

AERONAUTICAL MATERIAL SPECIFICATIONS

AMS 5700B

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc. 485 Lexington Ave., New York 17, N.Y.

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STEEL, CORROSION AND HEAT RESISTANT
14Cr - 14Ni - 2.4W - 0.4Mo

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
2. FORM: Bars, forgings, flash welded rings, and stock for forgings or flash welded rings.
3. APPLICATION: Primarily for parts, such as exhaust valves and valve seat inserts, requiring resistance to corrosion by combustion products at operating temperatures.
4. COMPOSITION:

Check Analysis
Under Min or Over Max

Carbon	0.40 - 0.50	0.02	0.02
Manganese	0.70 max	--	0.03
Silicon	0.30 - 0.80	0.05	0.05
Phosphorus	0.030 max	--	0.005
Sulfur	0.030 max	--	0.005
Chromium	13.00 - 15.00	0.15	0.15
Nickel	13.00 - 15.00	0.15	0.15
Molybdenum	0.20 - 0.50	0.03	0.03
Tungsten	1.75 - 3.00	0.10	0.10

5. CONDITION:

- 5.1 Bars, Forgings, and Flash Welded Rings: Annealed, having a uniform, refined structure.

5.1.1 All hexagons, and other bars 2.75 in. and less in diameter or distance between parallel sides shall be cold finished.

5.1.2 Flash welded rings shall not be supplied unless specified or permitted on purchaser's part drawing. When supplied, they shall be manufactured in accordance with latest issue of AMS 7490, unless otherwise specified.

- 5.2 Stock for Forgings or Flash Welded Rings: As ordered by the forging or flash welded ring manufacturer.

6. TECHNICAL REQUIREMENTS:

- 6.1 Heat Treatment: Bars, forgings, and flash welded rings shall be annealed by heating to 1650 F $\pm$ 25, holding at heat for 1 - 2 hr, and air cooling.

6.2 Hardness:

6.2.1 Bars: Shall have hardness not higher than Brinell 285 or equivalent when
Ø taken approximately midway between surface and center.

6.2.2 Forgings and Flash Welded Rings: Shall have hardness not higher than
Ø Brinell 285 or equivalent.

7. QUALITY: Material shall be uniform in quality and condition, clean, sound, and free from foreign materials and from internal and external imperfections detrimental to fabrication or to performance of parts.

8. TOLERANCES: Unless otherwise specified, tolerances shall conform to the latest issue of AMS 2241 as applicable and as specified below:

8.1 All hexagons, and other bars 2.75 in. and less in diameter or distance between parallel sides, Table I.

8.2 Bars, others than hexagons, over 2.75 in. in diameter or distance between parallel sides, Table II.

9. REPORTS:

9.1 Unless otherwise specified, 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. This report shall include the purchase order number, heat number, material specification number, 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.

9.2 Unless otherwise specified, 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, 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.

10. IDENTIFICATION:

10.1 Bars: Individual pieces or bundles shall have attached a metal or plastic tag embossed with the purchase order number, AMS 5700B, nominal size, and heat
Ø number, or shall be boxed and the box marked with the same information. In addition to the above identification, flats 2 x 1 in. and larger and other bars 1 in. and over in diameter or distance between parallel sides shall be stamped with the heat number within 2 in. of one end.

10.2 Forgings: Shall be identified in accordance with the latest issue of AMS 2808.

10.3 Flash Welded Rings: Shall be identified as agreed upon by purchaser and
Ø vendor.