



# AEROSPACE MATERIAL SPECIFICATION

**AMS5028™****REV. G**

Issued 1970-05  
Reaffirmed 2013-10  
Revised 2024-09

Superseding AMS5028F

Steel, Welding Wire  
1.05Cr - 0.55Ni - 1.0Mo - 0.07V (0.34 - 0.40C) (D6AC)  
Vacuum Melted, Environment-Controlled Packaging  
(Composition similar to UNS K23725)

## RATIONALE

AMS5028G is the result of a Five-Year Review and update of the specification. The revision updates composition testing and reporting (see 3.1 and 3.1.2), adds producer country or origin (see 4.4.1), and updates the exceptions requirements (see 8.6).

### 1. SCOPE

#### 1.1 Form

This specification covers a low-alloy steel in the form of welding wire.

#### 1.2 Application

This wire has been used typically as filler metal for gas-tungsten-arc and gas-metal-arc welding of heat-treatable steels of similar composition where the weld area is required to have strength comparable to that of the parent metal after heat treating, 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.

#### 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).

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

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

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**SAE WEB ADDRESS:**

**For more information on this standard, visit**  
<https://www.sae.org/standards/content/AMS5028G/>

AMS2813	Packaging and Marking of Packages of Welding Wire, Standard Method
AMS2814	Packaging and Marking of Packages of Welding Wire, Premium Quality
AMS2816	Identification, Welding Wire, Tab Marking Method
AMS2819	Identification, Welding Wire, Direct Color Code System
ARP1876	Weldability Test for Weld Filler Metal Wire
ARP4926	Alloy Verification and Chemical Composition Inspection of Welding Wire
AS7766	Terms Used in Aerospace Metals Specifications

## 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 A751 Chemical Analysis of Steel Products

ASTM D2650 Chemical Composition of Gases by Mass Spectrometry

## 2.3 Definitions

Terms used in AMS are defined in AS7766.

## 3. TECHNICAL REQUIREMENTS

### 3.1 Wire Composition

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 the purchaser.

**Table 1 - Composition**

Element	Min	Max
Carbon (see 3.1.1.1.1)	0.34	0.40
Manganese	0.60	0.90
Silicon	0.15	0.30
Phosphorus	--	0.008
Sulfur	--	0.008
Chromium	0.90	1.20
Nickel	0.40	0.70
Molybdenum	0.90	1.10
Vanadium	0.05	0.10
Copper	--	0.35
Hydrogen (see 3.1.1.1.1, 3.1.1.1.1.1)	--	0.0010 ( 10 ppm)
Oxygen (see 3.1.1.1)	--	0.0100 (100 ppm)
Nitrogen (see 3.1.1.1)	--	0.0050 ( 50 ppm)

3.1.1 Chemical analysis of initial ingot, bar, or rod stock before drawing is acceptable provided the processes used for drawing or rolling, annealing, and cleaning are controlled to ensure continued conformance to composition requirements.

3.1.1.1 Carbon, oxygen, nitrogen, and hydrogen shall also be determined periodically on finished wire (see 4.2.2).

3.1.1.1.1 The hydrogen content of the wire shall be determined at final diameter in accordance with ASTM D2650.

3.1.2 The producer may test for any element not listed in Table 1 and include this analysis in the report of 4.4. Reporting of any element not listed in the composition table is not a basis for rejection unless limits of acceptability are specified by the purchaser.

### 3.1.3 Check Analysis

Composition variations shall meet the applicable requirements of AMS2259. No variation over maximum is permitted for oxygen, nitrogen, and hydrogen.

### 3.2 Melting Practice

Steel shall be multiple melted using vacuum consumable electrode practice in the remelt cycle or shall be vacuum induction melted.

### 3.3 Condition

Wire shall be cold drawn, bright finish, in a temper and with a surface finish that will provide proper feeding of the wire in machine welding equipment.

### 3.4 Fabrication

3.4.1 Wire shall be formed from rod or bar descaled by a process that does not affect the composition of the wire.

3.4.2 In-process annealing, if required, between cold rolling or drawing operations shall be performed in vacuum or in protective atmosphere to avoid surface oxidation and absorption of other extraneous elements.

3.4.3 Butt welding is permissible provided both ends to be joined are alloy verified using a method or methods capable of distinguishing the alloy from all other alloys processed in the facility, or the repair is made at the wire processing station. The butt weld shall not interfere with uniform, uninterrupted feeding of the wire in machine welding.

3.4.4 Drawing compounds, oxides, dirt, oil, and other foreign materials shall be removed by cleaning processes that will neither result in pitting nor cause gas absorption by the wire or deposition of substances harmful to welding operations.

3.4.5 Residual elements and dissolved gases picked up during wire processing that can adversely affect the welding characteristics, the operation of the equipment, or the properties of the weld metal shall be removed.

### 3.5 Properties

Wire shall conform to the following requirements:

#### 3.5.1 Weldability

Melted wire shall flow smoothly and evenly during welding and shall produce acceptable welds. ARP1876 may be used to resolve disputes.

#### 3.5.2 Spooled Wire

Spooled wire shall conform to 3.5.2.1 and 3.5.2.2.

##### 3.5.2.1 Cast

Wire, wound on standard 12-inch (305-mm) diameter spools, shall have imparted to it a curvature such that a specimen sufficient in length to form one loop with a 1-inch (25-mm) overlap, when cut from the spool and laid on a flat surface, shall form a circle 15 to 50 inches (381 to 1270 mm) in diameter.

### 3.5.2.2 Helix

The specimen on which cast was determined, when laid on a flat surface and measured between adjacent turns, shall show a vertical separation not greater than 1 inch (25 mm).

## 3.6 Quality

Wire, as received by the purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to welding operations, operation of welding equipment, or properties of the deposited weld metal.

3.6.1 Surface irregularities inherent with a forming process that does not tear the wire surface are acceptable provided the wire conforms to the tolerances of 3.7.

## 3.7 Sizes and Tolerances

Wire shall be supplied in the sizes and to the tolerances shown in 3.7.1 and 3.7.2.

### 3.7.1 Diameter

Wire diameter shall be as shown in Table 2.

**Table 2A - Diameter tolerances, inch/pound units**

Form	Nominal Diameter Inch	Tolerance, Inch Plus and Minus
Cut Lengths	0.030, 0.045	0.001
Cut Lengths	0.052, 0.062, 0.078, 0.094, 0.125, 0.156, 0.188	0.002
Spools	0.007, 0.010, 0.015	0.0005
Spools	0.020, 0.030, 0.035, 0.045	0.001
Spools	0.062, 0.078, 0.094	0.002

**Table 2B - Diameter tolerances, SI units**

Form	Nominal Diameter Millimeters	Tolerance, Millimeter Plus and Minus
Cut Lengths	0.75, 1.15	0.025
Cut Lengths	1.32, 1.57, 1.98, 2.39, 3.18, 3.96, 4.78	0.05
Spools	0.18, 0.25, 0.38	0.013
Spools	0.51, 0.76, 0.89, 1.14	0.025
Spools	1.57, 1.98, 2.37	0.05

### 3.7.2 Length

Cut lengths shall be furnished in 18-, 27-, or 36-inch (457-, 686-, or 914-mm) lengths, as ordered, and shall not vary more than +0, -0.5 inch (+0, -13 mm) from the length ordered.

## 3.8 Exceptions

Any exceptions shall be authorized by the purchaser and reported as in 4.4.2.