

SARA SAE ENGINEERING SPECIFICATION**Section: SES 26 – 756****Issue: "A"****Rev No: "1"****Eff. Date: 05.10.2019****Page : 1 of 4****8630, 75 KSI (517 MPA), FORGING/BARSTOCK,H2S COMPATIBLE**

Rev	Reason of Change	Date	Prepared By	Reviewed By	Approved By	Status
0		11.03.2013	KKM	USR	KKD	Released
1	Quenching media temperature requirements amended & clause 6.7 added as per API 6A 21 st edition.	05-10-2019	MN	USR	AS	Released



Summary: This specification covers 8630 MOD3 steel forgings or bar stock with minimum yield strength of 75 Ksi (517 Mpa). This material is compatible with H₂S service.

1.0 Scope:

This specification covers 8630 MOD3 steel forgings or forged bar stock with minimum yield strength of 75 KSI (517 MPa). This material is compatible with H₂S service. Note this material is typically not available for diameters less than 5 inch in diameter.

2.0 Referenced Specifications:

Document	Description
API 6A/ISO 10423	Specification for Wellhead and Christmas Tree Equipment.
NACE MR0175/ISO15156	Petroleum and natural gas industries – Materials for use in H ₂ S – containing environments in oil and gas production.

3.0 Chemistry Requirements:

The chemistry shall meet the requirements listed in Table 1.

Table 1: Chemical Requirements.
(All are maximums unless otherwise noted)

ELEMENT	COMPOSITION
CARBON (C)	0.25 - 0.33
MANGANESE (Mn).	0.70 – 1.10
CHROMIUM	0.85-1.00
MOLYBDENUM	0.35 – 0.45
NICKEL	0.75-0.90
SILICON (Si).	0.15- 0.35
PHOSPHORUS (P).	0.025
SULPHUR (S).	0.025
VANADIUM	0.06
Copper	0.25
Titanium	0.06
Aluminum	0.035

4.0 Mechanical Properties:

The material shall meet the mechanical requirements of table 2.

Table 2: Mechanical Properties. (All values are minimums unless otherwise noted)

MECHANICAL PROPERTIES	RANGE
Tensile Strength	95,000 psi (655 MPa)
Yield Strength	75,000 psi (517 MPa)
Elongation in 2", 4D	17 %
Reduction in Area	35%
Brinell Hardness (Raw)	207-237 BHN
Brinell Hardness (Finished Part)	197-237 BHN



5.0 Heat Treatment:

PROCESS	ATMOSPHERE / MEDIA	TEMPERATURE	TIME AT TEMPERATURE
Normalized	Air	1598° F – 1697° F (870° C – 925° C)	30 Minutes / Inch of T, minimum Time is 30 Minutes.

Still air cool to below 400° F (204° C) before further processing.

Austenitizing (Ref. Note 1 & 2)	Air	1562° F – 1652° F (850° C – 900° C)	30 Minutes / Inch of T, minimum Time is 30 Minutes.
Quench	Water	The temperature of quenching medium shall not exceed 100 °F (38 °C) at the start of the quench nor exceed 49°C (120°F) at any time during the quench cycle	
	Polymer	50°F (10°C) min before quenching (See note 3)	
	Oil	-----	

Quench baths shall permit complete immersion of material, provide for adequate circulation of the media or agitation of material, and provide a means for indicating the temperature of the media. Baths shall be adequate to produce the required properties in the most massive material quenched. There shall be at least one gallon of quenchant per pound of material quenched. Location of Quenching equipment – quenching equipment shall be located in such a manner and handling facilities shall function with sufficient speed to prevent the initiation of transformation or sensitization the heat treatment load exits the furnace.

Temper	Air / Water	1184 °F – 1328 °F (640 °C – 720 °C)	1 hour per inch of maximum through thickness. One hour minimum.
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Cooling after tempering shall be air cooling or faster (By Water). Furnace cooling is not permitted. For heavy cross sections, rapid cooling after tempering may improve impact properties. The minimum tempering temperatures must be met in all cases to ensure that later steps of manufacturing.

Note : Maximum holding time shall not exceed five times (5x) the minimum holding time. In all case, holding time shall not start until parts or materials have reached specified heat treatment temperature. The 5x rule does not apply to the separate QTC (e.g. ER 5").

Note 1: The short blasting shall be carried out after each process of heat treatment (normalizing, Austenitize & Tempering).

Note 2: The austenitizing temperature shall be less than the normalizing temperature.

Note 3: The minimum start temperature of 50 °F (10 °C) for oil and polymer Quenching shall be followed except when a lower minimum start temperature is permitted for a specific quenching by the quenchant manufacturer. The start temperature shall be documented for all products.



SARA SAE ENGINEERING SPECIFICATION	
Section: SES 26 – 756	
Issue: "A"	Rev No: "1"
Eff. Date: 05.10.2019	Page : 4 of 4

5.1 Continuous Furnace Heat Treatment: Continuous furnace heat treatment shall be an acceptable alternative to conventional batch-type heat treatment for bars with diameters of 8 inches (203 mm) or less. The following parameters shall be followed and reported in accordance with SES 26-590.

Minimum bar temperature exiting final zone of Austenitizing Furnace	1525 °F (829 °C)
Minimum time in Austenitizing Furnace	5 minutes (see Note 2.1.g.1)
Minimum bar temperature exiting final zone of temperature furnace	1150 °F (621 °C)
Minimum time in tempering furnace	5 minutes (see Note 2.1.g.1)
Temperature of quench water	120 °F (49 °C) max

Note 1: Continuous furnaces consist of several different temperature zones through which the bar travels. The zone temperatures in the austenitizing furnace are chosen so as to heat the bar to a completely austenitic in relatively short time. The bar is then spray quenched before entering the tempering. Zone temperatures in the tempering furnace are chosen to produce the desired tempering effect, again in a relatively short time. The time spent in the austenitizing and tempering furnaces depends primarily upon the length of the furnace and the travel speed. Travel speed varies according to the diameter of the bar. The time in each furnace shall be sufficient to attain the desired mechanical properties and to produce a microstructure to that obtained in a conventional quench-and-temper heat treatment.

6.0 DOCUMENTATION REQUIRED :

- 6.1 Each shipment shall be accompanied by material certifications for each lot of material, The certifications must be positively relatable to the lot of material represented.
 - a) Mill certificate of raw material.
 - b) Chemical certificate for each lot of forging.
- 6.2 Mechanical properties certification as per section 4.0.
- 6.3 Impact testing certification as per section 5.0.
- 6.4 Certification of heat treatment including cycle time, temperature, cooling media, hardness and graphs.
- 6.5 Calibration certificate of furnace.
- 6.6 Ultrasonic test report certification of raw material.
- 6.7 Suppliers shall retain heat treat charts in a secure area for a period of no less than 10 years (e.g. electronic or paper).

7.0 TESTING TO BE CARRIED OUT BY SARA SAE:

- 7.1 At the time of lifting forgings re-verification of chemical properties.
- 7.2 Recheck of Tensile Strength, Yield Strength, Elongation, Reduction in Area, Hardness Impact Testing and UT Testing.
- 7.3 100% MPI testing after machining.

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