



AEROSPACE MATERIAL SPECIFICATION

AMS7725™**REV. F**

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Revised 2020-11

Superseding AMS7725E

Tungsten Heavy Alloy Shapes, Sintered, High Density

RATIONALE

AMS7725F results from a Five-Year Review and update of this specification that adds controls over compositions (3.1.1, 3.1.2) and prohibits unauthorized exceptions (3.5, 4.5.2, 5.1.1).

1. SCOPE

1.1 Form

This specification covers four classes of tungsten heavy metal in the form of sintered and annealed shapes.

1.2 Application

This material has been used for parts, such as counterbalance weights or projectiles, for which mechanical properties are tested from the sintered and annealed shapes and that require high weight per unit volume, but usage is not limited to such applications.

1.3 Classification

Products covered by this specification are classified as follows:

Class	Tungsten, Nominal %
1	90
2	92.5
3	95
4	97

Type 1 - Non-magnetic (see 8.9)

Type 2 - Magnetic (see 8.9)

1.3.1 If no Class is specified Class 1 shall be supplied. If no Type is specified, Type 2 shall be supplied.

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.

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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.

AMS2750 Pyrometry

ARP1917 Clarification of Terms Used in Aerospace Metals Specifications

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 B311 Density of Powder Metallurgy (PM) Materials Containing Less Than Two Percent Porosity

ASTM E8/E8M Tension Testing of Metallic Materials

ASTM E18 Rockwell Hardness of Metallic Materials

3. TECHNICAL REQUIREMENTS

3.1 Composition, Density, and Hardness

Composition, density, and hardness shall be as specified in Table 1.

Table 1 - Composition, density, and hardness properties

Class	Weight Percent Tungsten, Nominal	Density g/cc	Hardness HRC Maximum
1	90	16.85-17.30	32
2	92.5	17.15-17.85	33
3	95	17.75-18.35	34
4	97	18.25-18.85	35

3.1.1 Type 1

Shall have a nominal tungsten percentage corresponding to the Class specified with the balance being primarily an alloy of nickel and/or copper in such proportions as to meet the technical requirements.

3.1.2 Type 2

Shall have a nominal tungsten percentage corresponding to the Class specified with the balance being primarily an alloy of nickel, iron, and other elements as required in such proportions as to meet the technical requirements.

3.2 Condition

Product shall be supplied either as-sintered, or sintered and annealed. If no condition is specified, either condition may be supplied.

3.3 Properties

The product shall conform to the following requirements:

3.3.1 Tensile Properties

Specimens (see 4.3.1) shall conform to the requirements of Table 2 (see 8.2) determined in accordance with ASTM E8/E8M.

Table 2 - Minimum tensile properties

Class	Type	Ultimate Tensile Strength		Yield Strength at 0.2% Offset		Elongation ^A at Fracture Percent
		ksi	MPa	ksi	MPa	
1	1	94	648	75	517	2
1	2	110	758	75	517	5
2	1	94	648	75	517	2
2	2	110	758	75	517	5
3	1	94	648	75	517	1
3	2	105	724	75	517	3
4	2	100	689	75	517	2

^A Determine with a Class B2 or better extensometer.

3.3.2 Hardness

Hardness as specified in Table 1 shall be determined in accordance with ASTM E18.

3.3.3 Density

Density as specified in Table 1 shall be determined in accordance with ASTM B311.

3.3.4 Magnetic Permeability

When specified (see 8.5), Type I parts shall be measured for magnetic permeability using a Severn gauge or similar equipment. Permeability shall be 1.05 μ , maximum.

3.3.5 Microstructure

Shall be a uniform and homogeneous distribution of tungsten particles in a metallic matrix, when examined at 200X magnification minimum.

3.3.6 Annealing (see 8.7)

Parts shall be subjected to post sintering annealing heat treatment in accordance with the following:

Vacuum or inert gas heat treat. Gas, if used, shall meet the requirements of AWS C5.10.

Vacuum level shall be 10^{-4} Torr or lower.

Ramp to 2192 °F $\pm$ 25 °F (1200 °C $\pm$ 14 °C).

Hold at temperature for 5 to 15 hours.

Forced fan cool using nitrogen*, helium, or argon gas.

Parts shall be cooled to 932 °F (500 °C) within 5 minutes maximum.

Parts shall be processed on ceramic racks/boats. Contact with carbon based fixture or rack is not permitted.

Pyrometry per AMS2750.

*NOTE: CRACKED AMMONIA IS NOT PERMITTED AS SOURCE OF NITROGEN.

3.3.7 Alternate annealing processes are permissible when approved by the cognizant engineering organization only when demonstrated to produce equivalent physical and mechanical properties to the standard process. Composition shall meet the requirements in Table 1, 3.1.1, and 3.1.2 and shall be performed by any method agreed upon by the supplier and the purchaser.

3.4 Quality

Product, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from cracks, loose particles, and other imperfections detrimental to usage of the product.

3.5 Exceptions

Any exceptions shall be authorized by the purchaser and reported as in 4.5.2.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

The producer of shapes 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

Tensile properties (3.3.1), hardness (3.3.2), density (3.3.3), microstructure (3.3.4), magnetic permeability (when specified) (3.3.4) and quality (3.4) are acceptance tests and shall be performed on each lot.

4.2.2 Periodic Tests

Composition (3.1) is a periodic test.

4.3 Sampling

Shall be in accordance with the following. A lot shall be all sintered shapes formed from one blend of powder and thermally processed in a single batch or a single continuous sinter run.

4.3.1 Tensile properties, hardness, density and microstructure shall be taken from one part per lot. One tensile specimen minimum shall be extracted from the centerline of the thickest portion of the part and tested to show conformance to the requirements of 3.3.1. Where the part is of such a size or shape as to prevent extraction of a tensile specimen, a test block with a nominal thickness of the maximum section thickness of the actual production part, formed from the same blend of powder and thermally processed with the lot may be used and the tensile specimen shall be extracted from that block.

4.3.2 Composition shall be determined from a suitable sized sample of the blended powder used to manufacture the lot of sintered parts.

4.4 Approval

4.4.1 Sample sintered shapes from new or reworked master patterns shall be approved by purchaser before shapes for production use are supplied, unless such approval is waived by purchaser.

4.4.2 Producer shall use ingredients, processing techniques, and methods of inspection on production sintered shapes which are essentially the same as those used on the approved sample shapes. If necessary to make any change in ingredients, processing techniques, or methods of inspection, producer shall submit for reapproval a statement of the proposed changes in materials, processing, or both and, when requested, sample shapes. Production shapes made by the revised procedure shall not be shipped prior to receipt of reapproval.