



AEROSPACE MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
TWO PENNSYLVANIA PLAZA, NEW YORK, N.Y. 1000

AMS 5077B
Superseding AMS 5077A

Issued 6-1-42
Revised 5-1-69

STEEL TUBING, WELDED 0.22 - 0.28C (SAE 1025)

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

2. COMPOSITION:

Ø		min	max
	Carbon	0.22 - 0.28	
	Manganese	0.30 - 0.60	
	Phosphorus	--	0.040
	Sulfur	--	0.050
	Silicon	0.10 - 0.30	

- 2.1 Check Analysis: Composition variations shall meet the requirements of the latest issue of AMS 2259.

3. CONDITION: As welded, normalized, or stress relieved and having a uniform fine grain size in all parts of the tubing.

4. TECHNICAL REQUIREMENTS:

4.1 Tensile Properties:

	Tensile Strength, psi	55,000 min
	Yield Strength at 0.2% Offset or at 0.0064	
Ø	in 2 In. Extension Under Load, (E = 30,000,000), psi	36,000 min
	Elongation, % in 2 In.	
	Full Tube	22 min
	Strip Specimen	15 min

- 4.1.1 For each 2,000 psi in excess of 55,000 psi tensile strength, a reduction in elongation of 1% to a minimum elongation of 10% for full tube, or to a minimum elongation of 8% for strip specimens, shall be allowed.

- 4.2 Tensile Properties Normalized: The tubing shall be capable of developing the tensile properties specified in 4.1 when normalized by heating to 1625 F $\pm$ 10 (885 C $\pm$ 5.6) followed by cooling in still air.

- 4.3 Crushing Test: One or more samples shall be selected from each 1,000 ft or less from each lot of tubing in the shipment. Test samples shall be a full cross section of the tube, with the length equal to 1-1/2 times the nominal OD; the ends shall be perpendicular to the axis. Specimens shall withstand crushing under a gradually applied axial load until the cross-sectional dimension is increased in one zone by 20%, or until one complete fold is formed, or until the specimen is reduced in length to 2/3 of its original length without failure of the weld.

- 4.4 Welds shall have no external or internal imperfections which are greater than 1/16 in. in length nor have a total depth equivalent to more than half the nominal wall thickness.