

AEROSPACE MATERIAL SPECIFICATION

An American National Standard

SAE

AMS 5027D

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Superseding AMS 5027C

(R) STEEL, WELDING WIRE
1.05Cr - 0.55Ni - 1.0Mo - 0.08V (0.26 - 0.32C)
Vacuum Melted, Environment-Controlled Packaging

UNS K22925

1. SCOPE:

1.1 Form:

This specification covers a low-alloy steel in the form of welding wire.

1.2 Application:

This wire has been used typically as filler metal for gas-tungsten-arc welding of heat-treatable steels of similar composition where the weld area is required to have strength comparable to that of the base metal, but usage is not limited to such applications.

1.3 Classification:

Wire shall be classified as follows:

Type 1 - Bare Wire

Type 2 - Copper Coated

1.3.1 Type 1 shall be supplied unless Type 2 is specified.

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.

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2.1 SAE Publications:

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

- AMS 2259 Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
 AMS 2370 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Wrought Products and Forging Stock
 AMS 2813 Packaging and Marking of Packages of Welding Wire, Standard Method
 AMS 2814 Packaging and Marking of Packages of Welding Wire, Premium Quality
 AMS 2816 Identification, Welding Wire, Tab Marking Method
 AMS 2819 Identification, Welding Wire, Direct Color Code System
- ARP1876 Test for Weld Filler Metal Wire
 ARP4926 Verification and Chemical Composition Inspection of Welding Wire

2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

- ASTM E 350 Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

3. TECHNICAL REQUIREMENTS:

3.1 Wire 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 (3.1.1)	0.26	0.32
Manganese	0.60	0.90
Silicon	0.10	0.30
Phosphorus	--	0.010
Sulfur	--	0.010
Chromium	0.90	1.20
Nickel	0.40	0.70
Molybdenum	0.90	1.10
Vanadium	0.05	0.10
Copper (3.1.2)	--	0.35
Hydrogen (3.1.3)	--	0.0010 (10 ppm)
Oxygen (3.1.3)	--	0.0025 (25 ppm)
Nitrogen (3.1.3)	--	0.0050 (50 ppm)

- 3.1.1 Shall be determined on finished wire.
- 3.1.2 Shall be determined on finished wire if wire is supplied copper clad.
- 3.1.3 Shall be determined on finished wire, but not required for cut lengths.
- 3.1.4 Chemical analysis of initial ingot, bar, or rod stock before drawing, other than those analyses required to be done on the finished wire, is acceptable provided the processes used for drawing or rolling, annealing, and cleaning are controlled to ensure continued conformance to composition requirements.
- 3.1.5 Check Analysis: Composition variations shall meet the applicable requirements of AMS 2259. No variation over maximum is permissible for oxygen, nitrogen, and hydrogen.
- 3.2 Melting Practice:
- Steel shall be multiple melted using consumable electrode vacuum practice in the remelt cycle or shall be induction melted under vacuum.
- 3.3 Condition:
- Cold worked, bright finish, in a temper and with a surface finish which will provide proper feeding of the wire in machine welding equipment.
- 3.4 Fabrication:
- 3.4.1 Wire shall be formed from bar descaled by a process which does not affect the composition of the wire.
- 3.4.2 In process annealing, if required, between cold rolling or drawing operations, shall be performed in vacuum or in protective atmosphere to avoid surface oxidation and absorption of other extraneous elements.
- 3.4.3 Butt welding is permissible provided both ends to be joined are either alloy verified using a method or methods capable of distinguishing the alloy from all other alloys processed in the facility or the repair is made at the wire processing station. The butt weld shall not interfere with uniform, uninterrupted feeding of the wire in machine welding equipment.
- 3.4.4 Drawing compounds, oxides, dirt, oil, and other foreign materials shall be removed by cleaning processes which will neither result in pitting nor cause gas absorption by the wire or deposition of substances harmful to welding operations.
- 3.4.5 Residual elements and dissolved gases deposited on, or absorbed by the wire during processing that can adversely affect the welding characteristics, the operation of the equipment, or the properties of the weld metal, shall be removed.

- 3.4.6 When Type 2 copper-coated wire is specified, the copper coating shall be clean, bright, and uniform in appearance. A maximum of four discontinuities in any 36-inch (914-mm) length are acceptable provided the exposed wire is clean and bright. The maximum allowable discontinuity size shall be 0.25 inch (6.35 mm) in length. The thickness of the copper coating shall not exceed 0.0005 inch (0.0127 mm) on the diameter.

3.5 Properties:

Wire shall conform to the following requirements:

- 3.5.1 Weldability: Melted wire shall flow smoothly and evenly during welding and shall produce acceptable welds. ARP1876 may be used to resolve disputes.
- 3.5.2 Spooled Wire: Shall conform to 3.5.2.1 and 3.5.2.2.
- 3.5.2.1 Cast: Wire, wound on standard 12-inch (305-mm) diameter spools, shall have imparted to it a curvature, such that a specimen sufficient in length to form a loop with a 1 -inch (25-mm) overlap, when cut from the spool and laid on a flat surface, shall form a circle 15 to 50 inches (381 to 1270 mm) in diameter.
- 3.5.2.2 Helix: The specimen on which cast was determined, when laid on a flat surface and measured between adjacent turns, shall show a vertical separation not greater than 1 inch (25 mm).

3.6 Quality:

Wire, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to welding operations, operation of welding equipment, or properties of the deposited weld metal.

- 3.6.1 Surface irregularities inherent with a forming process which does not tear the wire surface are acceptable provided the wire conforms to the tolerances of 3.7.

3.7 Sizes and Tolerances:

Wire shall be supplied in the sizes and to the tolerances shown in 3.7.1 and 3.7.2.

3.7.1 Diameter shall be as shown in Table 2.

TABLE 2A - Sizes and Diameter Tolerances, Inch/Pound Units

Form	Standard Sizes Nominal Diameter Inch	Tolerance Inch plus and minus
Cut Lengths	0.030, 0.045	0.001
Cut Lengths	0.052, 0.062, 0.078, 0.094, 0.125, 0.156,	0.002
Spools	0.188	0.0005
Spools	0.007, 0.010, 0.015, 0.020	0.001
Spools	0.030, 0.035, 0.045	0.002
	0.063, 0.078, 0.094	

TABLE 2B - Sizes and Diameter Tolerances, SI Units

Form	Standard Sizes Nominal Diameter Millimeters	Tolerance Millimeter plus and minus
Cut Lengths	0.76, 11.14	0.025
Cut Lengths	1.32, 1.57, 1.98, 2.39, 3.18, 3.96, 4.78	0.05
Spools	0.18, 0.25, 0.38, 0.51	0.013
Spools	0.76, 0.89, 1.14	0.025
Spools	1.57, 1.98, 2.39	0.05

3.7.2 Length: Out lengths shall be furnished in 18, 27, or 36 inch (457, 686, or 914 mm) lengths, as ordered, and shall not vary more than +0, -0.5 inch (-13 mm) from the length ordered.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of wire 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 wire conforms to specified requirements.