

AEROSPACE MATERIAL SPECIFICATION

Submitted for recognition as an American National Standard



AMS 6346

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Steel Bars
0.95Cr - 0.20Mo (0.28 to 0.33C) (SAE 4130)
Hardened and Tempered, 125 Ksi (862 MPa) Tensile Strength

UNS G41300

1. SCOPE:

1.1 Form:

This specification covers an aircraft-quality, low-alloy steel in the form of heat treated bars.

1.2 Application:

These bars have been used typically for parts with sections 1.50 inch (38.100 mm) and under in nominal thickness requiring a minimum tensile strength of 125 ksi (862 MPa), but usage is not limited to such application.

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification 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.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2251 Tolerances, Low-Alloy Steel Bars

MAM 2251 Tolerances, Metric, Low-Alloy Steel Bars

AMS 2259 Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels

AMS 2301 Cleanliness, Aircraft Quality Steel, Magnetic Particle Inspection Procedure

MAM 2301 Cleanliness, Aircraft Quality Steel, Magnetic Particle Inspection Procedure, Metric (SI) Measurement

AMS 2370 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel, Wrought Products and Forging Stock

AMS 2806 Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat Resistant Steels and Alloys

AS1182 Standard Machining Allowance, Aircraft-Quality and Premium Aircraft-Quality Steel Bars and Mechanical Tubing

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2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM E 8 Tension Testing of Metallic Materials
 ASTM E 8M Tension Testing of Metallic Materials, Metric (SI) Measurement
 ASTM E 112 Determining the 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 Macrotech Testing, Steel Bars, Billets, Blooms, and Forgings

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	0.28	0.33
Manganese	0.40	0.60
Silicon	0.15	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	0.80	1.10
Molybdenum	0.15	0.25
Nickel	--	0.25
Copper	--	0.35

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

3.2 Conditions:

Bars shall be supplied in the following conditions:

3.2.1 Bars 0.500 Inch (12.70 mm) and Under in Nominal Diameter or Least Distance Between Parallel Sides: Hardened and tempered and cold finished.

3.2.2 Bars Over 0.500 Inch (12.70 mm) in Nominal Diameter or Least Distance Between Parallel Sides: Hot finished and hardened and tempered, or hardened and tempered and cold finished, as ordered.

3.3 Properties:

Bars shall conform to the following requirements:

- 3.3.1 Macrostructure: Visual examination of transverse full cross-sections from bars, and billets, 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

Cross-Sectional Area Square Inches	Cross-Sectional Area Square Centimeters	Macrographs
Upto 36, incl	Upto 230, incl	S2 - R1 - C2
Over 36 to 100, incl	Over 230 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.

- 3.3.3 Longitudinal Tensile Properties: Shall be as shown in Table 3 for product 1.50 inches (38.100 mm) and less in diameter or least distance between parallel sides (see 8.1), determined in accordance with ASTM E 8 or ASTM E 8M.

TABLE 3 - Longitudinal Tensile Properties, Minimum

Property	Value
Tensile strength	125 ksi (862 Mpa)
Yield strength at 0.2% Offset	100 ksi (689 Mpa)
Elongation in 4D	17%
Reduction of Area	55%

3.3.4 Decarburization:

- 3.3.4.1 Bars 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 ordered to specified microstructural requirements shall be agreed upon by purchaser and vendor.
- 3.3.4.3 Decarburization of bars to which 3.3.4.1 or 3.3.4.2 is not applicable shall be not greater than shown in Table 4.

TABLE 4A - Maximum Decarburization, Inch/Pound Units

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

TABLE 4B - Maximum Decarburization, SI Units

Nominal Diameter or Distance Between Parallel Sides Millimeters	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

- 3.3.4.4 Decarburization shall be measured by the metallographic method, or by HR30N scale hardness testing method, or by microhardness traverse method 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 measurement 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 determined using the microhardness traverse method shall govern.

- 3.3.4.4.1 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 inches (0.13 mm) and the width is 0.065 inch (1.65 mm) or less.

3.4 Quality:

Bars, 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 bars.

- 3.4.1 Steel shall be aircraft quality conforming to AMS 2301 or MAM 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.

3.5 Tolerances:

In accordance with AMS 2251 or MAM 2251.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of bars shall supply all samples of vendor's tests and shall be responsible for the performance of all required tests. Purchaser reserves the right to sample and perform any confirmatory testing deemed necessary to ensure that the bars conform to the specified requirements.

4.2 Classification of Tests:

All technical requirements are acceptance tests and shall be performed on each heat or lot as applicable.

4.3 Sampling and Testing:

In accordance with AMS 2370.

4.4 Reports:

The vendor of product shall furnish with each shipment a report showing the results of tests for chemical composition, macrostructure and frequency-severity cleanliness rating of each heat and for tensile properties and 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, AMS 6346, size and quantity.