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400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE MATERIAL SPECIFICATION

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AMS 5627E

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Superseding AMS 5627D

Submitted for recognition as an American National Standard

STEEL, CORROSION AND HEAT RESISTANT, BARS, WIRE, FORGINGS, TUBING AND RINGS
17Cr (SAE 51430)
Annealed

UNS S43000

1. SCOPE:

1.1 Form:

This specification covers a corrosion and heat resistant steel in the form of bars, wire, forgings, mechanical tubing, flash welded rings, and stock for forging or flash welded rings.

1.2 Application:

These products have been used typically for parts requiring oxidation resistance up to 1600 °F (871 °C) but useful at the higher temperatures only when strength requirements are moderately low, but usage is not limited to such applications.

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

2.1 SAE Publications:

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

AMS 2241 Tolerances, Corrosion and Heat Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Bars and Wire

MAM 2241 Tolerances, Metric, Corrosion and Heat Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Bars and Wire

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, Wrought 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 SAE Publications (Continued):

- AMS 2374 Quality Assurance Sampling and Testing, Corrosion and Heat Resistant Steel and Alloy Forgings
- AMS 2806 Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat Resistant Steels and Alloys
- AMS 2808 Identification, Forgings
- AMS 7493 Rings, Flash Welded, Ferritic and Martensitic Corrosion Resistant Steels

2.2 ASTM Publications:

Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

- ASTM A 370 Mechanical Testing of Steel Products
- ASTM E 112 Determining Average Grain Size
- ASTM E 353 Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

2.3 U.S. Government Publications:

Available from Standardization Documents Order Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

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

3. TECHNICAL REQUIREMENTS:**3.1 Composition:****(R)**

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	--	0.12
Manganese	--	1.00
Silicon	--	1.00
Phosphorus	--	0.040
Sulfur	--	0.030
Chromium	16.00	18.00
Nickel	--	0.75
Molybdenum	--	0.50
Copper	--	0.50
Aluminum	--	0.05
Tin	--	0.05

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; hardness and tensile strength shall be determined in accordance with ASTM A 370:

3.2.1 Bars: Annealed having hardness not higher than 202 HB, or equivalent (See 8.2).

3.2.1.1 All hexagons and other bars 0.500 to 2.750 inches (12.70 to 69.85 mm), inclusive, in nominal diameter or distance between parallel sides shall be cold finished.

3.2.1.2 Bars, other than hexagons, over 2.750 inches (69.85 mm) in nominal diameter or distance between parallel sides shall be hot finished.

3.2.2 Wire: Cold drawn and annealed having tensile strength not higher than 100 ksi (689 MPa) or equivalent hardness.

3.2.3 Forgings and Flash Welded Rings: Annealed having hardness not higher than 183 HB, or equivalent (See 8.2).

3.2.3.1 Flash welded rings shall not be supplied unless specified or permitted on purchaser's part drawing. When supplied, rings shall be manufactured in accordance with AMS 7493.

3.2.4 Mechanical Tubing: Annealed and cold finished having hardness not higher than 202 HB, or equivalent (See 8.2).

3.2.5 Stock for Forging or Flash Welded Rings: As ordered by the forging or flash welded ring manufacturer.

3.3 Properties:

The product shall conform to the following requirements:

3.3.1 Grain Size: Bars, wire, forgings, tubing, and stock for flash welded rings shall have grain size not larger than 0, determined by comparison of a polished and etched specimen with the chart in ASTM E 112. Grain size of flash welded rings shall be as agreed upon by purchaser and vendor.

3.4 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.

3.4.1 Grain flow of die forgings, except in areas which contain flash-line end grain, shall follow the general contour of the forgings showing no evidence of re-entrant grain flow.

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3.5 Tolerances:

Shall conform to all applicable requirements of the following:

3.5.1 Bars and Wire: AMS 2241 or MAM 2241.

3.5.2 Mechanical Tubing: AMS 2243 or MAM 2243.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

(R)

The vendor of the product shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to the requirements of this specification.

4.2 Classification of Tests:

Tests for all technical requirements are acceptance tests and shall be performed on each heat or lot as applicable.

4.3 Sampling and Testing:

(R)

Shall be in accordance with the following:

4.3.1 Bars, Wire, Mechanical Tubing, Flash Welded Rings, and Stock for Forging or Flash Welded Rings: AMS 2371.

4.3.2 Forgings: AMS 2374.

4.4 Reports:

4.4.1 The vendor of bars, wire, forgings, mechanical tubing, and flash welded rings shall furnish with each shipment a report showing the results of tests for chemical composition and grain size of each heat. This report shall include the purchase order number, heat and lot number, AMS 5627E, size, and quantity. If forgings are supplied, the part number and the size and melt source of stock used to make the forgings shall also be included.

4.4.2 The vendor of stock for forging or flash welded rings shall furnish with each shipment a report showing the results of tests for chemical composition of each heat. This report shall include the purchase order, lot number, AMS 5627E, size, and quantity.

4.5 Resampling and Retesting:

Shall be in accordance with the following:

4.5.1 Bars, Wire, Mechanical Tubing, Flash Welded Rings, and Stock for Forging or Flash Welded Rings: AMS 2371.

4.5.2 Forgings: AMS 2374.