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AEROSPACE MATERIAL SPECIFICATION

Submitted for recognition as an American National Standard

AMS 5769D

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Superseding AMS 5769C

G-31-40
G-31-45

ALLOY BARS, FORGINGS, AND RINGS, CORROSION AND HEAT RESISTANT
21Cr - 20Ni - 20Co - 3.0Mo - 2.5W - 1.0(Cb+Ta) - 0.15N - 32Fe
Solution Heat Treated

UNS R30155

1. SCOPE:

1.1 Form: This specification covers a corrosion and heat resistant alloy in the form of bars, forgings, flash welded rings, and stock for forging, flash welded rings, or heading.

1.2 Application: Primarily for parts, such as turbine rotors, shafts, blades, and bolts, requiring high strength up to 1350°F (730°C) and oxidation resistance up to 1800°F (980°C).

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 2248 - Chemical Check Analysis Limits, Wrought Corrosion and Heat Resistant Steels and Alloys, Maraging and Other Highly-Alloyed Steels, and Iron Alloys

AMS 2261 - Tolerances, Nickel, Nickel Alloy, and Cobalt Alloy Bars and Forging Stock

MAM 2261 - Tolerances, Metric, Nickel, Nickel Alloy, and Cobalt Alloy Bars and Forging Stock

AMS 2350 - Standards and Test Methods

AMS 2371 - Quality Assurance Sampling of Corrosion and Heat Resistant Steels and Alloys, Wrought Products Except Forgings and Forging Stock

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2.1.1 (Continued):

- AMS 2374 - Quality Assurance Sampling of Corrosion and Heat Resistant Steels and Alloys, Forgings and Forging Stock
- AMS 2375 - Control of Forgings Requiring First Article Approval
- AMS 2806 - Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Heat and Corrosion Resistant Steels and Alloys
- AMS 2808 - Identification, Forgings
- AMS 7490 - Rings, Flash Welded, Corrosion and Heat Resistant Austenitic Steels and Austenitic-Type Alloys

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

- ASTM E10 - Brinell Hardness of Metallic Materials
- ASTM E139 - Conducting Creep, Creep-Rupture, and Stress-Rupture Tests of Metallic Materials
- ASTM E353 - Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

2.3 U.S. Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.2.3.1 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 E353 or by spectrochemical or other analytical methods approved by purchaser:

	min	max
Carbon	0.08	0.16
Manganese	1.00	2.00
Silicon	--	1.00
Phosphorus	--	0.040
Sulfur	--	0.030
Chromium	20.00	22.50
Nickel	19.00	21.00
Cobalt	18.50	21.00
Molybdenum	2.50	3.50
Tungsten	2.00	3.00
Columbium + Tantalum	0.75	1.25
Nitrogen	0.10	0.20
Iron	remainder	

3.1.1 Check Analysis: Composition variations shall meet the requirements of AMS 2248.3.2 Condition: The product shall be supplied in the following condition:

3.2.1 Bars, Forgings, and Flash Welded Rings: Solution heat treated. Forgings shall be descaled.

3.2.1.1 Flash welded rings shall not be supplied unless specified or permitted on purchaser's part drawing. When supplied, they shall be manufactured in accordance with AMS 7490.

3.2.2 Stock for Forging, Flash Welded Rings, or Heading: As ordered by the forging, flash welded ring, or heading manufacturer.

3.3 Heat Treatment: Bars, forgings, and flash welded rings shall be solution heat treated by heating to $2150^{\circ}\text{F} \pm 25$ ($1175^{\circ}\text{C} \pm 15$), holding at heat for not less than 1 hr, and quenching in water.

3.4 Properties: The product shall conform to the following requirements:

3.4.1 Bars, Forgings, and Flash Welded Rings:

3.4.1.1 Hardness: Shall be as follows, determined in accordance with ASTM E10:

3.4.1.1.1 Bars and Forgings: 156 - 217 HB, or equivalent

3.4.1.1.2 Flash Welded Rings: 156 - 241 HB, or equivalent.

3.4.1.2 Stress-Rupture Properties at 1350°F (730°C): A tensile specimen, maintained at $1350^{\circ}\text{F} \pm 3$ ($730^{\circ}\text{C} \pm 2$) while a load sufficient to produce an initial axial stress of 32,000 psi (220 MPa) is applied continuously, shall not rupture in less than 23 hours. The test shall be continued to rupture without change of load. Elongation after rupture, measured at room temperature, shall be not less than 10% in 4D. Test shall be conducted in accordance with ASTM E139.

3.4.1.2.1 The test of 3.4.1.2 may be conducted using a load higher than required to produce an initial axial stress of 32,000 psi (220 MPa) but load shall not be changed while test is in progress. Time to rupture and elongation requirements shall be as specified in 3.4.1.2.

3.4.1.2.2 When permitted by purchaser, the test of 3.4.1.2 may be conducted using incremental loading. In such case, the load required to produce an initial axial stress of 32,000 psi (220 MPa) shall be used to rupture or for 23 hr, whichever occurs first. After the 23 hr and at intervals of 8 - 16 hr, preferably 8 - 10 hr, thereafter, the stress shall be increased in increments of 2,000 psi (15 MPa). Time to rupture and elongation requirements shall be as specified in 3.4.1.2.

3.4.2 Forging Stock: When a sample of stock is forged to a test coupon and heat treated as in 3.3, specimens taken from the heat treated coupon shall conform to the requirements of 3.4.1.1 and 3.4.1.2. If specimens taken from the stock after heat treatment as in 3.3 conform to the requirements of 3.4.1.1 and 3.4.1.2, the tests shall be accepted as equivalent to tests of a forged coupon.

3.4.3 Stock for Flash Welded Rings or Heading: Specimens taken from the stock after heat treatment as in 3.3 shall conform to the requirements of 3.4.1.1 and 3.4.1.2.

3.5 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.

3.5.1 Forgings shall have substantially uniform macrostructure. Standards for acceptance shall be as agreed upon by purchaser and vendor.

3.5.2 Grain flow of die forgings, except in areas which contain flash-line end grain, shall follow the general contour of the forgings showing no evidence of re-entrant grain flow.

3.6 Sizes: Except when exact lengths or multiples of exact lengths are ordered, straight bars will be acceptable in mill lengths of 6 - 20 ft (2 - 6 m) but not more than 10% of any shipment shall be supplied in lengths shorter than 10 ft (3 m).

3.7 Tolerances: Bars and forging stock shall conform to all applicable requirements of AMS 2261 or MAM 2261.

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 performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.5. Purchaser reserves the right to sample and to perform any confirmatory testing deemed 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 the following requirements are classified as acceptance tests and shall be performed on each heat or lot as applicable:

4.2.1.1 Composition (3.1) of each heat.

4.2.1.2 Hardness (3.4.1.1) and stress-rupture properties (3.4.1.2) of each lot of bars, forgings, and flash welded rings.

4.2.1.3 Tolerances (3.7) of bars and forging stock.

- 4.2.2 Periodic Tests: Tests of forging stock (3.4.2) and of stock for flash welded rings or heading (3.4.3) to demonstrate ability to develop required properties are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.
- 4.2.3 Preproduction Tests: Tests of forgings to determine conformance to all applicable technical requirements of this specification when AMS 2375 is specified are classified as preproduction tests and shall be performed prior to or on the first-article shipment of a forging to a purchaser, when a change in material, processing, or both requires reapproval as in 4.4, and when purchaser deems confirmatory testing to be required.
- 4.2.3.1 For direct U.S. Military procurement of forgings, substantiating test data and, when requested, preproduction forgings shall be submitted to the cognizant agency as directed by the procuring activity, contracting officer, or request for procurement.
- 4.3 Sampling: Shall be in accordance with the following:
- 4.3.1 Bars, Flash Welded Rings, and Stock for Flash Welded Rings or Heading: AMS 2371.
- 4.3.2 Forgings and Forging Stock: AMS 2374.
- 4.4 Approval: When specified, approval and control of forgings shall be in accordance with AMS 2375.
- 4.5 Reports:
- 4.5.1 The vendor of bars, forgings, and flash welded rings shall furnish with each shipment a report showing the results of tests for chemical composition of each heat and the results of tests on each lot to determine conformance to the other acceptance test requirements of this specification. This report shall include the purchase order number, heat number, AMS 5769D, size, and quantity. If forgings are supplied, the part number and the size and melt source of stock used to make the forgings shall also be included.
- 4.5.2 The vendor of stock for forging, flash welded rings, or heading shall furnish with each shipment a report showing the results of tests for chemical composition of each heat. This report shall include the purchase order number, heat number, AMS 5769D, size, and quantity.
- 4.5.3 The vendor of finished or semi-finished parts shall furnish with each shipment a report showing the purchase order number, AMS 5769D, 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 either a statement that the material conforms or copies of laboratory reports showing the results of tests to determine conformance.