



# AEROSPACE MATERIAL SPECIFICATION



AMS 5639H

Issued JUN 1953  
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Reaffirmed APR 2007

Superseding AMS 5639G

Steel, Corrosion-Resistant, Bars, Wire, forgings, Tubing, and Rings  
19Cr - 10Ni  
Solution Heat Treated

(Composition similar to UNS S30400)

## RATIONALE

This document has been reaffirmed to comply with the SAE 5-year Review policy.

### 1. SCOPE:

#### 1.1 Form:

This specification covers a corrosion-resistant steel in the form of bars, wire, forgings, mechanical tubing, flash welded rings, and stock for forging or flash welded rings.

#### 1.2 Application:

These products have been used typically for parts requiring corrosion and heat resistance up to 800 °F (427 °C), but usage is not limited to such applications. Welding, brazing, or other exposure to temperatures over 800 °F (427 °C) during fabrication may impair corrosion resistance.

### 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 supplied 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.

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**SAE WEB ADDRESS:** <http://www.sae.org>

**2.1 SAE Publications:**

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001 or [www.sae.org](http://www.sae.org).

- AMS 2241 Tolerances, Corrosion and Heat-Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Bars and Wire
- MAM 2241 Tolerances, Metric, Corrosion and Heat-Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Bars and Wire
- AMS 2243 Tolerances, Corrosion and Heat-Resistant Steel Tubing
- MAM 2243 Tolerances, Metric, Corrosion and Heat-Resistant Steel Tubing
- AMS 2248 Chemical Check Analysis Limits, Corrosion and Heat-Resistant Steels and Alloys, Maraging and Other Highly-Alloyed Steels, and Iron Alloys
- AMS 2371 Quality Assurance Sampling and Testing, Corrosion and Heat-Resistant Steels and Alloys, Wrought Products and Forging Stock
- AMS 2374 Quality Assurance Sampling and Testing, Corrosion and Heat-Resistant Steel and Alloy forgings
- AMS 2806 Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys
- AMS 2808 Identification, forgings
- AMS 7490 Rings, Flash Welded, Corrosion and Heat-Resistant Austenitic Steels and Austenitic-Type Alloys, or Precipitation Hardenable Alloys

**2.2 ASTM Publications:**

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or [www.astm.org](http://www.astm.org).

- ASTM A 262 Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels
- ASTM A 370 Mechanical Testing of Steel Products
- ASTM E 353 Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

**3 . TECHNICAL REQUIREMENTS:****3.1 Composition:**

Shall conform to the percentages by weight shown in Table 1, determined by wet chemical methods in accordance with ASTM E 353, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

**TABLE 1 – Composition**

Element	min	max
Carbon	--	0.08
Manganese	--	2.00
Silicon	--	1.00
Phosphorus	--	0.040
Sulfur	--	0.030
Chromium	18.00	20.00
Nickel	8.00	12.00
Molybdenum	--	1.00
Copper	--	1.00

**3.1.1 Check Analysis:** Composition variations shall meet the applicable requirements of AMS 2248.

**3.2 Condition:**

The product shall be supplied in the following condition:

**3.2.1 Bars, Wire, forgings, Mechanical Tubing, and Flash Welded Rings:** Solution heat treated.

**3.2.1.1 Bars and Wire:**

3.2.1.1 All hexagons, regardless of size, other bars 2.75 inches (69.8 mm) and under in nominal diameter or least distance between parallel sides, and wire shall be cold finished.

3.2.1.1.2 Bars, other than hexagons, over 2.75 inches (69.8 mm) in nominal diameter or least distance between parallel sides shall be hot finished and descaled.

3.2.1.2 Mechanical Tubing: Shall be cold finished.

3.2.1.3 Flash Welded Rings: Shall not be supplied unless specified or permitted on purchaser's part drawing. When supplied, rings shall be manufactured in accordance with AMS 7490.

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

### 3.3 Properties:

The product shall conform to the following requirements; tensile and hardness testing shall be performed in accordance with ASTM A 370.

#### 3.3.1 Tensile Properties:

3.3.1.1 Bars and forgings over 0.50 inch (12.7 mm) in Nominal Diameter or Least Distance Between Parallel Sides: Shall be as shown in Table 2.

TABLE 2 - Minimum Tensile Properties

Property	Value
Tensile Strength	75 ksi (517 MPa)
Yield Strength at 0.2% Offset	30.0 ksi (207 MPa)
Elongation in 4D	40%
Reduction of Area	50%

3.3.1.2 Wire: Shall have tensile strength of 85 to 125 ksi (586 to 862 MPa).

#### 3.3.2 Hardness:

3.3.2.1 forgings and flash welded rings: Shall be not higher than 187 HB, or equivalent (See 8.2).

3.3.2.2 Mechanical tubing: Shall be not higher than 90 HRB, or equivalent (See 8.2), determined approximately midway between outer and inner surfaces.

3.3.3 Susceptibility to intergranular attack: Specimens from the product shall pass the intergranular corrosion test performed in accordance with ASTM A 262, Practice E.

### 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 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 grain flow.

### 3.5 Tolerances:

Shall be as follows:

3.5.1 Bars and Wire: In accordance with AMS 2241 or MAM 2241.

3.5.2 Mechanical tubing: In accordance with AMS 2243 or MAM 2243.

**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:**

- 4.2.1 Acceptance Tests:** Compositions (3.1), tensile properties (3.3.1.1 or 3.3.1.2), hardness (3.3.2), susceptibility to intergranular attack (3.3.3), and tolerances (3.5) are acceptance tests and shall be performed on each heat or lot as applicable.
- 4.2.2 Periodic Tests:** Grain flow of die forgings (3.4.1) is a periodic test and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

**4.3 Sampling and Testing:**

Shall be as follows:

- 4.3.1 Bars, Wire, Mechanical Tubing, Flash Welded Rings, and Stock for Forging or Flash Welded Rings:** In accordance with AMS 2371.
- 4.3.2 forgings:** In accordance with AMS 2374.

**4.4 Reports:**

The vendor of the product shall furnish with each shipment a report showing the following results of tests and relevant information:

- 4.4.1 For each heat:**
  - Composition.
- 4.4.2 For each lot of bars, forgings, mechanical tubing, and flash welded rings:**
  - Tensile properties
  - Hardness
  - Susceptibility to intergranular attack.
- 4.4.3 A statement that the product conforms to the other technical requirements.**