



AEROSPACE MATERIAL SPECIFICATION

AMS5597**REV. F**

Issued 1965-09
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Reaffirmed 2015-04

Superseding AMS5597E

Nickel Alloy, Corrosion and Heat Resistant, Sheet, Strip, and Plate
52.5Ni - 19Cr - 3.0Mo - 5.1Cb (Nb) - 0.90Ti - 0.50Al - 18Fe
Consumable Electrode or Vacuum Induction Melted

1950 °F (1066 °C) Solution Heat Treated
(Composition similar to UNS N07718)

RATIONALE

AMS5597F has been reaffirmed to comply with the SAE five-year review policy.

1. SCOPE

1.1 Form

This specification covers a corrosion and heat resistant nickel alloy in the form of sheet, strip, and plate.

1.2 Application

These products have been used typically for parts, such as cases and ducts, requiring high strength at cryogenic temperatures and for short-time use up to 1000 °F (538 °C), particularly those parts which are formed or welded and then heat treated to develop required properties, 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.

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2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org.

AMS2262	Tolerances, Nickel, Nickel Alloy, and Cobalt Alloy Sheet, Strip, and Plate
AMS2269	Chemical Check Analysis Limits, Nickel, Nickel Alloys, and Cobalt Alloys
AMS2371	Quality Assurance Sampling and Testing, Corrosion and Heat-Resistant Steels and Alloys, Wrought Products and Forging Stock
AMS2807	Identification, Carbon and Low-Alloy Steels, Corrosion and Heat-Resistant Steels and Alloys, Sheet, Strip, Plate, and Aircraft Tubing
AS4194	Sheet and Strip Surface Finish Nomenclature

2.2 ASTM Publications

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM A 480/A 480M	Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip
ASTM E 8/E 8M	Tension Testing of Metallic Materials
ASTM E 18	Rockwell Hardness of Metallic Materials
ASTM E 112	Determining Average Grain Size
ASTM E 290	Bend Testing of Material for Ductility
ASTM E 354	Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys

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

TABLE 1 - COMPOSITION

Element	min	max
Carbon	--	0.08
Manganese	--	0.35
Silicon	--	0.35
Phosphorus	--	0.015
Sulfur	--	0.015
Chromium	17.00	21.00
Nickel	50.00	55.00
Molybdenum	2.80	3.30
Columbium (Niobium)	4.75	5.50
Titanium	0.65	1.15
Aluminum	0.20	0.80
Cobalt	--	1.00
Tantalum	--	0.05
Boron	--	0.006
Copper	--	0.30
Iron	remainder	

3.1.1 Check Analysis

Composition variations shall meet the applicable requirements of AMS2269.

3.2 Melting Practice

Alloy shall be multiple melted using consumable electrode practice in the remelt cycle or shall be induction melted under vacuum. If consumable electrode remelting is not performed in vacuum, electrodes which have been produced by vacuum induction melting shall be used for remelting.

3.3 Condition

The product shall be supplied in the following condition:

3.3.1 Sheet and Strip

Hot or cold rolled, solution heat treated, and, unless solution heat treatment is performed in an atmosphere yielding a bright finish, descaled having a surface appearance comparable to the following commercial corrosion-resistant steel finishes as described in ASTM A 480/A 480M and AS4194, and 3.3.1.1 or 3.3.1.2 as applicable.

3.3.1.1 Sheet

No. 2D finish.

3.3.1.2 Strip

No. 1 strip finish.

3.3.2 Plate

Hot rolled, solution heat treated, and, unless solution heat treatment is performed in an atmosphere yielding a bright finish, descaled.

3.4 Solution Heat Treatment

No specific heat treating instructions are specified but it is recommended that the product be solution heat treated by heating in a suitable protective atmosphere to $1950^{\circ}\text{F} \pm 25$ ($1066^{\circ}\text{C} \pm 14$) but in no case lower than 1850°F (1010°C), holding at heat for a time commensurate with product thickness, and cooling at a rate equivalent to an air cool or faster.

3.5 Properties

The product shall conform to the following requirements:

3.5.1 As Solution Heat Treated

3.5.1.1 Tensile Properties

Shall be shown in Table 2, determined in accordance with ASTM E 8/E 8M.

TABLE 2 - TENSILE PROPERTIES

Property	Value
Tensile Strength, max	140 ksi (965 MPa)
Yield Strength at 0.2% Offset, max	75.0 ksi (517 MPa)
Elongation in 2 Inches (50.8 mm) or 4D, min	30%

3.5.1.2 Hardness

Should be not higher than 25 HRC, or equivalent (See 8.2), determined in accordance with ASTM E 18, but the product shall not be rejected on the basis of hardness if the tensile properties of 3.5.1.1 are acceptable, determined on specimens taken from the same sample as that with nonconforming hardness or from another sample with similar nonconforming hardness.

3.5.1.3 Bending

Product shall be tested in accordance with ASTM E 290 using a sample prepared nominally 0.75 inch (19.0mm) in width with its axis of bending parallel to the direction of rolling and shall withstand without cracking when bending at room temperature through an angle of 180 degrees around a diameter equal to the bend factor shown in Table 3 times the nominal thickness of the product. In case of dispute, the results of tests using the guided bend test of ASTM E 290 shall govern.

TABLE 3 - BENDING PARAMETERS

Nominal Thickness Inch	Nominal Thickness Millimeters	Bend Factor
Up to 0.050, incl	Up to 1.27, incl	1
Over 0.050 to 0.1874, incl	Over 1.27 to 4.760, incl	2

3.5.1.4 Average Grain Size

Shall be ASTM No. 3 or finer, determined in accordance with ASTM E 112.

3.5.1.5 Microstructure

Metallographic examination shall disclose no significant alloy depleted layer (See 8.3) or other undesirable surface condition. Standards for acceptance shall be as agreed upon by purchaser and vendor.

3.5.2 After Precipitation Heat Treatment

The product shall have the following properties after being precipitation heat treated by heating to 1400 °F ± 15 (760 °C ± 8), holding at heat for 10 hours ± 0.5, furnace cooling to 1200 °F ± 15 (649 °C ± 8), holding at 1200 °F ± 15 (649 °C ± 8) until a total precipitation heat treatment time of 20 hours has been reached, and cooling in air. The product shall also meet the requirements of 3.5.2.1 and 3.5.2.2 after being re-solution heat treated by heating to 1950 °F ± 25 (1066 °C ± 14) in a suitable protective atmosphere, holding at heat for 60 minutes ± 5, and cooling at a rate equivalent to an air cool or faster and precipitation heat treated as above.

3.5.2.1 Tensile Properties

Shall be as shown in Table 4 for product 0.010 to 1.000 inch (0.25 to 25.40 mm), inclusive, in nominal thickness, determined in accordance with ASTM E 8/E 8M.

TABLE 4 - MINIMUM TENSILE PROPERTIES

Property	Value
Tensile Strength	180 ksi (1241 MPa)
Yield Strength at 0.2% Offset	150 ksi (1034 MPa)
Elongation in 2 Inches (50.8 mm) or 4D	15%

3.5.2.2 Hardness

Should be not lower than 38 HRC, or equivalent (See 8.2), determined in accordance with ASTM E 18, but the product shall not be rejected on the basis of hardness if the tensile properties of 3.5.2.1 are acceptable, determined on specimens taken from the same sample as that with nonconforming hardness or from another sample with similar nonconforming hardness.

3.6 Quality

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

3.7 Tolerances

Shall conform to all applicable requirements of AMS2262.