SAE Aerospace
An SAE International Group

AEROSPACE MATERIAL SPECIFICATION

SAE AMS 6442G

Issued	JUL 1948
Revised	APR 1987
Noncurrent	FEB 1998
Cancelled	SEP 2003

Superseding AMS 6442F

Steel Bars and Forgings
0.50Cr (0.98 - 1.10C) (SAE 50100)
For Bearing Applications

G50986

CANCELLATION NOTICE

This specification has been declared “CANCELLED” by the Aerospace Materials Division, SAE, as of September, 2003. By this action, this document will remain listed in the numerical section of the Index of Aerospace Materials Specifications.

Similar, but not necessarily identical products, are covered by the following specifications:

AMS 6440 Steel, Bars, Forgings, and Tubing, 1.45Cr (0.98 - 1.10C) for Bearing Applications

AMS 6444 Steel, Bars, Forgings, and Tubing, 1.45Cr (0.98 - 1.10C) Premium Aircraft-Quality, Consumable Vacuum Electrode Melted

TO PLACE A DOCUMENT ORDER: **Tel: 877-606-7323 (inside USA and Canada)**
Tel: 724-776-4970 (outside USA)
Fax: 724-776-0790
Email: custsvc@sae.org
SAE WEB ADDRESS: **http://www.sae.org**

1. SCOPE:

1.1 Form:

This specification covers a low-alloy steel in the form of bars, forgings, and forging stock.

1.2 Application:

Primarily for parts of small cross-section, such as needle bearings, requiring a through hardening steel usually with hardness of approximately 60 HRC and subject to very rigid inspection standards.

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications 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 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
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

2.2 ASTM Publications:

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

ASTM A370	Mechanical Testing of Steel Products
ASTM E45	Determining the Inclusion Content of Steels
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 REQUIREMENTS:

3.1 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	0.98	1.10
Manganese	0.25	0.45
Silicon	0.15	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	0.40	0.60
Nickel	--	0.25
Molybdenum	--	0.06
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 AMS 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, with microstructure of spheroidized cementite in ferrite matrix, having tensile strength not higher than 120,000 psi (825 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 and annealed, with microstructure of spheroidized cementite in ferrite matrix, having hardness not higher than 207 HB, or equivalent, except that bars ordered cold finished may have hardness as high as 248 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 Inclusion Rating: Shall be as follows:

3.3.1.1 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 macrographs of ASTM E381 agreed upon by purchaser and vendor.

3.3.1.2 Micro-Inclusion Rating: At least one specimen as in 4.3.4 from each ingot tested, as well as two-thirds of the total number of specimens and the average of all specimens, shall not exceed the following limits, determined in accordance with ASTM E45, Method A:

	Inclusion Rating	Inclusion Rating	Inclusion Rating	Inclusion Rating
Type	A	B	C	D
Thin	2.0	2.0	2.0	1.5
Heavy	1.5	1.5	1.5	1.5

3.3.2 Response to Heat Treatment: Specimens as in 4.3.5, protected by suitable means or treated in a neutral atmosphere to minimize scaling and prevent either carburization or decarburization, shall have substantially uniform hardness not lower than 60 HRC at any point below any permissible decarburization after being placed in a furnace which is at 1525°F ± 10 (830°C ± 5), allowed to heat to 1525°F ± 10 (830°C ± 5), held at heat for 20 min. ± 2, and quenched in commercial paraffin oil (100 SUS at 100°F (38°C)) at room temperature.

3.3.3 Decarburization:

3.3.3.1 Bars ordered ground, turned, or polished shall be free from decarburization on the ground, turned, or polished surfaces.

3.3.3.2 Allowable decarburization of bars and billets ordered for redrawing or forging or to specified microstructural requirements other than spheroidized cementite in ferrite matrix shall be as agreed upon by purchaser and vendor.

3.3.3.3 Decarburization of bars for anti-friction balls and rollers to which 3.3.3.1 or 3.3.3.2 is not applicable shall be not greater than shown in Table 1.

TABLE 1

Nominal Diameter or Distance Between Parallel Sides Inch	Depth of Decarburization Inch Hot Finished	Depth of Decarburization Inch Cold Finished
Up to 0.250, incl	0.005	0.003
Over 0.250 to 0.500, incl	0.006	0.004
Over 0.500 to 0.750, incl	0.008	0.006
Over 0.750 to 1.000, incl	0.010	0.008

TABLE 1 (SI)

Nominal Diameter or Distance Between Parallel Sides Millimetres	Depth of Decarburization Millimetres Hot Finished	Depth of Decarburization Millimetres Cold Finished
Up to 6.25, incl	0.12	0.08
Over 6.25 to 12.50, incl	0.15	0.10
Over 12.50 to 18.75, incl	0.20	0.15
Over 18.75 to 25.00, incl	0.25	0.20

3.3.3.4 Decarburization of bars to which 3.3.3.1, 3.3.3.2, or 3.3.3.3 is not applicable shall be not greater than shown in Table 2.

TABLE 2

Nominal Diameter or Distance Between Parallel Sides Inches	Depth of Decarburization Inch Hot Finished	Depth of Decarburization Inch Annealed	Depth of Decarburization Inch Cold Finished
Up to 1.000, incl	0.012	0.015	0.012
Over 1.000 to 2.000, incl	0.017	0.022	0.015
Over 2.000 to 3.000, incl	0.025	0.030	0.025
Over 3.000 to 4.000, incl	0.035	0.045	0.035
Over 4.000 to 5.000, incl	0.055	0.065	0.055

TABLE 2 (SI)

Nominal Diameter or Distance Between Parallel Sides Millimetres	Depth of Decarburization Millimetres Hot Finished	Depth of Decarburization Millimetres Annealed	Depth of Decarburization Millimetres Cold Finished
Up to 25.00, incl	0.30	0.38	0.30
Over 25.00 to 50.00, incl	0.42	0.55	0.38
Over 50.00 to 75.00, incl	0.62	0.75	0.62
Over 75.00 to 100.00, incl	0.88	1.12	0.88
Over 100.00 to 125.00, incl	1.38	1.62	1.38

3.3.3.5 Limits for depth of decarburization of bars over 5.000 in. (125.00 mm) in nominal diameter or distance between parallel sides shall be as agreed upon by purchaser and vendor.

3.3.3.6 Decarburization shall be measured by the microscopic method or by Rockwell Superficial 30-N 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 any decarburization or lack of decarburization thereon.

3.3.3.6.1 When determining the depth of decarburization, it is permissible to disregard local areas provided the decarburization of such areas does not exceed the above limits by more than 0.005 in. (0.12 mm) and the width is 0.065 in. (1.65 mm) or less.

3.4 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.

3.4.1 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 Bars 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 equal to, but not in addition to, the decarburization limits of 3.3.3 for the condition of bars ordered.

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 MAM 2251.

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 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 applicable technical requirements of this specification when AMS 2375 is specified are classified as preproduction tests and shall be performed prior to or 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, contracting officer, or 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 (3.3.1.1) testing 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 ingot of each heat.

4.3.4 Samples for micro-inclusion rating (3.3.1.2) shall consist of not less than six specimens from each heat selected so that the surface examined will be approximately parallel to the direction of rolling. The method of selection of specimens shall be such that a representative rating is ensured.

4.3.5 Samples for response to heat treatment (3.3.2) shall be the full cross-section of the bar ground on both faces normal to the axis so that length is 0.50 in. ± 0.010 (12.5 mm ± 0.25).

4.4 Approval:

When specified, approval and control of forgings shall be in accordance with AMS 2375.

4.5 Reports:

4.5.1 The vendor of bars and forgings shall furnish with each shipment a report showing the results of tests for chemical composition and inclusion rating of each heat and for response to heat treatment of each lot. This report shall include the purchase order number, heat number, AMS 6442G, size, and quantity. If forgings are supplied, the part number and the size and melt source of stock used to make the forgings shall also be included.

4.5.2 The vendor of forging stock shall furnish with each shipment a report showing the results of tests for chemical composition of each heat. This report shall include the purchase order number, heat number, AMS 6442G, size, and quantity.

4.5.3 The vendor of finished or semi-finished parts shall furnish with each shipment a report showing the purchase order number, AMS 6442G, contractor or other direct supplier of material, part number, and quantity. When material for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of material to determine conformance to the requirements of this specification and shall include in the report either a statement that the material conforms or copies of laboratory reports showing the results of tests to determine conformance.

4.6 Resampling and Retesting:

Shall be in accordance with the following:

4.6.1 Bars: AMS 2370.

4.6.2 Forgings and Forging Stock: AMS 2372.

5. PREPARATION FOR DELIVERY:

5.1 Identification:

The product shall be identified as follows:

5.1.1 Bars: In accordance with AMS 2806.

5.1.2 Forgings: In accordance with AMS 2808.