INCH-POUND

NOTICE
OF VALIDATION

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SUPERSEDING
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SOCIETY OF AUTOMOTIVE ENGINEERS

AEROSPACE MATERIAL SPECIFICATION

STEEL CASTINGS, INVESTMENT, CORROSION AND MODERATE HEAT RESISTANT 13Cr – 2.0Ni – 3.0W HARDENED AND TEMPERED

AMS 5354D dated 1 October 1982 with Acceptance Notice dated 1 September 1983 has been reviewed and determined to be valid for use in acquisition.

Custodians:
Army – MR
Navy – AS
Air Force – 11

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Air Force – 11

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AEROSPACE MATERIAL SPECIFICATION

AMS 5354D
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STEEL CASTINGS, INVESTMENT, CORROSION AND MODERATE HEAT RESISTANT 13Cr - 2.0Ni - 3.0W Hardened and Tempered

1. SCOPE:

1.1 Form: This specification covers a corrosion and moderate heat resistant steel in the form of investment castings.

1.2 Application: Primarily for parts, such as compressor blades and vanes, housings, and valves, for use up to 1000°F (540°C). Strength and resistance to tempering at the higher temperatures are greater than those of AMS 5350; ductility is better than that of AMS 5352 but with some sacrifice of attainable hardness.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) 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 2350 - Standards and Test Methods
AMS 2635 - Radiographic Inspection
AMS 2640 - Magnetic Particle Inspection
AMS 2645 - Fluorescent Penetrant Inspection
AMS 2694 - Repair Welding of Aerospace Castings
AMS 2804 - Identification, Castings

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

ASTM A370 - Mechanical Testing of Steel Products
ASTM E192 - Reference Radiographs of Investment Steel Castings for Aerospace Applications
ASTM E353 - Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

2.3 U.S. Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.3.1 Federal Standards:

Federal Test Method Standard No. 151 - Metals; Test Methods

2.3.2 Military Standards:

MIL-STD-794 - Parts and Equipment, Procedures for Packaging and Packing of

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E353, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other analytical methods approved by purchaser:

	min	max
Carbon	0.15	0.20
Manganese	--	1.00
Silicon	--	1.00
Phosphorus	--	0.04
Sulfur	--	0.03
Chromium	12.00	14.00
Nickel	1.80	2.20
Tungsten	2.50	3.50
Molybdenum	--	0.50
Copper	--	0.50

3.2 Condition: Hardened (air cooled from the austenitizing temperature) and tempered, having hardness not higher than 33 HRC or equivalent, determined in accordance with ASTM A370.

3.3 Casting: Castings shall be poured either from remelted metal from a master heat or directly from a master heat. In either case, metal for casting shall be qualified as in 3.4.

3.3.1 A master heat is refined metal of a single furnace charge or is metal blended as in 3.3.2. Gates, sprues, risers, and rejected castings shall be used only in preparation of master heats; they shall not be remelted directly without, refining, for pouring of castings.

3.3.2 Unless prohibited by purchaser, metal from two or more master heats may be blended provided that the composition of each master heat to be blended is within the limits of 3.1 and that the total weight of metal blended does not exceed 10,000 lb (4500 kg). Ingot and pig may be blended together, shot may be blended, but shot shall not be blended with ingot or pig. When two or more master heats are blended, the resultant blend shall be considered a master heat.

3.4 Master Heat Qualification: Each master heat shall be qualified by evaluation of chemical analysis and tensile specimens conforming to 3.4.1 and 3.4.2 respectively. A master heat may be considered conditionally qualified if vendor's test results show conformance to all applicable requirements of this specification. However, except when purchaser waives confirmatory testing, final qualification shall be based on purchaser's test results. Conditional qualification of a master heat shall not be construed as a guarantee of acceptance of castings poured therefrom.

3.4.1 Chemical Analysis Specimens: Shall be of any convenient size, shape, and form for vendor's tests. When chemical analysis specimens are required by purchaser, specimens shall be cast to a size, shape, and form agreed upon by purchaser and vendor.

3.4.2 Tensile Specimens: Shall be cast from remelted metal from each master heat except when castings are poured directly from a master heat, in which case specimens shall also be poured directly from the master heat. Specimens shall be of standard proportions in accordance with ASTM A370 with 0.250 in. (6.25 mm) diameter at the reduced parallel gage section. They shall be cast to size or shall be cast oversize and subsequently machined to 0.250 in. (6.25 mm) diameter. Center gating may be used.

3.5 Properties: Castings and representative tensile specimens produced in accordance with 3.4.2 shall conform to the following requirements; hardness and tensile testing shall be performed in accordance with ASTM A370:

3.5.1 Response to Heat Treatment:

3.5.1.1 Attainable Hardness: Castings and representative tensile specimens shall have hardness not lower than 45 HRC or equivalent after being heated to 1750°F ± 25 (955°C ± 15), held at heat for 60 min. ± 5 per inch (25 mm) of maximum section thickness, and cooled in still air.

3.5.1.2 Properties After Tempering: Casting and representative tensile specimens shall meet the following requirements after being rehardened as in 3.5.1.1 and tempered at 1075°F ± 10 (580°C ± 5) for 2 - 2-1/4 hr, and cooled in air:

3.5.1.2.1 Tensile Properties:

Tensile Strength, min	145,000 psi (1000 MPa)
Yield Strength at 0.2% Offset, min	115,000 psi (795 MPa)
Elongation in 4D, min	10%

3.5.1.2.2 Hardness: 32 - 38 HRC or equivalent.

3.6 Quality:

3.6.1 Castings, as received by purchaser, shall be uniform in quality and Ø condition, sound, and free from foreign materials and from internal and external imperfections detrimental to usage of the castings.

3.6.1.1 Castings shall have smooth surfaces and shall be well cleaned. Metallic shot or grit shall not be used for final cleaning, unless otherwise permitted.

3.6.2 Castings shall be produced under radiographic control, unless otherwise specified. This control shall consist of radiographic examination of castings in accordance with AMS 2635 until proper foundry technique, which will produce castings free from harmful internal imperfections, is established for each part number and of production castings as necessary to ensure maintenance of satisfactory quality.

3.6.3 When specified, castings shall be subjected to magnetic particle inspection in accordance with AMS 2640 and/or to fluorescent penetrant inspection in accordance with AMS 2645.

3.6.4 Radiographic, magnetic particle, fluorescent penetrant, and other quality Ø standards shall be as agreed upon by purchaser and vendor. ASTM E192 may be used to define radiographic acceptance standards.

3.6.5 Castings shall not be repaired by peening, plugging, welding, or other methods without written permission from purchaser.

3.6.5.1 When permitted in writing by purchaser, defects in castings may be Ø removed and the castings repaired by welding in accordance with AMS 2694.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of castings 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 castings conform to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests to determine conformance to requirements for composition (3.1), condition (3.2), attainable hardness (3.5.1.1), and quality (3.6) are classified as acceptance tests and shall be performed on each master heat or lot as applicable.

4.2.2 Periodic Tests: Tests to determine conformance to requirements for properties after tempering (3.5.1.2) are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

4.2.2.1 Tensile properties of separately-cast specimens shall be determined only when specified by purchaser or when specimens cut from castings are not available. Tensile properties of separately-cast specimens need not be determined when tensile properties of specimens cut from castings are determined.

4.2.3 Preproduction Tests: Tests to determine conformance to all technical requirements of this specification are classified as preproduction tests and shall be performed prior to or on the first-article shipment of a casting to a purchaser, when a change in material and/or processing requires reapproval as in 4.4.2, and when purchaser deems confirmatory testing to be required.

4.2.3.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material 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; a lot shall be all castings from a single master heat, heat treated as a batch, and presented for vendor's inspection at one time:

4.3.1 Two chemical analysis specimens in accordance with 3.4.1 and/or a casting from each master heat.

4.3.2 Three tensile specimens in accordance with 3.4.2 from each master heat, when requested.

4.3.3 Two preproduction castings in accordance with 4.4.1 of each part number.

4.3.4 One or more castings from each master heat when tensile properties of specimens machined from castings are required. Size, location, and number of specimens machined from castings shall be as specified on the drawing or as agreed upon by purchaser and vendor. When size, location, and number of specimens are not specified, not less than two tensile specimens, one from the thickest section and one from the thinnest section, shall be cut from a casting or castings from each master heat.

4.4 Approval:

4.4.1 Sample castings from new or reworked master patterns and the casting procedure shall be approved by purchaser before castings for production use are supplied, unless such approval be waived by purchaser.

4.4.2 Ø Vendor shall establish separately for tensile specimens used for master heat qualification and for production of sample castings of each part number parameters for the control factors of processing which will produce tensile specimens meeting master heat qualification requirements and acceptable castings; these shall constitute the approved casting procedures and shall be used for producing subsequent master heat qualification specimens and production castings. If necessary to make any change in parameters for the control factors of processing, vendor shall submit for reapproval a statement of the proposed changes in processing, and, when requested, sample test specimens, castings, or both. Production castings incorporating the revised operations shall not be shipped prior to receipt of reapproval.

4.4.2.1 Control factors for producing test specimens and castings include, but are not limited to the following:

Type of furnace and its capacity
Type and size of furnace charge
Time molten metal is in furnace
Furnace atmosphere
Ø Fluxing or deoxidation procedure
Number of ladles used in pour
Mold refractory formulation
Mold back-up material
Gating practices
Mold preheat and pouring temperatures (variations of ±25°F (±15°C) from established limits are permissible
Solidification and cooling procedures
Hardening and tempering heat treatment cycles
Cleaning operations
Methods of inspection

4.4.2.1.1 Any of the above control factors of processing for which parameters are considered proprietary by the vendor may be assigned a code designation. Each variation in such parameters shall be assigned a modified code designation.