

AEROSPACE MATERIAL SPECIFICATION

SAE

AMS 4534A

Issued JUL 1991
Revised SEP 1994

Superseding AMS 4534

Submitted for recognition as an American National Standard

COPPER-BERYLLIUM ALLOY, BARS AND RODS
98Cu - 1.9Be
Solution Heat Treated, Cold Worked, and
Precipitation Heat Treated (TH04, formerly HT)

UNS C17200

1. SCOPE:

1.1 Form:

This specification covers a copper-beryllium alloy in the form of bars and rods.

1.2 Application:

These products have been used typically for parts requiring a combination of high strength, wear resistance, and corrosion resistance, and where thermal conductivity, electrical conductivity, and low magnetic susceptibility may be important, but usage is not limited to such applications.

1.3 Safety - Hazardous Materials:

While the materials, methods, applications, and processes described or referenced in this specification may involve the use of hazardous materials, this specification does not address the hazards which may be involved in such use. It is the sole responsibility of the user to ensure familiarity with the safe and proper use of any hazardous materials and to take necessary precautionary measures to ensure the health and safety of all personnel involved.

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

2.1 SAE Publications:

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

AMS 2221 Tolerances, Copper and Copper Alloy Bars and Rods
 MAM 2221 Tolerances, Metric, Copper and Copper Alloy Bars and Rods
 AMS 2750 Pyrometry

2.2 ASTM Publications:

Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

ASTM B 249 General Requirements for Wrought Copper and Copper-Alloy Rod, Bar, and Shapes
 ASTM B 249M General Requirements for Wrought Copper and Copper-Alloy Rod, Bar, and Shapes (Metric)
 ASTM E 3 Preparation of Metallographic Specimens
 ASTM E 8 Tension Testing of Metallic Materials
 ASTM E 8M Tension Testing of Metallic Materials (Metric)
 ASTM E 18 Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials
 ASTM E 112 Determining the Average Grain Size
 ASTM E 478 Chemical Analysis of Copper Alloys

2.3 U.S. Government Publications:

Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

MIL-C-3993 Copper and Copper-Base Alloy Mill Products, Packaging of

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 478, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - Composition

Element	min	max
Beryllium	1.80	2.00
Cobalt + Nickel	0.20	--
Cobalt + Nickel + Iron	--	0.6
Aluminum	--	0.20
Silicon	--	0.20
Copper (3.1.1)	remainder	
Copper + sum of all named elements (3.1.2)	99.5	--

3.1.1 Applicable when copper is not determined by analysis. The reported (certified) value is the difference between the sum of all other specified elements and 100% and will therefore include unnamed elements. Limits for unnamed elements may be established by agreement between purchaser and manufacturer or supplier.

3.1.2 Applicable only when copper is determined by direct analysis.

3.2 Condition:

Hot reduced or hot and cold reduced, solution heat treated, cold worked, and precipitation heat treated, TH04 temper; (See 8.2).

3.3 Heat Treatment:

Product shall be heat treated as follows; pyrometry shall be in accordance with AMS 2750:

3.3.1 Solution: Heat within the range 1400 to 1475 °F (760 to 802 °C), hold at heat for 30 to 60 minutes, and cool as required.

3.3.2 Precipitation: Heat to 600 to 660 °F (316 to 349 °C), hold at heat for 2 to 3 hours, and cool as required.

3.4 Properties:

Product shall conform to the following requirements (See 8.3):

3.4.1 Tensile Properties: Shall be in accordance with Table 2, determined in accordance with ASTM E 8 or ASTM E 8M.

TABLE 2A - Minimum Tensile Properties, Inch-Pound Units

Nominal Diameter or Least Distance Between Parallel Sides, Inches	Tensile Strength ksi	Yield Strength at 0.2% Offset ksi	Elongation in 2 Inches %
Up to 0.375, incl	182	157	3
Over 0.375 to 1.000, excl	180	154	3
Over 1.000 to 2.000, excl	177	150	3
Over 2.000 to 2.500, excl	175	147	3
Over 2.500 to 3.000, incl	172	145	3

TABLE 2B - Minimum Tensile Properties, SI Units

Nominal Diameter or Least Distance Between Parallel Sides, Millimeters	Tensile Strength MPa	Yield Strength at 0.2% Offset MPa	Elongation in 50.8 mm %
Up to 9.52, incl	1255	1082	3
Over 9.52 to 25.40, excl	1241	1062	3
Over 25.40 to 50.80, excl	1220	1034	3
Over 50.80 to 63.50, excl	1207	1014	3
Over 63.50 to 76.20, incl	1186	1000	3

3.4.2 Hardness: Bars and rods 0.188 to 2.0 inches (4.78 to 50.8 mm), inclusive, (R) nominal diameter or least distance between parallel sides shall have hardness of 37 to 45 HRC, or equivalent (See 8.4), determined in accordance with ASTM E 18. Hardness requirements for bars and rods under 0.188 inch (4.78 mm) or over 2.00 inches (50.8 mm) in nominal diameter or least distance between parallel sides shall be agreed upon by purchaser and vendor.

3.4.3 Average Grain Size: The product shall have average grain size not larger than shown in Table 3, determined in accordance with ASTM E 112.

TABLE 3 - Maximum Average Grain Size

Nominal Diameter or Least Distance Between Parallel Sides Inches	Nominal Diameter or Least Distance Between Parallel Sides Millimeters	Grain Size Millimeter
Up to 1.000, excl	Up to 25.40, excl	0.050
1.000 to 1.500, excl	25.40 to 38.10, excl	0.075
1.500 to 2.000, excl	38.10 to 50.80, excl	0.100
2.000 to 3.000, excl	50.80 to 76.20, excl	0.125

3.4.3.1 Grain size requirements for product 3.000 inches (76.20 mm) and over in nominal diameter or least distance between parallel sides shall be agreed upon by purchaser and vendor.

3.4.4 Microstructure: Product shall contain not more than 6% beta phase (R) constituent, determined at 100X magnification on specimens prepared in accordance with ASTM E 3.

3.5 Quality:

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.

3.6 Tolerances:

Shall conform to AMS 2221 or MAM 2221 as applicable to refractory alloys.

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. 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:

Tests for all technical requirements are acceptance tests and shall be performed on each heat or lot as applicable.

4.3 Sampling and Testing:

Shall be in accordance with ASTM B 249 or ASTM B 249M and the following; a lot shall be all product with the same form, from the same heat, processed at one time through all steps of manufacture.

4.3.1 One or more chemical analysis samples from each heat shall be analyzed in accordance with 3.1.

4.3.2 One or more longitudinal tensile specimens from each lot shall be tested in accordance with 3.4.1. The axis of tensile specimens shall be located midway between the center and surface of product over 1.500 inches (38.10 mm) in nominal cross-sectional thickness.

4.3.3 One or more hardness specimens from each lot shall be tested in accordance with 3.4.2.

4.3.4 One or more specimens for grain size from each lot shall be tested in accordance with 3.4.3.

4.3.5 One or more specimens for microstructure from each lot shall be tested in accordance with 3.4.4.

4.4 Reports:

The vendor of the product shall furnish with each shipment a report showing the results of tests on each lot to determine conformance to the technical requirements. This report shall include the purchase order number, lot number, AMS 4534A, size, and quantity.