



# AEROSPACE MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.  
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

## AMS 6348

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Revised

UNS G41300

STEEL BARS  
0.95Cr - 0.20Mo (0.28 - 0.33C) (SAE 4130)  
Normalized

### 1. SCOPE:

- 1.1 Form: This specification covers an aircraft-quality, low-alloy steel in the form of bars.
- 1.2 Application: Primarily for parts, 0.50 in. (13 mm) and under in nominal 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 parts of greater thickness but requiring proportionately lower hardness.

### 2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) and Aerospace Standards (AS) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

- 2.1 SAE Publications: Available from Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.

#### 2.1.1 Aerospace Material Specifications:

AMS 2251 - Tolerances, Low-Alloy Steel Bars  
AMS 2259 - Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels  
AMS 2301 - Aircraft Quality Steel Cleanliness, Magnetic Particle Inspection Procedure  
AMS 2350 - Standards and Test Methods  
AMS 2370 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Wrought Products  
Except Forgings and Forging Stock  
AMS 2806 - Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Heat and Corrosion Resistant Steels and Alloys

#### 2.1.2 Aerospace Standards:

AS 1182 - Standard Machining Allowance, Aircraft Quality and Premium Quality Steel Products

- 2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM A255 - End-Quench Test for Hardenability of Steel  
ASTM A370 - Mechanical Testing of Steel Products  
ASTM E112 - Estimating the Average Grain Size of Metals  
ASTM E350 - Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron  
ASTM E381 - Rating Macroetched Steel

- 2.3 Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

#### 2.3.1 Federal Standards:

Federal Test Method Standard No. 151 - Metals; Test Methods

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2.3.2 Military Standards:

MIL-STD-163 - Steel Mill Products, Preparation for Shipment and Storage

3. TECHNICAL REQUIREMENTS:

- 3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E350, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other analytical methods approved by purchaser:

|            | 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 Condition: Bars shall be supplied in the following condition:

- 3.2.1 Bars 0.500 In. (12.70 mm) and Under in Nominal Diameter or Distance Between Parallel Sides: Normalized and cold finished.

- 3.2.2 Bars Over 0.500 In. (12.70 mm) in Nominal Diameter or Distance Between Parallel Sides: Hot finished and normalized or normalized and cold finished, as ordered.

- 3.3 Properties: Bars shall conform to the following requirements; hardness testing shall be performed in accordance with ASTM A370:

- 3.3.1 Macrostructure: Visual examination of transverse sections as in 4.3.1 from bars and billets, etched in accordance with ASTM E381 in hot hydrochloric acid (1:1) at 160° - 180° F (71° - 82° C) for sufficient time to develop a well-defined macrostructure, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the following macrographs of ASTM E381:

| Section Size         |                         | Macrographs    |
|----------------------|-------------------------|----------------|
| Square Inches        | (Square Centimetres)    |                |
| Up to 36, incl       | (Up to 232, incl)       | S2 - R1 - C2   |
| Over 36 to 100, incl | (Over 232 to 645, incl) | S2 - R2 - C3   |
| Over 100             | (Over 645)              | As agreed upon |

- 3.3.2 Grain Size: Predominantly 5 or finer with occasional grains as large as 3 permissible, determined in accordance with ASTM E112.

- 3.3.3 Hardenability: Shall be J34=5 min and J27=8 min, determined on the standard end-quench test specimen in accordance with ASTM A255 except that the steel shall be normalized at 1700° F  $\pm$  10 (925° C  $\pm$  5) and the test specimen austenitized at 1600° F  $\pm$  10 (870° C  $\pm$  5). 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.

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 and billets ordered for redrawing or to specified microstructural requirements shall be as 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 I.

TABLE I

| Nominal Diameter or Distance<br>Between Parallel Sides<br>Inches | Depth of Decarburization<br>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 I (SI)

| Nominal Diameter or Distance<br>Between Parallel Sides<br>Millimetres | Depth of Decarburization<br>Millimetres |
|-----------------------------------------------------------------------|-----------------------------------------|
| 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 Limits for depth of decarburization of bars over 4.000 in. (101.60 mm) in nominal diameter or distance between parallel sides shall be as agreed upon by purchaser and vendor.
- 3.3.4.4 Decarburization shall be measured by the microscopic method or by Rockwell Superficial 30-N scale or equivalent hardness testing method on hardened but untempered 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 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 or lack of decarburization thereon.
- 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 in. (0.13 mm) and the width is 0.065 in. (1.65 mm) or less.

### 3.4 Quality:

3.4.1 Steel shall be aircraft quality conforming to AMS 2301.

3.4.2 Bars, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from internal and external imperfections detrimental to usage of the bars.

3.4.2.1 Bars ordered ground, turned, or polished shall be free from seams, laps, tears, and cracks open to the ground, turned, or polished surfaces.

3.4.2.2 Bars ordered to surface conditions other than ground, turned, or polished shall, after removal of the standard machining allowance, be free from seams, laps, tears, cracks, and other defects exposed to the machined surfaces. Standard machining allowance shall be in accordance with AS 1182.

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

3.6 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of AMS 2251.

### 4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of bars shall supply all samples and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.4. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to ensure that the bars conform to the requirements of this specification.

4.2 Classification of Tests: Tests to determine conformance to all technical requirements of this specification are classified as acceptance tests and shall be performed on each lot.

4.3 Sampling: Shall be in accordance with AMS 2370 and the following:

4.3.1 Samples for macrostructure (3.3.1) testing shall be full cross-sectional specimens obtained from the finished billet or suitable rerolled product representing the top and bottom of at least the first, middle, and last usable ingots of each heat.

### 4.4 Reports:

4.4.1 The vendor of bars shall furnish with each shipment three copies of a report showing the results of tests for chemical composition, macrostructure, grain size, hardenability, and AMS 2301 frequency-severity rating of each heat. This report shall include the purchase order number, heat number, material specification number, size, and quantity from each heat.

4.4.2 The vendor of finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, material specification number, contractor or other direct supplier of bars, part number, and quantity. When bars for making parts are produced or purchased by the parts vendor, that vendor shall inspect each lot of bars to determine conformance to the requirements of this specification, and shall include in the report a statement that the bars conform, or shall include copies of laboratory reports showing the results of tests to determine conformance.

4.5 Resampling and Retesting: Shall be in accordance with AMS 2370.