

 <i>An SAE International Group</i>	AEROSPACE MATERIAL SPECIFICATION	SAE AMS6255	REV. E
		Issued 1984-07 Revised 2012-05	
		Superseding AMS6255D	
Steel Bars, Forgings, and Tubing 1.1Si - 1.45Cr - 1.0Mo - 0.08Al (0.16 - 0.22C) Double Vacuum Melted (Composition similar to UNS K21940)			

RATIONALE

AMS6255E results from a Five Year Review and update of this specification.

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

These products have been used typically for critical carburized parts, such as bearings, gears, and shafts, requiring high minimum core hardness within a narrow range, good resistance to elevated temperature up to 600 °F (316 °C), and subject to rigid magnetic particle inspection standards, but usage is not limited to such applications.

2. APPLICABLE DOCUMENTS

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org.

AMS2251	Tolerances, Low-Alloy Steel Bars
AMS2253	Tolerances, Carbon and Alloy Steel Tubing
AMS2259	Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
AMS2300	Steel Cleanliness, Premium Aircraft-Quality, Magnetic Particle Inspection Procedure

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AMS2370	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel, Wrought Products and Forging Stock
AMS2372	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Forgings
AMS2806	Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys
AMS2808	Identification, Forgings
AS1182	Standard Stock Removal Allowance, Aircraft-Quality and Premium Aircraft-Quality Steel Bars and Mechanical Tubing

2.2 ASTM Publications

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM A 255	Determining Hardenability of Steel
ASTM A 370	Mechanical Testing of Steel Products
ASTM A 604	Macroetch Testing of Consumable Electrode Remelted Steel Bars and Billets
ASTM E 45	Determining the Inclusion Content of Steel
ASTM E 112	Determining Average Grain Size
ASTM E 350	Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

3. TECHNICAL REQUIREMENTS

3.1 Composition

Shall conform to the percentages by weight shown in Table 1, determined by wet chemical methods in accordance with ASTM E 350, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - COMPOSITION

Element	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 AMS2259.

3.2 Melting Practice

Steel shall be multiple melted using vacuum induction melting plus consumable electrode vacuum remelting.

3.3 Condition

The product shall be supplied in the following condition; hardness and tensile strength shall be determined in accordance with ASTM A 370:

3.3.1 Bars

Bar shall not be cut from plate. (Also see 4.4.2.)

3.3.1.1 Bars 0.500 Inch (12.70 mm) and Under in Nominal Diameter or Least Distance Between Parallel Sides

Cold finished having tensile strength not higher than 125 ksi (862 MPa), or equivalent hardness (See 8.2).

3.3.1.2 Bars Over 0.500 Inch (12.70 mm) in Nominal Diameter or Least Distance Between Parallel Sides

Hot finished and annealed unless otherwise ordered, having hardness not higher than 229 HB, or equivalent (See 8.3). Bars ordered cold finished may have hardness as high as 248 HB, or equivalent (See 8.3).

3.3.2 Forgings

As ordered.

3.3.3 Mechanical Tubing

Cold finished unless otherwise ordered, having hardness not higher than 25 HRC, or equivalent (See 8.3). Tubing ordered hot finished and annealed shall have hardness not higher than 229 HB, or equivalent (See 8.3).

3.3.4 Forging Stock

As ordered by the forging manufacturer.

3.4 Properties

The product shall conform to the following requirements; hardness testing shall be performed in accordance with ASTM A 370:

3.4.1 Macrostructure Rating

Visual examination of transverse full cross-sections from bars, billets, tube rounds (solid, not hollow), and forging stock, etched in hot hydrochloric acid in accordance with ASTM A 604, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the macrographs of ASTM A 604 shown in Table 2.

TABLE 2 - MACROSTRUCTURE LIMITS

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

3.4.1.1 Macrostructure examination is not required for hollow tubes that are produced directly from ingots or blooms unless specified by purchaser, in which case the purchaser shall specify standards to be used.

3.4.2 Micro-Inclusion Rating of Each Heat

No specimen shall exceed the limits of Table 3, determined in accordance with ASTM E 45, Method D:

TABLE 3 - MICRO-INCLUSION RATING LIMITS

Type	A	A	B	B	C	C	D	D
	Thin	Heavy	Thin	Heavy	Thin	Heavy	Thin	Heavy
Worst Field Severity	1.5	1.0	1.5	1.0	1.5	1.0	1.5	1.0
Worst Field Frequency, maximum	a	1	a	1	a	1	3	1
Total Rateable Fields, Frequency, maximum	b	1	b	1	b	1	8	1

a - Combined A+B+C, not more than 3 fields

b - Combined A+B+C, not more than 8 fields

3.4.2.1 A rateable field is defined as one that 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 I-r, ASTM E 45.

3.4.3 Average Grain Size of Bars, Forgings and Tubing

Shall be ASTM No. 4 or finer, determined in accordance with ASTM E 112.

3.4.4 Hardenability of Each Heat

Shall be J1/16 inch (1.6 mm) = 47 HRC maximum and J6/16 inch (9.5 mm) = 30 HRC minimum, determined on the standard end-quench specimen in accordance with ASTM A 255 except that the steel shall be normalized at 1700 °F ± 10 (927 °C ± 6) and the specimen austenitized at 1650 °F ± 10 (899 °C ± 6).

3.5 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.

3.5.1 Steel shall be premium aircraft-quality conforming to AMS2300.

3.5.2 Bars and mechanical tubing ordered hot rolled or cold drawn, or ground, turned, or polished, shall, after removal of the standard stock removal allowance in accordance with AS1182, be free from seams, laps, tears, and cracks open to the ground, turned, or polished surfaces.

3.5.3 Grain flow of die forgings, except in areas which contain flash-line end grain, shall follow the general contour of the forgings showing no evidence of reentrant grain flow.

3.6 Tolerances

3.6.1 Bars

In accordance with AMS2251.

3.6.2 Mechanical Tubing

In accordance with AMS2253.

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 the performance of all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to specified requirements.

4.2 Classification of Tests

4.2.1 Acceptance Tests

Composition (3.1), condition (3.3), macrostructure (3.4.1), micro-inclusion rating (3.4.2), average grain size (3.4.3), hardenability (3.4.4), quality (3.5), and tolerances (3.6) are acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Periodic Tests

Frequency-severity cleanliness rating (3.5.1) and grain flow of die forgings (3.5.3) are periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

4.3 Sampling and Testing

4.3.1 Bars, Mechanical Tubing, and Forging Stock

In accordance with AMS2370.

4.3.2 Forgings

In accordance with AMS2372.

4.4 Reports

4.4.1 The vendor of bars, forgings and tubing shall furnish with each shipment a report showing the results of tests for composition, macrostructure, micro-inclusion rating and hardenability of each heat and for average grain size of each lot, and stating that the product conforms to the other technical requirements. This report shall include the purchase order number, heat and lot numbers, AMS6255E, product form and size (and/or part number, if applicable), and quantity. If forgings are supplied, the size and melt source of stock used to make the forgings shall also be included.

4.4.2 If the ship size/shape is cut from a larger cross section, report the nominal metallurgically worked size (See 3.3.1).

4.4.3 The vendor of forging stock shall furnish with each shipment a report showing the results of tests for composition, macrostructure, micro-inclusion rating and hardenability of each heat. This report shall include the purchase order number, heat number, AMS6255E, size and quantity.

4.5 Resampling and Retesting

4.5.1 Bars, Mechanical Tubing, and Forging Stock

In accordance with AMS2370.

4.5.2 Forgings

In accordance with AMS2372.