



# AEROSPACE MATERIAL SPECIFICATION

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

**AMS6396A**

Superseding AMS 6396

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## STEEL SHEET, STRIP, AND PLATE 0.80Cr - 1.8Ni - 0.25Mo (0.49 - 0.55C)

### 1. SCOPE:

- 1.1 Form: This specification covers an aircraft-quality, low-alloy steel in the form of sheet, strip, and plate.
- 1.2 Application: Primarily for heavy-section, heat treated parts requiring good tensile and endurance strengths in combination with good ductility.

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) 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 2252 - Tolerances, Alloy Steel Sheet, Strip, and Plate
- 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

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

- 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

- 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

#### 2.3.2 Military Standards:

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

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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
g	Carbon	0.49	- 0.55
	Manganese	0.65	- 0.85
	Silicon	0.15	- 0.35
	Phosphorus	—	0.025
	Sulfur	—	0.025
	Chromium	0.70	- 0.90
	Nickel	1.65	- 2.00
	Molybdenum	0.20	- 0.30
	Copper	—	0.35

3.1.1 Check Analysis: Composition variations shall meet the applicable requirements of AMS 2259, except that check analysis limit for carbon shall apply only to over maximum.

3.2 Condition: The product shall be supplied in the following condition; hardness tests shall be conducted in accordance with ASTM A370:

3.2.1 Sheet and Strip: Cold finished, bright or atmosphere spheroidize annealed, and descaled or hot rolled, annealed if necessary, and pickled; the product shall have hardness not higher than 95 HRB or equivalent.

3.2.2 Plate: Hot rolled, annealed if necessary, and descaled having hardness not higher than 28 HRC or equivalent.

3.3 Properties: Product shall conform to the following requirements; tensile, hardness, and bend testing shall be performed in accordance with ASTM A370:

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

3.3.2 Decarburization:

3.3.2.1 Product Under 0.045 In. (1.14 mm) in Nominal Thickness: The method of test and the allowance shall be as agreed upon by purchaser and vendor.

3.3.2.2 Product 0.045 to 0.375 In. (1.14 to 9.52 mm), Excl, in Nominal Thickness:

3.3.2.2.1 Specimens: Shall be the full thickness of the product except that specimens from plate over 0.249 in. (6.32 mm) thick shall be slices approximately 0.250 in. (6.35 mm) thick cut parallel to and preserving one original surface of the plate. Recommended specimen size is 1 x 4 in. (25 x 100 mm).

3.3.2.2.2 Procedure: Specimens shall be hardened by austenitizing and quenching; preferably, they shall not be tempered but, if tempered, the tempering temperature shall be not higher than 300°F (150°C). During heat treatment, specimens shall be protected by suitable atmosphere or medium or by suitable plating to prevent carburization or further decarburization. Protective plating, if used, shall then be removed from specimens of product 0.045 to 0.250 in. (1.14 to 6.35 mm), excl, in nominal thickness and a portion of the specimen shall be ground to a depth of 0.050 in. (1.27 mm) or one-half thickness, whichever is less. Specimens from product 0.250 to 0.375 in. (6.35 to 9.52 mm) excl, in nominal thickness shall be ground to remove 0.020 in. (0.51 mm) of metal from the original surface of the plate and a portion of the specimen

shall be further ground to a depth of at least one-third the original thickness of the specimen. At least three Rockwell hardness readings shall be taken on each prepared step and each group of readings averaged.

**3.3.2.2.3 Allowance:**

**3.3.2.2.3.1 Product 0.045 to 0.250 In. (1.14 to 6.35 mm), Excl, in Nominal Thickness:** The product shall show no layer of complete decarburization, determined microscopically at a magnification not exceeding 100X. It shall also be free from partial decarburization to the extent that the difference in hardness between the original surface and the portion ground as in 3.3.2.2.2 shall be not greater than 2 units on the Rockwell "A" scale.

**3.3.2.2.3.2 Product 0.250 to 0.375 In. (6.35 to 9.52 mm), Excl, in Nominal Thickness:** Shall be free from decarburization to the extent that the difference in hardness between the two prepared steps shall be not greater than 3 units on the Rockwell "A" scale.

**3.3.2.3 Product 0.375 In. (9.52 mm) and Over in Nominal Thickness:** The total decarburization, determined microscopically at a magnification not exceeding 100X on the as-supplied plate, shall be not greater than shown in Table I.

**TABLE I**

Nominal Thickness Inches	Depth of Decarburization Inch
0.375 to 0.500, incl	0.015
Over 0.500 to 1.000, incl	0.025
Over 1.000 to 2.000, incl	0.035
Over 2.000	As agreed upon

**TABLE I (SI)**

Nominal Thickness Millimetres	Depth of Decarburization Millimetres
9.52 to 12.70, incl	0.38
Over 12.70 to 25.40, incl	0.64
Over 25.40 to 50.80, incl	0.89
Over 50.80	As agreed upon

**3.3.3 Bending:** Product 0.749 in. (19.02 mm) and under in nominal thickness shall withstand, without cracking, free bending through the angle indicated below around a diameter equal to the nominal thickness of the product, with axis of bend parallel to the direction of rolling.

**TABLE II**

Nominal Thickness Inches	(Millimetres)	Angle, Deg min
Up to 0.188, incl	(Up to 4.78, incl)	180
Over 0.188 to 0.249, incl	(Over 4.78 to 6.32, incl)	135
Over 0.249 to 0.749, incl	(Over 6.32 to 19.02, incl)	90

**3.3.3.1** Bending requirements for plate over 0.749 in. (19.02 mm) in nominal thickness shall be as agreed upon by purchaser and vendor.

**3.3.4 Properties After Heat Treatment:** Product, oil quenched from  $1500^{\circ}\text{F} \pm 25^{\circ}$  ( $815^{\circ}\text{C} \pm 15^{\circ}$ ) and tempered for 2 hr  $\pm 0.1$  at a temperature not lower than  $1100^{\circ}\text{F}$  ( $595^{\circ}\text{C}$ ), shall have the following properties:

**3.3.4.1 Tensile Properties:**

Tensile Strength, min	150,000 psi (1034 MPa)
Yield Strength at 0.2% Offset, min	130,000 psi (896 MPa)
Elongation in 2 in. (50 mm) or 4D, min	8%

3.3.4.2 Hardness: Shall be 301 - 363 HB or equivalent.

3.4 Quality:

3.4.1 Steel shall be aircraft quality conforming to AMS 2301.

3.4.2 The product, 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 product.

3.5 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of AMS 2252.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of the product 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 product conforms to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests to determine conformance to requirements for composition (3.1), condition (3.2), grain size (3.3.1), decarburization (3.3.2), bending (3.3.3), quality (3.4), and tolerances (3.5) are classified as acceptance tests and shall be performed on each lot.

4.2.2 Periodic Tests: Tests to determine conformance to requirements for properties after heat treatment (3.3.4) are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

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

4.3.1 Specimens for tensile tests of widths 9 in. (229 mm) and over shall be taken with the axis of the specimen perpendicular to the direction of rolling; for widths less than 9 in. (229 mm), specimens shall be taken with the axis parallel to the direction of rolling.

4.4 Reports:

4.4.1 The vendor of the product shall furnish with each shipment three copies of a report showing the results of tests for chemical composition, grain size, and AMS 2301 frequency-severity rating of each heat and the results of tests on each size from each heat to determine conformance to the bending requirements. This report shall include the purchase order number, heat number, material specification number and its revision letter, 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 and its revision letter, contractor or other direct supplier of material, part number, and quantity. When material for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of material to determine conformance to the requirements of this specification, and shall include in the report a statement that the material conforms, 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.