

ALLOY BARS, FORGINGS, AND RINGS, CORROSION AND HEAT RESISTANT

41.5Ni - 16Cr - 37Fe - 2.9Cb - 1.8Ti

Consumable Electrode or Vacuum Induction Melted

1750°F (955°C) Solution Heat Treated

1. SCOPE:

- 1.1 Form: This specification covers a corrosion and heat resistant nickel alloy in the form of bars, forgings, flash welded rings, and stock for forging or flash welded rings.
- 1.2 Applications: Primarily for parts requiring high resistance to creep and stress-rupture up to 1300°F (705°C), oxidation resistance up to 1800°F (980°C), and good machinability, particularly parts which are welded and then precipitation heat treated to develop required properties.
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., 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

- AMS 2261 - Tolerances, Nickel, Nickel Alloy, and Cobalt Alloy Bars and Forging Stock
- AMS 2269 - Chemical Check Analysis Limits, Wrought Nickel Alloys and Cobalt Alloys
- AMS 2350 - Standards and Test Methods
- AMS 2371 - Quality Assurance Sampling of Corrosion and Heat Resistant Steels and Alloys, Wrought Products Except Forgings and Forging Stock
- AMS 2374 - Quality Assurance Sampling of Corrosion and Heat Resistant Steels and Alloys, Forgings and Forging Stock
- AMS 2375 - Control of Forgings Requiring First Article Approval
- AMS 2806 - Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Heat and Corrosion Resistant Steels and Alloys
- AMS 2808 - Identification, Forgings
- AMS 7490 - Rings, Flash Welded, Corrosion and Heat Resistant Austenitic Steels and Austenitic-Type Alloys

- 2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

- ASTM E8 - Tension Testing of Metallic Materials
- ASTM E10 - Brinell Hardness of Metallic Materials
- ASTM E112 - Estimating the Average Grain Size of Metals
- ASTM E139 - Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials
- ASTM E292 - Conducting Time-for-Rupture Notch Tension Tests of Materials
- ASTM E354 - Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys

- 2.3 U.S. Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.3.1 Federal Standards:

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

2.3.2 Military Specifications:

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

3. TECHNICAL REQUIREMENTS:

- 3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E354, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other analytical methods approved by purchaser:

	min	max
Carbon	--	0.06
Manganese	--	0.35
Silicon	--	0.35
Phosphorus	--	0.020
Sulfur	--	0.015
Chromium	14.50 -	17.50
Nickel	39.00 -	44.00
Columbium + Tantalum	2.50 -	3.30
Titanium	1.50 -	2.00
Aluminum	--	0.40
Boron	--	0.006
Copper	--	0.30
Iron	remainder	

- 3.1.1 Check Analysis: Composition variations shall meet the requirements of AMS 2269.

- 3.2 Condition: The product shall be supplied in the following condition:

- 3.2.1 Bars, Forgings, and Flash Welded Rings: Solution heat treated and descaled.

- 3.2.1.1 Bars shall be hot finished; round bars shall be turned or ground.

- 3.2.1.2 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 AMS 7490.

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

- 3.3 Heat Treatment: Bars, forgings, and flash welded rings shall be solution heat treated to conform to the requirements of 3.4.1.1.1, 3.4.1.1.2, and 3.4.1.2.

- 3.3.1 Bars: No specific heat treating instructions are specified but it is recommended that the bars be solution heat treated by heating within the range 1700° - 1800°F (925° - 980°C), holding at the selected temperature within ±25°F (±15°C) for a time commensurate with cross-sectional thickness, and cool as required.

- 3.3.2 Forgings and Flash Welded Rings: Shall be heated within the range 1700° - 1800°F (925° - 980°C), held at the selected temperature within ±25°F (±15°C) for not less than 30 min., and cooled as received.

- 3.4 Properties: The product shall conform to the following requirements:

3.4.1 Bars, Forgings, and Flash Welded Rings:

3.4.1.1 As Solution Heat Treated:

3.4.1.1.1 Hardness: Shall be not higher than 277 HB or equivalent, determined in accordance with ASTM E10.

3.4.1.1.2 Grain Size: Shall be as follows, determined by comparison of a polished and etched specimen with the chart in ASTM E112 or, in case of disagreement, by the intercept (Heyn) method:

3.4.1.1.2.1 Shall be predominantly 5 or finer in bars and flash welded rings 9 sq in. (58 cm²) and under in cross-sectional area.

3.4.1.1.2.2 Shall be predominantly 4 or finer in bars and flash welded rings over 9 sq in. (58 cm²) in cross-sectional area and in all forgings.

3.4.1.2 After Stabilization and Precipitation Heat Treatment: The product shall have the following properties after being stabilization heat treated by heating to 1550°F ± 15 (845° ± 8), holding at heat for 3 hr ± 0.25, and air cooling to room temperature and then precipitation heat treated by heating to 1325°F ± 15 (720°C ± 8), holding at heat for 8 hr ± 0.25, cooling at a rate not faster than 100 F (55 C) deg per hr to 1150°F ± 15 (620°C ± 8), holding at 1150°F ± 15 (620°C ± 8) for 8 hr ± 0.25, and cooling in air. Instead of the 100 F (55 C) deg per hr cooling rate to 1150°F ± 15 (620°C ± 8), the furnace cooling may be at any rate provided the time at 1150°F ± 15 (620°C ± 8) is adjusted to give a total precipitation heat treatment time of 18 hours.

3.4.1.2.1 Tensile Properties: Shall be as specified in Table I, determined in accordance with ASTM E8.

TABLE I

Nominal Diameter or Distance Between Parallel Sides Inches	Tensile Strength psi, min	Yield Strength at 0.2% Offset psi, min	Elongation in 4D %, min	Reduction of Area %, min
Up to 2.50, excl	170,000	130,000	12	15
2.50 to 4.00, incl	165,000	130,000	12	15

TABLE I (SI)

Nominal Diameter or Distance Between Parallel Sides Millimetres	Tensile Strength MPa, min	Yield Strength at 0.2% Offset MPa, min	Elongation in 4D %, min	Reduction of Area %, min
Up to 63.50, excl	1172	896	12	15
63.5 to 101.60, incl	1138	896	12	15

3.4.1.2.1.1 Tensile property requirements for product over 4.00 in. (101.60 mm) in nominal diameter or distance between parallel sides shall be as agreed upon by purchaser and vendor.

3.4.1.2.2 Hardness: Should be not lower than 285 HB or equivalent, determined in accordance with ASTM E10, but the product shall not be rejected on the basis of hardness if the tensile property requirements of 3.4.1.2.1 are met.

3.4.1.2.3 Stress-Rupture Properties at 1200°F (649°C): Shall be as follows; testing of notched specimens and of combination smooth-and-notched specimens shall be performed in accordance with ASTM E292 and of smooth specimens in accordance with ASTM E139:

- 3.4.1.2.3.1 A combination smooth and notched test specimen machined to the dimensions shown in Fig. 1 and Table II, maintained at $1200^{\circ}\text{F} \pm 3$ ($649^{\circ}\text{C} \pm 2$) while a load sufficient to produce an initial axial stress of 100,000 psi (690 MPa) is applied continuously, shall not rupture in less than 23 hours. The test shall be continued to rupture without change of load. Rupture shall occur in the smooth section and elongation of this section after rupture, measured at room temperature, shall be as specified below:

Nominal Diameter or Distance Between Parallel Sides		Elongation In 4D
Inches	(Millimetres)	%, min
Up to 4.00, incl	(Up to 101.60, incl)	4
Over 4.00	(Over 101.60)	As agreed upon by purchaser and vendor

- 3.4.1.2.3.2 As an alternate procedure, separate smooth and notched specimens, machined from adjacent sections of the same piece, with gage sections conforming to the respective dimensions of Table II may be tested individually under the conditions of 3.4.1.2.3.1. The smooth specimen shall not rupture in less than 23 hr and elongation after rupture, measured at room temperature, shall be as specified in 3.4.1.2.3.1. The notched specimen shall not rupture in less time than the companion smooth specimen but need not be tested to rupture.
- 3.4.1.2.3.3 The tests of 3.4.1.2.3.1 and 3.4.1.2.3.2 may be conducted using a load higher than required to produce an initial axial stress of 100,000 psi (690 MPa) but load shall not be changed while test is in progress. Time to rupture, rupture location, and elongation requirements shall be as specified in 3.4.1.2.3.1.
- 3.4.1.2.3.4 When permitted by purchaser, the tests of 3.4.1.2.3.1 and 3.4.1.2.3.2 may be conducted using incremental loading. In such case, the load required to produce an initial axial stress of 100,000 psi (690 MPa) shall be used to rupture or for 23 hr, whichever occurs first. After the 23 hr and at intervals of 8 - 16 hr, preferably 8 - 10 hr, thereafter, the stress shall be increased in increments of 5,000 psi (34.5 MPa). Time to rupture, rupture location, and elongation requirements shall be as specified in 3.4.1.2.3.1.
- 3.4.2 Forging Stock: When a sample of stock is forged to a test coupon and heat treated as in 3.3.2 and 3.4.1.2, specimens taken from the heat treated coupon shall conform to the requirements of 3.4.1.2.1, 3.4.1.2.2, and 3.4.1.2.3. If specimens taken from the stock after heat treatment as in 3.3.2 and 3.4.1.2 conform to the requirements of 3.4.1.2.1, 3.4.1.2.2, and 3.4.1.2.3, the tests shall be accepted as equivalent to tests of a forged coupon.
- 3.4.3 Stock for Flash Welded Rings: Specimens taken from the stock after heat treatment as in 3.3.2 and 3.4.1.2 shall conform to the requirements of 3.4.1.2.1, 3.4.1.2.2, and 3.4.1.2.3.

3.5 Quality:

- 3.5.1 Alloy shall be produced by multiple melting using consumable electrode practice in the remelt cycle or shall be induction melted under vacuum, unless otherwise permitted by purchaser. If consumable electrode remelting is not performed in vacuum, electrodes which have been produced by vacuum induction melting shall be used.
- 3.5.2 The product, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from internal and external imperfections detrimental to usage of the product.
- 3.5.2.1 Forgings shall have substantially uniform macrostructure and grain flow. Standards for acceptance shall be as agreed upon by purchaser and vendor.

3.6 Sizes: Except when exact lengths or multiples of exact lengths are ordered, straight bars will be acceptable in mill lengths of 6 - 24 ft (1.8 - 7.3 m) but not more than 25% of any shipment shall be supplied in lengths of 6 - 9 ft (1.8 - 2.7 m) except that for bars weighing over 25 lb per ft (37 kg/m), short lengths down to 2 ft (600 mm) may be supplied.

3.7 Tolerances: Unless otherwise specified, tolerances for bars and forging stock shall conform to all applicable requirements of AMS 2261.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of the product shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.5. Purchaser reserves the right to sample and to perform such confirmatory testing as deemed necessary to ensure that the product conforms to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests to determine conformance to the following requirements are classified as acceptance tests and shall be performed on each heat or lot as applicable:

4.2.1.1 Composition (3.1) of each heat.

4.2.1.2 Hardness (3.4.1.1.1) and grain size (3.4.1.1.2) of each lot of bars, forgings, and flash welded rings as solution heat treated.

4.2.1.3 Tensile (3.4.1.2.1), hardness (3.4.1.2.2), and stress-rupture (3.4.1.2.3) properties of each lot of bars, forgings, and flash welded rings after precipitation heat treatment.

4.2.1.4 Tolerances (3.7) of bars and forging stock.

4.2.2 Periodic Tests: Tests of forging stock (3.4.2) and stock for flash welded rings (3.4.3) to demonstrate ability to develop required properties are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

4.2.3 Preproduction Tests: Tests of forgings to determine conformance to all applicable technical requirements of this specification when AMS 2375 is specified are classified as preproduction tests and shall be performed on the first-article shipment of a forging to a purchaser, when a change in material or processing requires reapproval as in 4.4, and when purchaser deems confirmatory testing be required.

4.2.3.1 For direct U.S. Military procurement of forgings, substantiating test data and, when requested, preproduction forgings shall be submitted to the cognizant agency as directed by the procuring activity, the contracting officer, or the request for procurement.

4.3 Sampling: Shall be in accordance with the following:

4.3.1 Bars, Flash Welded Rings, and Stock for Flash Welded Rings: AMS 2371.

4.3.2 Forgings and Forging Stock: AMS 2374.

4.3.3 Grain size samples shall be taken from the mid-radius or 1/4 thickness position.

4.4 Approval: When specified, approval and control of forgings shall be in accordance with AMS 2375.

4.5 Reports:

- 4.5.1 The vendor of the product shall furnish with each shipment three copies of a report showing the results of tests for chemical composition of each heat and the results of tests on each lot to determine conformance to the other acceptance test requirements of this specification. This report shall include the purchase order number, heat number, AMS 5702A, solution heat treatment temperature used, size, and quantity from each heat. If forgings are supplied, the part number and the size and melt source of stock used to make the forgings shall also be included.
- 4.5.2 The vendor of finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, AMS 5702A, 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.
- 4.6 Resampling and Retesting: Shall be in accordance with the following:
- Ø 4.6.1 Bars, Flash Welded Rings, and Stock for Flash Welded Rings: AMS 2371.
- Ø 4.6.2 Forgings and Forging Stock: AMS 2374.
5. PREPARATION FOR DELIVERY:
- 5.1 Identification: The product shall be identified as follows:
- Ø 5.1.1 Bars: In accordance with AMS 2806.
- 5.1.2 Forgings: In accordance with AMS 2808.
- 5.1.3 Flash Welded Rings and Stock for Forging or Flash Welded Rings: As agreed upon by purchaser and vendor.
- 5.2 Packaging:
- 5.2.1 The product shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the product to ensure carrier acceptance and safe delivery. Packaging shall conform to carrier rules and regulations applicable to the mode of transportation.
- 5.2.2 For direct U.S. Military procurement, packaging shall be in accordance with MIL-STD-163, Level A or Level C, as specified in the request for procurement. Commercial packaging as in 5.2.1 will be acceptable if it meets the requirements of Level C.
6. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
7. REJECTIONS: Material not conforming to this specification or to modifications authorized by purchaser will be subject to rejection.
8. NOTES:
- 8.1 Marginal Indicia: The phi (Ø) symbol is used to indicate technical changes from the previous issue of this specification.