

**AEROSPACE  
MATERIAL  
SPECIFICATION****AMS 6277F**

Issued	JUL 1963
Reaffirmed	FEB 2001
Revised	MAY 2006

Superseding AMS 6277E

Steel, Bars, forgings, and tubing  
0.50Cr - 0.55Ni - 0.20Mo (0.18 - 0.23C) (SAE 8620)  
Vacuum Arc or Electroslag Remelted

(Composition similar to UNS G86200)

**RATIONALE**

AMS 6277F is a Five Year Review and update of this specification.

**1. SCOPE****1.1 Form**

This specification covers a premium aircraft-quality, low-alloy steel in the form of bars, forgings, mechanical tubing, and forging stock.

**1.2 Application**

These products have been used typically for carburized parts requiring high minimum core hardness in sections 0.375 inch (9.52 mm) and under in nominal thickness, and which are subject to rigid magnetic particle standards, but usage is not limited to such applications. The core may or may not be machinable after hardening.

**1.3 Classification**

Steel covered by this specification is classified by melting practice as follows:

Type 1 Multiple melted using electroslag (ESR) remelting in the final melt cycle.

Type 2 Multiple melted using consumable electrode vacuum arc (VAR) remelting in the final melt cycle.

**1.3.1 Unless a specific type is ordered, either type may be supplied.****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.

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## 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), or [www.sae.org](http://www.sae.org).

AMS 2251	Tolerances, Low-Alloy Steel Bars
AMS 2253	Tolerances, Carbon and Alloy Steel Tubing
AMS 2259	Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels
AMS 2300	Steel Cleanliness, Premium Aircraft-Quality, Magnetic Particle Inspection Procedure
AMS 2370	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Wrought Products and Forging Stock
AMS 2372	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel forgings
AMS 2806	Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat Resistant-Steels and Alloys
AMS 2808	Identification, forgings
AS1182	Standard Machining Allowance, Aircraft-Quality and Premium Aircraft-Quality Steel Bars and Mechanical Tubing

## 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, or [www.astm.org](http://www.astm.org).

ASTM A 255	Determining Hardenability of Steel
ASTM A 370	Mechanical Testing of Steel Products
ASTM A 604	Macroetch Testing of Consumable Electrode Remelted Steel Bars and Billets
ASTM E 112	Determining Average Grain Size
ASTM E 350	Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

## 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	0.18	0.23
Manganese	0.70	1.00
Silicon	0.15	0.35
Phosphorus	--	0.012
Sulfur	--	0.010
Chromium	0.40	0.60
Nickel	0.40	0.70
Molybdenum	0.15	0.25
Copper	--	0.35

#### 3.1.1 Check Analysis

Composition variations shall meet the applicable requirements of AMS 2259.

#### 3.2 Melting Practice

Steel shall be multiple melted using either electroslag or consumable electrode vacuum arc practice for the remelt cycle.

### 3.3 Condition

The product shall be supplied in the following condition; hardness and tensile strength shall be determined in accordance with ASTM A 370:

#### 3.3.1 Bars

##### 3.3.1.1 Bars 0.500 Inch (12.70 mm) and Under in Nominal Diameter or Least Distance Between Parallel Sides

Cold finished having tensile strength not higher than 125 ksi (862 MPa) or equivalent hardness (See 8.2).

##### 3.3.1.2 Bars Over 0.500 Inch (12.70 mm) in Nominal Diameter or Least Distance Between Parallel Sides

Hot finished and annealed having hardness not higher than 229 HB, or equivalent (See 8.3). Bars ordered cold finished may have hardness as high as 248 HB, or equivalent (See 8.3).

#### 3.3.2 forgings

As ordered.

#### 3.3.3 Mechanical Tubing

Cold finished, unless otherwise ordered, having hardness not higher than 25 HRC, or equivalent (See 8.3). Tubing ordered hot finished and annealed shall have hardness not higher than 99 HRB, or equivalent (See 8.3).

#### 3.3.4 Forging Stock

As ordered by the forging manufacturer.

### 3.4 Properties

The product shall conform to the following requirements; hardness testing shall be performed in accordance with ASTM A 370:

#### 3.4.1 Macrostructure

Visual examination of transverse full cross-sections from bars, billets, tube rounds, and forging stock, etched in hot hydrochloric acid in accordance with ASTM A 604, shall show no pipe or cracks. Except as specified in 3.4.1.1, porosity, segregation, inclusions, and other imperfections for product 36 square inches ( $232 \text{ cm}^2$ ) and under in cross-sectional area shall be no worse than the macrographs of ASTM A 604 shown in Table 2.

TABLE 2 - MACROSTRUCTURE LIMITS

Class	Condition	Severity
1	Freckles	A
2	White spots	A
3	Radial segregation	B
4	Ring pattern	B

3.4.1.1 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.

#### 3.4.2 Average Grain Size

Shall be ASTM No. 5 or finer, determined in accordance with ASTM E 112.

### 3.4.3 Hardenability

Shall be J 1/16 inch (1.6 mm) = 48 HRC maximum and J 3/16 inch (4.8 mm) = 32 HRC minimum (See 8.4), determined on the standard end-quench test specimen in accordance with ASTM A 255 except that the steel shall be normalized at 1700 °F ± 10 (927 °C ± 6) and the test specimen austenitized 1700 F ± 10 (927 C ± 6).

## 3.5 Quality

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.

3.5.1 Steel shall be premium aircraft-quality conforming to AMS 2300.

3.5.2 Bars and 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 surface.

3.5.3 Grain flow of die forgings, except in areas that contain flash line end grain, shall follow the general contour of the forgings showing no evidence of reentrant grain flow.

## 3.6 Tolerances

Shall be as follows:

3.6.1 Bars

In accordance with AMS 2251.

3.6.2 Mechanical Tubing

In accordance with AMS 2253.

## 4. QUALITY ASSURANCE PROVISIONS

### 4.1 Responsibility for Inspection

The vendor of the product 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 product conforms to specified requirements.

### 4.2 Classification of Tests

#### 4.2.1 Acceptance Tests

Composition (3.1), condition (3.3) macrostructure (3.4.1), average grain size (3.4.2), hardenability (3.4.3), and tolerances (3.6) are acceptance tests and shall be performed on each heat or lot as applicable

#### 4.2.2 Periodic Tests

Frequency-severity cleanliness rating (3.5.1) and grain flow of die forgings (3.5.3) are periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.