

**AEROSPACE
MATERIAL
SPECIFICATION**

AMS 6255

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Revised

STEEL BARS, FORGINGS, AND TUBING
1.1Si - 1.45Cr - 1.0Mo - 0.08Al (0.16 - 0.22C)
Premium Aircraft Quality, Double Vacuum Melted

1. SCOPE:

1.1 Form: This specification covers a premium aircraft-quality, low-alloy steel in the form of bars, forgings, mechanical tubing, and forging stock.

1.2 Application: Primarily for critical carburized parts, such as bearings, gears, and shafts, requiring high minimum core hardness with narrow range, good resistance to elevated temperature up to 600°F (315°C), and subject to very rigid magnetic particle inspection standards.

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

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

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2.1.1 Aerospace Material Specifications:

AMS 2251 - Tolerances, Low-Alloy Steel Bars
MAM 2251 - Tolerances, Metric, Low-Alloy Steel Bars
AMS 2253 - Tolerances, Carbon and Alloy Steel Tubing
MAM 2253 - Tolerances, Metric, Carbon and Alloy Steel Tubing
AMS 2259 - Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
AMS 2300 - Premium Aircraft-Quality Steel Cleanliness, Magnetic Particle Inspection Procedure
MAM 2300 - Premium Aircraft-Quality Steel Cleanliness, Magnetic Particle Inspection Procedure, Metric (SI) Measurement
AMS 2350 - Standards and Test Methods
AMS 2370 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Wrought Products Except Forgings and Forging Stock
AMS 2372 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, 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

2.1.2 Aerospace Standards:

AS 1182 - Standard Machining Allowance, Aircraft Quality and Premium Quality Steel Products

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

ASTM A255 - End-Quench Test for Hardenability of Steel
ASTM A370 - Mechanical Testing of Steel Products
ASTM A604 - Macroetch Testing of Consumable Electrode Remelted Steel Bars and Billets
ASTM E45 - Determining the Inclusion Content of Steel
ASTM E112 - Determining Average Grain Size
ASTM E350 - Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

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 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 wet chemical methods in accordance with ASTM E350, 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	0.16	0.22
Manganese	0.45	0.75
Silicon	0.90	1.25
Phosphorus	--	0.010
Sulfur	--	0.010
Chromium	1.25	1.65
Molybdenum	0.90	1.10
Aluminum	0.03	0.12
Nickel	--	0.25
Copper	--	0.35

- 3.1.1 Check Analysis: Composition variations shall meet the applicable requirements of AMS 2259.

- 3.2 Condition: The product shall be supplied in the following condition; hardness and tensile strength shall be determined in accordance with ASTM A370:

3.2.1 Bars:

- 3.2.1.1 Bars 0.500 In. (12.50 mm) and Under in Nominal Diameter or Distance Between Parallel Sides: Cold finished having tensile strength not higher than 125,000 psi (860 MPa) or equivalent hardness.

- 3.2.1.2 Bars Over 0.500 In. (12.50 mm) in Nominal Diameter or Distance Between Parallel Sides: Hot finished and annealed having hardness not higher than 229 HB or equivalent except that bars ordered cold finished may have hardness as high as 248 HB or equivalent.

- 3.2.2 Forgings: As ordered.

- 3.2.3 Mechanical Tubing: Cold finished having hardness not higher than 25 HRC or equivalent except that tubing ordered hot finished and annealed shall have hardness not higher than 229 HB or equivalent.

- 3.2.4 Forging Stock: As ordered by the forging manufacturer.

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

- 3.3.1 Macrostructure: Visual examination of transverse sections as in 4.3.3 from bars, billet, tube rounds or tubes, and forging stock, etched in accordance with ASTM A604 in hot hydrochloric acid (1:1) at 160° - 180°F (70° - 80°C) for sufficient time to develop a well-defined macrostructure, shall show no pipe or cracks. Except as specified in 3.3.1.1, porosity, segregation, inclusions, and other imperfections in product 36 sq in. (230 cm²) and under in cross-sectional area shall be no worse than the following macrographs of ASTM A604; macrostructure standards for product over 36 sq in. (230 cm²) in cross-sectional area shall be as agreed upon by purchaser and vendor:

Class	Condition	Severity
1	Freckles	A
2	White Spots	A
3	Radial Segregation	B
4	Ring Pattern	B

- 3.3.1.1 If tubes are produced directly from ingots or large blooms, transverse sections may be taken from tubes rather than tube rounds. Macrostructure standards for such tubes shall be as agreed upon by purchaser and vendor.

- 3.3.2 Micro-Inclusion Rating: No specimen as in 4.3.4 shall exceed the following limits, determined in accordance with ASTM E45, Method D:

Type	Inclusion Rating			
	A	B	C	D
Thin	1.5	1.5	1.5	1.5
Heavy	1.0	1.0	1.0	1.0

- 3.3.2.1 For types A, B, and C thin combined, there shall be not more than three fields of No. 1.5 A, B, and C types and not more than five other lower rateable A, B, and C type thin fields per specimen. For type D thin, there shall be not more than three No. 1.5 fields and no more than five other lower rateable D type thin fields per specimen. There shall be not more than one field each No. 1.0 A, B, C, or D type heavy per specimen.

- 3.3.2.2 A rateable field is defined as one which has a type A, B, C, or D inclusion rating of at least No. 1.0 thin or heavy in accordance with the Jernkontoret chart, Plate III, ASTM E45.

- 3.3.3 Grain Size: Predominantly 4 or finer with occasional grains as large as 2 permissible, determined in accordance with ASTM E112.

3.3.4 Hardenability: Shall be J47=1 max and J30=6 min, determined on the standard end-quench specimen in accordance with ASTM A255 except that the steel shall be normalized at $1700^{\circ}\text{F} \pm 10$ ($925^{\circ}\text{C} \pm 5$) and the specimen austenitized at $1550^{\circ}\text{F} \pm 10$ ($845^{\circ}\text{C} \pm 5$). The hardenability test is not required on a product which will not yield a suitable specimen but the steel from which the product is made shall conform to the hardenability specified.

3.4 Quality:

3.4.1 Steel shall be premium aircraft-quality conforming to AMS 2300 or MAM 2300; it shall be double vacuum melted using vacuum induction melting followed by vacuum consumable electrode remelting.

3.4.2 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.

3.4.2.1 Bars and tubing ordered ground, turned, or polished shall be free from seams, laps, tears, and cracks open to the ground, turned, or polished surfaces.

3.4.2.2 Product ordered to surface conditions other than ground, turned, or polished shall, after removal of the standard machining allowance, be free from seams, laps, tears, cracks, and other defects exposed to the machined surfaces. Standard machining allowance shall be in accordance with AS 1182.

3.5 Sizes: Except when exact lengths or multiples of exact lengths are ordered, straight bars and tubing will be acceptable in mill lengths of 6 - 20 ft (2 - 6 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 shall conform to all applicable requirements of the following:

3.6.1 Bars: AMS 2251 or MAM 2251.

3.6.2 Mechanical Tubing: AMS 2253 or MAM 2253.

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 any confirmatory testing 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 all technical requirements of this specification are classified as acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 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 prior to or on the first-article shipment of a forging to a purchaser, when a change in material or processing, or both, requires reapproval as in 4.4, and when purchaser deems confirmatory testing to be required.

4.2.2.1 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; a heat shall be the ingots produced from a single vacuum induction melt:

4.3.1 Bars and Mechanical Tubing: AMS 2370.

4.3.2 Forgings and Forging Stock: AMS 2372.

4.3.3 Samples for macrostructure (3.3.1) testing shall be full cross-sectional specimens obtained from the finished billet or suitable rerolled product representing the top and bottom of at least the first, middle, and last usable ingots of each heat.

4.3.4 Samples for micro-inclusion rating (3.3.2) shall consist of not less than six specimens obtained from the full cross-section of billet stock taken from the top and bottom of at least the first, middle, and last usable ingots from each heat.

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 a report showing the results of tests for chemical composition, macrostructure, micro-inclusion rating, grain size, hardenability, and AMS 2300 frequency-severity rating of each heat. This report shall include the purchase order number, heat number, AMS 6255, 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.