

AEROSPACE MATERIAL SPECIFICATION



AMS 6303F

Issued
Revised

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Superseding AMS 6303E

Steel Bars and Forgings, Low Alloy, Heat Resistant

0.65Si - 1.25Cr - 0.50Mo - 0.85V (0.25 - 0.30C)

(Composition similar to UNS K22770)

1. SCOPE:

1.1 Form:

This specification covers an aircraft-quality, low-alloy, heat-resistant steel in the form of bars, forgings, and forging stock.

1.2 Application:

These products have been used typically for parts, such as turbine discs, compressor discs, and fasteners, for service up to 1050°F (565°C), 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, 400 Commonwealth Drive, Warrendale, PA 15096-0001 or www.sae.org.

AMS 2251	Tolerances, Low-Alloy Steel Bars
AMS 2259	Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
AMS 2301	Steel Cleanliness, Aircraft Quality, Magnetic Particle Inspection Procedure
AMS 2370	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel, Wrought Products and Forging Stock
AMS 2372	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel, Forgings

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TO PLACE A DOCUMENT ORDER:

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SAE WEB ADDRESS:

2.1 (Continued):

- AMS 2806 Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat Resistant Steels and Alloys
- AMS 2808 Identification, Forgings
- AS1182 Standard Machining Allowance, Aircraft-Quality and Premium Aircraft-Quality Steel Bars and Mechanical Tubing

2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or www.astm.org.

- ASTM A 370 Mechanical Testing of Steel Products
- 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
- ASTM E 381 Macroetch Testing, Inspection, and Rating Steel Products Comprising Bars, Billets, Blooms, and Forgings
- ASTM E 384 Microindentation Hardness of Materials

3. TECHNICAL REQUIREMENTS:

3.1 Composition:

Shall conform to the percentages by weight shown in Table 1, determined 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	0.25	0.30
Manganese	0.60	0.90
Silicon	0.55	0.75
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	1.00	1.5
Molybdenum	0.40	0.60
Vanadium	0.75	0.95
Nickel	--	0.50
Copper	--	0.50

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 A 370:

3.2.1 Bars:

3.2.1.1 Bars 0.500 Inch (12.50 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 27 HRC (See 8.2).

3.2.1.2 Bars Over 0.500 Inch (12.50 mm) in Nominal Diameter or Least Distance Between Parallel Sides: Hot finished and annealed unless otherwise ordered, having hardness not higher than 241 HB, or equivalent (See 8.2). Bars ordered cold finished may have hardness as high as 248 HB, or equivalent.

3.2.2 Forgings: Annealed having hardness not higher than 241 HB, or equivalent (See 8.2).

3.2.3 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 A 370:

3.3.1 Macrostructure: Visual examination of transverse full cross sections from bars, billets, and forging stock, etched in hot hydrochloric acid, in accordance with ASTM E 381, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the macrographs of ASTM E 381 shown in Table 2.

TABLE 2 - Macrostructure Limits

Section Size Square Inches	Section Size Square Centimeters	Macrographs
Up to 36, incl	Up to 232, incl	S2 - R1 - C2
Over 36 to 100, incl	Over 232 to 645, incl	S2 - R2 - C3

3.3.2 Average Grain Size: Shall be ASTM No. 5 or finer, determined in accordance with ASTM E 112 (See 8.3).

3.3.3 Decarburization:

3.3.3.1 Bars ordered ground, turned, or polished shall be free from decarburization on the ground, turned, or polished surfaces.

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

- 3.3.3.3 Decarburization of bars to which 3.3.3.1 or 3.3.3.2 is not applicable shall be not greater than shown in Table 3.

TABLE 3A - Maximum Decarburization Limits, Inch/Pound Units

Nominal Diameter or Distance Between Parallel Sides Inches	Total Depth of Decarburization Inch
Up to 0.375, incl	0.015
Over 0.375 to 0.500, incl	0.017
Over 0.500 to 0.625, incl	0.019
Over 0.625 to 1.000, incl	0.022
Over 1.000 to 1.500, incl	0.025
Over 1.500 to 2.000, incl	0.030
Over 2.000 to 2.500, incl	0.035
Over 2.500 to 3.000, incl	0.040
Over 3.000 to 4.000, incl	0.045

TABLE 3B - Maximum Decarburization Limits, SI Units

Nominal Diameter or Distance Between Parallel Sides Millimeters	Total Depth of Decarburization Millimeters
Up to 9.52, incl	0.38
Over 9.52 to 12.70, incl	0.43
Over 12.70 to 15.88, incl	0.48
Over 15.88 to 25.40, incl	0.56
Over 25.40 to 38.10, incl	0.64
Over 38.10 to 50.80, incl	0.76
Over 50.80 to 63.50, incl	0.89
Over 63.50 to 76.20, incl	1.02
Over 76.20 to 101.60, incl	1.14

- 3.3.3.4 Decarburization shall be measured by the metallographic method, by the HR30N scale hardness testing method, or by a traverse method using microhardness testing in accordance with ASTM E 384. The hardness method(s) shall be conducted on a hardened but untempered specimen 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 depth under that surface below which there is no further increase in hardness. Such measurements shall be far enough away from any adjacent surface to be uninfluenced by any decarburization on the adjacent surface. In case of dispute, the depth of decarburization using the microhardness traverse shall govern.

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

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 AMS 2301.

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

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 AMS 2251.

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 (3.2), macrostructure (3.3.1), average grain size (3.3.2), decarburization (3.3.3), frequency-severity cleanliness (3.4.1), and tolerances (3.5) are acceptance tests and shall be performed as applicable.

4.2.2 Periodic Tests: Grain flow of die forgings (3.4.1) is a periodic test and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

4.3 Sampling and Testing:

Shall be as follows:

4.3.1 Bars and Forging Stock: In accordance with AMS 2370.

4.3.2 Forgings: In accordance with AMS 2372.