



AEROSPACE MATERIAL

Society of Automotive Engineers, Inc.

TWO PENNSYLVANIA PLAZA, NEW YORK, N.Y. 10001

SPECIFICATION

AMS5641B

Superseding AMS 5641A

Issued 6-1-42

Revised 5-15-71

STEEL BARS AND FORGINGS, CORROSION RESISTANT

18.5Cr - 10Ni (SAE 30303F)

Free-Machining; Swaging or Upsetting

1. SCOPE:

- 1.1 Form: This specification covers a free-machining corrosion resistant steel in the form of bars, wire, forgings, and forging stock.
- 1.2 Application: Primarily for parts which may be swaged or hot upset during fabrication and on which the amount of machining warrants use of a free-machining grade of steel. Corrosion resistance is similar to that of the standard 18-8 type.

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., Two Pennsylvania Plaza, New York, New York 10001.

2.1.1 Aerospace Material Specifications:

AMS 2241 - Tolerances, Corrosion and Heat Resistant Steel Bars and Wire and
Titanium and Titanium Alloy Bars and Wire
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
AMS 2808 - Identification, Forgings

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

- 2.3 Government Publications: Available from Superintendent of Documents, Government Printing Office, Washington, D. C. 20402.

2.3.1 Federal Standards:

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

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.

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	min	max
Carbon	--	0.12
Manganese	--	2.00
Silicon	--	0.70
Phosphorus	0.11 -	0.17
Sulfur	--	0.040
Chromium	17.00 -	20.00
Nickel	8.00 -	12.00
Selenium	0.15 -	0.30
Molybdenum	--	0.75
Copper	--	0.75

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

3.2 Condition:

3.2.1 Bars, Wire, and Forgings: Solution heat treated free from continuous carbide network.

3.2.1.1 Bars and Wire: All hexagons, other bars 2.75 in. (69.85 mm) and under in diameter or distance between parallel sides, and wire shall be cold finished.

3.2.2 Forging Stock: As ordered by the forging manufacturer.

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

3.3.1 Tensile Properties: Bars and wire shall have tensile properties as follows:

Tensile Strength	75,000 - 115,000 psi (517 - 793 MN/m ²)
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Elongation in 2 in. (50.8mm) or 4D, min Sizes 0.125 in. (3.18 mm) and over	35%
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3.3.2 Hardness: Forgings shall have hardness of 149 - 229 HB or equivalent.

3.4 Quality: The product shall be uniform in quality and condition, sound, and free from foreign materials and from internal and external imperfections, consistent with the type of steel involved, detrimental to fabrication or to performance of parts.

3.5 Sizes: Except when exact lengths or multiples of exact lengths are ordered, bars and straight wire will be acceptable in mill lengths of 6 - 20 ft (1.8 - 6.1 m) but not more than 10% of any shipment shall be supplied in lengths shorter than 10 ft (3 m).

3.6 Tolerances: Unless otherwise specified, tolerances for bars and wire shall conform to all applicable requirements of AMS 2241.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor 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 material 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 routine control tests.

4.3 Sampling: Bars and wire shall be sampled in accordance with AMS 2371. Forgings and forging stock shall be sampled as agreed upon by purchaser and vendor.

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 hardness and tensile property requirements. This report shall include the purchase order number, heat number, material specification number and its revision letter, size, and quantity from each heat. If forgings are supplied, the part number and size of stock used to make the forgings shall also be included.

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.

4.5 Resampling and Retesting: If any specimen used in the above tests fails to meet the specified requirements, disposition of the product may be based on the testing of three additional specimens for each original nonconforming specimen. Failure of any retest specimen to meet the specified requirements shall be cause for rejection of the material represented and no additional testing shall be permitted. Results of all tests shall be reported.

5. PREPARATION FOR DELIVERY:

5.1 Identification: The product shall be identified as follows:

5.1.1 Bars and Wire:

5.1.1.1 Each straight bar 0.500 in. (12.7 mm) and over in diameter or least width of flat surface shall be marked in a row of characters recurring at intervals not greater than 3 ft (914 mm) with AMS 5641B, heat number, and manufacturer's identification. 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 deleterious effect on the material or its performance and shall be sufficiently stable to withstand normal handling.

5.1.1.2 Straight bars and wire less than 0.500 in. (12.7 mm) in diameter or least width of flat surface shall be securely bundled and identified by a metal or plastic tag embossed with the purchase order number, AMS 5641B, heat number, nominal size, and manufacturer's identification and attached to each bundle or shall be boxed and the box marked with the same information.

5.1.1.3 Coiled bars and wire shall be securely bundled and identified by a metal or plastic tag embossed with the purchase order number, AMS 5641B, heat number, nominal size, and manufacturer's identification and attached to each coil or shall be boxed and the box marked with the same information.

5.1.2 Forgings: In accordance with AMS 2808.

5.1.3 Forging Stock: As agreed upon by purchaser and vendor.

5.2 Packaging: The product shall be prepared for shipment in accordance with commercial practice to assure carrier acceptance and safe transportation to the point of delivery. Packaging shall conform to requirements of carrier rules and regulations applicable to the mode of transportation.

6. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.