

**AEROSPACE
MATERIAL
SPECIFICATION**

AMS 5122F
Superseding AMS 5122E

Issued 1-23-40
Revised 1-1-85

STEEL STRIP
(0.90 - 1.04C) (SAE 1095)
Hard Temper

UNS G10950

1. SCOPE:

1.1 Form: This specification covers a carbon steel in the form of strip.

1.2 Application: Primarily for washers and other stamped parts requiring a smooth finish and only slight or no forming.

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

2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2232 - Tolerances, Carbon Steel Sheet, Strip, and Plate

MAM 2232 - Tolerances, Metric, Carbon Steel Sheet, Strip, and Plate

AMS 2259 - Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels

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 - Determining Average Grain Size

ASTM E350 - Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

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2.3 U.S. 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

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	0.90	1.04
Manganese	0.30	0.50
Silicon	0.10	0.30
Phosphorous	--	0.040
Sulfur	--	0.050

3.1.1 Check Analysis: Composition variations shall meet the applicable requirements of AMS 2259.

3.2 Condition: Cold finished, hard temper.

3.3 Properties: Strip shall conform to the following requirements; 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 by comparison of a polished and etched specimen with the chart in ASTM E112.

3.3.2 Hardness: 47 - 52 HRC or equivalent.

3.3.3 Decarburization:

3.3.3.1 Product Under 0.045 In. (1.12 mm) in Nominal Thickness: The method of test and the allowance shall be as agreed upon by purchaser and vendor.

3.3.3.2 Product 0.045 In. (1.12 mm) and Over in Nominal Thickness:

3.3.3.2.1 Specimens: Shall be the full thickness of the strip. Recommended specimen size is 1 x 4 in. (25 x 100 mm).

3.3.3.2.2 Procedure: A portion of the specimen shall be ground to a depth of 0.050 in. (1.25 mm) or one-half thickness, whichever is less. At least three Rockwell hardness readings shall be taken on the original surface and on the ground portion and each group of readings averaged.

3.3.3.2.3 Allowance: Strip 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 3.3.3.2.2 shall be not greater than 2 units on the Rockwell "A" scale.

3.3.4 Bending: Strip or finished parts shall bend sufficiently to take a permanent deformation without cracking, with axis of bend parallel to the direction of rolling.

3.3.5 Finish: Strip shall have a bright finish as produced by cold rolling or polishing. A clean, blue finish as produced by heating at low temperature is acceptable.

3.4 Quality: Strip, 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 strip.

3.5 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of AMS 2232 or MAM 2232.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of strip shall supply all samples for vendor's tests 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 sample and to perform any confirmatory testing deemed necessary to ensure that the strip conforms 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 heat or lot as applicable.

4.3 Sampling: Shall be in accordance with AMS 2370.

4.4 Reports:

4.4.1 The vendor of strip shall furnish with each shipment a report showing the results of tests for chemical composition of each heat and for hardness of each lot. This report shall include the purchase order number, heat number, AMS 5122F, size, and quantity from each heat.

4.4.2 The vendor of finished or semi-finished parts shall furnish with each shipment a report showing the purchase order number, AMS 5122F, contractor or other direct supplier of strip, part number, and quantity. When strip for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of strip to determine conformance to the requirements of this specification and shall include in the report either a statement that the strip conforms or copies of laboratory reports showing the results of tests to determine conformance.

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

5. PREPARATION FOR DELIVERY:

5.1 Identification: Each strip shall be marked as in 5.1.1 unless purchaser permits a method from 5.1.2.

5.1.1 Each strip shall be marked on one face, in the respective location indicated below, with AMS 5122F, heat number, manufacturer's identification, and nominal thickness. The characters shall be of such size as to be legible, shall be applied using a suitable marking fluid, and shall be removable in hot alkaline cleaning solution without rubbing. The markings shall have no deleterious effect on the strip or its performance and shall be sufficiently stable to withstand normal handling. The specification number, manufacturer's identification, and nominal thickness shall be continuously line marked; the heat number may be included in the line marking or may be marked at one location on each piece.

5.1.1.1 Flat Strip 6 In. (150 mm) and Under in Nominal Width: Shall be marked in one or more lengthwise rows of characters recurring at intervals not greater than 3 ft (900 mm).

5.1.1.2 Flat Strip Over 6 In. (150 mm) in Nominal Width: Shall be marked in lengthwise rows of characters recurring at intervals not greater than 3 ft (900 mm), the rows being spaced not more than 6 in. (150 mm) apart and alternately staggered.

5.1.1.3 Coiled Strip: Shall be marked near both the outside and inside ends of the coil; the markings shall be applied as in 5.1.1 or shall appear on a durable tag or label attached to the coil and marked with the information of 5.1.1. When the strip is wound on cores, the tag or label may be attached to the core.

5.1.2 When purchaser permits, each strip may be marked near one end, coils being marked near the outside end, with AMS 5122F, heat number, manufacturer's identification, and nominal thickness, using any suitable marking fluid. As an alternate method, individual pieces and bundles shall have attached a durable tag marked with the above information or shall be boxed and the box marked with the same information.

5.2 Protective Treatment: Strip shall be oiled prior to shipment.