



# AEROSPACE MATERIAL SPECIFICATION

**AMS6250™****REV. N**Issued 1939-12  
Revised 2020-10

Superseding AMS6250M

Steel Bars, Forgings, and Tubing  
1.5Cr - 3.5Ni (0.07 - 0.13 C) (3310)  
(Composition similar to UNS K44910)

## RATIONALE

AMS6250N results from a Five-Year Review and update of this specification that revises analytical methods (3.1), macrostructure (3.3.1.2) and hardenability (3.3.3), prohibits unauthorized exceptions (3.6), and revises quality (3.4.2), reporting, and marking (4.4.1, 4.4.4, 5.2.1, 8.7).

### 1. SCOPE

#### 1.1 Form

This specification covers an 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, including gears, that require high minimum core hardness with narrow range, but usage is not limited to such applications.

##### 1.2.1 The core is machinable after hardening.

### 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 +1 724-776-4970 (outside USA), [www.sae.org](http://www.sae.org).

AMS2251 Tolerances, Low-Alloy Steel Bars

AMS2253 Tolerances, Carbon and Alloy Steel Tubing

AMS2259 Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels

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SAE WEB ADDRESS:

**For more information on this standard, visit**  
<https://www.sae.org/standards/content/AMS6250N/>

AMS2301	Steel Cleanliness, Aircraft Quality, Magnetic Particle Inspection Procedure
AMS2370	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Wrought Products and Forging Stock
AMS2372	Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Forgings
AMS2806	Identification Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys
AMS2808	Identification Forgings
ARP1917	Clarification of Terms Used in Aerospace Metals Specifications
AS1182	Standard Stock Removal 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, [www.astm.org](http://www.astm.org).

ASTM A255	Determining Hardenability of Steel
ASTM A370	Mechanical Testing of Steel Products
ASTM A751	Standard Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products
ASTM E112	Determining Average Grain Size
ASTM E140	Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness
ASTM E381	Macroetch Testing, Inspection, and Rating Steel Products Comprising Bars, Billets, Blooms, and Forgings

## 3. TECHNICAL REQUIREMENTS

### 3.1 Composition

Shall conform to the percentages by weight shown in Table 1, determined in accordance with ASTM A751 or by other analytical methods acceptable to purchaser.

**Table 1 - Composition**

Element	Min	Max
Carbon	0.07	0.13
Manganese	0.40	0.70
Silicon	0.15	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	1.25	1.75
Nickel	3.25	3.75
Molybdenum	--	0.06
Copper	--	0.35

3.1.1 Aluminum, vanadium, and columbium are optional grain refining elements and need not be determined or reported unless used to satisfy the average grain size requirements of 3.3.2.2.

### 3.1.2 Check Analysis

Composition variations shall meet the applicable requirements of AMS2259.

### 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

Bar shall not be cut from plate.

##### 3.2.1.1 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 125.0 ksi (862 MPa), or equivalent hardness (see 8.3).

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

Hot finished and annealed or tempered, unless otherwise ordered, having hardness not higher than 229 HB, or equivalent (see 8.2). Bars ordered cold finished may have hardness as high as 248 HB, or equivalent (see 8.2).

#### 3.2.2 Forgings

As ordered.

#### 3.2.3 Mechanical Tubing

Cold finished, unless otherwise ordered, having hardness not higher than 25 HRC, or equivalent (see 8.2). Tubing ordered hot finished and annealed shall have hardness not higher than 99 HRB, or equivalent (see 8.2).

#### 3.2.4 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 full cross-sections from bars, billets, tube rounds, and forging stock, etched in hot hydrochloric acid in accordance with ASTM E381, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the macrographs of ASTM E381 shown in Table 2.

**Table 2 - Macrostructure limits**

Cross-Sectional Area Square Inches	Cross-Sectional Area Square Centimeters	Macrographs
Up to 36, incl	Up to 232, incl	S2 - R1 - C2
Over 36 to 133, incl	Over 232 to 858, incl	S2 - R2 - C3
Over 133	Over 858	Note 1

Note 1: Limits for larger sizes shall be agreed upon by the purchaser and producer. The purchaser shall have written approval of the agreement from the cognizant engineering organization.

3.3.1.1 If tubes are produced directly from ingots or large blooms, transverse sections may be taken from the tubes rather than tube rounds. Macroetch standards for such tubes shall be agreed upon by purchaser and producer.

3.3.1.2 Macrostructure examination is not required for bored/hollow forgings (including ring forgings) and tubings that are produced directly from ingots or blooms unless specified by the purchaser, in which case the purchaser shall specify standards to be used.

### 3.3.2 Average Grain Size of Bars, Forgings, and Tubing

Average grain size shall be determined by either 3.3.2.1 or 3.3.2.2.

3.3.2.1 Shall be ASTM No. 5 or finer, determined in accordance with ASTM E112.

3.3.2.2 The product of a heat shall be considered to have an ASTM No. 5 or finer austenitic grain size if one or more of the following are determined by heat analysis (see 8.5):

3.3.2.2.1 A total aluminum content of 0.020 to 0.050%.

3.3.2.2.2 An acid soluble aluminum content of 0.015 to 0.050%.

3.3.2.2.3 A vanadium content of 0.02 to 0.08%.

3.3.2.2.4 A columbium content of 0.02 to 0.05%.

### 3.3.3 Hardenability of Each Heat

Shall be J 1/16 inch (1.588 mm) = 41 HRC max and J 6/16 inch (9.525 mm) = 32 HRC 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 °F (927 °C ± 6 °C) and the test specimen austenitized at 1500 °F ± 10 °F (816 °C ± 6 °C). Cast specimen does not need to be normalized.

## 3.4 Quality

The product 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 Steel shall be aircraft-quality conforming to AMS2301.

3.4.2 Bars and mechanical tubing shall be free from seams, laps, tears, and cracks after removal of the standard stock removal allowance in accordance with AS1182.

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

## 3.5 Tolerances

### 3.5.1 Bars

In accordance with AMS2251.

### 3.5.2 Mechanical Tubing

In accordance with AMS2253.

## 3.6 Exceptions

Any exceptions shall be authorized by the purchaser and reported as in 4.4.4.

## 4. QUALITY ASSURANCE PROVISIONS

### 4.1 Responsibility for Inspection

The producer of the product shall supply all samples for producer'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 (3.2), macrostructure (3.3.1), average grain size (3.3.2), hardenability (3.3.3), frequency-severity cleanliness rating (3.4.1), and tolerances (3.5) are acceptance tests and shall be performed on each heat or lot as applicable. If grain refining elements (3.3.2.2) are not present, the ASTM E112 grain size test (3.3.2.1) shall be conducted on each lot.

#### 4.2.2 Periodic Tests

If grain refining elements (3.3.2.2) are present, the ASTM E112 grain size test (3.3.2.1) shall be conducted on a periodic basis and shall be performed at a frequency selected by the producer (not to exceed 1 year), unless frequency of testing is specified by purchaser. Grain flow of die forgings (3.4.3) is a periodic test and shall be performed at a frequency selected by the producer, unless frequency of testing is specified by purchaser.

### 4.3 Sampling and Testing

#### 4.3.1 Bars, Mechanical Tubing, and Forging Stock

In accordance with AMS2370.

#### 4.3.2 Forgings

In accordance with AMS2372.

### 4.4 Reports

4.4.1 The producer of bars, forgings, and tubing shall furnish with each shipment a report showing producer identity, country where the metal was melted (e.g., final melt in the case of metal processed by multiple melting operations), the results of tests for composition, macrostructure (except when not required per 3.3.1.2), hardenability and frequency-severity cleanliness rating of each heat and for condition, and, if measured, average grain size of each lot, and stating that the product conforms to the other technical requirements. This report shall include the purchase order number, heat and lot numbers, AMS6250N, product form and size (and/or part number, if applicable), and quantity. If forgings are supplied, the size and melt source of stock used to make the forgings shall also be included. If the grain size requirement of 3.3.2.2 is met by the aluminum, vanadium, and/or columbium content, the aluminum, vanadium, and/or columbium content shall be reported and a statement that the chemistry satisfies the grain size requirement shall be included.

4.4.2 Report the nominal metallurgically worked cross sectional size and the cut size, if different (see 3.2.1).

4.4.3 The producer of forging stock shall furnish with each shipment a report showing producer identity, country where the metal was melted (e.g., final melt in the case of metal processed by multiple melting operations), and the results of tests for composition, macrostructure, hardenability, and frequency-severity cleanliness rating and the results of additional property requirements imposed by the purchase order (see 8.7). This report shall include the purchase order number, heat number and lot numbers, AMS6250N, size, and quantity.