

AEROSPACE MATERIAL SPECIFICATION



AMS 5562D

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Superseding AMS 5562C

Steel, Corrosion and Heat Resistant, Seamless Tubing 9.0Mn - 20Cr - 6.5Ni - 0.28N Solution Heat Treated

UNS S21904

1. SCOPE:

1.1 Form:

This specification covers a corrosion and heat resistant steel in the form of seamless tubing.

1.2 Application:

This tubing has been used typically for parts, such as fluid-conducting lines, requiring both corrosion and heat resistance, especially when such parts are welded or brazed during fabrication, and which require strength higher than that of the 18-8 type steels, or require oxidation resistance up to 1100 °F (593 °C), but usage is not limited to such applications.

2. APPLICABLE DOCUMENTS:

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications:

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

AMS 2243	Tolerances, Corrosion and Heat Resistant Steel Tubing
MAM 2243	Tolerances, Metric, Corrosion and Heat Resistant Steel Tubing
AMS 2248	Chemical Check Analysis Limits, Corrosion and Heat Resistant Steels and Alloys, Maraging and Other Highly-Alloyed Steels, and Iron Alloys
AMS 2371	Quality Assurance Sampling and Testing, Corrosion and Heat Resistant Steels and Alloys, Wrought Products and Forging Stock

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2.1 (Continued):

- AMS 2634 Ultrasonic Inspection, Thin Wall Metal Tubing
 AMS 2807 Identification, Carbon and Low-Alloy Steels, Corrosion and Heat Resistant Steels and Alloys, Sheet, Strip, Plate, and Aircraft Tubing

2.2 ASTM Publications:

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

- ASTM A 262 Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels
 ASTM A 370 Mechanical Testing of Steel Products
 ASTM A 450/A 450M General Requirements for Carbon, Ferritic Alloy and Austenitic Alloy Steel Tubes
 ASTM E 353 Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys
 ASTM E 426 Electromagnetic (Eddy-Current) Examination of Seamless and Welded Tubular Products, Austenitic Stainless Steel and Similar Alloys
 ASTM E 1417 Liquid Penetrant Examination

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

TABLE 1 - Composition

Element	min	max
Carbon	--	0.04
Manganese	8.00	10.00
Silicon	--	1.00
Phosphorus	--	0.060
Sulfur	--	0.030
Chromium	19.00	21.50
Nickel	5.50	7.50
Nitrogen	0.15	0.40
Molybdenum	--	0.75
Copper	--	0.75

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

3.2 Condition:

Solution heat treated, and, unless solution heat treatment is performed in an atmosphere yielding a bright finish, pickled as required or passivated.

3.3 Fabrication:

Tubing shall be produced by a seamless process. Any surface finishing operation applied to remove objectional sets and surface blemishes shall be performed prior to final solution heat treatment. A light polish to improve external surface appearance may be employed after solution heat treatment and, if performed, the product shall be subsequently passivated.

3.4 Properties:

Tubing shall conform to the following requirements:

3.4.1 Tensile Properties: Shall be as shown in Table 2, determined in accordance with ASTM A 370.

TABLE 2 - Minimum Tensile Properties

Property	Value
Tensile Strength	90.0 ksi (621 MPa)
Yield Strength at 0.2% Offset	50.0 ksi (345 MPa)
Elongation in 2 Inches (50.8 mm)	
Strip Specimens	40%
Full Tube Specimens	45%

3.4.2 Flarability: Specimens as in 4.3.1 shall withstand flaring at room temperature, without formation of cracks or other visible defects, by being forced axially with steady pressure over a hardened and polished tapered steel pin having a 74-degree included angle to produce a flare having a permanent expanded OD not less than shown in Table 3.

TABLE 3A - Flarability, Inch/Pound Units

Nominal OD Inches	Expanded OD Inches	Nominal OD Inches	Expanded OD Inches
0.125	0.200	0.750	0.937
0.188	0.302	1.000	1.187
0.250	0.359	1.250	1.500
0.312	0.421	1.500	1.721
0.375	0.484	1.750	2.106
0.500	0.656	2.000	2.356
0.625	0.781		

TABLE 3B - Flarability, SI Units

Nominal OD Millimeters	Expanded OD Millimeters	Nominal OD Millimeters	Expanded OD Millimeters
3.18	5.08	19.05	23.80
4.78	7.67	25.40	30.15
6.35	9.12	31.75	38.10
7.92	10.69	38.10	43.71
9.52	12.29	44.45	53.49
12.70	16.66	50.80	59.84
15.88	19.84		

3.4.2.1 Tubing with nominal OD between any two standard sizes shown in Table 3 shall take the same percentage flare as shown for the larger of the two sizes.

3.4.3 Pressure Test: The tubing shall show no bulges, leaks, pinholes, cracks, or other defects when subjected to an internal hydrostatic pressure (P), except that a diametric permanent set of 0.002 inch per inch (0.002 mm/mm) of diameter is acceptable. The hydrostatic pressure (P) shall be determined using Equation 1:

$$P = S \frac{D^2 - d^2}{D^2 + d^2} \quad (\text{Eq. 1})$$

where:

P = Test pressure in ksi (MPa)
 S = Minimum yield strength from 3.4.1
 D = Nominal OD
 d = Nominal ID

3.4.4 Susceptibility to Intergranular Attack: Specimens from tubing, after sensitizing treatment, shall pass the intergranular corrosion test performed in accordance with ASTM A 262, Practice E. After exposure, tubing shall be tested in accordance with the flattening test requirements of ASTM A 450/A 450M. Samples shall be taken from tubing after final annealing but may be taken prior to cold working.

3.5 Quality:

Tubing, as received by purchaser, shall be uniform in quality and condition and shall have a finish conforming to the best practice for high quality aircraft tubing. It shall be smooth and free from grease, oil and other foreign matter, heavy scale or oxide, burrs, seams, tears, grooves, laminations, slivers, pits, and other imperfections detrimental to usage of the tubing. Surface imperfections, such as handling marks, straightening marks, light mandrel and die marks, shallow pits, and scale pattern, will not be considered injurious if the imperfections are removable within the tolerances specified for wall thickness, but removal of such imperfections is not required.

3.5.1 Tubing shall be free from grease or other foreign matter. Metallic flakes or particles shall not be collected by a clean, white cloth drawn through the length of the bore of a test sample. Discoloration of the cloth, without the presence of flakes or particles, is acceptable.

3.5.2 When specified, tubing shall be subjected to fluorescent penetrant inspection in accordance with ASTM E 1417 to ultrasonic inspection in accordance with AMS 2634, to electromagnetic (eddy-current) inspection in accordance with ASTM E 426, or to any combination thereof. Tubing shall meet the requirements of 3.5 and other acceptance criteria established by the cognizant engineering organization.

3.6 Tolerances:

Shall conform to all applicable requirements of AMS 2243 or MAM 2243.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of tubing 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 tubing conforms to specified requirements.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Composition (3.1), tensile properties (3.4.1), nondestructive inspection when specified (3.5.2), and tolerances (3.6) are acceptance tests and shall be performed on each heat or lot as applicable.