



# AEROSPACE MATERIAL SPECIFICATION

AMS4049™

REV. N

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Superseding AMS4049M

Aluminum Alloy, Sheet and Plate, Alclad  
5.6Zn - 2.5Mg - 1.6Cu - 0.23Cr (Alclad 7075; -T6 Sheet - T651 Plate)  
Solution and Precipitation Heat Treated  
(Composition similar to UNS A97075)

## RATIONALE

AMS4049N results from a Five-Year Review and update of this specification with changes to prohibit unauthorized exceptions (3.3.5, 3.6, 4.4.1, 5.1.1, 8.5), add provisions for usage of AS6279 (Section 2, 3.7), update applicable documents (Section 2, 8.2), elongation values to show 50.8 mm or 4D and add missing values within AMS guidance (Table 3B), and ordering information (8.6), and allow the use of the immediate prior specification revision (8.4).

## 1. SCOPE

### 1.1 Form

This specification covers an aluminum alloy in the form of sheet and plate with thickness from 0.008 to 4.000 inches (0.20 to 101.6 mm), inclusive, clad on two sides (see 8.6).

### 1.2 Application

These products have been used typically for structural use, including machined parts subject to excessive warpage during machining, but usage is not limited to such applications.

1.2.1 Certain design and processing procedures may cause these products to become susceptible to stress-corrosion cracking; ARP823 recommends practices to minimize such conditions.

## 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 +1 724-776-4970 (outside USA), [www.sae.org](http://www.sae.org).

AMS2355	Quality Assurance, Sampling and Testing, Aluminum Alloys and Magnesium Alloy, Wrought Products (Except Forging Stock), and Rolled, Forged, or Flash Welded Rings
AMS2772	Heat Treatment of Aluminum Alloy Raw Materials
ARP823	Minimizing Stress-Corrosion Cracking in Wrought Heat-Treatable Aluminum Alloy Products
AS6279	Standard Practice for Production, Distribution, and Procurement of Metal Stock
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 B594	Ultrasonic Inspection of Aluminum-Alloy Wrought Products
ASTM B660	Packaging/Packing of Aluminum and Magnesium Products
ASTM B666/B666M	Identification Marking of Aluminum and Magnesium Alloy Products

## 2.3 ANSI Accredited Publications

Copies of these documents are available online at <https://webstore.ansi.org/>.

ANSI H35.1/H35.1M	Alloy and Temper Designation Systems for Aluminum
ANSI H35.2	Dimensional Tolerances for Aluminum Mill Products
ANSI H35.2M	Dimensional Tolerances for Aluminum Mill Products (Metric)

## 3. TECHNICAL REQUIREMENTS

### 3.1 Composition

Shall conform to the percentages by weight shown in Tables 1 and 2, determined in accordance with AMS2355.

**Table 1 - Composition, core (7075)**

Element	Min	Max
Silicon	--	0.40
Iron	--	0.50
Copper	1.2	2.0
Manganese	--	0.30
Magnesium	2.1	2.9
Chromium	0.18	0.28
Zinc	5.1	6.1
Titanium	--	0.20
Other Elements, each	--	0.05
Other Elements, total	--	0.15
Aluminum	remainder	

**Table 2 - Composition, cladding (7072)**

Element	Min	Max
Silicon + Iron	--	0.7
Copper	--	0.10
Manganese	--	0.10
Magnesium	--	0.10
Zinc	0.8	1.3
Other Elements, each	--	0.05
Other Elements, total	--	0.15
Aluminum	remainder	

3.2 Product shall be supplied in the following condition; heat treatment shall be performed in accordance with AMS2772.

3.2.1 Sheet

Solution and precipitation heat treated to the T6 temper (refer to ANSI H35.1/H35.1M).

3.2.2 Plate

Solution heat treated, stretched to produce a nominal permanent set of 2%, but not less than 1-1/2%, nor more than 3%, and precipitation heat treated to the T651 temper (refer to ANSI H35.1/H35.1M).

3.2.2.1 Plate shall receive no further straightening operations after stretching.

3.3 Properties

3.3.1 The product shall conform to the following requirements, determined in accordance with AMS2355.

3.3.2 Tensile Properties

Shall be as shown in Table 3.

**Table 3A - Minimum tensile properties, inch/pound units**

Nominal Thickness Inches	Tensile Strength ksi	Yield Strength at 0.2% Offset ksi	Elongation in 2 Inches or 4D %
0.008 to 0.011, incl	68.0	58.0	5
Over 0.011 to 0.039, incl	71.0	61.0	8
Over 0.039 to 0.062, incl	72.0	62.0	9
Over 0.062 to 0.187, incl	74.0	64.0	9
Over 0.187 to 0.249, incl	76.0	65.0	9
Over 0.249 to 0.499, incl	75.0	65.0	9
Over 0.499 to 1.000, incl	78.0	68.0	7
Over 1.000 to 2.000, incl	77.0	67.0	6
Over 2.000 to 2.500, incl	76.0	64.0	5
Over 2.500 to 3.000, incl	72.0	61.0	5
Over 3.000 to 3.500, incl	71.0	58.0	5
Over 3.500 to 4.000, incl	67.0	54.0	3

**Table 3B - Minimum tensile properties, SI units**

Nominal Thickness Millimeters		Tensile Strength MPa	Yield Strength at 0.2% Offset MPa	Elongation % in 50.8 mm or 4D
0.20 to	0.28, incl	469	400	5
Over 0.28 to	0.99, incl	490	420	8
Over 0.99 to	1.57, incl	496	427	9
Over 1.57 to	4.75, incl	510	441	9
Over 4.75 to	6.32, incl	524	448	9
Over 6.32 to	12.67, incl	517	448	9
Over 12.67 to	25.40, incl	538	469	7
Over 25.40 to	50.80, incl	531	462	6
Over 50.80 to	63.50, incl	524	441	5
Over 63.50 to	76.20, incl	496	420	5
Over 76.20 to	88.90, incl	490	400	5
Over 88.90 to	101.60, incl	462	372	3

### 3.3.3 Bending

Product shall withstand, without cracking, bending at room temperature through an angle of 180 degrees around a diameter equal to the bend factor shown in Table 4 times the nominal thickness of the product with axis of bend parallel to the direction of rolling.

**Table 4 - Bending parameters**

Nominal Thickness Inches	Nominal Thickness Millimeters	Bend Factor
0.008 to 0.020, incl	0.20 to 0.51, incl	6
Over 0.020 to 0.063, incl	Over 0.51 to 1.60, incl	7
Over 0.063 to 0.091, incl	Over 1.60 to 2.31, incl	8
Over 0.091 to 0.125, incl	Over 2.31 to 3.18, incl	9
Over 0.125 to 0.249, incl	Over 3.18 to 6.32, incl	10
Over 0.249 to 0.499, incl	Over 6.32 to 12.67, incl	12

### 3.3.4 Cladding Thickness

After rolling, the average cladding thickness per side shall be as shown in Table 5.

**Table 5 - Minimum average cladding thickness**

Total Thickness of Composite Product Inches	Total Thickness of Composite Product Millimeters	Average Cladding Thickness per Side % of Thickness Minimum	Average Cladding Thickness per Side % of Thickness Maximum
0.008 to 0.062, incl	0.20 to 1.57, incl	3.2	--
Over 0.062 to 0.187, incl	Over 1.57 to 4.75, incl	2.0	--
Over 0.187 to 0.499, incl	Over 4.75 to 12.67, incl	1.2	--
Over 0.499 to 4.000, incl	Over 12.67 to 101.60, incl	1.2	3.0

### 3.3.5 Mechanical property requirements for product outside the range covered by Table 3 shall be agreed upon between purchaser and producer and reported per 4.4.1.

### 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 plate.

3.4.1 When specified, each plate 0.500 inch (12.70 mm) and over in nominal thickness shall be ultrasonically inspected in accordance with ASTM B594 and shall meet the requirements of Table 6 as applicable.

**Table 6 - Ultrasonic class**

Nominal Thickness Inches	Nominal Thickness Millimeters	Ultrasonic Class
Over 0.500 to 1.500, excl	Over 12.70 to 38.10, excl	B
Over 1.500 to 3.000, incl	Over 38.10 to 76.20, incl	A
Over 3.000 to 4.000, incl	Over 76.20 to 101.60, incl	B

### 3.5 Tolerances

Shall conform to all applicable requirements of ANSI H35.2 or ANSI H35.2M.

### 3.6 Exceptions

Any exceptions shall be authorized by the purchaser and reported as in 4.4.1.

3.7 Production, distribution, and procurement of metal stock shall comply with AS6279. This requirement becomes effective 18 months after publication of AMS4049N.

## 4. QUALITY ASSURANCE PROVISIONS

### 4.1 Responsibility for Inspection

The producer of the product shall supply all samples for producer'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 product conforms to specified requirements.

### 4.2 Classification of Tests

#### 4.2.1 Acceptance Tests

Composition (3.1), tensile properties (3.3.1), and tolerances (3.5) and when specified UT inspection (3.4.1) are acceptance tests and, except for core composition, shall be performed on each inspection lot.

#### 4.2.2 Periodic Tests

Bending (3.3.2) and cladding thickness (3.3.3) are periodic tests and shall be performed at a frequency selected by the producer unless frequency of testing is specified by purchaser.

### 4.3 Sampling and Testing

Shall be in accordance with AMS2355.

### 4.4 Reports

The producer of the product shall furnish with each shipment a report stating that the product conforms to the composition requirements and tolerances and showing the numerical results of tests on each inspection lot to determine conformance to the other acceptance test requirements. This report shall include the purchase order number, inspection lot number, AMS4049N, size, and quantity. The report shall include the identity of the producer and the size of the mill product.