

Steel, Bars  
0.95Cr - 0.20Mo (0.28 - 0.33C) (SAE 4130)  
Special Aircraft Quality Cleanliness  
Normalized

(Composition similar to UNS G41300)

**RATIONALE**

AMS6528C results from a Five Year Review and update of this specification.

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

This specification covers a special aircraft-quality, low-alloy steel in the form of bars.

**1.2 Application**

These bars have been used typically for parts required to meet stringent magnetic inspection criteria, having sections 0.50 inch (12.7 mm) and under in nominal thickness at time of heat treatment, and requiring a through-hardening steel capable of developing hardness as high as 35 HRC when properly hardened and tempered, and also for parts of greater thickness but requiring proportionately lower hardness, but usage is not limited to such applications.

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

AMS2251 Tolerances, Low-Alloy Steel Bars

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

AMS2304 Steel Cleanliness, Special Aircraft-Quality, Magnetic Particle Inspection Procedure

AMS2370 Quality Assurance Sampling and Testing, Carbon and Low-Alloy Steel Wrought Products and Forging Stock

AMS2806 Identification, Bars, Wire, Mechanical Tubing, and Extrusions, Carbon and Alloy Steels and Corrosion and Heat-Resistant Steels and Alloys

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 A 255 Determining Hardenability of Steel

ASTM A 370 Mechanical Testing of Steel Products

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

ASTM E 381 Macroetch Testing Steel Bars, Billets, Blooms, and forgings

ASTM E 384 Knoop and Vickers Hardness of Materials

## 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	0.28	0.33
Manganese	0.40	0.60
Silicon	0.15	0.35
Phosphorus	--	0.015
Sulfur	--	0.008
Chromium	0.80	1.10
Molybdenum	0.15	0.25
Nickel	--	0.25
Copper	--	0.35

### 3.1.1 Check Analysis

Composition variations shall meet the applicable requirements of AMS2259.

### 3.2 Condition

Bar shall not be cut from plate. (Also see 4.4.2.)

3.2.1 Hot rolled and normalized at 1700 °F ± 25 (927 °C ± 14).

3.2.1.1 When specified, either a cold drawn or cold finished surface shall be supplied.

3.2.1.1.1 Cold finished surface shall be produced by turning, grinding, polishing, or burnishing, or combination thereof; surface hardness shall be not more than 3 points HRC harder than hardness at mid-radius, determined in accordance with ASTM A 370.

3.2.1.2 Cold finished surface may be supplied when cold drawn, hot rolled, or no surface condition is specified.

3.2.1.3 Cold drawn surface may be supplied when hot rolled or no surface condition is specified.

### 3.3 Properties

Bars shall conform to the following requirements; hardness testing shall conform to ASTM A 370:

#### 3.3.1 Macrostructure

Visual examination of transverse full cross-sections from bars and billets, etched in hot hydrochloric acid in accordance with ASTM E 381, shall show no pipe or cracks. Porosity, segregation, inclusions, and other imperfections shall be no worse than the macrographs of ASTM E 381 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 100, incl	Over 232 to 645, incl	S2 - R2 - C2
Over 100 to 133, incl	Over 645 to 858, incl	S2 - R2 - C3
Over 133	Over 858	Note 1

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

### 3.3.2 Average Grain Size

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

### 3.3.3 Hardenability of Each Heat

Shall be J5/16 inch (7.9 mm) = 34 HRC minimum and J8/16 inch (12.7 mm) = 27 HRC minimum, determined in accordance with ASTM A 255 except that the normalizing temperature shall be 1700 °F ± 10 (927 °C ± 6).

### 3.3.4 Decarburization

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

3.3.4.2 Allowable decarburization of bars and billets ordered for redrawing or to specified microstructural requirements shall be as agreed upon by purchaser and vendor.

3.3.4.3 Decarburization of bars to which 3.3.4.1 or 3.3.4.2 is not applicable shall be not greater than shown in Table 3.

TABLE 3A - MAXIMUM DEPTH OF DECARBURIZATION, INCH/POUND UNITS

Nominal Thickness or Distance Between Parallel Sides Inches	Total Depth of Decarburization Inch
Up to 0.375, incl	0.010
Over 0.375 to 0.500, incl	0.012
Over 0.500 to 0.625, incl	0.014
Over 0.625 to 1.000, incl	0.017
Over 1.000 to 1.500, incl	0.020
Over 1.500 to 2.000, incl	0.025
Over 2.000 to 2.500, incl	0.030
Over 2.500 to 3.000, incl	0.035
Over 3.000 to 4.000, incl	0.045

TABLE 3B - MAXIMUM DEPTH OF DECARBURIZATION, SI UNITS

Nominal Thickness or Distance Between Parallel Sides Millimeters	Total Depth of Decarburization Millimeters
Up to 9.52, incl	0.25
Over 9.52 to 12.70, incl	0.30
Over 12.70 to 15.88, incl	0.36
Over 15.88 to 25.40, incl	0.43
Over 25.40 to 38.10, incl	0.51
Over 38.10 to 50.80, incl	0.64
Over 50.80 to 63.50, incl	0.76
Over 63.50 to 76.20, incl	0.89
Over 76.20 to 101.60, incl	1.14

3.3.4.4 Decarburization shall be measured by the metallographic method, by the HR30N scale hardness testing method, or by a traverse method using microhardness testing in accordance with ASTM E 384. The hardness method(s) shall be conducted on a hardened but untempered specimen 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 on the adjacent surface. In case of dispute, the depth of decarburization determined using the microhardness traverse method shall govern.

3.3.4.4.1 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 inch (0.13 mm) and the width is 0.065 inch (1.65 mm) or less.

### 3.4 Quality

Bars, 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 bars.

3.4.1 Steel shall be special aircraft-quality conforming to AMS2304 (See 8.2).

3.4.2 Bars, ordered hot rolled or cold drawn, or ground, turned, or polished, shall, after removal of the standard stock removal allowance in accordance with AS1182, be free from seams, laps, tears, and cracks open to the ground, turned, or polished surface.

### 3.5 Tolerances

Shall conform to all applicable requirements of AMS2251.

## 4. QUALITY ASSURANCE PROVISIONS

### 4.1 Responsibility for Inspection

The vendor of bars 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 bars conform to specified requirements.

### 4.2 Classification of Tests

#### 4.2.1 Acceptance Tests

Composition (3.1), macrostructure (3.3.1), average grain size (3.3.2), hardenability (3.3.3), decarburization (3.3.4), 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.

#### 4.2.2 Periodic Tests

Cold finished surface hardness (3.2.1.1.1) is a periodic test and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

### 4.3 Sampling and Testing

Shall be in accordance with AMS2370 and the following: