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Acknowledgments

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  – Jessica Robertson, Mike Katcher, Vinay Deodeshmukh

• Technical support: Hong Wang, ORNL

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• Funding from DOE Crosscutting Research Program
  – Support of ComTEST/Energy Industries of Ohio

• Legacy funding from DOE EERE (AMO) ARRA (stimulus) funding
  – 24 creep frames rebuilt for CF8C-Plus ASME BPV Code Case
The goal is to code qualify Haynes 282 for A-USC & more

• Objective
  – With Haynes International, deploy Ni-base alloy Haynes® 282® for applications in superheaters, reheaters, and steam delivery pipes, by completing base metal and cross-weld mechanical testing needed for an ASME Boiler and Pressure Vessel Code Case and the associated microstructural analyses needed for assurance of boiler-relevant lifetimes

• Milestones
  – Complete tensile testing of 3 commercial 282 heats (completed 6/30/16)
  – Complete 100,000 h of creep testing (cumulative) (completed 7/31/16)
  – Complete report compiling all 282 tensile and creep results (complete 1/2017)
  – Complete 250,000 h of creep testing (cumulative) (delayed, now at 217 kh).
  – Complete all tensile testing on cross-weld specimens (6/30/17).
  – Complete 400,000 h of creep testing (cumulative) (delayed, 9/30/17).
  – Complete all base metal creep testing (9/30/18)
Haynes® 282® began full scale production in 2005

- 60 full-scale heats produced in numerous product forms
  - Sheet (0.3-3 mm), plate (4-54 mm), bar, wire, billet and tube
- Largest ingot 20” diameter VIM+ESR
- Produced 225 metric tons (½ million lbs.) ship weight to date
- Many aircraft and land based gas turbine engine builders testing worldwide. Applications include combustor rings, combustor liners, turbine cases, fuel nozzles, turbine exhaust cases, exhaust guide vane assemblies, fasteners, sheet and plate fabrications for LBGT hot gas path
- Other markets in test: automotive turbochargers, metallic thermal protection, ultra-supercritical power boilers and steam turbines, etc.
Many commercial developments achieved

- SAE-AMS 5951 specification issued for sheet and plate
- UNS N07208 assigned
- Many evaluations underway worldwide for aero engine and land based gas turbine components
- Selected specific applications
  - Multi-year contract for PW1000 geared turbofan aero engine
  - APU components for the new Airbus A350XWB
  - helicopter gas turbine exhaust guide vane assembly
- Casting developments underway by several alloy foundries
282 has a unique combination of strength and fabricability

- **Superior creep strength due to:**
  - Controlled amounts of gamma-prime (γ') forming elements
  - Controlled amounts of solid solution strengthening elements

- **Superior fabricability due to:**
  - Relatively low equilibrium γ' volume fraction resulting in slower γ' precipitation kinetics.
  - Typical issues:
    - Poor hot workability: limited T range due to γ' formation
    - Poor cold formability: insufficient cooling rate from anneal
    - Poor weldability: strain age cracking
### Composition of Several Haynes Gamma-Prime ($\gamma'$) Strengthened Alloys

<table>
<thead>
<tr>
<th>Alloy</th>
<th>Ni</th>
<th>Fe</th>
<th>Co</th>
<th>Cr</th>
<th>Mo</th>
<th>Al</th>
<th>Ti</th>
<th>C</th>
<th>$\gamma'$</th>
</tr>
</thead>
<tbody>
<tr>
<td>263 alloy</td>
<td>Bal.</td>
<td>0.7*</td>
<td>20</td>
<td>20</td>
<td>6</td>
<td>0.6*</td>
<td>2.4*</td>
<td>0.06</td>
<td>12</td>
</tr>
<tr>
<td>282 alloy</td>
<td>Bal.</td>
<td>1.5*</td>
<td>10</td>
<td>19</td>
<td>8.5</td>
<td>1.5</td>
<td>2.1</td>
<td>0.06</td>
<td>19</td>
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<tr>
<td>R-41 alloy</td>
<td>Bal.</td>
<td>5*</td>
<td>11</td>
<td>19</td>
<td>10</td>
<td>1.5</td>
<td>3.1</td>
<td>0.09</td>
<td>24</td>
</tr>
<tr>
<td>Waspaloy alloy</td>
<td>Bal.</td>
<td>2*</td>
<td>13.5</td>
<td>19</td>
<td>4.3</td>
<td>1.5</td>
<td>3.0</td>
<td>0.08</td>
<td>27</td>
</tr>
</tbody>
</table>

*maximum all values are in wt.%

282® alloy has a higher level of solid-solution strengthenener (Mo) than Waspaloy or 263 alloy.
282 has a unique combination of strength and fabricability

### Stress-to-Produce Rupture in 1000 h

<table>
<thead>
<tr>
<th>Temperature °F (°C)</th>
<th>PK-33 Alloy</th>
<th>R41 Alloy</th>
<th>282 Alloy</th>
<th>Waspaloy</th>
<th>90 Alloy</th>
<th>263 Alloy</th>
</tr>
</thead>
<tbody>
<tr>
<td>1200 (649)</td>
<td>-</td>
<td>90 (621)</td>
<td>80 (552)</td>
<td>80 (552)</td>
<td>-</td>
<td>64 (441)</td>
</tr>
<tr>
<td>1300 (704)</td>
<td>68 (467)</td>
<td>68 (469)</td>
<td>56 (386)</td>
<td>58 (400)</td>
<td>45 (309)</td>
<td>45 (310)</td>
</tr>
<tr>
<td>1400 (760)</td>
<td>45 (307)</td>
<td>43 (296)</td>
<td>38 (262)</td>
<td>36 (248)</td>
<td>29 (197)</td>
<td>28 (193)</td>
</tr>
<tr>
<td>1500 (816)</td>
<td>27 (187)</td>
<td>24 (165)</td>
<td>23 (159)</td>
<td>20 (138)</td>
<td>13 (92)</td>
<td>15 (103)</td>
</tr>
<tr>
<td>1600 (871)</td>
<td>15 (102)</td>
<td>13 (90)</td>
<td>12 (83)</td>
<td>7 (48)</td>
<td>6 (44)</td>
<td>7 (48)</td>
</tr>
<tr>
<td>1700 (927)</td>
<td>5 (37)</td>
<td>7 (48)</td>
<td>6 (41)</td>
<td>3 (21)</td>
<td>3 (20)</td>
<td>4 (28)</td>
</tr>
</tbody>
</table>
Comparative T-T-H Curves ($R_c = 30$)

282® alloy hot working range = 1750 - 2150°F (954 - 1177°C)

282® alloy offers an extended hot working range due to slower formation of gamma-prime ($\gamma'$) versus Waspaloy or R-41 alloy
282 fabricability due to low as-annealed strength

- 282 has low strength in the annealed condition (very little γ' present)
- Low strength in the annealed condition is desirable for good formability
Excellent Retained Strength after Thermal Exposure

Only 282 was found to increase in strength after 1000 h thermal exposure at 1400° F (760° C)
282 also retains high room temperature ductility compared to other gamma-prime (γ′) alloys

**Thermal Exposure: 1600°F (871°C) for 1000 hours**

<table>
<thead>
<tr>
<th>Alloy</th>
<th>RT Tensile Ductility (% elongation to failure)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>As-Age Hardened*</td>
</tr>
<tr>
<td>263</td>
<td>36</td>
</tr>
<tr>
<td><strong>282</strong></td>
<td><strong>30</strong></td>
</tr>
<tr>
<td>Waspaloy</td>
<td>27</td>
</tr>
<tr>
<td>R-41</td>
<td>22</td>
</tr>
</tbody>
</table>

*Age Hardening Treatment: 1850°F (1010°C)/2h/AC + 1450°F (778°C)/8h/AC
282 has comparable low-cycle fatigue life

- LCF resistance of 282 alloy is superior to 263 alloy
- At high strain ranges 282 has similar LCF resistance as Waspaloy and R-41
282 has lower coefficient of thermal expansion

Lower CTE is beneficial for thermal fatigue resistance
Example 282 Microstructure in Age Hardened Condition

- Annealing range: 2025 to 2100°F (1107 to 1149°C)
- Age-hardening heat treatment:
  1850°F (1010°C)/2h/AC + 1450°F (788°C)/8h/AC
- Typical grain size: ASTM 4-4½
282 has good resistance to strain-age cracking
Controlled heating-rate tensile test

- The relatively low $\gamma'$ volume fraction in 282 results in improved resistance to strain-age cracking
- 282 approaches the strain-age cracking resistance of 263 alloy and possesses much higher resistance than Waspaloy and R-41 alloys
Composition suggests strain-age cracking resistance

Prager & Shira plot (PS Plot) showing susceptibility of nickel based superalloys to strain age cracking / fabrication & weldability problems.
Haynes 282 code case project started in FY15

- Project kicked off April 1, 2015
  - 17,300 h ago

- Creep frames inherited from 2009 ARRA project to deploy CF8C-Plus
  - $600,000 investment in 24 frames (16 with DAQ)

- Most 282 specimens have been delivered
  - Part of Haynes International cost share
  - Single age heat treatment (4h at 800°C)
  - Three base metal heats (~60 each)
  - GTA and GMAW cross-weld specimens
  - Waiting for all weld metal specimens
    - Waiting to do all weldment tensile tests together

- 11 creep tests started by December 2015
  - New grips machined for 282 creep tests
  - Matrix 1100°-1700°F (927°C)
    - 8 frames upgraded to type S TC (Pt/PtRh)
  - Four frames added DAQ
    - Minimum creep rate desired on all creep tests
>500,000 h of creep testing needed on three heats and weld specimens

<table>
<thead>
<tr>
<th>°F</th>
<th>°C</th>
<th>500h</th>
<th>1400h</th>
<th>4000h</th>
<th>10,000h</th>
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<tbody>
<tr>
<td>1100</td>
<td>593</td>
<td>all</td>
<td>all</td>
<td>all</td>
<td>all</td>
</tr>
<tr>
<td>1150</td>
<td>621</td>
<td>1 heat</td>
<td></td>
<td>1 heat</td>
<td></td>
</tr>
<tr>
<td>1200</td>
<td>649</td>
<td>all</td>
<td>all</td>
<td>all</td>
<td>all</td>
</tr>
<tr>
<td>1250</td>
<td>677</td>
<td>1 heat</td>
<td></td>
<td>1 heat</td>
<td></td>
</tr>
<tr>
<td>1300</td>
<td>704</td>
<td>all</td>
<td>all</td>
<td>all</td>
<td>all</td>
</tr>
<tr>
<td>1350</td>
<td>732</td>
<td>1 heat</td>
<td></td>
<td>1 heat</td>
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<tr>
<td>1400</td>
<td>760</td>
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<td>1500</td>
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<td>1600</td>
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<td>1650</td>
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<td>1 heat</td>
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<td>all</td>
<td>all</td>
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</table>
Less creep testing required on GTA + GMAW specimens and only rupture time (use frames without DAQ)

<table>
<thead>
<tr>
<th>°F</th>
<th>°C</th>
<th>1,000h</th>
<th>2,500h</th>
<th>4,500h</th>
<th>6,000h</th>
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<tr>
<td>1700</td>
<td>927</td>
<td>all</td>
<td>all</td>
<td>all</td>
<td>all</td>
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</table>

Only 6 all weld-metal tests required
Prior double-aged 282 creep data was not applicable

- Single-aged treatment preferred by boiler community
  - 4h at 800°C selected
- Some data were available from ORNL and GE
  - Some just rupture time
- Decision was made to start over with new test matrix to 927°C (1700°F)
  - Allow use to 871°C (1600°F)
Base metal tensile testing finished in 2016
Base metal tensile testing finished in 2016
Project continues to progress after 23+ months

- Primarily 2 heats tested
  - 3rd heat starting to fill open frames
- 68 tests started
  - 52 failed (2 in threads)
  - 16 in progress
  - >217,000 h completed
  - 43% complete
    - Heat 1 is 87% complete (30 of 40 done)
    - Heat 2 is 64% complete (16 of 29 done)
- Weldments only need rupture time
  - Will start to fill in on 4 frames without DAQ
Estimates of 282 stress allowables are being generated
Most creep testing will be complete in late 2018

30,000 h test not scheduled to fail until late 2019
Highly dependent on productivity and tests not running long (5 now over time)
Spending going well
Significant progress expected in next year

• Project is on-schedule and on-budget
  – Averaged >13,000 h of creep testing/month in past 12 months
  – Trying to keep at least 20 frames running with minimal down time
  – Should complete cumulative 250,000 h creep milestone in 2-3 months

• Tensile testing of cross-weld specimens to be completed in 2017
  – Waiting for all-weld specimens
  – Perform all (~54) at one time to save money

• Haynes International will assemble data for ASME review

• If budget allows, crept microstructure will be characterized
Backup slides
282® alloy does not require rapid cooling rates after annealing due to slower formation of gamma-prime ($\gamma'$) versus Waspaloy or R-41.
Conclusions about Haynes 282

- HAYNES® 282® alloy offers the unique combination of high creep strength to 871°C/1600°F and fabricability
  - Better creep strength than Waspaloy, almost as good as René 41
  - Better fatigue resistance than alloy 263
  - Higher temperature capability than 718 or 718 Plus
  - Easier to fabricate than Waspaloy or René 41
- Excellent thermal stability and low thermal expansion
- Easy availability in a broad variety of product forms and sizes
Effect of Thermal Exposure on the Room-Temperature Ductility of HAYNES 282 Alloy

The ductility of 282 alloy remains greater than 20% even after thermal exposures as long as 16,000 hours.