



AEROSPACE MATERIAL SPECIFICATION

AMS6280™**REV. N**Issued 1942-09
Revised 2022-07

Superseding AMS6280M

Steel Bars, Forgings, Rings and Forging Stock
0.50Cr - 0.55Ni - 0.20Mo (0.28 - 0.33C) (SAE 8630)
(Composition similar to UNS G86300)

RATIONALE

AMS6280N is the result of a Five-Year Review and update of the specification. The revision updates the title to match the scope, prohibits unauthorized exceptions (3.6, 5.2.1, 8.6), updates composition testing (3.1), removes approval requirements (Table 2), updates jominy requirements (3.3.3), updates decarburization test methods (3.3.4.4.1, 3.3.4.4.2), address reduced testing from AMS2301 (4.2.1, 4.4.4), allows prior revisions (8.7), and adds information on AS1182 (8.4).

1. SCOPE

1.1 Form

This specification covers an aircraft-quality, low-alloy steel in the form of bars, forgings, flash welded rings, and stock for forging or flash welded rings.

1.2 Application

These products have been used typically for parts, with sections 0.500 inch (12.70 mm) and under in thickness at time of heat treatment, requiring a through-hardening steel capable of developing hardness as high as 35 HRC when properly hardened and tempered and also for parts of greater thickness but requiring proportionately lower hardness, but usage is not limited to such applications.

2. APPLICABLE DOCUMENTS

The following publications form a part of this document to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order. In the event of conflict between the text of this document and references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or +1 724-776-4970 (outside USA), www.sae.org.

AMS2251 Tolerances, Low-Alloy Steel Bars

AMS2259 Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels

AMS2301 Steel Cleanliness, Aircraft Quality, Magnetic Particle Inspection Procedure

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SAE WEB ADDRESS:

For more information on this standard, visit
<https://www.sae.org/standards/content/AMS6280N/>

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
AMS7496	Rings, Flash Welded, Carbon and Low-Alloy Steels
AS7766	Terms Used in Aerospace Metals Specifications
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 A255	Determining the Hardenability of Steel
ASTM A370	Mechanical Testing of Steel Products
ASTM A751	Chemical Analysis of Steel Products
ASTM E112	Determining Average Grain Size
ASTM E140	Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness
ASTM E381	Macroetch Testing, Steel Bars, Billets, Blooms, and Forgings
ASTM E1077	Estimating the Depth of Decarburization of Steel Specimens

2.3 Definitions

Terms used in AMS are defined in AS7766.

3. TECHNICAL REQUIREMENTS

3.1 Composition

Shall conform to the percentages by weight, shown in Table 1 determined in accordance with ASTM A751 or by other analytical methods acceptable to purchaser.

Table 1 - Composition

Element	Min	Max
Carbon	0.28	0.33
Manganese	0.70	0.90
Silicon	0.15	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

3.1.1 Aluminum, vanadium, and columbium (niobium) are optional grain refining elements and need not be determined or reported unless used to satisfy the average grain size requirements of 3.3.2.2.

3.1.2 Check Analysis

Composition variations shall meet the applicable requirements of AMS2259.

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

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

3.2.1.1 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 hardness not higher than 26 HRC.

3.2.1.2 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 8.2). Bars ordered cold finished may have hardness as high as 248 HB, or equivalent (see 8.2).

3.2.2 Forgings and Flash Welded Rings

As ordered.

3.2.2.1 Flash welded rings shall not be supplied unless specified or permitted on purchaser's part drawing. When supplied, flash welded rings shall be manufactured in accordance with AMS7496.

3.2.3 Stock for Forging or Flash Welded Rings

As ordered by the forging or flash welded ring 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 full cross sections from bars, billets, and stock for forging or flash welded rings, etched in hot hydrochloric acid in accordance with ASTM E381, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the macrographs of ASTM E381 shown in Table 2.

Table 2 - Macrostructure limits

Cross-Sectional Area Square Inches	Cross-Sectional Area Square Centimeters	Macrographs
Up to 36, incl	Up to 232, incl	S2 - R1 - C2
Over 36 to 133, incl	Over 232 to 858, incl	S2 - R2 - C3
Over 133	Over 858	Note 1

NOTE 1: Limits for larger sizes shall be agreed upon by purchaser and producer.

3.3.2 Average Grain Size of Bars, Forgings, and Flat Welded Rings

Average grain size shall be determined by either 3.3.2.1 or 3.3.2.2.

3.3.2.1 Shall be ASTM No. 5 or finer, determined in accordance with ASTM E112.

3.3.2.2 The product of a heat shall be considered to have an ASTM No. 5 or finer austenitic grain size if one or more of the following are determined by heat analysis (see 8.5):

3.3.2.2.1 A total aluminum content of 0.020 to 0.050%.

3.3.2.2.2 An acid soluble aluminum content of 0.015 to 0.050%.

3.3.2.2.3 A vanadium content of 0.02 to 0.08%.

3.3.2.2.4 A columbium (niobium) content of 0.02 to 0.05%.

3.3.3 Hardenability of Each Heat

Shall be J5/16 inch (7.9 mm) = 35 HRC minimum and J8/16 inch (12.7 mm) = 28 HRC minimum, determined on the standard end-quench test specimen in accordance with ASTM A255, except that the steel shall be normalized at 1700 °F ± 10 °F (927 °C ± 6 °C) and the test specimen austenitized at 1525 °F ± 10 °F (829 °C ± 6 °C). Cast specimens do not need to be normalized.

3.3.4 Decarburization

3.3.4.1 Bars and flash welded rings ordered ground, turned, or polished shall be free from decarburization on the ground, turned, or polished surfaces.

3.3.4.2 Allowable decarburization of bars and billets ordered for redrawing or forging or to specified microstructural requirements shall be as agreed upon by purchaser and producer.

3.3.4.3 Decarburization of bars and flash welded rings that 3.3.4.1 or 3.3.4.2 is not applicable shall be not greater than shown in Table 3.

Table 3A - Maximum depth of decarburization limits, inch/pound units

Nominal Diameter or Distance Between Parallel Sides Inches		Total Depth of Decarburization, Inches
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

Table 3B - Maximum depth of decarburization limits, SI units

Nominal Diameter or Distance Between Parallel Sides Millimeters		Total Depth of Decarburization, Millimeters
Up	to 9.52, incl	0.25
Over 9.52	to 12.70, incl	0.30
Over 12.70	to 15.88, incl	0.36
Over 15.88	to 25.40, incl	0.43
Over 25.40	to 38.10, incl	0.51
Over 38.10	to 50.80, incl	0.64
Over 50.80	to 63.50, incl	0.76
Over 63.50	to 76.20, incl	0.89
Over 76.20	to 101.60, incl	1.14

3.3.4.3.1 When permitted by purchaser, flash welded rings, to be machined all over by purchaser, may have decarburization greater than shown in Table 3 provided such decarburization is removable within the machining allowance for the part.

3.3.4.4 Decarburization shall be evaluated by one of the two methods of 3.3.4.4.1 or 3.3.4.4.2, selected at the discretion of the producer.

3.3.4.4.1 Metallographic (Microscopic) Method

A cross section taken perpendicular to the surface shall be prepared, in accordance with ASTM E1077, etched, and examined metallographically at a magnification not to exceed 200X. The product shall not show a layer of complete (ferrite) or partial decarburization exceeding the limits of Table 3.

3.3.4.4.2 Hardness Traverse (Microindentation) Method

The total depth of decarburization shall be determined by a traverse method using microindentation hardness testing in accordance with ASTM E1077. Samples shall be hardened but untempered and protected during heat treatment to prevent changes in surface carbon content. Measurements shall be far enough away from any adjacent surface to be uninfluenced by any decarburization on the adjacent surface. Acceptance shall be as listed in Table 3.

3.3.4.4.3 When determining the depth of decarburization, it is permissible to disregard local areas provided the decarburization of such areas does not exceed the above limits by more than 0.005 inch (0.13 mm) and the width is 0.065 inch (1.65 mm) or less.

3.3.4.4.4 In case of dispute, the total depth of decarburization determined using the microindentation hardness traverse method shall govern.

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.

3.4.1 Steel shall be aircraft-quality conforming to AMS2301.

3.4.2 Bars shall be free from seams, laps, tears, and cracks after removal of the standard stock removal allowance in accordance with AS1182.

3.4.3 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.

3.5 Tolerances

Bars shall conform to all applicable requirements of AMS2251.

3.6 Exceptions

Any exceptions shall be authorized by the purchaser and reported as in 4.4.5.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

The producer of the product shall supply all samples for producer'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), hardness (3.2.1), macrostructure (3.3.1), average grain size (3.3.2), hardenability (3.3.3), decarburization (3.3.4), frequency-severity cleanliness ratings (3.4.1), and tolerances (3.5) are acceptance tests and shall be performed on each heat or lot as applicable. If grain refining elements (3.3.2.2) are not present, the ASTM E112 grain size test (3.3.2.1) shall be conducted on each lot. If process qualification in accordance with AMS2301 has been met, the frequency-severity cleanliness rating shall be conducted on a periodic basis as defined in AMS2301.

4.2.2 Periodic Tests

Grain flow of die forgings is a periodic test and shall be performed at a frequency selected by the producer unless frequency of testing is specified by the purchaser. If grain refining elements (3.3.2.2) are present, the ASTM E112 grain size test (3.3.2.1) shall be conducted on a periodic basis and shall be performed at a frequency selected by the producer (not to exceed 1 year) unless frequency of testing is specified by purchaser.

4.3 Sampling and Testing

4.3.1 Bars, Flash Welded Rings, Forging Stock, and Stock for Flash Welded Rings

In accordance with AMS2370.

4.3.2 Forgings

In accordance with AMS2372.

4.4 Reports

4.4.1 The producer of bars, forgings and flash welded rings shall furnish with each shipment a report showing producer identity, country where the metal was melted (e.g., final melt in the case of metal processed by multiple melting operations), the results of composition, macrostructure, hardenability and frequency-severity cleanliness rating for each heat (see 4.4.4) and for average grain size of each lot and stating that the product conforms to other technical requirements. This report shall include the purchase order number, heat and lot numbers, AMS6280N, product form, 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. If the grain size requirement of 3.3.2 is met by the aluminum, vanadium and/or columbium (niobium) content, the aluminum, vanadium, and/or columbium (niobium) content shall be reported and a statement that the chemistry satisfies the grain size requirement shall be included.

4.4.2 If the ship size/shape is cut from a larger cross section, report the nominal metallurgically worked size (see 3.2.1).

4.4.3 The producer of stock for forging and flash welded rings shall furnish with each shipment a report showing producer identity, country where the metal was melted (e.g., final melt in the case of metal processed by multiple melting operations) and the results of tests for composition, macrostructure, hardenability and frequency-severity rating of each heat (see 4.4.4). This report shall include the purchase order number, heat number, AMS6280N, size, and quantity.

4.4.4 Reduced Testing

If the producer has qualified for periodic testing for frequency-severity cleanliness rating in accordance with AMS2301, then the frequency severity cleanliness rating is not required to be reported for each shipment. In this circumstance, the report shall read, "Process qualification in accordance with AMS2301 has been completed."

4.4.5 When material produced to this specification is beyond the sizes allowed in the scope or tables, or other exceptions are taken to the technical requirements listed in Section 3 (see 5.2), the report shall contain a statement "This material is certified as AMS6280N(EXC) because of the following exceptions:" and the specific exceptions shall be listed.

4.5 Resampling and Retesting

4.5.1 Bars, Flash Welded Rings, Forging Stock, and Stock for Flash Welded Rings

In accordance with AMS2370.

4.5.2 Forgings

In accordance with AMS2372.

5. PREPARATION FOR DELIVERY

5.1 Sizes

Except when exact lengths or multiples of exact lengths are ordered, straight bars will be acceptable in mill lengths of 6 to 20 feet (1.8 to 6.1 m), but not more than 10% of any shipment shall be supplied in lengths shorter than 10 feet (3 m).

5.2 Identification

5.2.1 Bars

In accordance with AMS2806.

5.2.1.1 When technical exceptions are taken (see 4.4.5), the material shall be identified with AMS6280N(EXC).

5.2.2 Forgings

In accordance with AMS2808.