



AEROSPACE MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
TWO PENNSYLVANIA PLAZA, NEW YORK, N. Y. 10001

AMS 5547C

Superseding AMS 5547B

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STEEL SHEET AND STRIP, CORROSION AND MODERATE HEAT RESISTANT
15.5Cr - 4.5Ni - 2.9Mo - 0.10N
Solution Heat Treated

1. SCOPE:

1.1 Form: This specification covers a hardenable, corrosion and moderate heat resistant steel in the form of sheet and strip.

1.2 Application: Primarily for parts requiring oxidation resistance and high strength up to 800° F (427° C) and where such parts may require welding during fabrication.

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., Two Pennsylvania Plaza, New York, New York 10001.

2.1.1 Aerospace Material Specifications:

AMS 2242 - Tolerances, Corrosion and Heat Resistant Steel and Iron-Base Alloy Sheet, Strip, and Plate and Titanium and Titanium-Alloy Sheet, Strip, and Plate

AMS 2248 - Chemical Check Analysis Limits, Wrought Heat and Corrosion Resistant Steels and Alloys

AMS 2350 - Standards and Test Methods

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

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

ASTM A370 - Mechanical Testing of Steel Products

ASTM E353 - Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

2.3 Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, Pennsylvania 19120.

2.3.1 Federal Standards:

Federal Test Method Standard No. 151 - Metals; Test Methods

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E353, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other approved analytical methods:

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	min	max
Carbon	0.10	0.15
Manganese	0.50	1.25
Silicon	--	0.50
Phosphorus	--	0.040
Sulfur	--	0.030
Chromium	15.00	16.00
Nickel	4.00	5.00
Molybdenum	2.50	3.25
Nitrogen	0.07	0.13

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 Sheet: Hot rolled or cold rolled, solution heat treated, and descaled (No. 2D Finish).

3.2.2 Strip: Cold rolled, solution heat treated, and descaled (No. 1 Strip Finish).

3.3 Solution Heat Treatment: The product shall be solution heat treated by heating to $1900^{\circ}\text{F} \pm 25$ ($1037.8^{\circ}\text{C} \pm 14$), holding at heat for not less than 45 min. per inch (25 mm) of thickness, and quenching in water or otherwise cooling as rapidly as possible to room temperature.

3.4 Properties: The product shall conform to the following requirements: tensile, hardness, and bend testing shall be performed in accordance with ASTM A370:

3.4.1 As Solution Heat Treated:

3.4.1.1 Hardness: Shall be not higher than 35 HRC or equivalent.

3.4.1.2 Bending: The product shall withstand, without cracking, free bending through an angle of 180 deg (3.14 rad) around a diameter equal to 3 times the nominal thickness of the product with axis of bend parallel to the direction of rolling.

3.4.2 As Re-solution Heat Treated, Sub-Zero Cooled, Austenite Conditioned, Sub-Zero Cooled, and Tempered: The product shall conform to the following requirements after being heat treated as follows: Re-solution heat treat by heating to $1900^{\circ}\text{F} \pm 25$ ($1037.8^{\circ}\text{C} \pm 14$), holding at heat for not less than 45 min. per inch (25 mm) of thickness, and quenching in water or otherwise cooling as rapidly as possible to room temperature; cool to -100°F (-73°C) or colder, hold at this temperature for not less than 3 hr, and warm in air to room temperature; austenite condition by heating to $1750^{\circ}\text{F} \pm 10$ ($954.4^{\circ}\text{C} \pm 5.6$), holding at heat for 10-60 min. and quenching in water or otherwise cooling as rapidly as possible to room temperature; cool to -100°F (-73°C) or colder, hold at this temperature for not less than 3 hr, and warm in air to room temperature; temper by heating to $1000^{\circ}\text{F} \pm 25$ ($537.8^{\circ}\text{C} \pm 14$), holding at heat for not less than 3 hr, and cooling in air.

3.4.2.1 Tensile Properties:

Tensile Strength, min	165,000 psi	(1138 MPa)
Yield Strength at 0.2% Offset, min	140,000 psi	(965 MPa)
Elongation in 2 in. (50.8 mm), min	10%	

3.4.2.1.1 Elongation requirements apply to product over 0.0100 to 0.1875 in. (0.254 to 4.762 mm), excl, in thickness; elongation requirements for product 0.0100 in. (0.254 mm) and under in thickness shall be as agreed upon by purchaser and vendor.

3.4.2.2 Hardness: Should be 37 - 44 HRC or equivalent but the product shall not be rejected on the basis of hardness if the tensile property requirements of 3.4.2.1 are met.

3.5 Quality:

- 3.5.1 Steel shall be multiple melted using consumable electrode process in the remelt cycle, unless otherwise permitted.
- 3.5.2 The product shall be uniform in quality and condition, essentially free of grain boundary carbides, clean, sound, and free from foreign materials and from internal and external imperfections detrimental to fabrication or to performance of parts.
- 3.6 Tolerances: Unless otherwise specified, tolerances shall conform to all applicable requirements of AMS 2242.

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 assure that the product 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 or routine control tests.
- 4.3 Sampling: Shall be in accordance with AMS 2371 and the following; a heat shall be the consumable electrode remelted ingots produced from steel originally melted as a single furnace charge:
- 4.3.1 Tensile test specimens from 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), tensile test 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 of the results of tests for chemical composition of each heat in the shipment and the results of tests on each thickness from each heat to determine conformance to the other technical requirements of this specification. 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: If any specimen used in the above tests fails to meet the specified requirements, disposition of the product may be based on the results of testing three additional specimens for each original nonconforming specimen. Failure of any retest specimen to meet the specified requirements shall be cause for rejection of the product represented and no additional testing shall be permitted. Results of all tests shall be reported.

5. PREPARATION FOR DELIVERY:

- 5.1 Identification: Each sheet and strip shall be marked on one face, in the respective location indicated below, with AMS 5547C, heat number, manufacturer's identification, and nominal thickness. The characters shall be of such size as to be clearly legible, shall be applied using a suitable marking fluid, and shall be capable of being removed in hot alkaline cleaning solution without rubbing. The markings shall have no deleterious effect on the material or its performance and shall be sufficiently stable to withstand normal handling.