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Superseding AMS5694H	

Steel, Corrosion and Heat-Resistant, Welding Wire  
27Cr - 21.5Ni

(Composition similar to UNS S31080)

**RATIONALE**

AMS5694J adds standard wording related to welding wire condition (3.2.1) and results from a Five Year Review and update of this specification.

**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 corrosion and heat resistant steels and alloys of similar composition, 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 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), [www.sae.org](http://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
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
ARP1876	Weldability Test for Weld Filler Metal Wire
ARP4926	Alloy Verification and Chemical Composition, Inspection of Welding Wire

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<http://www.sae.org/technical/standards/AMS5694J>

## 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](http://www.astm.org).

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

## 3. TECHNICAL REQUIREMENTS

### 3.1 Composition

Wire 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.

Element	min	max
Carbon	--	0.15
Manganese	1.25	2.50
Silicon	0.25	0.60
Phosphorus	--	0.030
Sulfur	--	0.025
Chromium	26.00	28.00
Nickel	20.50	22.50
Molybdenum	--	0.75
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 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.

3.2.1 Wire shall have a smooth finish that is free from slivers, depressions, scratches, scale, seams, laps, and foreign matter that would adversely affect welding characteristics, operation of the welding equipment, or properties of the weld metal.

### 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 do not tear the wire surfaces are acceptable provided the wire conforms to the tolerances 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 in 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 Spooled Wire

Shall conform to 3.4.2.1 and 3.4.2.2.

##### 3.4.2.1 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.

##### 3.4.2.2 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).

### 3.5 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 characteristics, 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 Inch	Tolerance	
		Inch Plus	Inch Minus
Cut Lengths	0.030, 0.035, 0.045	0.001	0.001
Cut Lengths	0.062, 0.078, 0.094, 0.125, 0.156, 0.187	0.002	0.002
Spools	0.007, 0.010, 0.015	0.0005	0.0005
Spools	0.020, 0.030, 0.035, 0.045	0.001	0.001
Spools	0.062, 0.078, 0.094	0.002	0.002

TABLE 2B - SIZES AND DIAMETER TOLERANCES, SI UNITS

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

### 3.6.2 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, -0.5 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 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), cast (3.4.2.1), and helix (3.4.2.2) are periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

### 4.3 Sampling and Testing

In accordance with AMS2371.

### 4.4 Reports

The vendor of wire shall furnish with each shipment a report showing the results of tests for chemical composition of each heat, and stating that the wire conforms to the other technical requirements. This report shall include the purchase order number, heat and lot numbers, AMS5694J, nominal size, and quantity.

### 4.5 Resampling and Retesting

In accordance with AMS2371.

## 5. PREPARATION FOR DELIVERY

5.1 Wire shall be supplied either on spools in one continuous length for machine welding or in cut lengths for manual welding, as ordered. Wire on each spool or in each package of cut lengths shall be from the same heat of steel.