



AEROSPACE MATERIAL SPECIFICATION

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

AMS 5085B
Superseding AMS 5085A

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STEEL SHEET, STRIP, AND PLATE
0.47 - 0.55 (SAE 1050)
Annealed

1. SCOPE:

- 1.1 Form: This specification covers a carbon steel in the form of sheet, strip, and plate.
- 1.2 Application: Primarily for stamped or formed parts which may subsequently be heat treated.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

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

2.1.1 Aerospace Material Specifications:

AMS 2232 - Tolerances, Carbon Steel Sheet, Strip, and Plate
AMS 2259 - Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
AMS 2350 - Standards and Test Methods
AMS 2370 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Wrought Products
Except Forgings and Forging Stock

- 2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, Pennsylvania 19103.

ASTM A370 - Mechanical Testing of Steel Products
ASTM E112 - Estimating the Average Grain Size of Metals
ASTM E350 - Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel,
Ingot Iron, and Wrought Iron

- 2.3 Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, Pennsylvania 19120.

2.3.1 Federal Standards:

Federal Test Method Standard No. 151 - Metals; Test Methods

3. TECHNICAL REQUIREMENTS:

SAE Technical Board rules provide that: "All technical reports, including standards approved and practices recommended, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no agreement to adhere to any SAE standard or recommended practice, and no commitment to conform to or be guided by any technical report. In formulating and approving technical reports, the Board and its committees will not investigate or consider patents which may apply to the subject matter. Prospective users of the report are responsible for protecting themselves against infringement of patents."

- 3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E350, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other approved analytical methods:

	min	max
Carbon	0.47	0.55
Manganese	0.60	0.90
Silicon	0.10	0.35
Phosphorus	--	0.040
Sulfur	--	0.050

- 3.1.1 Check Analysis: Composition variations shall meet the applicable requirements of AMS 2259.

- 3.2 Condition: The product shall be supplied in the following condition; hardness shall be not higher than 85 HRB or equivalent, determined in accordance with ASTM A370:

- 3.2.1 Sheet and Strip: Cold rolled and bright annealed; or hot rolled, annealed if necessary, and descaled.

- 3.2.2 Plate: Hot rolled, annealed if necessary, and descaled.

- 3.3 Properties: The product shall conform to the following requirements; hardness and bend tests shall be performed in accordance with ASTM A370:

- 3.3.1 Bending: The product shall withstand, without cracking, bending at room temperature through an angle of 180 deg (3.14 rad) around a diameter equal to twice the nominal thickness of the product, with axis of bend parallel to the direction of rolling.

- 3.3.2 Decarburization:

- 3.3.2.1 Product Under 0.045 In. (1.14 mm) in Thickness: The method of test and the allowance shall be as agreed upon by purchaser and vendor.

- 3.3.2.2 Product 0.045 to 0.375 In. (1.14 to 9.52 mm), Excl, in Thickness:

- 3.3.2.2.1 Specimens: Shall be the full thickness of the product except that specimens from plate over 0.249 in. (6.32 mm) thick shall be slices approximately 0.250 in. (6.35 mm) thick cut parallel to and preserving one original surface of the plate. Recommended specimen size is 1 x 4 in. or 25 x 100 millimetres.

- 3.3.2.2.2 Procedure: Specimens shall be hardened by austenitizing and quenching; preferably, they shall not be tempered but, if tempered, the tempering temperature shall be not higher than 300° F (149° C). During heat treatment, specimens shall be protected by suitable atmosphere or medium or by suitable plating to prevent carburization or further decarburization. Protective plating, if used, shall then be removed from specimens of material 0.045 to 0.250 in. (1.14 to 6.35 mm), excl, in thickness and a portion of the specimen shall be ground to a depth of 0.050 in. (1.27 mm) or one-half thickness, whichever is less. Specimens from product 0.250 to 0.375 in. (6.35 to 9.52 mm) excl, in thickness shall be ground to remove 0.020 in. (0.51 mm) from the original surface of the plate and a portion of the specimen shall be further ground to a depth of at least one-third the original thickness of the specimen. At least three Rockwell hardness readings shall be taken on each prepared step and each group of readings averaged.

- 3.3.2.2.3 Allowance:

- 3.3.2.2.3.1 Product 0.045 to 0.250 In. (1.14 to 6.35 mm), Excl, in Thickness: The product shall show no layer of complete decarburization as determined microscopically at a magnification not exceeding 100X. It shall also be free from partial decarburization to the extent that the difference in hardness between the original surface and the portion ground as in 3.3.2.2.2 shall be not greater than 2 units on the Rockwell "A" scale.
- 3.3.2.2.3.2 Product 0.250 to 0.375 In. (6.35 to 9.52 mm), Excl, in Thickness: Shall be free from decarburization to the extent that the difference in hardness between the two prepared steps shall be not greater than 3 units on the Rockwell "A" scale.
- 3.3.2.2.3.3 Product 0.375 In. (9.52 mm) and Over in Thickness: The total decarburization as determined microscopically at a magnification not exceeding 100X on the plate, as supplied, shall be not greater than shown in Table I:

TABLE I

Nominal Thickness Inches	Depth of Decarburization Inch
0.375 to 0.500, incl	0.015
Over 0.500 to 1.000, incl	0.025
Over 1.000 to 2.000, incl	0.035
Over 2.000	As agreed upon

TABLE I (SI)

Nominal Thickness Millimetres	Depth of Decarburization Millimetre
9.52 to 12.70, incl	0.38
Over 12.70 to 25.40, incl	0.64
Over 25.40 to 50.80, incl	0.89
Over 50.80	As agreed upon

- 3.3.3 Grain Size: Predominantly 5 or finer with occasional grains as large as 3 permissible, ASTM E112, McQuaid-Ehn test.
- 3.4 Quality: The product shall be uniform in quality and condition, clean, sound, and free from foreign materials and from internal and external imperfections detrimental to fabrication or to performance of parts.
- 3.5 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of AMS 2232.

4. QUALITY ASSURANCE PROVISIONS:

- 4.1 Responsibility for Inspection: The vendor of the product shall supply all samples and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.4. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to assure that the product conforms to the requirements of this specification.
- 4.2 Classification of Tests: Tests to determine conformance to all technical requirements of this specification are classified as acceptance or routine control tests.
- 4.3 Sampling: Shall be in accordance with AMS 2370.
- 4.4 Reports:

- 4.4.1 The vendor of the product shall furnish with each shipment three copies of a report of the results of tests for chemical composition of each heat in the shipment and the results of tests on each size from each heat to determine conformance to the other technical requirements of this specification. This report shall include the purchase order number, heat number, material specification number and its revision letter, size, and quantity from each heat.
- 4.4.2 The vendor of finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, material specification number and its revision letter, contractor or other direct supplier of material, part number, and quantity. When material for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of material to determine conformance to the requirements of this specification, and shall include in the report a statement that the material conforms, or shall include copies of laboratory reports showing the results of tests to determine conformance.

Ø 4.5 Resampling and Retesting: Shall be in accordance with AMS 2370.

5. PREPARATION FOR DELIVERY:

5.1 Identification: The product shall be identified as in 5.1.1 unless purchaser permits a method from 5.1.2.

5.1.1 Each sheet, strip, and plate shall be marked on one face, in the respective location indicated below, with AMS 5085B, heat number, manufacturer's identification, and nominal thickness. The characters shall be of such size as to be clearly legible, shall be applied using a suitable marking fluid, and shall be capable of being removed in hot alkaline cleaning solution without rubbing. The markings shall have no deteriorious effect on the material or its performance and shall be sufficiently stable to withstand normal handling. The specification number, manufacturer's identification, and nominal thickness shall be continuously line marked; the heat number may be included in the line marking or may be marked at one location on each piece.

5.1.1.1 Flat Strip 6 In. (152 mm) and Under in Width: Shall be marked in one or more lengthwise rows of characters recurring at intervals not greater than 3 ft (914 mm).

5.1.1.2 Flat Sheet, Flat Strip Over 6 In. (152 mm) in Width, and Plate: Shall be marked in lengthwise rows of characters recurring at intervals not greater than 3 ft (914 mm), the rows being spaced not more than 6 in. (152 mm) apart and alternately staggered.

Ø 5.1.1.3 Coiled Sheet and Strip: Shall be marked near both the outside and inside ends of the coil; the marking at either or both ends shall be applied as in 5.1.1 or shall appear on a durable tag or label attached to the coil and marked with the information of 5.1.1. When the inside end of the coil is inaccessible, as when the product is wound on cores, the tag or label may be attached to the core.

Ø 5.1.2 When purchaser permits, each sheet, strip, and plate may be marked near one end, coils being marked near the outside end, with AMS 5085B, heat number, manufacturer's identification, and nominal thickness, using any suitable marking fluid. As an alternate method, individual pieces and bundles shall have attached a durable tag marked with the above information or shall be boxed and the box marked with the same information.

5.2 Protective Treatment: The product shall be oiled prior to shipment.