

ALLOY SHEET, STRIP, AND PLATE, CORROSION AND HEAT RESISTANT
21Cr - 32.5Ni - 0.38Ti - 0.38Al - 45Fe
Solution Heat Treated

UNS N08800

1. SCOPE:

1.1 Form: This specification covers a corrosion and heat resistant iron alloy in the form of sheet, strip, and plate.

1.2 Application: Primarily for low-stressed parts requiring corrosion and oxidation resistance up to 2100°F (1150°C), particularly where such parts may require welding during fabrication.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2262 - Tolerances, Nickel, Nickel Alloy, and Cobalt Alloy Sheet, Strip, and Plate

MAM 2262 - Tolerances, Metric, Nickel, Nickel Alloy, and Cobalt Alloy Sheet, Strip, and Plate

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

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

ASTM A751 - Methods, Practices, and Definitions for Chemical Analysis of Steel Products

ASTM E8 - Tension Testing of Metallic Materials

ASTM E290 - Semi-Guided Bend Test for Ductility of Metallic Materials

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

2.3.1 Military Standards:

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 any of the analytical methods specified in ASTM A751:

	min	max
Carbon	--	0.10
Manganese	--	1.50
Silicon	--	1.00
Sulfur	--	0.015
Chromium	19.00 -	23.00
Nickel	30.00 -	35.00
Titanium	0.15 -	0.60
Aluminum	0.15 -	0.60
Copper	--	0.75
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 Sheet and Strip: 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 applicable:

3.2.1.1 Sheet: No. 2D finish.

3.2.1.2 Strip: No. 1 strip finish.

3.2.2 Plate: Hot rolled and solution heat treated; when so ordered, plate shall be descaled.

3.3 Properties: The product shall conform to the following requirements:

- 3.3.1 Tensile Properties: Shall be as follows for product 0.010 - 2.00 in. (0.25 - 50.0 mm), incl, in nominal thickness, determined in accordance with ASTM E8; tensile property requirements for product under 0.010 in. (0.25 mm) or over 2.00 in. (50.0 mm) in nominal thickness shall be as agreed upon by purchaser and vendor:

Tensile Strength, min	65,000 psi (450 MPa)
Yield Strength at 0.2% Offset, min	25,000 psi (170 MPa)
Elongation in 2 in. (50 mm) or 4D, min	30%

- 3.3.2 Bending: Product 0.250 in. (6.25 mm) and under in nominal thickness shall withstand, without cracking, bending in accordance with ASTM E290 at room temperature through an angle of 180 deg around a diameter equal to the bend factor times the nominal thickness of the product with axis of bend parallel to the direction of rolling.

Nominal Thickness		Bend Factor
Inch	Millimetres	
Up to 0.050, incl	Up to 1.25, incl	1
Over 0.050 to 0.250, incl	Over 1.25 to 6.25, incl	2

- 3.3.2.1 Bending requirements for product over 0.250 in. (6.25 mm) in nominal thickness 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.

- 3.5 Tolerances: Shall conform to all applicable requirements of AMS 2262 or MAM 2262.

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 4.4. 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 to determine conformance to all technical requirements of this specification are classified as acceptance tests and shall be performed on each heat or lot as applicable.

- 4.3 Sampling: Shall be in accordance with AMS 2371.

4.4 Reports:

- 4.4.1 The vendor of the product shall furnish with each shipment a report showing the results of tests for chemical composition of each heat and for tensile and bending properties on each lot. This report shall include the purchase order number, heat number, AMS 5871B, size, and quantity.
- 4.4.2 The vendor of finished or semi-finished parts shall furnish with each shipment a report showing the purchase order number, AMS 5871B, 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 either a statement that the material conforms or copies of laboratory reports showing the results of tests to determine conformance.

4.5 Resampling and Retesting: Shall be in accordance with AMS 2371.

5. PREPARATION FOR DELIVERY:

- 5.1 Identification: Each sheet, strip, and plate shall be marked on one face, in the respective location indicated below, with AMS 5871B, heat number, manufacturer's identification, and nominal thickness. The characters shall be of such size as to be legible, shall be applied using a suitable marking fluid, and shall be removable in hot alkaline cleaning solution without rubbing. The markings shall have no deleterious effect on the product or its performance and shall be sufficiently stable to withstand normal handling.
 - 5.1.1 Flat Strip 6 In. (150 mm) and Under in Width: Shall be marked in one or more lengthwise rows of characters recurring at intervals not greater than 3 ft (900 mm).
 - 5.1.2 Flat Sheet, Flat Strip Over 6 In. (150 mm) in Width, and Plate: Shall be marked in lengthwise rows of characters recurring at intervals not greater than 3 ft (900 mm), the rows being spaced not more than 6 in. (150 mm) apart and alternately staggered.
 - 5.1.3 Coiled Sheet and Strip: Shall be marked near both the outside and inside ends of the coil; the markings shall be applied as in 5.1 or shall appear on a durable tag or label attached to the coil and marked with the information of 5.1. When the product is wound on cores, the tag or label may be attached to the core.
- 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.