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SAE-AMS5823, "STEEL, CORROSION AND HEAT RESISTANT, WELDING WIRE 11.8CR - 2.8NI - 1.6C0 - 1.8MO - 0.32V", was adopted on 22-MAY-95 for use by the Department of Defense (DoD). Proposed changes by DoD activities must be submitted to the DoD Adopting Activity: ASC/EN01, Building 560, 2530 Loop Road West, Wright-Patterson AFB, OH 45433-7101. Copies of this document may be purchased from the Society of Automotive Engineers 400 Commonwealth Drive Warrendale, Pennsylvania, United States, 15096-0001.  
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# AEROSPACE MATERIAL SPECIFICATION

**SAE**

AMS 5823D

Issued MAY 1973  
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Superseding AMS 5823C

Submitted for recognition as an American National Standard

STEEL, CORROSION AND HEAT RESISTANT, WELDING WIRE  
11.8Cr - 2.8Ni - 1.6Co - 1.8Mo - 0.32V

UNS S41780

## 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-tungsten-arc or gas-metal-arc welding of parts fabricated from steels of similar composition requiring joints with good strength and oxidation resistance up to 800 °F (427 °C), but usage is not limited to such applications.

## 2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

### 2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2248 Chemical Check Analysis Limits, Wrought 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 2813 Packaging and Marking of Packages of Welding Wire, Standard Method

AMS 2814 Packaging and Marking of Packages of Welding Wire, Premium Quality

AMS 2816 Identification, Welding Wire, Tab Marking Method

AMS 2819 Identification, Welding Wire, Direct Color Code System

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## 2.1 (Continued):

ARP1876 Weldability Test for Weld Filler Metal Wire

ARP4926 Alloy Verification and Chemical Composition Inspection of Welding Wire

## 2.2 ASTM Publications:

Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

ASTM E 353 Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

## 3. TECHNICAL REQUIREMENTS:

## 3.1 Composition:

(R)

Wire 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     | 0.10  | 0.15  |
| Manganese  | 0.40  | 1.30  |
| Silicon    | --    | 0.40  |
| Phosphorus | --    | 0.030 |
| Sulfur     | --    | 0.030 |
| Chromium   | 11.00 | 12.50 |
| Nickel     | 2.50  | 3.00  |
| Cobalt     | 1.30  | 2.00  |
| Molybdenum | 1.50  | 2.00  |
| Vanadium   | 0.25  | 0.40  |
| Nitrogen   | --    | 0.045 |
| Copper     | --    | 0.75  |

3.1.1 Chemical analysis of initial ingot, bar, or rod stock before drawing is acceptable provided the 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 requirements of AMS 2248.

## 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.

3.2.1 In-process annealing between cold rolling or drawing operations shall be performed in a protective atmosphere to ensure freedom from surface oxidation and absorption of other extraneous elements.  
(R)

3.2.2 Wire shall be furnished on spools for machine welding or in cut lengths for manual welding, as ordered.  
(R)

3.2.3 Drawing compounds, oxides, dirt, oil, and other foreign materials shall be removed by cleaning processes which will neither result in pitting nor cause gas absorption by the wire or deposition of substances harmful to welding operations.

### 3.3 Properties:

Wire shall conform to the following requirements:

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

3.3.2 Spooled Wire: Shall conform to 3.3.2.1 and 3.3.2.2.

3.3.2.1 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.

3.3.2.2 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).

### 3.4 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.

### 3.5 Sizes and Tolerances:

Wire shall be supplied in the sizes and to the tolerances shown in 3.5.1 and 3.5.2.

## 3.5.1 Diameter: Shall be as shown in Table 2.

TABLE 2A - Sizes and Diameter Tolerances, Inch/Pound Units

| Form        | Nominal Diameter<br>Inch   | Tolerance<br>Inch<br>Plus | Tolerance<br>Inch<br>Minus |
|-------------|----------------------------|---------------------------|----------------------------|
|             |                            |                           |                            |
| Cut Lengths | 0.030, 0.045, 0.062, 0.078 | 0.002                     | 0.002                      |
| Cut Lengths | 0.094, 0.125, 0.156, 0.188 | 0.003                     | 0.003                      |
| Spools      | 0.007, 0.010, 0.015, 0.020 | 0.0005                    | 0.0005                     |
| Spools      | 0.030, 0.035, 0.045        | 0.001                     | 0.002                      |
| Spools      | 0.062, 0.078, 0.094        | 0.002                     | 0.002                      |

TABLE 2B - Sizes and Diameter Tolerances, SI Units

| Form        | Nominal Diameter<br>Millimeters | Tolerance<br>Millimeter<br>Plus | Tolerance<br>Millimeter<br>Minus |
|-------------|---------------------------------|---------------------------------|----------------------------------|
|             |                                 |                                 |                                  |
| Cut Lengths | 0.76, 1.14, 1.57, 1.98          | 0.05                            | 0.05                             |
| Cut Lengths | 2.39, 3.18, 3.96, 4.78          | 0.08                            | 0.08                             |
| Spools      | 0.18, 0.25, 0.38, 0.51          | 0.013                           | 0.013                            |
| Spools      | 0.76, 0.89, 1.14                | 0.025                           | 0.05                             |
| Spools      | 1.57, 1.98, 2.39                | 0.05                            | 0.05                             |

3.5.2 Length: Cut lengths shall be furnished in 18, 27, or 36 inch (457, 686, or 914 mm) lengths, as ordered, and shall not vary more than +0, -1/2 inch (-13 mm) from the length ordered.

## 4. QUALITY ASSURANCE PROVISIONS:

## 4.1 Responsibility for Inspection:

The vendor of wire shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the wire conforms to the requirements of this specification.

## 4.2 Classification of Tests:

4.2.1 Acceptance Tests: Composition (3.1), sizes and tolerances (3.5), 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 (3.3.1), cast (3.3.2.1), and helix (3.3.2.2) are periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.