

**AEROSPACE
MATERIAL
SPECIFICATION**

Submitted for recognition as an American National Standard

AMS 4055C

Issued 9-15-57
Revised 1-1-87

Superseding AMS 4055B

ALUMINUM ALLOY SHEET, CLAD TWO SIDES
0.6Mg - 0.35Si - 0.28Cu (No. 22-0 Brazing Sheet)
Annealed

This specification has been declared "NONCURRENT" by the Aerospace Materials Division, SAE, as of April 11, 1986. It is recommended that this specification not be specified for new designs.

This cover sheet should be attached to the "C" revision of the subject specification.

This specification is under the jurisdiction of AMS Committee "D".

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1. SCOPE:

- 1.1 Form: This specification covers an aluminum alloy in the form of sheet.
- 1.2 Application: Primarily for brazed assemblies which are subjected to heat treatment after joining.

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 2202 - Tolerances, Aluminum Alloy and Magnesium Alloy Sheet and Plate
MAM 2202 - Tolerances, Metric, Aluminum Alloy and Magnesium Alloy Sheet and Plate
AMS 2770 - Heat Treatment of Wrought Aluminum Alloy Parts
AMS 2350 - Standards and Test Methods
AMS 2355 - Quality Assurance Sampling and Testing of Aluminum Alloys and Magnesium Alloys, Wrought Products (Except Forging Stock) and Flash Welded Rings
MAM 2355 - Quality Assurance Sampling and Testing of Aluminum Alloys and Magnesium Alloys, Wrought Products (Except Forging Stock) and Flash Welded Rings, Metric (SI) Units

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

2.2.1 Military Specifications:

MIL-H-6088 - Heat Treatment of Aluminum Alloys

2.2.2 Military Standards:

MIL-STD-649 - Aluminum and Magnesium Products, Preparation for Shipment and Storage

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Shall conform to the following percentages by weight, determined in accordance with AMS 2355 or MAM 2355:

	Core (6951)			Cladding (4343)	
	min	max		min	max
Magnesium	0.40	0.8	Silicon	6.8	8.2
Silicon	0.20	0.50	Iron	--	0.8
Copper	0.15	0.40	Copper	--	0.25
Iron	--	0.8	Zinc	--	0.20
Zinc	--	0.20	Manganese	--	0.10
Manganese	--	0.10	Other Impurities, each	--	0.05
Other Impurities, each	--	0.05	Other Impurities, total	--	0.15
Other Impurities, total	--	0.15	Aluminum	remainder	
Aluminum	remainder				

3.2 Condition: Annealed.

3.3 Heat Treatment: Sheet shall be annealed by heating to $760^{\circ}\text{F} \pm 25$ ($405^{\circ}\text{C} \pm 15$), holding at heat for 2 - 3 hr, furnace cooling at 50 F (28 C) deg per hr to 500°F (260°C) or below, and air cooling. Furnace surveys and calibration of temperature controllers and recorders shall be in accordance with MIL-H-6088.

3.4 Cladding: Shall be applied to both faces of the core.

3.4.1 Cladding Thickness: After rolling, the average cladding thickness shall be as follows:

Total Thickness of Composite Product		Cladding Thickness per Side % of Total Thickness min avg
Inch	Millimetres	
0.010 to 0.091, excl	0.25 to 2.30, excl	8
0.091 to 0.249, incl	2.30 to 6.25, incl	4