



AEROSPACE MATERIAL SPECIFICATION

AMS5776™**REV. H**

Issued 1957-01
Reaffirmed 2015-12
Revised 2021-10

Superseding AMS5776G

Steel, Corrosion and Heat-Resistant, Welding Wire
12.5Cr (SAE 51410)
(Composition similar to UNS S41001)

RATIONALE

AMS5776H is the result of a Five-Year Review and update of the specification. The revision prohibits unauthorized substitution (3.7, 4.4.1, 5.3.1, 8.5), updates composition testing (3.1), allows prior revisions (8.6), and adds country of origin to reports (4.4).

1. SCOPE

1.1 Form

This specification covers a corrosion and heat-resistant steel in the form of welding wire.

1.2 Application

This wire has been used typically as filler metal for gas-metal-arc or gas-tungsten-arc welding of steels of similar composition requiring joints with strength and corrosion resistance comparable to those of the basis metal, but usage is not limited to such applications.

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 15096-000, Tel: 877-606-7323 (inside USA and Canada) or +1 724-776-4970 (outside USA), www.sae.org.

AMS2248 Chemical Check Analysis Limits, Corrosion and Heat-Resistant Steels and Alloys, Maraging and Other Highly Alloyed Steels, and Iron Alloys

AMS2371 Quality Assurance Sampling and Testing, Corrosion and Heat-Resistant Steels and Alloys, Wrought Products and Forging Stock

AMS2813 Packaging and Marking of Packages of Welding Wire, Standard Method

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SAE WEB ADDRESS:

For more information on this standard, visit
<https://www.sae.org/standards/content/AMS5776H>

AMS2814	Packaging and Marking of Packages of Welding Wire, Premium Quality
AMS2816	Identification, Welding Wire, Tab Marking Method
AMS2819	Identification, Welding Wire, Direct Color Code System
AMS5504	Steel, Corrosion and Heat-Resistant, Sheet, Strip, and Plate, 12.5Cr (410), Annealed
ARP1876	Weldability Test for Weld Filler Metal Wire
ARP1917	Clarification of Terms Used in Aerospace Metals Specifications
ARP4926	Alloy Verification and Chemical Composition, Inspection of Welding Wire

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 E18	Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials
ASTM A751	Chemical Analysis of Steel Products
ASTM E140	Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness

3. TECHNICAL REQUIREMENTS

3.1 Wire Composition

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

Table 1 - Composition

Element	Min	Max
Carbon	0.10	0.15
Manganese	--	1.00
Silicon	--	1.00
Phosphorus	--	0.025
Sulfur	--	0.015
Phosphorus + Sulfur	--	0.030
Chromium	11.50	13.50
Nickel	--	0.75
Molybdenum	--	0.50
Aluminum	--	0.05
Copper	--	0.50
Tin	--	0.05
Nitrogen	--	0.08

3.1.1 Chemical analysis of initial ingot, bar, or rod stock before drawing is acceptable provided processes used for drawing or rolling, annealing, and cleaning are controlled to ensure continued conformance to composition requirements.

3.1.2 Check Analysis

Composition variations shall meet the applicable requirements of AMS2248.

3.2 Condition

Cold worked, bright finish, in a temper and with a surface finish which will provide proper feeding of the wire in machine welding equipment.

3.3 Fabrication

- 3.3.1 Wire shall be formed from rod or bar descaled by a process which does not affect the composition of the wire. Surface irregularities inherent with a forming process that does not tear the wire surfaces are acceptable provided the wire conforms to the tolerance of 3.6.
- 3.3.2 Butt welding is permissible provided both ends to be joined are alloy verified using a method capable of distinguishing the alloy from all other alloys processed within the facility or the repair is made at the wire processing station. The butt weld shall not interfere with uniform, uninterrupted feeding of the wire in machine welding.
- 3.3.3 In-process annealing, if required, between cold rolling or drawing operations, shall be performed in vacuum or protective atmospheres to ensure freedom from surface oxidation and absorption of other extraneous elements.
- 3.3.4 Residual elements, drawing compounds, oxides, dirt, oil, dissolved gasses and other foreign materials picked up during wire processing that can adversely affect the welding characteristics, the operation of the equipment, or the properties of the weld metal, shall be removed by cleaning processes that will neither result in pitting nor cause gas absorption by the wire or deposition of substances harmful to welding operations.

3.4 Properties

Wire shall conform to the following requirements:

3.4.1 Weldability

Melted wire shall flow smoothly and evenly during welding and shall produce acceptable welds. ARP1876 may be used to resolve disputes.

3.4.2 Response to Heat Treatment

Weld metal deposits approximately 1/4 inch (6.4 mm) in thickness, deposited on AMS5504 steel, shall attain hardness of 35 to 45 HRC, or equivalent (see 8.2), determined in accordance with ASTM E18, after being heated to 1750 °F ± 10 °F (954 °C ± 6 °C), held at heat for 30 minutes ± 3 minutes, and cooled at a rate equivalent to cooling in still air.

3.4.3 Spooled Wire

Shall conform to 3.4.3.1 and 3.4.3.2.

3.4.3.1 Cast

Wire, wound on standard 12 inch (305 mm) diameter spools, shall have imparted to it a curvature such that a specimen sufficient in length to form one loop with a 1 inch (25 mm) overlap, when cut from the spool and laid on a flat surface, shall form a circle 15 to 50 inches (381 to 1270 mm) in diameter.

3.4.3.2 Helix

The specimen on which cast was determined, when laid on a flat surface and measured between adjacent turns, shall show a vertical separation not greater than 1 inch (25 mm).

3.5 Quality

Wire, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to welding operations, operation of welding equipment, or properties of the deposited weld metal.

3.6 Sizes and Tolerances

Wire shall be supplied in the sizes and to the tolerances shown in 3.6.1 and 3.6.2.

3.6.1 Diameter

Shall be as shown in Table 2.

Table 2A - Sizes and diameter tolerances, inch/pound units

Form	Nominal Diameter Inches	Tolerance Inches
		Plus and Minus
Cut Lengths	0.030, 0.035, 0.045	0.001
Cut Lengths	0.062, 0.078, 0.094, 0.125, 0.156, 0.187	0.002
Spools	0.007, 0.010, 0.015	0.0005
Spools	0.020, 0.030, 0.035, 0.045	0.001
Spools	0.062, 0.078, 0.094	0.002

Table 2B - Sizes and diameter tolerances, SI Units

Form	Nominal Diameter Millimeters	Tolerance Millimeters
		Plus and Minus
Cut Lengths	0.76, 0.89, 1.14	0.025
Cut Lengths	1.57, 1.98, 2.39, 3.18, 3.96, 4.75	0.05
Spools	0.18, 0.25, 0.38	0.013
Spools	0.51, 0.76, 0.89, 1.14	0.025
Spools	1.57, 1.98, 2.39	0.05

3.6.2 Length

Cut lengths shall be furnished in 18-inch, 27-inch, or 36-inch (457-mm, 686-mm, or 914-mm) lengths as ordered, and shall not vary more than +0, -0.5 inch (-13 mm) from the length ordered.

3.7 Exceptions

Any exceptions shall be authorized by the purchaser and reported as in 4.4.1

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

The producer of wire 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 to perform any confirmatory testing deemed necessary to ensure that the wire conforms to specified requirements.

4.2 Classification of Tests

4.2.1 Acceptance Tests

Composition (3.1), sizes and tolerances (3.6), and alloy verification (5.2) are acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Periodic Tests

Weldability (3.4.1), response to heat treatment (3.4.2), cast (3.4.3.1), and helix (3.4.3.2) are periodic tests and shall be performed at a frequency selected by the producer unless frequency of testing is specified by purchaser.