

## AEROSPACE MATERIAL SPECIFICATION

**SAE**

**AMS 6323J**

Issued NOV 1994  
Revised APR 1997

Superseding AMS 6323H

Submitted for recognition as an American National Standard

STEEL, MECHANICAL TUBING  
0.50Cr - 0.55Ni - 0.25Mo (0.38 - 0.43C) (SAE 8740)

UNS G87400

### 1. SCOPE:

#### 1.1 Form:

This specification covers an aircraft-quality, low-alloy steel in the form of mechanical tubing.

#### 1.2 Application:

This tubing has been used typically for parts, 0.375 inch (9.52 mm) and under in section thickness at time of heat treatment, requiring a through-hardening steel capable of developing hardness as high as 50 HRC when properly hardened and tempered and also parts of greater thickness but requiring proportionately lower hardness, 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.

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## 2.1 SAE Publications:

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

- AMS 2253 Tolerances, Carbon and Alloy Steel Tubing
- MAM 2253 Tolerances, Metric, Carbon and Alloy Steel Tubing
- AMS 2259 Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
- AMS 2301 Cleanliness, Aircraft Quality Steel, Magnetic Particle Inspection Procedure
- MAM 2301 Cleanliness, Aircraft Quality Steel, Magnetic Particle Inspection Procedure, Metric (SI) Measurement
- AMS 2370 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Wrought Products and Forging Stock
- AMS 2806 Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat Resistant Steels and Alloys
- AS1182 Standard Machining Allowance, Aircraft-Quality and Premium Aircraft-Quality Steel Bars and Mechanical Tubing

## 2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

- ASTM A 255 End-Quench Test for Hardenability of Steel
- ASTM E 18 Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials
- ASTM E 112 Determining the Average Grain Size
- ASTM E 350 Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron
- ASTM E 381 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 by wet chemical methods in accordance with ASTM E 350, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - Composition

| Element    | min  | max   |
|------------|------|-------|
| Carbon     | 0.38 | 0.43  |
| Manganese  | 0.75 | 1.00  |
| Silicon    | 0.15 | 0.35  |
| Phosphorus | --   | 0.025 |
| Sulfur     | --   | 0.025 |
| Chromium   | 0.40 | 0.60  |
| Nickel     | 0.40 | 0.70  |
| Molybdenum | 0.20 | 0.30  |
| Copper     | --   | 0.35  |

3.1.1 Check Analysis: Composition variations shall meet the applicable requirements of AMS 2259.

### 3.2 Condition:

Cold finished, unless otherwise ordered, having hardness not higher than 25 HRC, or equivalent (See 8.2). Tubing ordered hot finished and annealed or tempered shall have hardness not higher than 99 HRB, or equivalent. Hardness shall be determined in accordance with ASTM E 18.

### 3.3 Properties:

Tubing shall conform to the following requirements:

3.3.1 Macrostructure: Visual examination of transverse full cross-sections from tube rounds or tubes, etched in hot hydrochloric acid in accordance with ASTM E 381, shall show no pipe or cracks. Except as specified in 3.3.1.1, porosity, segregation, inclusions, and other imperfections shall be no worse than the macrographs of ASTM E 381 shown in Table 2.

TABLE 2 - Macrostructure Limits

| Section Size<br>Square Inches | Section Size<br>Square Centimeters | Macrographs |
|-------------------------------|------------------------------------|-------------|
| Up to 36, incl                | Up to 232, incl                    | S2-R1-C2    |
| Over 36 to 100, incl          | Over 232 to 645, incl              | S2-R2-C3    |

3.3.1.1 If tubes are produced directly from ingots or large blooms, transverse sections may be taken from tubes rather than tube rounds. Macrostructure standards for such tubes shall be as agreed upon by purchaser and vendor.

3.3.2 Average Grain Size: Shall be ASTM No. 5 or finer, determined in accordance with (R) ASTM E 112 (See 8.3).

3.3.3 Hardenability: Shall be J50=5 minimum and J40=8 minimum, determined on the standard end-quench test specimen in accordance with ASTM A 255 except that the steel shall be normalized at  $1700\text{ }^{\circ}\text{F} \pm 10$  ( $927\text{ }^{\circ}\text{C} \pm 6$ ) and the test specimen austenitized at  $1500\text{ }^{\circ}\text{F} \pm 10$  ( $816\text{ }^{\circ}\text{C} \pm 6$ ).

#### 3.3.4 Decarburization:

3.3.4.1 Tubing ordered ground, turned, or polished shall be free from decarburization on the ground, turned, or polished surfaces.

3.3.4.2 Allowable decarburization of pierced billets, of tube rounds and tubing for redrawing or forging, or of tubing ordered to specified microstructural requirements shall be as agreed upon by purchaser and vendor.

3.3.4.3 Decarburization of tubing to which 3.3.4.1 or 3.3.4.2 is not applicable shall be not greater than shown in Table 3.

TABLE 3A - Maximum Decarburization, Inch/Pound Units

| Nominal Wall Thickness    | Depth<br>ID | Depth<br>OD |
|---------------------------|-------------|-------------|
| Inches                    | Inch        | Inch        |
| Up to 0.109, incl         | 0.008       | 0.015       |
| Over 0.109 to 0.203, incl | 0.010       | 0.020       |
| Over 0.203 to 0.400, incl | 0.012       | 0.025       |
| Over 0.400 to 0.600, incl | 0.015       | 0.030       |
| Over 0.600 to 1.000, incl | 0.017       | 0.035       |
| Over 1.000                | 0.020       | 0.040       |

TABLE 3B - Maximum Decarburization, SI Units

| Nominal Wall Thickness    | Depth<br>ID | Depth<br>OD |
|---------------------------|-------------|-------------|
| Millimeters               | Millimeter  | Millimeter  |
| Up to 2.77, incl          | 0.20        | 0.38        |
| Over 2.77 to 5.16, incl   | 0.25        | 0.51        |
| Over 5.16 to 10.16, incl  | 0.30        | 0.64        |
| Over 10.16 to 15.24, incl | 0.38        | 0.76        |
| Over 15.24 to 25.40, incl | 0.43        | 0.89        |
| Over 25.40                | 0.51        | 1.02        |

3.3.4.4 Decarburization shall be measured by the microscopic method or by HR30N scale or equivalent hardness testing method on hardened but untempered specimens protected during heat treatment to prevent changes in surface carbon content. Depth of decarburization, when measured by a hardness method, is defined as the perpendicular distance from the surface to the depth under that surface below which there is no further increase in hardness. Such measurements shall be far enough away from any adjacent surface to be uninfluenced by decarburization thereon.

3.3.4.4.1 When determining the depth of decarburization, it is permissible to disregard local areas provided the decarburization of such areas does not exceed the limits of Table 3 by more than 0.005 inch (0.13 mm) and the width is 0.065 inch (1.65 mm) or less.

#### 3.4 Quality:

Tubing, 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 tubing.

3.4.1 Steel shall be aircraft quality conforming to AMS 2301 or MAM 2301.

3.4.2 Mechanical tubing ordered hot rolled or cold drawn or ground, turned, or polished shall, after removal of the standard machining allowance in accordance with AS1182, be free from seams, laps, tears, and cracks open to the ground, turned, or polished surfaces.

#### 3.5 Tolerances:

Shall conform to all applicable requirements of AMS 2253 or MAM 2253.

#### 4. QUALITY ASSURANCE PROVISIONS:

##### 4.1 Responsibility for Inspection. (R)

The vendor of tubing 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 tubing conforms to specified requirements.

##### 4.2 Classification of Tests:

All technical requirements are acceptance tests and shall be performed on each heat or lot as applicable.

##### 4.3 Sampling and Testing:

Shall be in accordance with AMS 2370.