



AEROSPACE MATERIAL SPECIFICATIONS

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc.

485 Lexington Ave., New York, N. Y. 10017

AMS 6280E

Superseding AMS 6280D

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STEEL BARS, FORGINGS, AND RINGS 0.50Cr - 0.55Ni - 0.20Mo (0.28 - 0.33C) (SAE 8630)

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 with sections 0.50 in. or less in thickness at the time of heat treatment which require a through-hardening steel capable of developing hardness as high as Rockwell C 35 when properly hardened and tempered and also parts of greater thickness but requiring proportionately lower hardness.

4. **COMPOSITION:**

	min	max
Carbon	0.28	0.33
Manganese	0.70	0.90
Silicon	0.20	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	0.40	0.60
Nickel	0.40	0.70
Molybdenum	0.15	0.25
Copper	--	0.35

- 4.1 **Check Analysis:** Composition variations shall meet the requirements of the latest issue of AMS 2259, paragraph titled "Low Alloy Steels".

5. **CONDITION:** Unless otherwise ordered, the product shall be supplied in the following condition:

- 5.1 **Bars:** In a machinable condition and hot finished having hardness not higher than Brinell 229 or equivalent, except that bars ordered cold finished may have hardness as high as Brinell 248 or equivalent.

- 5.2 **Forgings:** As ordered.

- 5.3 **Flash Welded Rings:** Normalized and tempered to a hardness not higher than Brinell 241 or equivalent.

- 5.3.1 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 the latest issue of AMS 7496, unless otherwise specified.

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

6. **TECHNICAL REQUIREMENTS:** When ASTM methods are specified for determining conformance to the following requirements, tests shall be conducted in accordance with the issue of the ASTM method listed in the latest issue of AMS 2350.

- 6.1 **Hardenability:** The hardenability shall be J35=5 min and J28=8 min when determined on the standard end-quench test specimen in accordance with the Method of Determining Hardenability published in the latest issue of the SAE Handbook, except that the steel shall be normalized at $1700\text{ F} \pm 10$ ($926.7\text{ C} \pm 5.6$) and the test specimen austenitized at $1525\text{ F} \pm 10$ ($829.4\text{ C} \pm 5.6$). 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.
- 6.2 **Grain Size:** Predominantly 5 or finer with occasional grains as large as 3 permissible, ASTM E112, McQuaid-Ehn Test.
- 6.3 **Decarburization:**
- 6.3.1 Bars ordered ground, turned, or polished shall be free from decarburization on the ground, turned, or polished surfaces.
- 6.3.2 Allowable decarburization of bars and billets ordered for redrawing or forging or to specified micro-structural requirements shall be as agreed upon by purchaser and vendor.
- 6.3.3 Decarburization of bars to which 6.3.1 or 6.3.2 is not applicable shall be not greater than the following:

Nominal Diameter or Distance Between Parallel Sides Inches	Depth of Decarburization Inch
Up to 0.375, incl	0.010
Over 0.375 to 0.500, incl	0.012
Over 0.500 to 0.625, incl	0.014
Over 0.625 to 1.000, incl	0.017
Over 1.000 to 1.500, incl	0.020
Over 1.500 to 2.000, incl	0.025
Over 2.000 to 2.500, incl	0.030
Over 2.500 to 3.000, incl	0.035
Over 3.000 to 4.000, incl	0.045

- 6.3.3.1 Limits for depth of decarburization of bars over 4.000 in. in nominal diameter or distance between parallel sides shall be as agreed upon by purchaser and vendor.
- 6.3.4 Unless otherwise agreed upon by purchaser and vendor, decarburization shall be measured by the microscopic method, or by Rockwell Superficial 30-N scale hardness method, or equivalent hardness testing method, on hardened but untampered specimens protected during heat treatment to prevent changes in surface carbon content. Depth of decarburization, when measured by a hardness method, is defined as the perpendicular distance from the surface to the nondecarburized depth under that surface below which there is no further increase in hardness. Measurements shall be far enough away from any adjacent surface to be uninfluenced by any decarburization or lack of decarburization thereon.
- 6.3.4.1 When determining the depth of decarburization, it is permissible to disregard local areas provided the decarburization of such areas does not exceed the limits above by more than 0.005 in. and the width is 0.065 in. or less.
7. **QUALITY:** Steel shall be aircraft quality and shall conform to the requirements of the latest issue of AMS 2301. The product 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 for bars shall conform to all applicable requirements of the latest issue of AMS 2251; for all hexagons, tolerances for cold finished shall apply.