

MAGNETIC ALLOY SHEET AND STRIP
50Ni - 50Fe
Stamping Quality

UNS K95000

1. SCOPE:

1.1 Form: This specification covers a magnetic nickel-iron alloy in the form of sheet and strip.

1.2 Application: Primarily for parts used in magnetic circuits requiring a high magnetic permeability and saturation induction after high temperature annealing in hydrogen.

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 2242 - Tolerances, Corrosion and Heat Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Sheet, Strip, and Plate

MAM 2242 - Tolerances, Metric, Corrosion and Heat Resistant Steel, Iron Alloy, Titanium, and Titanium Alloy Sheet, Strip, and Plate

AMS 2350 - Standards and Test Methods

AMS 2371 - Quality Assurance Sampling of Corrosion and Heat Resistant Steels and Alloys, Wrought Products Except Forgings and Forging Stock

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2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM A341 - Direct-Current Magnetic Properties of Materials Using D-C Permeameters and the Ballistic Test Methods

ASTM E18 - Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials

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

2.3.1 Military Standards:

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

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Shall be an alloy containing approximately 50% nickel and 50% iron with other alloying elements in such proportions as required to provide a product meeting the requirements of 3.3.

3.2 Condition: Cold rolled having a surface appearance comparable to the following commercial corrosion-resistant steel finishes as applicable:

3.2.1 Sheet: No. 2D finish

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3.2.2 Strip: No. 1 strip finish

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3.3 Properties: The product shall conform to the following requirements:

3.3.1 Hardness: Shall be not lower than 90 HRB, or equivalent, determined in accordance with ASTM E18.

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3.3.2 Magnetic Properties: Shall be as follows, determined in accordance with ASTM A341 on specimens as in 4.3.1 annealed by heating to $2150^{\circ}\text{F} \pm 25$ ($1175^{\circ}\text{C} + 15$) in a dry hydrogen atmosphere having a dew point of -60°F (-50°C) or lower, holding at heat for $4 \text{ hr} \pm 0.25$, and cooling in a non-oxidizing atmosphere at a rate not greater than 100°F (55°C) per hr to 1100°F (595°C) or lower unless another cooling rate is recommended by the alloy producer:

3.3.2.1 Maximum Permeability, min

Nominal Thickness		
Inch	Millimetres	
Up to 0.020, excl	Up to 0.50, excl	60,000
0.020 and over	0.50 and over	40,000

3.3.2.2 Permeability at 100 Gausses (0.001T), min

Nominal Thickness		
Inch	Millimetres	
Up to 0.020, excl 0.020 and over	Up to 0.50, excl 0.50 and over	8,000 6,000

3.3.2.3 Induction at 100 Oersteds (7960 A/m), min 15,000 gaussses (1.5T)

3.4 Quality: The product, 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 product.

3.5 Tolerances: Shall conform to all applicable requirements of AMS 2242 or MAM 2242.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of the product shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.4. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to the requirements of this specification.

4.2 Classification of Tests: Tests to determine conformance to all technical requirements of this specification are classified as acceptance tests and shall be performed on each heat or lot as applicable.

4.3 Sampling: Shall be in accordance with AMS 2371 and the following; a lot shall be all product of the same thickness from the same heat of alloy.

4.3.1 Samples for magnetic properties (3.3.2) testing shall be selected in accordance with either 4.3.1.1. or 4.3.1.2; the sampling method used shall be reported with the test results.

4.3.1.1 A pilot sample nominally 0.014 in. (0.35 mm) thick from each heat of alloy.

4.3.1.2 A sample taken at random from finished product from each lot.

4.4 Reports:

4.4.1 The vendor of the product shall furnish with each shipment a report showing the results of tests for hardness of each lot and for magnetic properties of each heat. This report shall include the purchase order number, heat number, AMS 7719A, cooling rate if other than 100°F (55°C) per hr and method of sampling and test specimen thickness used for magnetic properties, size, and quantity.

4.4.2 The vendor of finished or semi-finished parts shall furnish with each shipment a report showing the purchase order number, AMS 7719A, contractor or other direct supplier of material, part number, and quantity. When material for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of material to determine conformance to the requirements of this specification and shall include in the report either a statement that the material conforms or copies of laboratory reports showing the results of tests to determine conformance.

4.5 Resampling and Retesting: Shall be in accordance with AMS 2371.

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5. PREPARATION FOR DELIVERY:

5.1 Identification: The product shall be identified as in 5.1.1 unless purchaser permits a method from 5.1.2.

5.1.1 Each sheet and strip shall be marked on one face, in the respective location below, with AMS 7719A, heat number, manufacturer's identification, and nominal thickness. The characters shall be of such size as to be legible, shall be applied using a suitable marking fluid, and shall be removable in hot alkaline cleaning solution without rubbing. The marking shall have no deleterious effect on the product or its performance and shall be sufficiently stable to withstand normal handling.

5.1.1.1 Flat Strip 6 In. (150 mm) and Under in Width: Shall be marked in one or more lengthwise rows of characters recurring at intervals not greater than 3 ft (900 mm).

5.1.1.2 Flat Sheet and Flat Strip Over 6 In. (150 mm) in Width: Shall be marked in lengthwise rows of characters recurring at intervals not greater than 3 ft (900 mm), the rows being spaced not more than 6 in. (150 mm) apart and alternately staggered.

5.1.1.3 Coiled Sheet and Strip: Shall be marked near both the outside and inside ends of the coil; the markings shall be applied as in 5.1.1 or shall appear on a durable tag or label attached to the coil and marked with the information of 5.1.1. When the product is wound on cores, the tag or label may be attached to the core.

5.1.2 When purchaser permits, each sheet and strip may be marked near one end, coils being marked near the outside end, with AMS 7719A, heat number, manufacturer's identification, and nominal thickness, using any suitable marking fluid. As an alternate method, individual pieces and bundles shall have attached a durable tag marked with the above information or shall be boxed and the box marked with the same information.

5.2 Packaging:

5.2.1 The product shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the product to ensure carrier acceptance and safe delivery. Packaging shall conform to carrier rules and regulations applicable to the mode of transportation.

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