



AEROSPACE MATERIAL SPECIFICATION

AMS7904™**REV. F**

Issued 1991-04
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Revised 2024-12

Superseding AMS7904E

Beryllium Bars, Rods, Tubing, and Shapes,
High Ductility Grade

RATIONALE

AMS7904F results from a Five-Year Review and update of this specification with changes to prohibit unauthorized exceptions (see 3.6, 4.4.1, 5.1.1, and 8.4); add product size limitation for Radiographic Inspection (see 3.4.2); relocate Definitions (see 2.4); update Applicable Documents (see Section 2, 2.4, and 3.4.1), Surface Finish (see 3.2.1), Average Grain Size (see 3.3.2), Density (see 3.4.1), and Ordering Information (see 8.5); and allow the use of the immediate prior specification revision (see 8.3).

1. SCOPE

1.1 Form

This specification covers beryllium in the form of bars, rods, tubing, and machined shapes fabricated from vacuum hot-pressed powder.

1.2 Application

These products have been used typically for parts requiring a combination of high strength-to-weight ratio, high modulus of elasticity, and high ductility, but usage is not limited to such applications.

1.3 Safety - Hazardous Materials

While the materials, methods, applications, and processes described or referenced in this specification may involve the use of hazardous materials, this specification does not address the hazards that may be involved in such use. It is the sole responsibility of the user to ensure familiarity with the safe and proper use of any hazardous materials and to take necessary precautionary measures to ensure the health and safety of all personnel involved.

1.3.1 Warning

Inhaling dust or fumes containing beryllium may cause chronic beryllium disease, a serious chronic lung disease, in some individuals. Over time, lung disease can be fatal. Read the product-specific Safety Data Sheet (SDS) for additional environmental, health, and safety information before working with beryllium or beryllium-containing materials.

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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 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.

AMS2806 Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys

AS7766 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 E112 Determining Average Grain Size

ASTM E1417 Liquid Penetrant Testing

ASTM E1742 Radiographic Examination

2.3 ASME Publications

Available from ASME, P.O. Box 2900, 22 Law Drive, Fairfield, NJ 07007-2900, Tel: 800-843-2763 (U.S./Canada), 001-800-843-2763 (Mexico), 973-882-1170 (outside North America), www.asme.org.

ASME B46.1 Surface Texture

ASME Y14.5M Dimensioning and Tolerancing

2.4 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. Beryllium oxide shall be determined by gas fusion; aluminum, iron, magnesium, silicon, and other elements by spectrochemical methods; and carbon by combustion. Beryllium shall be determined by difference. In case of disputes between analyses by different spectrochemical methods, emission spectroscopy shall govern.

Table 1 - Composition

Element	Min	Max
Beryllium Oxide	--	0.9
Aluminum	--	0.05
Carbon	--	0.09
Iron	--	0.08
Magnesium	--	0.01
Silicon	--	0.04
Other Elements, each (see 3.1.1)	--	0.04
Beryllium	99.0	--

3.1.1 Determination is not required for routine acceptance of each lot.

3.2 Condition

Vacuum hot pressed with secondary options of heat treatment, stress relief, and/or hot isostatic pressing (HIP) after vacuum hot pressing.

3.2.1 Surface Finish

If surface finish is not specified, the material shall be furnished with an as-sawed, as HIP, and/or machined surface. Machined surfaces shall have surface finish no greater than 125 microinches (3.2 μm), determined in accordance with ASME B46.1.

3.3 Properties

The product shall conform to the following requirements:

3.3.1 Tensile Properties

Shall be determined in the longitudinal and transverse directions at room temperature as shown in Table 2 in accordance with ASTM E8/E8M with the rate of strain set at 0.005 in/in/min (0.005 mm/mm/min) and maintained within a tolerance of ± 0.002 in/in/min (± 0.002 mm/mm/min) through the 0.2% offset yield strain and may be increased thereafter to 0.05 in/in/min (0.05 mm/mm/min).

Table 2 - Minimum tensile properties

Property	Value
Tensile Strength	42.0 ksi (290 MPa)
Yield Strength at 0.2% Offset	30.0 ksi (207 MPa)
Elongation in 4D	3.0%

3.3.1.1 Transverse requirements in Table 2 apply only to product that a tensile specimen not less than 2.50 inches (63.5 mm) in length can be obtained.

3.3.2 Average Grain Size

The average grain size shall be determined in accordance with ASTM E112. The mean intercept length shall be no larger than 20 microns.

3.4 Quality

The product, as received by the 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 Density

Shall be at least 99.0% of theoretical density, determined using the water displacement method as described in ASTM B311. Density determination shall be accurate to the second decimal place or better.

3.4.1.1 Theoretical density shall be calculated using Equation 1.

$$\text{Theoretical Density (gm/cm}^3\text{)} = \frac{100\%}{\frac{100 - \%BeO}{1.8477 \text{ gm/cm}^3} + \frac{\%BeO}{3.009 \text{ gm/cm}^3}} \quad (\text{Eq. 1})$$

3.4.2 Radiographic Inspection

Radiographic inspection, to a penetrameter sensitivity of 2%, shall be performed in accordance with ASTM E1742 on product less than 10 inches (25.4 cm) thick; however, exceptions are taken to the penetrameter contrast requirement and applicable area of penetrameter density ranges of +30% or -15% from the density at penetrameter location(s). The decision to accept or reject may be made directly beneath the IQI/shim combination.

3.4.2.1 Radiographic indications (voids or inclusions) shall conform to the following requirements:

3.4.2.1.1 Maximum Dimension of Any Indication

Any dimension of any indication, measured in the plane of the radiograph, shall not exceed 0.030 inch (0.76 mm).

3.4.2.1.2 Maximum Average Dimension of Any Indication

The average dimension of an indication shall be the arithmetic average of the maximum and minimum dimensions, measured in the plane of the radiograph, and shall not exceed 0.020 inch (0.51 mm).

3.4.2.1.3 Total Combined Volume per Cubic Inch (16.4 cm³) of All Indications

The total combined volume per cubic inch (16.4 cm³) of all detectable radiographic indications shall not exceed the volume of a 0.050-inch (1.27-mm) diameter sphere (e.g., total spherical volume shall not exceed 0.000065 cubic inches [1.07 mm³]). For calculation purposes, assume all indications are spherical.

3.4.2.1.4 Part Density Uniformity

The terms variable density areas, banding, or striations denote relatively large areas of a radiograph that vary in density as compared to the surrounding area. These areas shall not vary in radiographic density by more than 5% compared to the surrounding area of comparable section thickness. Suspect areas shall be re-radiographed and interpreted with the appropriate penetrameter or beryllium of 5% in thickness placed as follows:

- Less dense (darker radiograph) areas shall be covered by the penetrameter. The radiograph of the covered area shall appear lighter than that of the adjacent area.
- More dense (lighter radiograph) areas shall have the penetrameter placed immediately adjacent to them. The radiograph of the covered areas shall appear lighter than that of the suspect more dense area.

3.4.2.1.4.1 Discrete high-density (light radiograph) indications, or areas in product 1.000 inch (25.40 mm) and under in nominal thickness, which are 5% or less in radiographic density variation compared to the surrounding material, are acceptable.

NOTE: The minimum detectable size of voids and inclusions will increase as the section thickness increases.

3.4.3 Surface Condition

The product shall be free from cracks, determined as in 3.4.3.1 or 3.4.3.2.

3.4.3.1 Visual

No restrictions to size or number of visual imperfections if they do not hold fluorescent penetrant dye.

3.4.3.2 Surface Indications

Penetrant inspection shall be performed in accordance with ASTM E1417, Type 1, Level 2.

3.4.3.2.1 Individual Indications

Shall not exceed 0.050 inch (1.27 mm) in major dimension.

3.4.3.2.1.1 Frequency

Any 1 square inch (6.45 cm²) shall contain no more than three indications measuring 0.003 to 0.050 inch (0.08 to 1.27 mm) in major dimension.

3.5 Tolerances

Product shall conform to the dimensions and dimensional tolerances specified in the purchase order and applicable drawings. If tolerances are not specified, the following standard tolerances shown in Table 3, in accordance with ASME Y14.5M, shall apply.

Table 3A - Tolerances, inch/pound units

Feature	Size Inches	Tolerance, Inches	
		Plus	Minus
Diameter, Width, or Thickness	Up to 3, incl	0.016	0.000
Diameter, Width, or Thickness	Over 3 to 20, incl	0.062	0.000
Diameter, Width, or Thickness	Over 20	0.250	0.000
Length	Up to 20, incl	0.125	0.000
Length	Over 20	0.250	0.000

Table 3B - Tolerances, SI units

Feature	Size Millimeters	Tolerance, Millimeters	
		Plus	Minus
Diameter, Width, or Thickness	Up to 76, incl	0.41	0.00
Diameter, Width, or Thickness	Over 76 to 508, incl	1.57	0.00
Diameter, Width, or Thickness	Over 508	6.35	0.00
Length	Up to 508, incl	3.18	0.00
Length	Over 508	6.35	0.00

3.6 Exceptions

Any exceptions shall be authorized by the purchaser and reported as in 4.4.1.