



# AEROSPACE MATERIAL SPECIFICATION

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

**AMS 5528D**  
Superseding AMS 5528C

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UNS S17700

STEEL SHEET, STRIP, AND PLATE, CORROSION RESISTANT  
17Cr - 7.1Ni - 1.1Al

## 1. SCOPE:

- 1.1 Form: This specification covers a corrosion-resistant, precipitation-hardenable steel in the form of sheet, strip, and plate.
- 1.2 Application: Primarily for parts requiring corrosion resistance and high strength up to 600 F (316 C), and where such parts may require welding during fabrication.

## 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, PA 15096.

### 2.1.1 Aerospace Material Specifications:

AMS 2242 - Tolerances, Corrosion and Heat Resistant Steel and Iron Base Alloy Sheet, Strip, and Plate and Titanium and Titanium Alloy Sheet, Strip, and Plate

AMS 2248 - Chemical Check Analysis Limits, Wrought Heat and Corrosion Resistant Steels and Alloys

AMS 2350 - Standards and Test Methods

AMS 2371 - Quality Assurance Sampling of Corrosion and Heat Resistant Alloys, Wrought Products Except Forgings

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

ASTM A370 - Mechanical Testing of Steel Products

ASTM E353 - Chemical Analysis of Stainless, Heat Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

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

### 2.3.1 Federal Standards:

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

### 2.3.2 Military Standards:

MIL-STD-163 - Steel Mill Products, Preparation for Shipment and Storage

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3. TECHNICAL REQUIREMENTS:

- 3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E353, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other approved analytical methods:

|            | min           | max   |
|------------|---------------|-------|
| Carbon     | --            | 0.09  |
| Manganese  | --            | 1.00  |
| Silicon    | --            | 1.00  |
| Phosphorus | --            | 0.040 |
| Sulfur     | --            | 0.030 |
| Chromium   | 16.00 - 18.00 |       |
| Nickel     | 6.50 - 7.75   |       |
| Aluminum   | 0.75 - 1.50   |       |

- 3.1.1 Check Analysis: Composition variations shall meet the requirements of AMS 2248.

- 3.2 Condition: The product shall be supplied in the following condition:

- 3.2.1 Sheet: Cold rolled, solution heat treated, and descaled (No. 2D Finish).

- 3.2.2 Strip: Cold rolled, solution heat treated, and descaled (No. 1 Strip Finish).

- 3.2.3 Plate: Hot rolled, solution heat treated, and descaled.

- 3.3 Solution Heat Treatment: The product shall be solution heat treated by heating to  $1950^{\circ}\text{F} \pm 25$  ( $1065^{\circ}\text{C} \pm 15$ ), holding at heat for a time commensurate with thickness and the heating equipment and procedure used, and cooling in air.

- 3.4 Properties: The product shall conform to the following requirements; tensile, hardness, and bend testing shall be performed in accordance with ASTM A370:

- 3.4.1 As Solution Heat Treated:

- 3.4.1.1 Tensile Properties: Shall be as follows:

TABLE I

| Nominal Thickness<br>Inch | Tensile<br>Strength<br>psi, max | Yield Strength<br>at 0.2% Offset<br>psi, max | Elongation<br>in 2 in. or 4D<br>%, min |
|---------------------------|---------------------------------|----------------------------------------------|----------------------------------------|
| 0.005 to 0.010, incl      | 150,000                         | 65,000                                       | 20                                     |
| Over 0.010                | 150,000                         | 55,000                                       | 20                                     |

TABLE I (SI)

| Nominal Thickness<br>Millimetres | Tensile<br>Strength<br>MPa, max | Yield Strength<br>at 0.2% Offset<br>MPa, max | Elongation<br>in 50.8 mm or 4D<br>%, min |
|----------------------------------|---------------------------------|----------------------------------------------|------------------------------------------|
| 0.13 to 0.25, incl               | 1034                            | 448                                          | 20                                       |
| Over 0.25                        | 1034                            | 379                                          | 20                                       |

3.4.1.2 Hardness: Shall be not higher than 92 HRB or equivalent.

3.4.1.3 Bending: Product 0.275 in. (6.98 mm) and under in nominal thickness shall withstand, without cracking, bending through the angle indicated below around a diameter equal to the bend factor times the nominal thickness of the product with axes of bends both perpendicular and parallel to the direction of rolling. Only one type of test will be required in routine inspection; in case of dispute, results of tests using the V-block procedure shall govern.

| Nominal Thickness         |                           | Type of Bend | Angle deg, min | Bend Factor |
|---------------------------|---------------------------|--------------|----------------|-------------|
| Inch                      | (Millimetres)             |              |                |             |
| Up to 0.187, incl         | (Up to 4.75, incl)        | Free Bend    | 180            | 1           |
| Up to 0.187, incl         | (Up to 4.75, incl)        | V-Block      | 135            | 1           |
| Over 0.187 to 0.275, incl | (Over 4.75 to 6.98, incl) | Free Bend    | 180            | 3           |
| Over 0.187 to 0.275, incl | (Over 4.75 to 6.98, incl) | V-Block      | 135            | 3           |

3.4.1.3.1 Bending requirements for plate over 0.275 in. (6.98 mm) in nominal thickness shall be as agreed upon by purchaser and vendor.

3.4.2 As Austenite Conditioned and Precipitation Heat Treated: Product shall be austenite-conditioned by heating to  $1400^{\circ}\text{F} \pm 25$  ( $760^{\circ}\text{C} \pm 15$ ), holding at heat for 90 min.  $\pm 5$ , cooling to  $55^{\circ}\text{F} \pm 5$  ( $12^{\circ}\text{C} \pm 3$ ) within 1 hr, holding at that temperature for not less than 30 min., and then precipitation heat treated by heating to  $1050^{\circ}\text{F} \pm 10$  ( $565^{\circ}\text{C} \pm 5$ ), holding at heat for 90 min.  $\pm 5$ , and cooling to room temperature.

3.4.2.1 Product 0.005 to 1.000 In. (0.13 to 25.40 mm), Incl, in Thickness:

3.4.2.1.1 Tensile Properties: Shall be as follows:

|                                    |                                         |
|------------------------------------|-----------------------------------------|
| Tensile Strength                   | 180,000 - 210,000 psi (1241 - 1448 MPa) |
| Yield Strength at 0.2% Offset, min | 150,000 psi (1034 MPa)                  |
| Elongation in 2 in. (50.8 mm), min |                                         |

| Nominal Thickness         |                            |    |
|---------------------------|----------------------------|----|
| Inch                      | (Millimetres)              |    |
| 0.005 to 0.010, incl      | (0.13 to 0.25, incl)       | 4% |
| Over 0.010 to 0.019, incl | (Over 0.25 to 0.48, incl)  | 5% |
| Over 0.019 to 1.000, incl | (Over 0.48 to 25.40, incl) | 6% |

3.4.2.1.2 Hardness: Shall be 38 - 46 HRC or equivalent.

3.4.2.2 Product Over 1.000 In. (25 mm) in Thickness: Shall be as agreed upon by purchaser and vendor.

3.5 Quality: The product, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from internal and external imperfections detrimental to usage of the product.

3.6 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of AMS 2242.

#### 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 ensure 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 tests.
- 4.3 Sampling: Shall be in accordance with AMS 2371 and the following:
- 4.3.1 Specimens for tensile tests of widths 9 in. (229 mm) and over shall be taken with the axis of the specimen perpendicular to the direction of rolling; for widths less than 9 in. (229 mm), specimens shall be taken with the axis parallel to the direction of rolling.
- 4.4 Reports:
- 4.4.1 The vendor of the product shall furnish with each shipment three copies of a report showing the results of tests for chemical composition of each heat and the results of tests on each thickness 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, thickness, 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 2371.

#### 5. PREPARATION FOR DELIVERY:

- 5.1 Identification: Each sheet, strip, and plate shall be marked, in the respective location indicated below, with AMS 5528D, 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 removable in hot alkaline cleaning solution without rubbing. The markings shall have no deleterious effect on the product or its performance and shall be sufficiently stable to withstand normal handling.
- 5.1.1 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).
- 5.1.2 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.
- 5.1.3 Coiled Sheet and Strip: Shall be marked near both the outside and inside ends of the coil; the markings shall be applied as in 5.1 or shall appear on a durable tag or label attached to the coil and marked with the information of 5.1. 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.
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