

AEROSPACE MATERIAL SPECIFICATION



AMS 7908A

Issued OCT 1991
Revised SEP 2001

Superseding AMS 7908

Beryllium Hipped Near-Net Preforms Standard Grade

1. SCOPE:

1.1 Form:

This specification covers beryllium in the form of bar, rod, tubing, and shapes fabricated from beryllium powder consolidated by hot isostatic pressing (HIP).

1.2 Application:

This product has been used typically for parts requiring high strength-to-weight ratio and high modulus of elasticity, 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 which 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: Beryllium Product: Inhalation of dust or fumes may cause serious chronic lung disease. Potential cancer hazard is based principally on animal tests.

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 canceled 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, 400 Commonwealth Drive, Warrendale, PA 15096-0001 or <http://www.sae.org>.

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

2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or <http://www.astm.org>.

ASTM E 8 Tension Testing of Metallic Materials
 ASTM E 8M Tension Testing of Metallic Materials (Metric)
 ASTM E 112 Determining Average Grain Size
 ASTM E 1417 Liquid Penetrant Examination
 ASTM E 1742 Radiographic Examination

2.3 ANSI Publications:

Available from ANSI, 25 West 43rd Street, New York, NY 10036-8002.

ANSI B46.1 Surface Texture
 ANSI Y14.5M Dimensioning and Tolerancing

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 metallic impurities by spectrochemical methods; and carbon by combustion. Beryllium shall be determined by difference. In case of disputes between analysis by different spectrochemical methods, DC plasma shall govern.

TABLE 1 - Composition

Element	min	max
Beryllium Oxide	--	1.5
Carbon	--	0.15
Iron	--	0.13
Aluminum	--	0.10
Magnesium	--	0.08
Silicon	--	0.06
Other Metallic Impurities, each	--	0.04
Beryllium	98.5	--

3.2 Condition:

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

- 3.2.1 Surface Finish: The product shall be furnished with a machined surface. The standard surface finish shall be no greater than 110 Ra [125 microinches (3.2 μm) rms], determined in accordance with ANSI B46.1.

3.3 Properties:

The product shall conform to the following requirements.

- 3.3.1 Tensile Properties: Shall be as shown in Table 2, determined at room temperature in accordance with ASTM E 8 or ASTM E 8M:

TABLE 2 - Minimum Tensile Properties

Property	Value
Tensile Strength	60 ksi (414 MPa)
Yield Strength at 0.2% Offset	43.0 ksi (296 MPa)
Elongation in 4D	3%

- 3.3.2 Grain Size: Shall average no larger than 20 microns (20 μm), determined in accordance with ASTM E 112, using the intercept method at 500X magnification.

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 Soundness:

- 3.4.1.1 The product shall be free from cracks, determined as in 3.4.2.1 or 3.4.2.2.

- 3.4.1.2 Density: Shall be at least 99.0% of theoretical density, determined by the water displacement method. The accuracy of density determination shall be to the second decimal, or better.

- 3.4.1.2.1 The theoretical density shall be calculated using Equation 1:

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

3.4.1.3 Thermally Induced Porosity (TIP) Resistance:

3.4.1.3.1 Sample product shall be subjected to a TIP test consisting of a heat treatment in inert atmosphere or under vacuum at 1450 °F (788 °C) for one hour.

3.4.1.3.2 The minimum density allowed following the TIP heat treatment shall be 99.0% of the theoretical density, calculated as shown in 3.4.1.2.1. The maximum drop in the density due to the TIP resistance test shall be 0.20%.

3.4.1.4 Radiographic Inspection: Radiographic inspection to a penetrameter sensitivity of 2% shall be performed in accordance with ASTM E 1742; 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).

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

3.4.1.4.1.1 Maximum Dimension of any Indication: Any dimension of any indication, measured in the plane of the radiograph, shall not exceed 0.050 inch (1.27 mm).

3.4.1.4.1.2 Maximum Average Dimension of any Indication: The average dimension of any indication shall be the arithmetic average of the maximum and minimum dimensions, measured in the plane of the radiograph, and shall not exceed 0.030 inch (0.76 mm).

3.4.1.4.1.3 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 $6.5 \times 10^{-5} \text{ in}^3$ [1.07 mm³]). For calculation purposes, assume all indications are spherical.

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

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

3.4.1.4.1.5 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.

3.4.2 Surface Condition:

3.4.2.1 Visual: No restrictions to size or number of visual imperfections if they do not hold fluorescent penetrant dye and are acceptable in accordance with 3.4.2.2 and dimensional tolerance requirements.

3.4.2.2 Surface Indications: Penetrant inspection shall be performed in accordance with ASTM E 1417, Type 1, Level 2.

3.4.2.2.1 Individual Indications: Shall not exceed 0.050 inch (1.27 mm) in major dimension.

3.4.2.2.2 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 so specified, tolerances shown in Table 3 shall apply in accordance with ANSI Y14.5M (See 8.2).

TABLE 3A - Dimensional Tolerances, Inch/Pound Units

Dimension	Inches	Tolerance, Inch plus	Tolerance, Inch 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 - Dimensional Tolerances, SI Units

Dimension	Millimeters	Tolerance, Millimeters plus	Tolerance, Millimeters 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

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:

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

4.3 Sampling and Testing:

Shall be in accordance with the following; a lot shall be all product manufactured from a specific powder lot and HIP cycle in the same condition.

4.3.1 Composition: Not less than one sample from each lot.

4.3.2 Tensile Properties: Not less than one round specimen from each lot at any location.

4.3.3 Grain Size: Not less than one specimen from each lot.

4.3.4 Thermally Induced Porosity (TIP) Resistance: Not less than one sample for TIP from each lot.

4.3.5 Density: Each part, unless a sampling plan has been agreed upon by purchaser and vendor.

4.3.6 Radiography: Each part, unless a sampling plan has been agreed upon by purchaser and vendor.

4.3.7 Penetrant Inspection: Each part, unless a sampling plan has been agreed upon by purchaser and vendor.

4.3.8 Tolerances: Each part, unless a sampling plan has been agreed upon by purchaser and vendor.

4.4 Reports:

The vendor of the product shall furnish with each shipment a report showing the results of tests for chemical composition, tensile properties, grain size, and TIP test response of each lot and stating that the product conforms to the other technical requirements. This report shall include the purchase order number, lot number, AMS 7908A, serial number, and quantity.