identification is not specified, each forging shall be identified with at least the following information:

3.1 Metallic Materials Other Than Aluminum, Magnesium, and Their Alloys:

3.1.1 Die Forgings:

3.1.1.1 Minimum Identification: Shall be as follows:

Forging/Part Number
Heat Identification
Vendor Identification

3.1.1.2 Optional Identification: When required, each forging shall also be marked with the following information:

Serial Numbers and/or Lot Numbers
Special Acceptance Stamps

3.1.1.3 Special Identification: Marking requirements not covered by 3.1.1.1 or 3.1.1.2 shall be as agreed upon by purchaser and vendor.

3.1.2 Hand Forgings: Each forging shall be steel impression stamped or ink marked with the information required by 3.1.1, unless otherwise specified. In addition, an arrow indicating the direction of longitudinal grain flow shall be included in the marking.

3.1.2.1 The marking on square or rectangular hand forgings shall be on a face parallel to the long-transverse grain direction. The marking location for other hand forgings, such as rounds, biscuits, or contoured shapes, shall be at the option of the forging vendor, unless otherwise specified.

3.1.3 Small Forgings: When the forging configuration does not permit identification marking as in 3.1.1, the markings to appear on the forging shall be as specified on the forging drawing or purchase order and all other required marking shall be provided by the forging vendor by tagging or by marking on the container.

3.1.4 Forged or Rolled Rings: Each forged or rolled ring shall be identified in accordance with 3.1.1, unless otherwise specified. In addition, an arrow indicating the direction of predominant grain flow shall be applied when this direction is other than circumferential.

3.2 Aluminum, Magnesium, and Their Alloys:

3.2.1 Die Forgings:

3.2.1.1 Minimum Identification: Shall be as follows:

Forging/Part Number
Alloy Designation and Condition/Temper
Vendor Identification
Die Equipment/Cavity Number or Letter, when more than one set of dies is used
Heat Identification and/or Lot Number

3.2.1.2 Optional Identification: When required, each forging shall also be marked with the following information:

Serial Numbers
Inspection Acceptance Stamps

3.2.1.3 Special Identification: Marking requirements not covered by 3.2.1.1 or 3.2.1.2 shall be as agreed upon by purchaser and vendor.

3.2.2 Hand Forgings: Each forging shall be steel impression stamped or ink marked with the information required by 3.2.1, unless otherwise specified. In addition, an arrow indicating the direction of longitudinal grain flow shall be included in the marking.

3.2.2.1 The marking on square or rectangular hand forgings shall be on a face parallel to the long-transverse grain direction. The marking location for other hand forgings, such as rounds, biscuits, or contoured shapes, shall be at the option of the forging vendor, unless otherwise specified.

3.2.3 Small Forgings: When the forging configuration does not permit identification marking as in 3.2.1, the markings to appear on the forging shall be as specified on the forging drawing or purchase order and all other required marking shall be provided by the forging vendor by tagging or by marking on the container.

3.2.4 Forged or Rolled Rings: Each forged or rolled ring shall be identified in accordance with 3.2.1, unless otherwise specified. In addition, an arrow indicating the direction of predominant grain flow shall be applied when this direction is other than circumferential.

3.3 Test Material: When test material is a separate entity, or is removed from the parent forging, it shall be identified in such a manner as to afford traceability to the forging or forgings which it represents and, if applicable, to the location and grain direction within the forging. This identification shall be maintained until testing is completed. Any of the marking methods included in AS 478 may be used.

3.4 Identification Changes: If dies are used to produce forgings of different materials, any raised identification marking not applicable to the changed material shall be ground off the forging and the applicable identification shall be impression marked on the forging in the same location.