

 <i>An SAE International Group</i>	AEROSPACE MATERIAL SPECIFICATION	SAE AMS-T-6845	REV. B
		Issued 1999-01 Noncurrent 2007-12 Stabilized 2013-07	
		Superseding AMS-T-6845A	
Tubing, Steel, Corrosion-Resistant (S30400), Aerospace Vehicle Hydraulic System 1/8 Hard Condition			

RATIONALE

AMS-T-6845B stabilizes this document because equivalent technical requirements are contained in AMS5566.

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AMS5566 Steel, Corrosion Resistant, Seamless or Welded Hydraulic Tubing 19Cr - 10Ni (304) High Pressure, Cold Drawn

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This document has been taken directly from U.S. Military Specification MIL-T-6845D, Notice 2 and contains only minor editorial and format changes required to bring it into conformance with the publishing requirements of SAE technical standards. The initial release of this document is intended to replace MIL-T-6845D, Notice 2. Any part numbers established by the original specification remain unchanged.

The original Military Specification was adopted as an SAE standard under the provisions of the SAE Technical Standards Board (TSB) Rules and Regulations (TSB 001) pertaining to accelerated adoption of government specifications and standards. TSB rules provide for (a) the publication of portions of unrevised government specifications and standards without consensus voting at the SAE Committee level, and (b) the use of the existing government specification or standard format.

Under Department of Defense policies and procedures, any qualification requirements and associated qualified products lists are mandatory for DOD contracts. Any requirement relating to qualified products lists (QPL's) has not been adopted by SAE and is not part of this SAE technical document.

1. SCOPE:

1.1 Scope:

This specification presents requirements for thin-walled (inside diameter greater than four times the wall thickness and outside diameter 1/4 inch and larger) corrosion-resistant steel tubing in approximately the 1/8 hard condition, of special quality, suitable for use in high-pressure hydraulic systems.

1.2 Classification:

Tubing shall be furnished in the following types and classes. Unless otherwise specified, either of the types and classes indicated may be furnished at the option of the contractor, provided that all material furnished on an individual order shall be of one type and class only.

Manufacturing process type

Type I - Seamless

Type II - Welded and drawn

Ultrasonic Class, Type II only

Class 1 - 0.125 Inch length ultrasonic calibration standard

Class 2 - 0.060 inch length ultrasonic calibration standard

Class 3 - Ultrasonic testing not required

2. APPLICABLE DOCUMENTS:

The following publications, of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2243 Tolerances - Corrosion and Heat Resistant Steel Tubing

2.2 U.S. Government Publications:

Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

QQ-P-35 Passivation Treatments for Corrosion-Resisting Steel

MIL-H-6875 Heat Treatment of Steels

FED-STD-151 Metals; Test Methods

FED-STD-183 Continuous Identification Marking of Iron and Steel Products

MIL-STD-129 Marking for Shipment and Storage

MIL-STD-163 Steel Mill Products Preparation for Shipment and Storage

MIL-STD-753 Corrosion-Resistant Steel Parts: Sampling, Inspection and Testing for Surface Passivation

MS33584 Tubing End, Standard Dimensions for Flared

AND10104 Tubing, Steel, Corrosion-Resistant, Round Standard Dimensions For

2.3 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM E 112 Estimating the Average Grain Size of Metals

ASTM A 370 Mechanical Testing of Steel Products

2.4 ANSI Publications:

Available from ANSI, 11 West 42nd Street, New York, NY 10036-8002.

ANSI B46.1 Determining Average Grain Size