



AEROSPACE MATERIAL SPECIFICATION

AMS6290™**REV. K**Issued 1939-12
Revised 2018-06

Superseding AMS6290J

Steel, Bars and Forgings, Carburizing
1.8Ni - 0.25Mo (0.11 - 0.17C) (SAE 4615)
(Composition similar to UNS G46150)

RATIONALE

AMS6290K results from a Five-Year Review and update of this specification that revises composition testing analytical methods (3.1), grain size determination (3.1.1, 3.3.2 and 4.2), quality (3.4.2), reporting (4.4) and identification (5.2).

1. SCOPE

1.1 Form

This specification covers an aircraft-quality, low-alloy steel in the form of bars, forgings, and forging stock.

1.2 Application

These products have been used typically for carburized parts which require low minimum core hardness and allow a wide hardness range in sections 0.375 inch (9.50 mm) and under in nominal thickness, but usage is not limited to such applications. The core may or may not be machinable after hardening.

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.

AMS2251 Tolerances, Low-Alloy Steel Bars

AMS2259 Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels

AMS2301 Steel Cleanliness, Aircraft Quality Magnetic Particle Inspection Procedure

AMS2370 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel, Wrought Products and Forging Stock

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AMS2372	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Forgings
AMS2806	Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys
AMS2808	Identification, Forgings
ARP1917	Clarification of Terms Used in Aerospace Metals Specifications
AS1182	Standard Stock Removal Allowance, Aircraft-Quality and Premium Aircraft-Quality Steel Bars and Mechanical Tubing

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 A255	Determining Hardenability of Steel
ASTM A370	Mechanical Testing of Steel Products
ASTM A751	Standard Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products
ASTM E112	Determining Average Grain Size
ASTM E140	Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness
ASTM E381	Macroetch Testing Steel Bars, Billets, Blooms, and Forgings

3. TECHNICAL REQUIREMENTS

3.1 Composition

Shall conform to the percentages by weight shown in Table 1, determined in accordance with ASTM A751 or other analytical methods acceptable to purchaser.

Table 1 - Composition

Element	Min	Max
Carbon	0.11	0.17
Manganese	0.45	0.65
Silicon	0.15	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Nickel	1.65	2.00
Molybdenum	0.20	0.30
Chromium	--	0.20
Copper	--	0.35

3.1.1 Aluminum, vanadium and columbium are optional grain refining elements and need not be determined or reported unless used to satisfy the average grain size requirements of 3.3.2.2.

3.1.2 Check Analysis

Composition variations shall meet the applicable requirements of AMS2259.

3.2 Condition

The product shall be supplied in the following condition; hardness and tensile strength shall be determined in accordance with ASTM A370:

3.2.1 Bars

3.2.1.1 Bars 0.500 Inch (12.70 mm) and Under in Nominal Diameter or Least Distance Between Parallel Sides

Cold finished having tensile strength not higher than 125 ksi (862 MPa) or equivalent hardness (see 8.2).

3.2.1.2 Bars Over 0.500 Inch (12.70 mm) in Nominal Diameter or Least Distance Between Parallel Sides

Hot finished, unless otherwise ordered, having hardness not higher than 229 HB, or equivalent (see 8.3). Bars ordered cold finished shall have hardness not higher than 241 HB, or equivalent (see 8.3).

3.2.1.3 Bar shall not be cut from plate (also see 4.4.2).

3.2.2 Forgings

As ordered.

3.2.3 Forging Stock

As ordered by the forging manufacturer.

3.3 Properties

The product shall conform to the following requirements:

3.3.1 Macrostructure

Visual examination of transverse full cross-sections from bars, billets, and forging stock, etched in hot hydrochloric acid in accordance with ASTM E381, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the macrographs of ASTM E381 shown in Table 2.

Table 2 - Macrostructure limits

Cross-Sectional Area Square Inches	Cross-Sectional Area Square Centimeters	Macrographs
Up to 36, incl	Up to 230, incl	S2 - R1 - C2
Over 36 to 133, incl	Over 230 to 858, incl	S2 - R2 - C3
Over 133	Over 858	Note 1

NOTE 1: Limits for larger sizes shall be agreed upon by purchaser and producer. The purchaser shall have written approval of the agreement from the cognizant engineering organization.

3.3.2 Average Grain Size

Average grain size shall be determined by either 3.3.2.1 or 3.3.2.2.

3.3.2.1 Shall be ASTM No. 5 or finer, determined in accordance with ASTM E112.

3.3.2.2 The product of a heat shall be considered to have an ASTM No. 5 or finer austenitic grain size if one or more of the following are determined by heat analysis (see 8.5):

- 3.3.2.2.1 A total aluminum content of 0.020 to 0.050%.
- 3.3.2.2.2 An acid soluble aluminum content of 0.015 to 0.050%.
- 3.3.2.2.3 A vanadium content of 0.02 to 0.08%.
- 3.3.2.2.4 A columbium content of 0.02 to 0.05%.

3.3.3 Hardenability

Shall be J 1/16 inch (1.588 mm) = HRC 43 maximum and J 6/16 inch (9.525 mm) = HRC 18 minimum, determined on the standard end-quench test specimen in accordance with ASTM A255, except that the steel shall be normalized at 1700 °F ± 10 °F (927 °C ± 6 °C) and the test specimen austenitized at 1700 °F ± 10 °F (927 °C ± 6 °C).

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 Steel shall be aircraft-quality conforming to AMS2301.

3.4.2 Bars shall be free from seams, laps, tears, and cracks after removal of the standard stock removal allowance in accordance with AS1182.

3.4.3 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 reentrant flow.

3.5 Tolerances

Shall be as follows:

3.5.1 Bars

In accordance with AMS2251.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

The supplier of the product shall supply all samples for producer's tests and shall be responsible for the performance of all required tests. Purchaser reserves the right to sample and perform any confirmatory testing deemed necessary to ensure that the product conforms to specified requirements.

4.2 Classification of Tests

4.2.1 Acceptance Tests

Composition (3.1), condition (3.2), macrostructure (3.3.1), average grain size (3.3.2), hardenability (3.3.3), frequency-severity cleanliness rating (3.4.1), and tolerances (3.5) are acceptance tests and shall be performed on each heat or lot as applicable. If grain refining elements (3.3.2.2) are not present, the ASTM E112 grain size test (3.3.2.1) shall be conducted on each lot.

4.2.2 Periodic Tests

If grain refining elements (3.3.2.2) are present, the ASTM E112 grain size test (3.3.2.1) shall be conducted on a periodic basis and shall be performed at a frequency selected by the producer (not to exceed 1 year) unless frequency of testing is specified by purchaser. Grain flow of die forgings (3.4.3) is a periodic test and shall be performed at a frequency selected by the producer unless frequency of testing is specified by purchaser.

4.3 Sampling and Testing

Shall be as follows:

4.3.1 Bars and Forging Stock

In accordance with AMS2370.

4.3.2 Forgings

In accordance with AMS2372.

4.4 Reports

4.4.1 The producer of bars or forgings shall furnish with each shipment a report showing the producer identity, country where the metal was melted (e.g., final melt in the case of metal processed by multiple melting operations), results of tests for composition, macrostructure, frequency-severity cleanliness rating, hardenability of each heat, for condition (hardness) and, if measured, average grain size of each lot, and stating that the product conforms to the other technical requirements. This report shall include the purchase order number, heat and lot numbers, AMS6290K, product form, size (and/or part number, if applicable), and quantity. If forgings are supplied, the size and melt source of stock used to make the forgings shall also be included. If the grain size requirement of 3.3.2 is met by the aluminum, vanadium and/or columbium content, the aluminum, vanadium and/or columbium content shall be reported and a statement that the chemistry satisfies the grain size requirement shall be included.

4.4.2 Report the nominal metallurgically worked cross sectional size and the cut size, if different (see 3.2.1.3).

4.4.3 The producer of forging stock shall furnish with each shipment a report showing the producer identity, country where the metal was melted (e.g., final melt in the case of metal processed by multiple melting operations) and the composition, macrostructure, frequency-severity rating, and hardenability of each heat. This report shall include the purchase order number, heat number, AMS6290K, size (and/or part number, if applicable) and quantity.

4.4.4 When material produced to this specification has purchaser approved exceptions taken to the technical requirements listed in Section 3 (see 5.2) the report shall contain a statement "This material is certified as AMS6290K(EXC) because of the following exceptions:" and the specific exceptions shall be listed.

4.5 Resampling and Retesting

Shall be as follows:

4.5.1 Bars and Forging Stock

In accordance with AMS2370.

4.5.2 Forgings

In accordance with AMS2372.

5. PREPARATION FOR DELIVERY

5.1 Sizes

Except when exact lengths or multiples of exact lengths are ordered, straight bars will be acceptable in mill lengths of 6 to 20 feet (1.8 to 6.1 m), but not more than 10% of any shipment shall be supplied in lengths shorter than 10 feet (3 m).