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SAE-AMS6294, "STEEL BARS AND FORGINGS, CARBURIZING 1.8NI - 0.25MO (0.17 - 0.22C) (SAE 4620)", was adopted on 01-AUG-86 for use by the Department of Defense (DoD). Proposed changes by DoD activities must be submitted to the DoD Adopting Activity: Commander, Defense Supply Center Philadelphia, ATTN: DSCP-ILEA, 700 Robbins Avenue, Philadelphia, PA 19111-5096. Copies of this document may be purchased from the Society of Automotive Engineers 400 Commonwealth Drive Warrendale, Pennsylvania, United States, 15096-0001. <http://www.sae.org/>

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400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE MATERIAL SPECIFICATION

Submitted for recognition as an American National Standard

AMS 6294F
Superseding AMS 6294E

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REAFFIRMED**APR '94**

STEEL BARS AND FORGINGS, CARBURIZING
1.8Ni - 0.25Mo (0.17 - 0.22C) (SAE 4620)

UNS G46200

1. SCOPE:

1.1 Form: This specification covers an aircraft-quality, low-alloy steel in the form of bars, forgings, and forging stock.

1.2 Application: Primarily for carburized parts which require high minimum core hardness and allow wide hardness range in sections 0.375 in. (9.5 mm) and under in nominal thickness. The core may or may not be machinable after hardening.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications and Aerospace Standards shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

- AMS 2251 - Tolerances, Low-Alloy Steel Bars
- MAM 2251 - Tolerances, Metric, Low-Alloy Steel Bars
- AMS 2259 - Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
- AMS 2301 - Aircraft Quality Steel Cleanliness, Magnetic Particle Inspection Procedure
- AMS 2350 - Standards and Test Methods
- AMS 2370 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Wrought Products Except Forgings and Forging Stock
- AMS 2372 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Forgings and Forging Stock
- AMS 2375 - Control of Forgings Requiring First-Article Approval

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2.1.1 (Continued):

AMS 2806 - Identification, Bars, Wire, Mechanical Tubing, and Extrusions,
Carbon and Alloy Steels and Heat and Corrosion Resistant
Steels and Alloys

AMS 2808 - Identification, Forgings

2.1.2 Aerospace Standards:

AS 1182 - Standard Machining Allowance, Aircraft Quality and Premium
Quality Steel Products

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

ASTM A255 - End-Quench Test for Hardenability of Steel

ASTM A370 - Mechanical Testing of Steel Products

ASTM E112 - Determining Average Grain Size

ASTM E350 - Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon
Electrical Steel, Ingot Iron, and Wrought Iron

ASTM E381 - Macroetch Testing, Inspection, and Rating Steel Products,
Comprising Bars, Billets, Blooms, and Forgings

2.3 U.S. Government Publications: Available from Commanding Officer, Naval
Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.2.3.1 Military Standards:

MIL-STD-163 - Steel Mill Products, Preparation for Shipment and Storage

3. TECHNICAL REQUIREMENTS3.1 Composition: Shall conform to the following percentages by weight,
determined by wet chemical methods in accordance with ASTM E350 or by
spectrographic or other analytical methods approved by purchaser:

	min	max
Carbon	0.17	0.22
Manganese	0.45	0.65
Silicon	0.15	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Nickel	1.65	2.00
Molybdenum	0.20	0.30
Chromium	--	0.20
Copper	--	0.35

3.1.1 Check Analysis: Composition variations shall meet the applicable
requirements of AMS 2259.3.2 Condition: The product shall be supplied in the following condition;
hardness and tensile strength shall be determined in accordance with
ASTM A370:

3.2.1 Bars:

3.2.1.1 Bars 0.500 In. (12.50 mm) and Under in Nominal Diameter or Distance Between Parallel Sides: Cold finished having tensile strength not higher than 130,000 psi (895 MPa) or equivalent hardness.

3.2.1.2 Bars Over 0.500 In. (12.50 mm) in Nominal Diameter or Distance Between Parallel Sides: Hot finished having hardness not higher than 229 HB or equivalent except that bars ordered cold finished may have hardness as high as 241 HB or equivalent.

3.2.2 Forgings: As ordered.

3.2.3 Forging Stock: As ordered by the forging manufacturer.

3.3 Properties: The product shall conform to the following requirements; hardness testing shall be performed in accordance with ASTM A370:

3.3.1 Macrostructure: Visual examination of transverse sections as in 4.3.3 from bars, billets, and forging stock, etched in accordance with ASTM E381 in hot hydrochloric acid (1:1) at 160° - 180°F (70° - 80°C) for sufficient time to develop a well-defined macrostructure, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the following macrographs of ASTM E381:

Section Size		Macrographs
Square Inches	Square Centimetres	
Up to 36, incl	Up to 230, incl	S2 - R1 - C2
Over 36 to 100, incl	Over 230 to 645, incl	S2 - R2 - C3
Over 100	Over 645	As agreed upon

3.3.2 Grain Size: Predominantly 5 or finer with occasional grains as large as 3 permissible, determined in accordance with ASTM E112.

3.3.3 Hardenability: Shall be J48=1 max and J27=3 min, determined on the standard end-quench test specimen in accordance with ASTM A255 except that the steel shall be normalized at 1700°F ± 10 (925°C ± 5) and the test specimen austenitized at 1700°F ± 10 (925°C ± 5). The hardenability test is not required on a product which will not yield a suitable specimen but the steel from which the product is made shall conform to the hardenability specified.

3.4 Quality:

3.4.1 Steel shall be aircraft quality conforming to AMS 2301.

3.4.2 The product, 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 product.

3.4.2.1 Bars ordered ground, turned, or polished shall be free from seams, laps, tears, and cracks open to the ground, turned, or polished surfaces.

3.4.2.2 Product ordered to surface conditions other than ground, turned, or polished shall, after removal of the standard machining allowance, be free from seams, laps, tears, cracks, and other defects exposed to the machined surfaces. Standard machining allowance shall be in accordance with AS 1182.

3.5 Sizes: Except when exact lengths or multiples of exact lengths are ordered, straight bars will be acceptable in mill lengths of 6 - 20 ft (2 - 6 m) but not more than 10% of any shipment shall be supplied in lengths shorter than 10 ft (3 m).

3.6 Tolerances: Bars shall conform to all applicable requirements of AMS 2251 or Ø MAM 2251.

4 . QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of the product shall supply all Ø samples for vendor's tests and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.5. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests to determine conformance to all technical requirements of this specification are classified as acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Preproduction Tests: Tests of forgings to determine conformance to all Ø applicable technical requirements of this specification when AMS 2375 is specified are classified as preproduction tests and shall be performed on the first-article shipment of a forging to a purchaser, when a change in material, processing, or both requires reapproval as in 4.4, and when purchaser deems confirmatory testing to be required.

4.2.2.1 For direct U.S. Military procurement of forgings, substantiating test data and, when requested, preproduction forgings shall be submitted to the cognizant agency as directed by the procuring activity, the contracting officer, or the request for procurement.

4.3 Sampling: Shall be in accordance with the following:

4.3.1 Bars: AMS 2370.

4.3.2 Forgings and Forging Stock: AMS 2372.

4.3.3 Samples for macrostructure (3.3.1) rating shall be full cross-sectional specimens obtained from the finished billet or suitable rerolled product representing the top and bottom of at least the first, middle, and last usable ingots of each heat.