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AFML-TR-78-13

RESEARCH TO CONDUCT AN EXPLORATORY EXPERIMENTAL AND ANALYTICAL INVESTIGATION OF ALLOYS

GOVERNMENT PRODUCTS DIVISION PRATT & WHITNEY AIRCRAFT WEST PALM BEACH, FLORIDA

MARCH 1978

TECHNICAL REPORT AFML-TR-78-18 For Period February 1975 – April 1977



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HARRY & LIPSIT Project Engineer High Temperature Materials Group

FOR THE COMMANDER

HENRY C. GRAHAM Acting Chief, Processing and High Temperature Materials Branch Metals and Ceramics Division Air Force Materials Laboratory

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Development program was to identify alloys which exhibited ductility at low and intermediate temperatures. A large number of alloys have been prepared and examined, and as a result of this screening program, alloys meeting the ductility requirements have been identified in the Ti-Al-Nb system. It has been found that the elevated temperature properties of these alloys are somewhat lower than anticipated and methods of eliminating this problem through the use of alloying additions such as silicon are described. The importance of heat treatment and structure on mechanical properties is documented and the most effective treatments identified. Powder metallurgy preforms and castings have been used to prepare larger isothermally forged sections of selected alloys. Material from these forgings was used to generate tensile, creep, stress rupture and fatigue properties over a range of temperatures. In addition, physical properties were determined on one alloy. The results of these tests are presented and are considered sufficiently promising to warrant considerations of these alloys for use in gas turbine engine components. Manufacturing and processing procedures that have been studied include casting, forging, welding, diffusion bonding, brazing and machining. The results indicate that for the new alloy compositions many of the practices currently used for conventional titanium alloys are applicable to the aluminides.

FOREWORD

This interim report covers work performed on Contract F33615-75-C-1167, Project No. 7021-01-68, in the period February, 1975 to April, 1977.

The investigation was conducted by the Commercial Products Division, Pratt & Whitney Aircraft, East Hartford, Connecticut, under the technical direction of Dr. H. A. Lipsitt, AFML/LLM, Wright-Patterson Air Force Base, Ohio.

Mr. D. L. Ruckle was program manager for the first year and Dr. M. J. Blackburn for the second year of the program. Mr. S. Z. Hayden and Mr. C. E. Bevan were the responsible engineers. The experimental assistance of Mr. D. Haase is gratefully acknowledged.



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I. INTRODUCTION

High performance gas turbine engine designs inherently depend on high strength, lightweight materials. In the past, major advances in engine technology have been associated with the widespread applications of nickel and cobalt base superalloys and the conventional alpha-beta titanium alloys. Recently, intensive development programs have been directed toward the application of both metal and resin matrix composite materials in compressor structure. Significant programs are also being conducted to develop the basic materials and design technology necessary to apply ceramics to the highest temperature turbine blades and vanes. This latter effort is important in that it depends on changes in design philosophy and capability as a result of the brittle nature of ceramic materials, as well as advancement of material capability itself.

A third area of new materials technology has been identified with the potential to work profound changes in engine weight and performance. This is the development and application of intermetallic compounds or ordered alloys. In general, these materials exhibit properties which lie between conventional metallic alloys and ceramics in that they have limited ductility and attractive high temperature strength. Two such compounds of interest for high temperature use have been identified in the titanium-aluminum system, the $Ti_3Al(\alpha_2)$ phase and the TiAl (γ) phase. The former titanium aluminide has been extensively studied in the USSR, (1,2) and at least one Soviet alloy is reported to be based on TizAl with a use temperature to 1500°F. Some preliminary work on the TiAl type materials in the United States had indicated a potential use temperature up to 1800°F in a non-coated condition; internal work at Pratt & Whitney Aircraft in 1972-73 had verified the properties and potential of both of these ordered materials.

Based on this preliminary evaluation, design analysis and payoff studies were conducted which indicate significant weight savings in a wide range of engine applications, such as an advanced transport engine (ATE), an advanced tactical fighter engine (ATF), or an advanced supersonic transport engine (AST). Turbine rotor weight savings from 30 to 40% (3 to 5% of engine weight) could be achieved with widespread application of the titanium aluminides in rotating hardware, or engine weight savings of up to 16% by application of these materials in static structures such as vanes, cases and bearing supports.

Another major area of benefit in application of these materials relates to the growing problem of availability of strategic materials. The majority of current known reserves of the elements necessary for superalloys are controlled by foreign sources. Although the supply of nickel itself seems stable, U.S. reserves are projected to be less than 500,000 tons of the 45,000,000 world reserves. The supply of chromium, which is a critical requirement in conventional superalloys, depends heavily on sources such as the USSR and Turkey. Mainland China possesses the majority of the world supply of tungsten. The successful use of titanium aluminides would reduce United States dependence on superalloy constituent elements, and would potentially reduce high temperature material costs at the same time.

Current U.S. supply of titanium is largely dependent on Australia and Canada; however, of the estimated world titanium reserves of 123,000,000 tons, over 33,000,000 tons exist within the U.S., and 30,000,000 tons within Canada. The majority of the United States supply of titanium occurs as ilmenite (FeTiO₃), and though it is slightly more expensive to process than rutile (TiO₂), it represents an enormous

domestic reserve of this critical metal.

Thus it was clear that the technical advantages of applying aluminide alloys coupled with the material conservation considerations fully justified a program. A necessary requirement before initiating such a program was a clear definition of anticipated problems coupled with a technical approach to overcome such problems.

The two major areas of concern were the lack of ductility at low temperatures and the processing characteristics of this class of alloys about which little was known. Improved ductility was deemed necessary not only from the standpoint of adequate performance of the materials under service conditions, but also to facilitate component assembly under shop conditions. The development of processing methods for aluminides was obviously necessary in order to produce components and to incorporate sections into a gas turbine engine. Various aspects of the approach, definition and performance of a program aimed at a solution to these problems are describe. in this report, which covers work on Contract F33615-C-75-1167. However, it should be emphasized that this effort is but one element of an integrated program being performed by the Air Force, through both internal and contractually sponsored work.

This interim summary covers work performed on Ti_3Al or a_2 type alloys from February, 1975 to April, 1977. The effort can be divided into three parts:

- Alloy Development
- Alloy Scale-Up and Characterization
- Processing and Manufacturing Methods

This report will cover each of these areas separately although some overlap exists. It should also be emphasized that work continues on the project; the results obtained in future work could modify some of the conclusions drawn in this report.

II. ALLOY DEVELOPMENT

1. Introduction

The first analyses of the titanium aluminum system showed a wide range of solid solution stability of pure alpha Ti up to the intermetallic phase TiAl (γ). The existence of an intervening phase or phases was recognized by the mid to late fifties and the next decade was spent in, often acrimonious, discussion of the structure, composition and stability field of these phases. (4, 5)It is generally agreed that only one phase occurs, with a composition based on Ti₃Al (often denoted alpha two, α_2). Cc⁻troversy continues over the stability range cf this phase and its structure although for all practical purposes a hexagonal superlattice with a DO19 structure is an accurate description. Several of the physical and mechanical properties of this TigAl phase have been determined, although data are rather sparse for non-stoichiometric compositions. In general, the physical properties measurements indicate that bonding tends to be metallic in this alloy although evidence of some covalency has been obtained. The compound shows extensive plasticity at high temperatures, but little or no ductility is observed in tension at room temperature.

Thus, the most significant problem in the development of the titanium aluminide materials is the potential consequences of their limited low temperature ductility on other important design properties. Low ductility in itself is not normally directly related to component failure in conventional metallic components; however, it can function as a secondary cause of failure. For example, the low cycle fatigue behavior of materials is partially a function of ductility as well as microstructure, surface stress state, residual dislocation structure and other factors. In addition, foreign object damage capability of airfoils is also partially a function

of ductility, as well as factors such as fracture initiation energy and fracture toughness.

Ductility can be related to thermal fatigue life although other factors such as modulus of elasticity and thermal coefficient of expansion are also important. Ductility can also dramatically affect load transfer from areas with strong norch concentrations to adjacent areas. Such load transfer is particularly important in dovetail or fir tree turbine blade root design to avoid notched stress rupture failure. The general effects of low temperature ductility on component behavior must be considered in relation to specific component maximum load-temperature sequencing during an engine cycle. For example, it is rare for turbine engine components to achieve maximum load and minimum temperature at the same instant in time. The basic problem in evaluation of new materials is to develop sufficient specific property data under engine related temperature and load conditions to identify the full design capability, as well as to identify specific problem areas where material and design capability improvement is required. Definition of basic environmental effects such as oxidation rates can also be critical in material application; the oxidation testing being conducted by the Air Force is covering this area of characterization.

2. Program Goals

As the program has evolved, the property goals defined for aluminide alloys have both changed and broadened. Early in the program the two major alloy requirements were as follows:

 Ductility of 2-3% tensile elongation at 500°F--which corresponds approximately to the idle temperature in many turbine engines. • Stress rupture capability equal to the nickel-base alloy INCO 713 (comparison to be made on a density-corrected basis).

3. Background

In designing the alloy development program several factors had to be considered, including the previous work performed on Ti_3Al type alloys. The following paragraphs cover aspects of the known characteristics of Ti_3Al at the outset of this program which were deemed useful in defining an approach to alloy development.

<u>Alloying Behavior</u> - In considering the basic alloying characteristics of Ti_3Al , both the extent of solubility and the nature of phase mixtures formed when the solubility is exceeded have to be considered. These features are shown schematically in the phase diagrams in Figures 1(a) and (b), which are constructed for intermediate temperatures (1200-1600°F)--the potential application temperature range for Ti_3Al type alloys. Examples of the bounding phases for the addition of a beta stabilizing element such as niobium are shown in Figure 1(a).

The direction and extent of the single phase (Ti_3Al) field modification is dictated by both the solubility of an element and the atomic site on which substitution occurs in the Ti_3Al lattice. Figure 1(b) illustrates the direction in which the phase field will move for the cases of elements that replace aluminum, titanium and both elements in the Ti_3Al lattice, respectively.

Elements that replace aluminum in Ti_3Al are found in groups IIIA to VA and these elements, coupled with the known solubilities (atomic %), are as follows:



Figure 1. Ternary Schematics

Ga	(50-100%)	Ge	(>1%)	As	(?)
In	(High)	Sn	(100%)	Sb	(>18)
Ti	(?)	Pb	(High)	Bi	(>1%)

Elements known to replace titanium are found in the B subgroups of the periodic table as follows:

Sc	(~,58)	Hf	(>5%)	Mo (~ 18) (Probably >18)
Y	(<1%)	v	(>1%)	W (>1%)
La	(?)	Nb	(~68)	Mn, Fe, Co, Ni, Cu (>1%)
Ti		Та	(>1%)	Ag (<1%)
Zr	(50%)	Cr	(<1%)	

Elements that are of finite solubility but do not fall into the above classification include:

Be (v8%) Carbon, Boron, Silicon, Oxygen and Nitrogen

Structural parameters that may be changed by the addition of solute elements within the single phase regions are the ordering kinetics and critical temperature, T_c. In stoichiometric Ti₃Al, it is impossible to suppress ordering by conventional quenching techniques although a very fine domain size is produced by water quenching. However, on annealing at intermediate temperature, e.g., 1475°F, rapid domain growth occurs and virtually complete elimination of anti-phase domain boundaries (APB's) occurs, resulting in a high degree of long range order.⁽⁵⁾ This is also true in alloys with quite wide deviations from stoichiometry. The influence of specific elements on ordering kinetics has not been studied in any detail. However, niobium additions certainly retard the ordering rate, and quite small domain sizes are retained after quite long aging treatments.⁽⁷⁾ Similar effects have been observed in some hafnium containing alloys.

The bounding phases that can occur when the solid solubility limit of a given element is exceeded will obviously be strongly dependent upon several factors, including composition and temperature. Figure 1(a) is a schematic of bounding phases for an element that replaces titanium, such as Nb, Mo, etc. An additional complication in these systems is the tendency of the β -phase to order to a B2 type structure. Elements from the later transition series, such as Fe, Ni, Co, etc., tend to form intermetallic phases of the form TiX or Ti₂X.

With the aluminum replacing elements, the situation tends to be relatively straightforward at substoichiometric compositions, in that solid solutions (a) and a two-phase region $(a + a_2)$ will occur. However, in aluminum-rich alloys, complexities can arise with higher phases from the TiX system; for example, at the composition Ti₃ (Al_{0.5}Ga_{0.5}), the phase Ti₂Ga is formed within an a_2 matrix.⁽⁸⁾ The number of other possible phases in many of these systems could further complicate potential phase equilibria in these regions of a ternary phase diagram.

Another possibility, which will be developed in more detail later, is to produce mixtures of $Ti_3Al + X_3Al$ phases in which the X_3Al has an ordered face centered cubic structure. This type of structure can occur in the Ti-Al-Zr system.

Structural Modifications - The above paragraphs detail the possible phase structures that could form at intermediate temperatures in systems based on Ti_3Al . At high temperatures the β -phase is stable in all dilute systems and in many more conventional alloys.

Cooling from the region of β -phase stability will result in transformation; in most of the systems of interest, rapid

cooling will lead to a martensitic structure and slower cooling to an acicular structure formed by nucleation and growth. The essential point is that morphologically similar structures to those in conventional titanium alloys can also be produced in these alpha two base systems.

Since we are dealing with a hexagonal structure, a second structural modification, controlled texture, may be possible in these alloys. Solid state processing methods would have to be employed to produce a specific texture, since the lack of suitable mold materials would appear to preclude controlled solidification methods. The advent of successful sheet procussing methods could allow the analysis and perhaps exploitation of such effects.

Flow and Fracture - Considering the dearth of mechanical property data (at least in tension), the flow and fracture characteristics of Ti₃Al are reasonably well documerced. It has been shown that, at least in compression, a type dislocations are mobile at room temperature. (8) Both basal and prism slip systems can be activated and there is a distinct tendency for rather sharp planar dislocation grouping to occur. The basic problem would therefore oppear to be the operation of slip or possibly twinning systems capable of producing displacements normal to the c-axis of the hexagonal structure. One such possibility is the \overline{c} + \overline{a} type dislocation which is apparently readily formed in the ductile alloys from the Ti-Al-Ga system. Apparently, fracture occurs at ambient temperatures by cleavage failure, on the same strange plane of separation observed in stress corrosion failures of conventional alpha-phase titanium alloys. The influence of microstructure and grain size has not been studied. The basic conclusions that can be drawn from the observations to date are that the low temperature brittleness of Ti,Al seems to

be related to the absence of slip modes capable of producing displacements normal to the Jasal plane. Heat treatment and grain size control may be possible methods of controlling flow and fracture properties, but no clear-cut directions can be accurately defined at this point.

Lipsitt⁽⁹⁾ has measured the tensile properties of Ti_3Al , manufactured by powder metallurgy methods, over a range of temperatures. It was shown that finite ductility occurs above ~ 1200 F, although specimen yielding occurred below this temperature. This is the only information that quantitatively defines the ductility problem and allows an assessment to be made of ductility changes produced by alloying additions.

 $\frac{\text{Ti}-\text{Al}-\text{Ga}}{(10)}$ - Early measurements in this system by Hoch and Gegel⁽¹⁰⁾ showed that alloys near the composition $\text{Ti}_3(\text{Al}_{0.5}\text{Ga}_{0.5})$ had quite high tensile ductility at room temperature. Williams and Blackburn⁽⁸⁾ suggested that this occurred due to a particle ductilizing effect of the Ti_2Ga phase that occurs in this alloy. Godden and Roberts⁽¹¹⁾ confirmed that ductility occurs in this system (although over a narrow compositional range) and found that maximum ductility occurred in a single phase (α_2) alloy. The cost of gallium precludes its use in engineering materials, at least at high concentrations. Thus, one of the objectives of any alloy development program is to duplicate this ductilizing effect with more economic alloying additions.

<u>Ti-Al-Nb</u> - Both German⁽¹²⁾ and Russian⁽¹³⁾ work has shown that this system appears an attractive base on which to build an alloy development program. It has been shown that in specific alloy compositions over 4% elongation is observed below 1000°F. <u>Ti-Al-Mo</u> - Weissmann and coworkers⁽¹⁴⁾ have recently evaluated alloys from the $\alpha + \alpha_2 + \beta$ phase field in this system. By carefully controlling the microstructure, ductilities of several percents have been obtained at room temperature. However, the specific heat treatments employed would seem incompatible with subsequent use of material at high temperatures; this emphasizes one of the difficulties inherent in this type of system--thermal stability.

<u>Creep Properties</u> - The exact composition of the Russian alloy ST5 is unknown, but assuming it is virtually pure Ti₃Al, a convenient baseline for comparison of creep properties is offered. It has been shown that the creep properties of the alpha two phase and its alloys are considerably better than those of conventional alloys. Alloys from the following systems have been shown to exhibit improved properties over the base compound:

> Ti-Al-Nb Ti-Al-Sn Ti-Al-Hf Ti-Al-W Ti-Al-W

In summary, the alloying characteristics of alloys based on Ti_3Al are known in sufficient detail to identify both the elements that are soluble and the phase mixtures that bound the single-phase region. The effect of single component additions on properties, especially in tension, are less well documented; however, at least two systems are known that show some promise for room temperature ductility.

4. Alloy Formulation

Although some definition of useful alloy development directions could be derived from the above discussion, the large number of compositional effects available for study had to be restricted to a smaller number of specific directions. In addition, a methodology had to be established which allowed an assessment of the mechanical property capability of a large number of alloys. The following sections cover the selection and evaluation of alloys studied in the current program.

The alloys selected for evaluation fall into five general groups which are listed below, together with the reasons for choosing the systems.

- Single (substitutional) element additions tc provide some basic solubility and property data and identify useful ternary phase systems.
- Two (or more) substitutional element additions (one element Nb or Zr) - to investigate the potential of modifying properties by two substitutional element additions.
- Two element additions one substitutional, one interstitial - to study the possibility of amplifying creep resistance by dynamic strain aging processes.
- Additions to produce two-phase structures of the α_2 + β type to control the ordering reaction in the beta phase and then extend the study to modification of the α_2 component of the system.
- Additions to promote a two-phase mixture of ordered hexagonal (DO₁₉) and face centered cubic (Ll₂) phases it was hypothesized that in a two-phase mixture, a ductile component, Ll₂-phase, may produce some overall ductility in the whole system.

It is inevitable that some overlap between these areas occur. The first three areas may be combined as all relate to the single phase Ti₃Al region and will be discussed as a general group.

Single-Phase Alloys - The additions selected for study included both elements for which no previous information was available (e.g., W, Ta) and also additional studies on systems for which some results had been generated.

The studies of two (or more) additions were confined to systems in which some indication of property improvement for any given three elements had been shown. For example, the Ti-Al-Nb ternary system appeared a useful base upon which to build.

The third group of alloys examined the usefulness of interaction between interstitial and substitutional elements in a Ti₃Al solid solution. It was anticipated that by analogy with conventional titanium alloys containing silicon additions, a dynamic strain aging process may occur and thus improve creep and stress rupture characteristics. Previous exploratory work at P&WA had demonstrated some promise for Hf-C additions.

Alpha Two Plus Beta Systems - The basic problem with the use of the beta phase as a potential ductilizing phase in an α_2 + β type alloy is the tendency to ordering in this phase. The product phase, often denoted B2, has an ordered B2 lattice or possibly Heusler structure (L2₁). The formation tendency is accentuated by high aluminum content; in fact, it was first detected in Ti-Al-Mo alloys near the composition Ti₂AlMo. ⁽¹⁵⁾ This ordering reaction tends to embrittle the beta phase and thus, it has to be eliminated or controlled if practical use is to be made of the structure. There is the rather remote possibility that a phase similar in nature to NiTi could be produced. NiTi, although possessing the B2 structure, exhibits considerable plasticity at ambient temperatures. (16) The first effort was aimed at controlling the ordering reaction in the beta phase and then attempting to modify the alpha two component of the system. The background for such as approach was rather sparse; it was known that the Ti-Al-Mo and Ti-Al-Nb systems exhibit ordered B2 beta phases. The influence of vanadium and chromium on structure was not as well documented, but Russian and early USA work had not shown much promise in these systems. Addition of the later transition elements, at least as single element additions, tends to produce $a_2 + \beta + compound$ or $a_2 + compound$ type structures; again, these alloys show little evidence of low temperature ductility, although in the case of iron, high temperature ductility is enhanced. The major effort in this segment of the work was on alloys from the Ti-Al-Nb system.

Ordered Hexagonal and (Face Centered) Cubic Mixtures - The basic philosophy behind the study of such a system is that in a two-phase mixture, a ductile component may yield some overall ductility to the whole system. It should be noted that compounds that have an ordered face centered cubic structure $(Ll_2 \text{ class})$, as a group include more examples of ductile intermetallics than any other class of intermetallics.

Specifically, $2r_3Al$ is the only intermetallic of Group IV element based compounds which exhibit >10% elongation at room temperature. (17) Recent P&WA studies of the Ti-Al-Zr system have shown that, contrary to earlier Russian work, the mixed $Ll_2:DO_{19}$ structure does not occur until the zirconium content is approximately 50%. This large concentration, coupled with the rather low beta-transus, would seem to
exclude this system from active consideration for the development of useful engineering materials. However, it may be possible to perturb the phase equilibria based on the crystal chemistry of the early transition elements, as outlined below. The essenti. aim would be to bring the mixed structure closer to the Ti₃Al composition.

If we examine the alloying behavior of the early transition elements with Group III and IVA elements, Figure 2 can be constructed for AB_3 compounds. It can be seen that four phase stability regions may be delineated, DO_{19} , Ll_2 , Al5 and systems which do not form AB_3 compounds. Both yttrium and cerium aluminides exist in both the DO_{19} and Ll_2 structural forms. These aid in positioning the boundaries. As usual, the only theoretical treatment that has been attempted for predicting the relative stability of the Ll_2 and Al5 structures does not work for these compounds. Macklin⁽⁸⁾ calculates that $2r_3Al$ should have an Al5 structure and Nb₃Al should have an Ll_2 structure, when in fact, the reverse is true.

The specific alloy systems studied in the present program were selected from the $Ti=\lambda l=2r$ system with addition of In, La, etc.

5. Experimental Methods

The basic problem in conducting any meaningful evaluation of alloys, such as those under consideration here, is to measure properties on a restricted amount of material. It is obvious that to melt large amounts of material, process and conduct a screening evaluation program for all alloy compositions was impossible within the confines of the program. Thus, the following sequence of stages was used in the alloy





Periods III-VB Transition Elements Showing Crystal Structure of AB₃ Compound Formation With Group IIIA Elements

development program.

- 1) Formulate alloys.
- 2) Melt 100 gram buttons by a non-consumable arc method. High purity materials were used to prepare alloys; for example, electrolytic titanium with an oxygen content of 0.03%. Alloys were melted at least five times to ensure homogeneity.
- 3) Evaluate the structure of the cast alloys and measure hardness. As a check of the flow and fracture characteristics of the alloy, the hardness impressions in unetched sections were examined by optical microscopy. The tendency for the material to crack and the intensity of slip markings around the impressions were recorded.
- 4) Homogenize buttons by thermal treatments at 1800-2000°F for periods of up to one week. Changes in structure and hardness were evaluated after this treatment.
- 5) Isothermally forge buttons to produce thin pancakes. Investigate the structure and hardness produced by this operation.
- 6) Cut bend specimens from the forged section and measure strength and bend doctality over the temperature range of room temperature to (200°). A three point bend rig and an Instron Test machine were used for these tests.
- Conduct heat treatment and structural studies on the remainder of the Outping and evaluate bend ductility of material after selected heat treatments.

If, at the completion of this screening study, an alloy showed promise, it was scaled up to a two-pound size. Alloys were melted in a non-consumable arc furnace and drop cast into a copper mold approximately 1.5" in diameter. A number of these castings were x-rayed, which revealed the presence of shrinkage porosity. In most cases this porosity did not

influence subsequent forging operations, but a small number of defects were detected after forging (usually in locations in which little flow occurred). Thus, many of the latter ingots were HIP'ed at 2250°F for four hours at 15 ksi, which served to heal shrinkage porosity and also increased the alloy homogeneity. Forging of ingots was performed on isothermal TZM dies. Usually the ingot was split into two pieces which yielded pancakes four inches in diameter and three-tenths of an inch thick. This was a sufficient size to produce about four specimen blanks. As in many cases where more than one heat treatment was studied, these specimen blanks were heat treated individually. Specimens, shown in Figure 3, were then prepared from the heat treated sections and used to measure the tensile and creep rupture properties of the material. Remaining pieces of the forging blank were used for additional heat treatment and bend property determinations. The microstructure and hardness of every alloy was recorded at each stage of the cycle. In a small number of cases more sophisticated techniques, such as x-ray analysis, transmission electron microscopy, etc., were used to elucidate phase structure and flow and fracture processes.



Figure 3. Tensile and Creep Rupture Specimen

54.

A flow chart illustration the sequence of evaluation steps is shown in Figure 4.





6. Results and Discussion

In this section the rather extensive results obtained in the Alloy Development part of the program are reviewed. The large amount of information makes detailed discussion of each alloy impossible and thus we shall attempt to give a general summary with emphasis on the more positive aspects. Documentation of microstructures is also a problem as it would take about three thousand micrographs to illustrate all features of each alloy at the various stages of processing. Therefore, again, micrographs typical of groups of alloys or a specific processing or heat treatment will be given. It was noted in the introduction to this section that a logical scale-up sequence had been defined for studying alloys. To aid in the continuity of the story, we shall combine the results obtained on both button and the larger drop castings, for the initial evaluation sequence was the same for both product forms. In some cases alloys have been produced on both forms. Finally, it should be noted that emphasis has shifted several times during the course of the study. To give one example, in early 1976 it appeared that the Ti-Al-Zr system offered the best alloy base for further study, but by the end of the year the Ti-Al-Nb system had supplanted this system. Such factors explain why emphasis may have been placed on a specific alloy at a given point in time which, in retrospect, could be considered nct worthy of analysis.

Table 1 lists all alloys melted in the study, compositions are given in both weight and atomic percent; in subsequent discussions, atomic percent will be used to describe alloys. The alloys are arranged in the groupings defined in Section 4, although in some cases overlap occurs. The results of the evaluation of alloys, in both the as-cast and homogenized conditions, are given in Table 2. Assessment of the propensity

TABLE 1

List of α_2 Alloy Compositions Melted

Alloy No.	W/0	A/0	
	m 16.7 .1	44-2541	#4=41
	ana = 1,2 × 1 Anas 194	T1-2541	TIAL
T1-20 Single Fla	ment Additions		11341
TL-A	71-5. 441-1.1Sc	T1-25A1-15C	
T1-9	71-15.941-5.350	T1-25A1-55C	
TI-10	11-15-541-1-50	T1-25A1-1Cu	
71-11	71-15.541-7.300	T1-25A1-5Cu	
m1_12	11 - 15 St 1 - 414	T1-2541-1M	
m-13	14 - 1 - 6 - 4 - 4 - 604	71-25A1-5N1	
11-13	Ttal 15 717-1 700	T1-2541-1Ce	
11-14		71-2541-564	
-1-17 	#4_15 6.1_2 sta	71-25A1-14C	
71-31	11-11-11-11-Rt.	T1-2541-54g	
T1-32		T1-2541-181	
11-33		74-25A1-534	
T1-34		T4-2541-15h	
T1-35	1. + 17 + 7 miles - 000	11-2 JAL-150	
		11-27A1-750	
+25	7	11-2741-114	
#30	1-23. 762-4.702	T1-25A1-3CU	
#35	and the stand of the second	11-2341-14	
#35	71-1 . AL-+.17B	T1-25AL-1TE	
71-40	11-10.1-1-Be	T1-25.0A1-2.0Be	
11-41		T1-25.0A1-5.0Be	
T1-42	24 - 24 - 7 AL-2 - Late	T1-22.5A1-5.0Be	
T1-53	31-1* /1-16.1Mb	T1-25A1-8ND	
#50	71-19.111-14.32r	T1-30A1-72r	
#51	me.r.chielo.dir	T1-30A1-142 r	
Two or Bore	e element additions		
T1-4	11-17. AL212-3.204	T1-25A1-2ND-2GA	
T1-3	71-14.7A1-10.1ND-7.0CB	TI-25AL-SND-SGE	
71-5,(#34)	-1-15.CAL-10.3ND-1.3M1	T1-25AL-5ND-LN1	
11-6	T1-14.543-10.2ND-2.3Pd	T1-2541-5ND-LPG	
11-7,(#33)	71-15.041-10.3Mb-1.4Cu	T1-25A1-5ND-1Cu	
T1-16	T1-8.211-12.05a-7.3Ge	T1-15A1-558-5Ge	
T1-25	71-14.5/14.705-3.68u	T1-23.75A1-3.75N	n-1.255n
T1-28	T1-12.6A1-14.4ND-6.1Su	T1-22.5A1-7.500-	2.5Sa
T1-37	21-14.6A1-10.1ND-3.9M	T1-25A1-5Nb-1Hr	
T1-38	71-14.EA1-10.0No-3.94	11-25A1-5ND-1W	
T1-39	"1-17.941-10.3No-4.0W	T1-30A1-5Nb-1W	
71-46	T1-14.EA1-10.2ND-1.3N1-2.1Ho	TS-25A1-5ND-1N1-	110
#29	T1-16.0A2-10.080-1.0Fe	T1-26.4A1-4.8Nb-	-0.8Te
#33	71-15.CA1-10.3%b-1.4Cu	T1-25A1-5ND-1Cu	
#34	. T1-15.0-1-10.3ND-1.3W1	T1-25A1-5ND-1H1	
#3	T1-14.6A1-10.0ND-3.9H	T1-25A1-5N5-181	
11-54	T1-14.2A1-15.6ND-3.6W	T1-25A1-8ND-1W	
T1-55	T1-14.4A1-15.9ND-2.1Mo	T1-25A1-8N0-1H0	
T1-56	71-14.241-15.6ND-3.8Ta	T1-25A1-8M0-1TE	
11-57	71-14.2A1-15.630-3.8Hf	T1-25A1-8ND-11	
T1-58	71-14.6A1-16.080-1.1V	11-25A1-8ND-1V	
#53	71-14.641-16.0ND-1.2Te	T1-25A1-8ND-1Fe	
155	"1-1 411-16.0ND-1.0Fe	T1-25A1-8ND-0.81	FC 54
#50	11-14.231-15.000-3.8K	T1-25A1-810-1W	
11-47	-1-15.011-10.300-1.331-1.1V	T1-254 1-5ND-1 N	5 ¹ V
#45	":-]. Al-10.075-1.381-4.0W	T1-27A1-7ND -1N1-	

TABLE 1 (Cont'd)

Alloy No.	w/o		10	
#57 .	T1-14.241-15.6M	-3.8m	P1-2541_8:0	h_17s
#58	T1-14.2A1-15.6Nb	-3.8Hr	2541-BM	b-18f
=59	71-14.6A1-16.0Nb	-1.17		b=17
-55	71-14.5A1-10.0Nb	0.7N1	-2541-5M	
Interact	ion Effects			
71-1	T1-13.841-18.2H	- 170		F=0.7C
71-30	T1-12.0A1-34.47F	03	1-23.141-	18.77
#31	T1-15.041-18.0M		M-25 041-	2126
#32	T1-15.041-18.0Nb	-1.5Hf-0.5551	T1-26A1-9.	LNB-0.4Hf-0.8S1
aluó	T1-13.841-9.5ND-	9.42r-6.15a-0.151	1-25A1-5	ND-52r-2.550-0.2551
71-50	T1-13.5A1-21.4Nb	-0.65Cr-0.1551	11-2421-11	no-0.5cu-0.2551
T1-51	T1-13.5A121.4Nb-	0.65N1-0.1551	11-2441-11	ND-0.5N1-0.2551
11-52	T1-13.5A1-21.4Nb	-0.6Fe-0.155	T1-24A1-11	30-0.5Fe-0.2551
T1-59	T1-14.2A1-15.7Nb	-3.8Hf-0.1C	1-25A18ND	-1H1-0.4C
71-00	T1-14.7A1-16.2Nb	-0.23	1-25A1-3N	b-12
~1-01	T14.5A1-15.9ND	-0.981	T1-25A1-3N	5 :51
#DC	71-13.641-21.4ND	-0.305	T1-24.241-	11.0Nt-0.15h
#11 ····	T1-13.6A1-21.4mb	-0.LA1	-1-24.241-	11.015-0.131
pf2	T1-15.6A1-21.4ND	-0.1551 1	1-24A1-11	No-0.2551
Alpha two plus	Beta Systems			
±12	T1-13.541-21.4Nb	6 P	T1-2441-11	10
72-44	T1-14.3A1-19.7Mb	-1.2Hf	71-25.241-	10.1Nb-0.3Hf
T1-48	T1-14.341-19.7Nb	-1.211	T1-25A1-10	ND-LN1
≠ 47	T1-13.6A1-28.2ND		1-2541-15	3
Mixed Heragonal	+ Cubic Systems			
T1-17	T1-2.041-61.42r-25.8In	T1-6.25A1-56.252	r-13.75In	25:75/T13A1:2r3In
T1-18	T1-4.8A1-48.92r-20.5In	T1-12.541-37.52r	-12.5 In	50:50/T13A1:213In
11-19	T1-9.041-30.42r-12.8In	TI-18.75A1-18.75	2r-c.25In	75:25/T13A1:2r3In
T1-21	T1-8.041-92.0Zr	TI-22.641-77.22		Zr3Al
T1-22	T1-9.341-77.72	T1-23.541-58.0Zr		25:75/T13A1:2F3A1
T1-23 (#21)	T1-10.841-59.3Zr	T1-24.041.38.02r		50:50/T13A1:ZF3A1
T1-24 (#22)	T1-12.941-34.72F	T1-24. 341-19. 72F		75:25/T13AL:2F3AL
T1-20 .	T1-14.1AL-7.72F-3.3Sh	T1-23.77A1-3.77Z	r-1.2750	97:5/T13AL:27288
T1-27	T1-12.0A1-14.22F-0.138	T1-22.741-7.72-	2.758	90:10/T1341:2F358
11-57 (#C)/	TL-12 241-22 77-1 84	M-2541-18 220-1	-The	15.25/113A1-2 A1-35
425	T1-13 141-32 47-3 71-	TH-2541-18 77-1		75.25/74241.7 204141.8
106	M_0.741_31 07+10 70-	TH-2541-18 87-5	Sa	75-25/71-41-7741-544
71-43	14 -0. 841-3117-10 2Th	T1-20.041-18 87-	-5.00	75.25/11241.7 -24145
422	M-12 041-21 77-	AL ON EA1 10 FR-		/ma = 42
10	T4-14 441-18 27-	11-64 - 241-19 - 75F	17:27	12 5/04-41-2-241
11-49	T1-13.441-33.27=-0 28	T1-2541-18.257	18 75.25	/T1-A1-7-A1+18
			- ())	/ angra . un gran au

NOTE: Number designation e.g., #28 identifies drop casting; letter plus number designation e.g., T1-46 identifies button

TABLE 2

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Microstructural, Hardness and Qualitative Evaluation of α_2 Alloy

0 - None S - Silght M - Moderate E - Extensive

												P.a.a.u			· Forcell		· Percell				1					
Pha se Preser	Single P Cingle N		Single F.	Studie II	2-11486	2- Hate	2-17:446		2-ihead	2-19466	Cincie P	Sinvle P	Sirgle P	•	Segregat lun	2-lhase	Segregation	2-lhase?	2-Ihase		2-Pase	Single or		Single !		2-11486
SIIp/ Crecking	2		1/H	H/H	+/2	H/H	E/E	H/4	H/4	N/H	3/4	E/E	E/E	H/H	H/H	N/S	H/H	N/S	N/S	f	s/r	M/E		H/H	E/S	5/:
Nogen1zed Hardness HV10	245		87T	201	162	244	352	E.	110		274	284	2%6	123	いた	120	541	592	252	ļ	152	283		172	25	259
Heat Heat	1000°C/3444E		1000/144	111/00.1	1000/144	1000/144	10001	10001	1000/144	2/ /0001	22/0001	22/0101	10001	22/0001	1000/88	Monor Ha	1000/08	1000	yound de		1000/96	1000/96		1000/144	1000/144	1000/1
Conching	S. H		1/0	s/M	(/M	E/E	s/E	E/E	H/H	5/3			5/5			2/2		ale a		ole	m/m	H/H		E/0	E/0	N/N
He here	-62 10-2		30.	376		5.6	11(,0	281	358	2	220					(1)	55		121	5	200	80		504	538	281
Allor	11-20	SHULLINGS	8-11	71-9	01-11	11-11	1-11	TI-IL	11-15	11-31	2-1-12	11-33		-11-30	0-11	01-11			DZ	T1-53	•	22	lement addition	4.10		(Training
	Try II	S INCLE ELEMENT	r1-25A1-1Se	T1-25A1-55e	T1-25A1-1Cu	T1-25A1-5Cu	107-TVC2-11		11-25A1-5Ge	TI-25A1-INC	T1-25A1-5M	T1-25A1-181	T1-25A1-5B1	T1-25A1-15b	T1-25A1-53b	T1-25A1-2Be	T1-25A1-5Be	T1-22.5A1-5Be	T1-25A1-1Fe	T1-25A1-8M		T1-3041-142r	Two or more e			

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Composition (\$)	Alloy	Hardness HV-10	SIIP/ Cracking	Heat Treatment (C/Hrs.)	Hardness HV-10	Slip/ Cracking	Present
Tu 2341-586-194	71-6	101	S/M	1000/144	245	3/ **	
11-151-56-10	T1-7(#33)	345	0/H	10001	52	0/W	2-Hase
	11-16 25-11	314	¥: ¥¥	1000/72	336	S/M	Futectic 2-itase
Loss and a	1-28	IUE	- / -	22/07/1	5.).		
1		Tor		1) hant	f m	2	ougle mase
11-11-11-11-11	71-37	350	m/.:	21/0001	162	M/M	
11-11-11-11-11-11	11-38	14 2. *	0/0	10001	330	Distorte	a/5
NT-1047-110-11	11-39	44 . 84	6/3	JCHIN/12	34%	Distorte	d/5
107-10-100-11	133	1.2	:/:	JONNO/CH.	240	5/3	2-Illase
INT-INC-DUCT		3645	H/::	1040/1/	253	5/H	2-Ihase
107-00-00-00	5	544	H/H	10001	223	S/M	
	621	1 07	:/:	10KN/9'	56.1	s/s	2-Russ
Ti-PS.2Alio.1m-	T1-44	. 128	5/5	10000/vm	510	e la	
O. Jar				- lans		212	
101-1001-1007-11	T1-48	294	5/3	10001	242	W/vs	
AT-ME-CHIC-TA	11-54	611	0/0	1000/01	315	s/w	2-Ituse
	-1-22	14 M.	0/3	1000/91	Jul	M/VS	2-ituee
All and the second	2-1-1	(.24	EV/S	1000/001	202	N/S	2-ituse
The state of the s	14-11		2/2	JOHN/".	5.5	N/S	2-11ace
ALCOHOLD AND AND AND AND AND AND AND AND AND AN	T1-50	4. M	3/2	JONN/M	257	WVS	2-Mase
		1	H/H	16/unit		S/H	2-Itase
ALL AND AL		21.16				SA/H	2-1948e
Trutter and the	- L.S.	22	N/W	inn/di	.140		S-ITIMEE
71-25A1-0m-1m	1.4	542		BORAN AN	200		
V1-400-100-10	.65.	922	N	10.010	218	2/14	2-11-00
き ころい いっかい つきんしてい	455+	245	H-::/H	JUNNI/91	101	1/C	2-Ilase
11-2341-310-1102-11	11-46	342	0/3	1000/10	3.00	S/V3	2-Hune
AT-101-00-196-10	71-47	3th	W/S	Inun/un	257	N/S	2-Ihase
Intersection Effecto	P ²	258	H	10001/96	306	H/H	2-ihase
PL-2542-588-0.76	1-11	373	M/S	2L/0001			Carbides
0. A-127.01-141.15-17	B T1-30	121	0/0	1000/96	361		Borides
いからいまいまで	P 46	З ^с	NM	7000/36	236	E/H	2-Phase
-MA.O. MI. O. MW.	132	429	s/s	36/0001	229	s/s	Single + Silici
Inter-order-tak-th	24	237	M/vs	1000/90	122	e/s	2-itase
			•				

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•As-HIP'ed at 22507/15 ks1/3 hours

			ADLE 2				
Composition (\$)	Alloy Mumber	Hardnese 30-10	SI1p/ Cracking	Huat Treatment (C/lire.)	Hardness IN-10	S11p/ CrackIng	Hase(a) resent
T1-24A1-110-0.5Cu-	05-11	353	0/0	1000/96	259	M/VS	2-11400
T1-24A1-1100-0.501-	12-51	337	0/0	45/001	21.0	SV/M	2-Hase
0.2551 11-24A1-110-0.57	71-52	415	0/0	36/0001	Ste	M/v3	2-Pase
0.2551 T1-25A1-8Nb-1HF-0.4C	11-59	116	S-M/S	1000/96	692	s/vs	2-Hase
T1-25A1-8No-1B	07-11	293	s/s	1000/14	233	5-M/5	Single buride
T1-23A1-8ND-0.2B1	19-11	415	s/s	1000/10	£23	a,¥	Cuaplex
-24.241-11.0ND-	#ico	561	S-M/S	95/00A	243	M/S	2-Hase
0.15b T1-24.2A1-11.0Nb- 0.1B1	. to	218	5/3	vic/cont	217	H-E/VS	2-Huse
Alpha two plus Bata Sy	riters						
H-Shalling	4 ,2	NG8	\$/0	30001	24.40	5/15	2-Mass
-41-25.241-10.13b-		337	s/s	1000/16	235	s/0	2-Mase
0.3HF T1-25A1-10Nb-1M1	84-12	Prime Prime	s/5	1000/ce.	24.2	61/H	2-Mass
T1-25A1-15Hb	14	224	R/S	1(x00/u	503	2/W	single or two phase
Hired liszagonal and Cu	bic Systems						
ALE 12: 14-14-14-14-14-14-14-14-14-14-14-14-14-1	71-17	235	3/0	111/0001	217	s/5	Cumples
50:50/TIAL:21210	11-18	175	N/O	1000/111	1.25	N/0	Coplex
75:25/TIJA1:2rju	11-19	£1	0/W	1010/001	359	M ^S	Cimule Hand
ZF3AL	1-11	115	0/0	0/1/006	9		Cuppler
20:50/TIMI Zrad	T1-23 (#21)	519	0/0	021/006	362		Cumplex
INETS: INEIT/25:27	T1-24 (122)	536	0/0	900/170	255	e le	Sinele Place
95:5/Tijh1:Zr38n	8 2	335 ali A	N/S	1000/72	288	E/N	Single Place
15:25/11/01:04	(Ea) 62-11	25	0/0	1000/72	ŝ		Cuides
+13c 75:25/71-A1:2r-A1+1Y	124	184	5/5	96/0001	306	N/S	Complex . Unide
75:25/713A1:2r3A1+59n	82	310	N/S	1000/00	3.6	H/S	3-Itase (Cumples)
15:25/11 JA1:21 JA2:27	574	120	N/NS	1000/88	316	N/S	Complex + porcelty
75:25/713AL:223AL	22	110	5/5	1000/96	200	5/H	Complex + oxides
87.5.12.5/TIMI ZIMI	-64	254	H/H	1000/96	231	H/H	Complex
15:25/TIAL: Zr341+14	61-11	ŝ	SV/M	1000/96	331	SA/M	Complex + Borides

1.3 1.2.2

of a given alloy to flow and fracture was made by analyzing individual hardness impressions. Figure 5 gives examples of such evaluations with varying tendency to cracking. Figure 5(a) shows an alloy which exhibits no cracking; Figure 5(b) shows an example of moderate cracking which is often difficult to distinguish from coarse slip lines; Figure 5(c) shows more extensive cracks; and Figure 5(d) illustrates a cracked section of an alloy not associated with a hardness indentation. Obviously alloys which exhibited such spontaneous cracking were eliminated from the program. The shape of hardness impressions also varied in certain alloys, in some cases very distorted shapes being formed as shown in Figure 6. Such anisotrophy may reflect the influence of crystallographic orientation on flow and fracture characteristics.

Many of the alloys exhibited high hardness in the as-cast condition and a low tendency to crack around hardness impressions. Homogenization treatments resulted in reduction in hardness and an increased tendency to crack. These changes can be correlated with structural modifications. In the ascast condition, alloys usually exhibited an acicular structure not unlike beta transformed structures in conventional titanium alloys. The degree of acicularity has been found to depend on alloy composition. The base Ti₃Al and dilute alloys exhibit irregular plate-like structures, shown in Figure 7, not unlike the massive-type martensite formed in pure titanium. Alloys containing transition elements tend to consist of must finer plates, as illustrated in Figure 8. During homogenization treatments, multiphase alloys retain acicular structure although some coarsening may occur, Figure 9.

In single-phase alloys high temperature exposure results in recrystallized structures of the type shown in Figure 10.





Ti-25Al-1Ge A/O As-cast



200X Ti-25Al-5Bi A/O (Tl-34) As-cast

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Figure 5. Photomicrographs of Hardness Impressions in Ti₃Al Base Alloys (a) No Cracking (b) Slight Cracking (c) Extensive Cracking (d) Spontaneous Cracking



Figure 6. An Example of a Distorted Hardness Impression Observed in Some Alpha Two Base Alloys (Ti-25Al-5Nb-5Zr-2.5Sn-0.25Si, As-Cast)



Figure 7. Coarse Acicular (Colony) Structure Found in Alpha Two Alloys With Low Solute Contents in the As-Cast Condition (Ti-25Al-1Fe)

100X

Figure 8. The Fine Acicular (Widmanstatten) Structures Observed in Alpha Two Alloys with an Intermediate Concentration of Transition Elements in the As-Cast Condition (Ti-26.4Al-4.8Nb-0.3Fe)



Figure 9. The Coarsened Acicular Structure in the Alloy Ti-24Al-11Nb After Homogenization at 1830°F for 96 Hours



Figure 10. The Equiaxed Alpha Two Structure Formed in the Ti-28A1-5Nb Alloy After Homogenization at 1830°F for 96 Hours

We shall return to a more detailed discussion of the phase and structural relationships in these alloys in a later section.

If the characteristics of individual or groups of alloys are examined, the following trends emerge:

• Most alloys in the Single Element Group appear to offer only a hardness increase over the base Ti₃Al compound. Copper and iron may increase crack resistance. Niobium additions are also beneficial; a point to be expanded upon below. Alloys containing scandium are of interest from both a hardness and phase structure viewpoint. It can be seen that the Ti-25Al-1Sc alloy exhibits the lowest hardness of any alloy in Table 2, after homogenization. If the scandium content is increased to 5%, oxide particles can be observed which have been shown by microprobe analysis to be scandia. Other elements from Group IIIB show similar behavior (see Alloys #24 and #25). It is possible that the low hardness results from an oxygen scavenging action of scandium. As has been found that oxygen content has a marked effect on ductility of some alpha two alloys, the additions of small amounts of Group IIIB elements could be an effective method of reducing the bulk oxygen content of such alloys.

- All alloys from the Multi-Addition Group contain either niobium or zirconium as the third element.
 Examination of the slip/cracking relationships for this series indicates more promising trends in that the cracking tendency, even in the homogenized condition, is reduced. A tendency to improve characteristics as the niobium content increases can also be detected, a trend which carries into the alpha two plus beta system discussed below.
- The majority of alloys in the Interactions Group are also based on Ti-Al-Nb base alloys. In several cases the solubility limit of the interstitial elements were exceeded in the alloys leading to the formation of quite large precipitates, which are probably deleterious to mechanical properties. Examination of these results, and assuming the solubility of the interstitial elements is not strongly dependent on composition, can set the solubility ranges for silicon and carbon, based on the criterion of precipitate detectability in optical micrographs, at between 0.4 and 0.7% carbon and between 0.25 and 0.4% for silicon.
 The alpha two plus beta group contains several alloys with attractive characteristics and as we shall discuss

several alloys in considerably more detail below. It appears from these and other Ti-Al-Nb alloys that the limit of stability of alpha two at intermediate temperatures (\sim 1700°F) along the (Ti-Nb)₃Al compositional line is about 10 atomic percent niobium.

• The alloys produced to study the mixed cubic plus hexagonal structures also contain several compositions with attractive characteristics. It can be seen from Table 2 that in the as-cast condition in virtually all alloys, high hardness values are combined with little or no tendency to crack. Upon homogenization, which was usually accompanied by recrystallization to an approximately equiaxed structure, the majority of alloys soften and show an increased propensity to cracking. It may also be noted that the alloys containing Group IIIB elements contain oxide particles and only very low concentrations of these elements are present in the matrix. Figure 11 illustrates this point for these alloys.

A. Forging

In order to increase the homogeneity and produce structural refinement, a large number of alloys were forged on isothermal dies. This process also served to increase the structural integrity of the material and produced shapes compatible with the sectioning of mechanical property specimens from the forged sections. As an additional step, many of the alloys produced in the form of two-pound drop castings were hot isostatically pressed (HIP'ed) before forging. It has been found that the process increases the material yield to virtually 100% after forging. Nearly all alloys were forged at 2000°F (1090°C), which in some alloys is above the beta transus but in most lies in the two phase alpha (two) plus beta phase field. The forging operation coupled with a relatively slow cooling rate can give rather coarse structures.



Figure 11. Oxide Particles (Scandia) Formed in the Ti-25Al-18.32r-1Sc Alloy (As-Cast)

Over eighty alloys have been forged and an assessment of the forging characteristics together with structural information and hardness values are given in Table 3. It can be seen that a very large number of alloys were forged with no problem, or ly five alloys showing pronounced cracking tendencies. The latter group included the base compound Ti_3Al , although a second ingot forged with only minor difficulty, alloys containing high concentrations of bismuth and germanium (#T1-34, 15) and an alloy from the Ti_3Al-2r_3Al series containing yttrium (#24). Forging reduction of >70 percent in height were achieved in most alloys.

The structure of alloys tended to be refined by the forging

TABLE 3

Isothermal Forging Results for α_2 Alloy Compositions

			•	Forgling	And Boundary	10013	
Committee (ala)	Number	Tennerature	Reduction	(Cracking)	Hardness	Cracking	Mcrustructure
					HV-10		
T13A1	T1-20	2000°F	ł	3	166	I	Single Phase
Sinele Element Addi	tions						
T1-25A1-15c	11- 0	2000°F	64.7	;	229	E/E	
T1-25Al-5Cu	11-11	2000	62.1	1	315	1/3	
T1-25Al-1Ge	11-14	2000	61.9	R	196	A/F	2nd Phase at Boundary
T1-25A1-1Fe	028	2050	63.3	•	338	N/S	
T1-25A1-3Cu	020	2000	81.2	¢	352	N/S	
T1-25A1-14	635	2050	0.3	0	317	E/H	
T1-25A1-3Ta	136	2050	0, 48	×	327	H/H	
T1-25A1-55e	11-9	2000	69.2	s	302	S/S	Single + Oxides
T1-25A1-1Cu	11-10	2000	63.4	0	213	3/3	Single
T1-25A1-1N1	TI-12	2000	17.6	•	286	H/H	2-Phase
T1-25A1-5ME	11-13	2000	66.3	5	306	S/E	2-Phase
T1-25A1-5Ge	T1-15	2000	63.5	3	100	S/S	Complex
T1-25A1-1AE	11-11	2000	64.2	s	276	E/E	2-Phase?
T1-25A1-5AE	11-32	2000	63.3	4	280	2/2	2-Phase
71-25A1-181	EC-11	2000	17.6	2	279	2/2	Single Fine GS
T1-25A1-5B1	11-34	2000	54.6	••	213	N/E	Single Fine GS
71-2JA1-15b	21-15	2000	62.0	0	286	3/E	Single or Two
T1-25A1-55b	11-34	2000	66.1	s	154	W/W	2-Phase
T1-25A1-1Pe	028	2000	01.2	0	278	N/S	
T1-25A1-28e	11-40	2000	67.1	SA	202	W/W	Segregation
T1-25A1-5Be	11-11	2000	71.5	•	11	N/S	2-Phase
T1-22.5A1-58e	11-42	2000	64.7	0	110	N/S	Segregat los
T1-25AL-6Mb	11-53	2000	9.69	•	162	S/H	2-Phase
T1-20A1-72r	020	2000	80.5	0	342	N/S	2-Phase
T1-30AJ-142r	151	2000	80.8	0	401	S/H	2-Fhase
Two or Nore Element	Additions						
rt-25Al-286-26a	1-11	2000	61.9	s	194	W/W	
		0000			170	E/M	Acteular
BOC-BAC-TVC7-11			1 97		2110		
THE-ENC-IVC2-IL	(110)(-1)		1.74				
	146311-11					N/N	2-Phase
T1-23. (JAL-J. /JTA-1	0-11			•			

1.634 0 - None; S = Slight; M = Moderate; E = Extensive

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TABLE 3 (Cont'd)

Constant and Color	Alloy	Forging		Macroeffects	As Forged	Slip/	
		Tenperature	Reduct ion	(Cracking)	Hardn.ss	Cracking	Microstructure
T1-22.5A1-7.5Mb-2.55m	T1-28	2000	67.4	9	HV-10	MIC	
T1-26.4A1-4.8Nb-0.8Fe	\$29	2000	61.3	0	204		
71-25A1-5Nb-2Pd	9-1L	2000	60.3		251		
T1-Z5A1-SMb-1HF	11-37	2000	72.6	C	BPC		
T1-25A1-5Nb-1W	T1-36	2000	64.1	C	118		2-Pisco
11-30A1-5Nb-1W	11-19	2000	ci.5	0	144	• •	
T1-i3A1-55a-5Ge	11-16	2000	05.9	0	141	M/M	
11-23A1-5Nb-1Cu	111	20-00	d.2. 1	0	15	11/14	
1-25A1-556-1N1		2000	5.15	n	122	M/M	
0HI-INI-0:45- TV:0-1H	T1-46	2000	63.2	0	-00	110	
T1-25A1-5N6-1H1-1V	T1 7	2000	04.4	.	14	514	
11-25A1-BND-1W	11-54	2000	11.2		141	515	
T1-25A1-4Nb-1Mo	71-55	2000	1.17			510	
11-25A1-AND-ITa	T1-56	2000	1 1			010	2- Phase
T1-25A1-6Nb-1HE	11-57	2000				-1/10- 5	é-l'liuse
1-25A1-6Mb-1V	T1-58	0002		5.	***	64/H	2-1 hase
T1-25A1-8Nb-1Fe	153	2000			6	A/S	Z-Phase
T1-25A1-8Nb-0.8Fe	154				217	S/H	Fine - Actular
T1-25A1-8Nb-1U			0.10		269	5/H	2-Phase
T1-25A1-8Wh-17-			0.00	3	283	W/H	2-Plune
T1-25A1_BM6_1M6		0000	0.00	c	250	W/W	2-Phase
T1-2541 BNA-10		0007	80.0	0	260	S-M/S	2-Phase
T1-241-644 144 111		2000	0.08	3	256	N/S	2-Phase
AT-INT-GAC-INC-IN	22	2000	0.61	0	299	W/W	
AT-THC O-QUE-TVC7-11	550	2000	67.0	2	273	H/H	Coatae Acteular
Interaction Effects							
T1-25A1-5Mf-0.7C	1-11	2000	75.0				l
T1-25.9AL-9Nb	160	2000		• •		•	Carbides
T1-26A1-9.1M-0.4HF-					294	s/s	
0.851		-	81.4	•	293	5/5	Sil.cides
T1-23.1A1-18.72r-4.68	T1-30	2000	64 4	J			
T1-25A1-5Nb-52r-2.55a-	146	2000			000	2/2	Complex
.2551	:			3	201	H/H	
TI-26A1-9.1Mb-0.4Mf- 0.851	132	2000	80.8	3	262	S/W	
\$1-24A1-11Nb-0.5Cu- 0.2551	T1-50	2000	12.4	0	230	H/H	2-Phase
0 - Nune; S - Slight: M	- Moderate	s: E - Extendior					

TABLE 3 (Cont'd)

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				2.123101		6144	
	Alloy	Forging	E duce fun	Inscretified (CrackIne hold	Mardness	Cracking	Microstruc
Composition (a/o)	Munber	Saperature-			hv-16		
	5	2000	72.5	9	232	N-E/S	2-Pliane
1077 O-14C O-44 - 14 - 14			1 56		247	M/S	2-Phase
Tech. or June 1 and the second		0000		0	269	S/VS	2-Phase
11-11-11-11-11-11-11-11-11-11-11-11-11-	60-11				156	M/VS	Complex
11-1291-100-10		0000	2.15		676	M/S	2-Phase
11-11-1-11-0-11-0-11-11-11-11-11-11-11-1	14-11	0007			900	5/M	2-Phase
11-2441-1100-0.2551	154	2000	4. 61			2/1	2-Phase
11-14.241-11m-0.15h	99	2000	0.08	-	867		
111.0-011-141.44-17	191	2000	90.08	•	237	H- E/H	
Alpha The plase lates System							
X 2 X 0 X 2	645	2000	81.5	0	261	S/S	2-Phase
The second secon	17-11	2000	66.7	•	221	S/S	
Tr. Plate Date - 10		1000	63.5	0	263	N/S	
	111	2000	19.4	0	202	S/S	2-Phase
ment many and Cubic	Systems						
Statistics and a	71-17	2000	5.10	,	216	0/0	Mult lphase
and		2000	6.5.9	•	309	2/5	Multiphese -
ur Erzie andersteine	12-11	2100	1.7	0	329	1	
and the second se	11-22	2000	1.9"	Ģ	367	• •	
and a second sec	71-23(021	1 1700	66.7	•	129	S/S	
	11-24(022	1 1700	76.3	z	263	N/N	
and the second se	T1-26	2000	. 67.6	0	225	8/H	
the larry at 27 So	11-27	2000	67.5	0	124	S/S	
1. 11. 11. 2r. Al-15c	T1-29(123	2000	81.8	•	.62	H/H	OxIdex
VI-12 AI-17	024	2000	87.8	0	202	H/S	Oxides
ALL	025	2000	4.11	s	297	H/H	Oxides'
11-11-12- A1+55a	026	2050	63.3	. 0	0/0	S/S	
Party Alize In	71-19	2000	\$6.8	0	294	E/S	Complex
PACINE AL Zr. AL+SIA	C9-11	2000	65.8	0	600	S/H	Comp lex
The The Tay and Tay and	622	2000	80.6	0	345	S/S	
IL TO AND AND ALZE AL	670	2000	0.18	•	212	H/H	Complex
Bi-IA, TS-IA, ITAG-21	67-11	2000	10.8	•	110	N/S	Complex
and a second sec			¢	•			•

operation; even in illoys forged above the beta transus, a much finer beta grain size was evident compared with the ascast structure. In most cases, however, no major improvement in slip/cracking characteristics were observed in as-forged material; the results tending to lie between as-cast and the homogenized evaluation cited above (Table 4). This result is not surprising in view of the structure/property relationships found in this class of alloys--a point that we shall elaborate on below.

B. Bend Test Results

Sections were prepared from the forged sections and three point bend tests performed over a range of temperatures in order to provide a more direct assessment of the mechanical property capability of the alloys. Before proceeding to the results obtained, some general aspects of these tests will be described. In the early tests performed, the total bend ductility was reported which includes both the elastic and plastic components; rather than change in the middle of the program, this procedure has been retained. As we shall see the total bend deflection corresponds reasonably well to the plastic strain obtained in a tensile test. However, in alloys with a high yield stress, the elastic deflection can be a large component of the total value cited. The maximum strain that can be achieved in the bend rig is 4 to 63 depending on specimen geometry at this point the specimen intersects the lower plate of the fixture thus preventing further displacement. This condition is represented by the designation "plastic" in the following tables. The correlation of the yield stress measured in these bend tests and values obtained in subsequent tensile tests was not as good as the ductility values, although trends were faithfully reproduced. This is no doubt related to the complex strain

TABLE. 4

		Parad - 166019		2	0 = None 5 = Slight M = Moderat E = Extensi
Composition (a/o)	Alloy No.	8 Hr., A.C. HV-10	Slip/ Cracking	1 Hr. A.C. HV-10	Slip/ Cracking
TijAl		226	E/M	•	
Single Element Additions					
T1-2541-1Fe	28	247	н/н	336	M/M
T1-25AL-800	T1-53	-	-	-73	S/VS
1-30AL-72r	50		•	409	M/S
11-30A1-14Zr	51	•	-	589	S/VS
Two or more Element addition	6.8				
T1-25A1-5ND-1Cu	33	258	H/M	290	S/S
71-25A1-5ND-1N1	34	271	N/S-M	302	M/M
11-25A1-5ND-1Hf	43	215	I-H/S	335	M/S
T1-26.4A1-4.8mb-0.8Fe	29	278	H/H	319	M/M
T1-25A1-200-1W	T1-54	•	•	498	0/0
T1-25A1-200-1MO	T1-55	•	•	485	s/0
T1-25A1-000-1Ta	71-56	•	•	414	VS/O
T1-25A1-800-141	T1-57	•	•	456	S/VS
T1-25A1-800-1V	T1-58	-	•	404	S/VS
T1-25A1-800-1Fe	53	-	-	298	3/5
11-25A1-90-0.3Fe	54	•	-	300	S/VS
T1-2, 1-870-14	56	-	-	+61	5/13
71-25A1-8W0-1TA	57	•	-	402	5/0-V3
T1-25A1-80-1Hf	52		-	298	S/VS
71-25A1-800-17	59		•	412	3-M/S
1-25AI-5ND5NI-1U Threfaction Effects	45	290	5/M	259 399	8/V3 W/N
T1-25A1-500-521-2.5802551	46	307	s'/M	329	M/N
T1-26A1-9.100-0.4HT-0.851	32	256	5/5	331	M/S
T1-24A1-11TD 5Cu2551	T1-50	-	-	464	0/0
T1-24A1-11ND 5N12551	T1-51	-	-	402	3/S
T1-24A1-11ND5Fe2551	T1-52	-	•	487	S/S
T1-25A1-800-1854C	T1-59	•	•	302	S///S
T1-25A1-80-13	T1-60	•	•	306	\$/0
11-25A1-8Nb281	T1-61	•	•	477	s /0
T1-24.2A1-1150-0.150	60	-	•	483	8-H/V8
71-34,7-1-16-8-25511	52	:	:	253	870/0-13
Alpha Two Flus Bets Systems	E				
T1-24A1-1176	12	218	8/5	318	8/3
T1-25A1-1510	47	-	•	404	0/0
Mixed Mexagonal and Cubic 4	lystens				
75:25/T1:A1:2-3A1	22	293	H/S	423	H/S
75:25/T13A1:2-1A1+11A	25	257	8/M	•	
75:25/T13A1:2-3A1+55a	26	342	5/5	362	5/M
87.5:12.5/T13A1:2r3A1	49	•	•	393	M/S

gradients present in a bend bar compared with the homogeneous strain in a tensile test. Typically, values of yield strength measured in the bend tests were about fifty percent higher than tensile yield strength.

In the initial stages of this program it had been intended to use the Ti₃Al base compound as the reference point in order to assess relative changes in such factors as the ductile: brittle transition temperature. However, the first Ti₃Al ingot fabricated cracked during forging and thus sound material was not available for testing. Thus, instead, the alloy used in the characterization program (Section III), Ti-25Al-5Nb (Ti-16Al-10Nb weight 3), was used to provide the baseline. As a substantial tensile data base was accumulated on this alloy, it formed a useful comparison point.

A data compilation for all alloys tested is given in Table 5. Nearly all of the initial testing was performed on material in the as-forged condition, as little or nothing was known about the influence of heat treatment. As our state of understanding has improved, material subjected to various thermal cycles has been tested and these results are also included in Table 5.

Turning to the results obtained, it can be seen that the Ti-25Al-5Nb alloy exhibits a reduction in ductility as the test temperature decreases, the values falling below 1% at temperatures <800°F. The alloy shows "plastic" behavior at 1200°F. Thus many tests were conducted in the temperature range 800-1200°F for comparison purposes. Most single element additions produced little or no change in bend properties in this temperature region. However, increasing the niobium content to 8% resulted in the achievement of plastic behavior at 800°F, about a 400 degree improvement with

TABLE 5

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Three Point Bend Test Results for α_2 Alloy Compositions

Composition	Alloy	Heat	Test Tesperature (**)	Strein Rate (outer Fiber) in/in/ain.	0.2% Offset Yield Strength(Kei	Harlaum Fiber Stress at Fracture (Kal)	Maximum Fiber Strain at Fracture (5)
(Program Alloy)	· ·	Trentert Beta Forged +2200'F/1Ac+ 1650'F/8/Ac	M 900 800 800 1100 800 1000 1000 1000 1000	0.0011 0.0012 0.0010 0.0010 0.0010 0.0011	~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~	60.8 58.6 109.1 119.2 117.9 112.7	0.662 0.896 1.37 2.61 2.59 Plantic
т _з м	•	As-Porged	800	١	109.2	113.9	6.935
Bingle Element	Aditions	Ì					
ri-25A1-1 80	11-6	As-Forged	8011	0.0012 0.0012 0.0012	- 12	60.9 62.1 74.9	0.529 0.613 1.08
11-25A2-5Cu	п-ц	As-Forged	1200	0.0049	78.5 Bi.0	80.0 99.2 64.3	1.08 1.38 1.45
11-25A1-1Cu	11-10	2100/1/Ac	800	C.107.0		95.5	0.746
111-122-17	21-1L	2100/1/Ac	800 1000	0.000	68.0 100.0	78.2	1.21 2.32
H-2541-181	11-13	As-Forged	1000	01(0,0		68.7	0.743
1-2541-Ive	11-11	As-Forged	800	0100.0	•	63.9	0.537
11-25A1-15b	m-35	As-Forged	1000	0.0010	•	80.8	0.688
-11-23A1-Ue	924	As-Forged As-Forged 2200/1/Ac	F 8 F	:::	75.0	67.4 102.5 93.5	0.700 1.25 0.600

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Composition (a/o)	Alloy Marber	lieat Treatment	Test Tenture (°F)	Strein Rate (Outer Fiber) in/in/ain.	0.cp Offaet Yield Strength(Kal)	Filer Stress at Fracture (Kat)	Maximum Fiber Strain at Fract (\$)
T1+25A1-210-20a	1-12	As-Forged	1000	0.0012		6:t9	1.05
11-25A1-5ND-5ra	11-J	As-Forged	1000 1832		33 5	40.3 44.6	0.912 Flantic
T1-25A2-536-1Cu	(Ec.5)2-11	As-Forged	1160 1200 1200	C. GAG? 0.0412 0.0412	1.0 (2.0 61.0	73.5 8.9 8.9	1.79 1.46 Hinetir
1-23.75A1-3.75H	n-71-25	As-forged	non	1100.0	•	70.3	6.570
T1-22.5A1-7.5Mb- 2.5Sn	71-28	As-Forged	1398	7,00,0 0100,0 1500,0		26.3 117.9 101.1	0.659 1.01 1.10
			500 2000 2000 2000 2000 2000 2000 2000	1100.0 1000.0 1100.0 1100.0	104.0 95.0 83.5 68.8	130.2 113.7 109.1 107.3 88.1	565.58E
::-3041-516-14	11-39	As-Forged	1000 1100 1100	1100.0 1100.0	179.0 174.5 158.5	196.2 189.8 183.9	1.93 Flatic Flatic
T1-1642-1046-17e (v/o)	62#	As-Forged	1000 1100 1200	0.000) 0.0010 0.0010	120.5 106.5 66.0	121.8 142.6 82.7	1.39 Plantic Plantic
ri-15A1-58n-50e ri-25A1-5Nb-1Mi- 1Nb	71-16 71-40	As-Forged As-Forged	800 KT	0.0012 		118.2 115.2 122.8	1.01 0.825 0.927
ri-25A1-5Nb-1Hi- LV	14-11	As-Forged	001 000 000		108.0 - 87.4	102.2 100.4 130.7	21.6 66.0 9.0

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composition (a/o)	Allar	Instant	Teat Temperature	Strain Rate (Outer Fiber) in/in/ain.	0.2% Offeet Yield Strength(Kei)	Maximum Fiber Stress at Fracture (Kai)	Mariaum Fiber Strain at Fracture (5)
-1-2541-5Be	14-12	As-Porged	3	:	•	39.5	0.861
949-TV\$2-H	ES-12	As-Forged As-Forged 2200/1/Ac	E8 E8	::::	131.7 86.1	134.1 133.9 134.6 228.3	1.09 Maetic 0.877 1.69
-1112-52-511-	\$12	As-Forged	ž F	:	•	6.521	0.78
3		2200/1/40	8 E	: ::	161.8 145.5	130.0 175.7 197.9	1.00 2.40 2.40
	24	As-Porged As-Porged 2200/1/As 2200/1/As	8 = 8 = 8		80.5 309.6	245.9 245.9 245.9	0.608 3.02 1.44 2.42
-241-142-11	ri K	As-Porged As-Porged 2200/1/Ac 2200/1/Ac	F8F8			279.2 279.2 284.3	0.642 1.17 1.45 1.60
No of Bore elem	mt addition						
HL-485-IN2-H	(+6#)5-12	As-Forged	12 00 00 00 00 00 00 00 00 00 00 00 00 00	0.0017 0.0010 0.0012 0.0012 0.0012 0.0012 0.0012	2,25,00 2,20,00 2,00,00	110.9 103.6 117.8 1.72 1.01.2 130.3	0.768 1.39 1.88 3.98 Plaetic Plaetic

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Composition (a/o)	Alloy Mumber	Heat Treatment	Teat Teaperature (*f)	Strain Mate (Outer Fiber) in/in/ain.	0.2% offset Yield Strength(Kei)	Haxlaum Fiber Stress at Fracture (Kal)	Maximum Fiber Strain at Fractu (\$)
TH-25A1-5Mb-1HC	11-37	As-Forged	00 1	0.0010		124.2	0.952
		As-Forged	600	0.0010	117.0	120.4	1.1
		As-Porged	80	0.0011	109.0	14.8.0	3.18
		2100/1/Ac	600	0.009	•	130.8	0.993
		2100/1/Ac	800	0.007	124.0	154.1	1.70
WI-ONS-TAS-IT	T1-38	As-Forged	1,000	0.000	162.0	162.4	1.22
		,	000	0.0014	151.0	157.1	1.7
			006	0.0018	145.0	178.2	3.67
			1000	0.0011	137.0	174.4	3.65
			1100	0.0010	121.5	146.9	Flastic
		2100/1/Ac	900j	6100.0	183.0	217.5	2.45
71-2511-510-1Cn	(33	As-Forged	RT	:	•	80.4	0.71
		As-Forged	800		58.8	104.9	3.77
		1650/8/Ac	Ŧ		•	67.7	0.579
		2200/1/Ac	Ŧ			92.5	0.642
	2200/1/00-2	+1500/8/Ac	ŧ		1	1.92	664.0
T1-25A1-5Nb- N1	154	As-Forged	ħ			40.0	0.516
		An-Forged	800		62.0	99.2	2.06
		2200/1/Ac	ŧ		•	61.8	0.379
	2200/1/00+	1500/8/Ac	t		•	112.9	0.682
T1-25A1-5Hb-1Hf	Ent	As-Forged	ŧ		•	81.6	0.668
		An-Forged	800	_	80.4	135.1	3.26
		1650/8/Ac	Ŧ		•	1.1	0.629
		2200/1/Ac	Ŧ	_	•	158.1	0.933
T1-26.411-4.8hb-	624	As-Forged	Ŧ		þ	70.8	n kns
0.81-		As-Forged	800		89.2	121.1	1.99
		2200/1/Ac	ŧ	*	136.7	130.7	1.19
	2200/1/Ac+	1650/8/Ac	£!		ŀ	4.441	0.832
-m/-TV(2-11	ĩ	VI-LOLÉCO	Bon		106 6	2.5	
			1200		120.1	150.5	3.42
		2200/1/vc	RT		A A	9.141	1.00

TABLE 5 (Cont'd)

Composition (s/s)	Alloy	Tentent	Teat Teaperature (°F)	Strnin Rate (outer Fiber) in/in/win.	0.2% Offeet Tield Btrength(Kel)	Maximum Fiber Stress at Fracture (Kai)	Maximum Fiber Strain at Fractur (5)
NT-940-TV52-11	¥-11	As-Porged As-Porged As-Porged 2200/1/Ac 2200/1/Ac	F8 F8	:	153.5 116.3 349.8 256.5	157.4 187.3 355.5 286.6	1.15 Platte 2.52 2.58
0HL-010-LIVS11	55-EL	As-Forged As-Forged 2200/1/Ac 2200/1/Ac	r8 r 8		145.5 107.1 309.2	149.2 161.9 255.9 348.1	1.19 Plantic 1.72 2.77
11-2541-010-111	24-11	As-Porged As-Porged 2200/1/Ac 2200/1/Ac	2828	-	133.3 83.5 234.9 213.1	149.5 123.2 275.3 258.1	1.76 Plantic 2.60 2.91
11	15-14	An-Forged An-Forged 2200/1/Ac 2200/1/Ac	r8r8		1.4c1 91.1 297.9 215.0	144.5 137.1 327.4 238.6	1.41 Flattc 2.5 1.87
11-910-115-11	95-12	As-Forged As-Porged 2200/1/Ac 2200/1/Ac	es es		126.9 84.4 272.1	148.3 128.9 255.9 329.3	1.89 Flaatic 1.83 3.36
	£	As-Forged As-Forged 2200/1/Ac 2200/1/Ac	F878	_	98.9 156.1	91.6 122.2 202.6 204.2	x 7 2 2 2
19-0-000-TVS-11	\$	As-Forged As-Forged 2200/1/Ac 2200/1/Ac	ešeš		- 1.761 1.761	104.8 125.1 152.4 205.1	0.78 1.43 2.10 3.70

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Composition (a/a)	Alloy	Het.	Test Test (°r)	Strain Rate (Outer Fiber) to/to/etc	0.25 Offset Yield	Maximus Piber Stress at Practure (v_o)	Maximum Fiber Strain at Fract
	and the second se					Teen I	11
AT-OHO-TWC 3-TT	2	Va-Lorged	005	-	138.9	141.0	1.10
			800	-	6.611	179.4	Lastic
	2050/1/9c	h min/Ac	¥			276.0	1.97
			800		262.9	268.1	3.36
T1-25A1-8ND-17a	151	As-Forged	¥			107 0	1
			500	_	5.2	116.8	1.33
			800		88.2	135.8	Flatte
		2000/1/Ac	RT		209.8	264.9	3.01
			800		155.9	217.1	Plastic
T1-25A1-816-1Hr	854	As-Forged	¥		1	4.1	0.72
			200		50.2	122.1	2.05
			800		0, 40	140.6	Plastic
	2050/1/9	c 3 min/Ac	RT			167.3	1.06
			800		226.2	273.6	2.73
11-25A1-010-1V	654	As-Forged	ŧ			105.7	de o
			8		87.8	0.911	
			800	_	02.0	133.7	Plantic
		2000/1/Ac	ŧ		•	170.3	1.33
			800		140.9	213.7	3.89
T1-25.2AL-1116-	N 6c	As-Forged	ł		100.0	135.8	2.80
0.15b			200		87.5	135.2	9.1.6
		covered	800		75.5	130.9	Ilatic
		2000/1/Ac	ŧ		171.4	253.4	flastic
			800	_	140.5	204.9	Plastic
	#61	As-Forged	RT		101.7	140.4	2.92
0.181			80		64.1	133.1	69.4
		covered	900	-,	69.7	0.411	2.78
		2000/1/Ac	ES Ba		142.5	210.4	Plastic Flastic

TABLE 5 (Cont'd)

Composition (a/o)	Alloy	Heat Freetwent	Test Treperature ('T)	Strain Hate (Outer Fiber) <u>in/in/a</u> in.	0.2% Offset Tield Strength(Kal)	Harlaus Fiber Stress at Fracture (Kai)	Harthum Pibe Strain at P (\$)	er Fracture
Interaction	m Effecte							
-JNS-TV5-14	1-11	34/1/ocdt	F3388831	0.0000 0.0009 0.0009 0.0018 0.0001	•••••	91.1 119.6 121.7 1125.7 1125.7 1185.7	0.425 0.717 0.880 1.23 0.917	
27.81-INI-23-17	- 11-30	As-Forged	800 800	0.0010 0.0012	147.0	172.6	1.5	
2°-9111-1742-11	ž	-7072a	FFFS		96.1 109.2 291.6 201.6	118.5 271.1 204.1	1.69 1.76 2.16 Pantic	
ti-2541-516-52r-	Ł	As-Porged 2200/1/Ac	8 1 8		111.8 105.7	1.061 7.311 8. ML	1.52 0.663 2.31	

TABLE 5 (Cont'd)

TL-MAL-LINE- T1-50 An-Porged HT H H0.1 140.9 1.78 5002581 2200/1/Ac 800 800 205.2 273.6 11.91 5002581 2200/1/Ac 800 800 205.2 273.6 11.91 71-2MA-LINE- T1-51 An-Forged HT 117.3 125.9 11.37 0.58142581 T1-71 An-Forged HT 117.3 125.9 11.36 0.58142581 T1-51 An-Forged HT 11.73 125.9 11.36 0.58142581 T1-51 An-Forged HT 11.41 11.40 11.40 0.58142581 T1-51 An-Forged HT 11.41 11.41 11.40 0.58142581 T1-52 An-Forged HT 11.41 11.42 11.40 0.58142581 T1-59 An-Forged HT 11.41 11.42 11.40 0.58142581 T1-59 An-Forged HT 11.41 11.42 11.40 116400 HT 200 HT 11.41 11.42 11.40 116400 HT 200 HT 11.41 11.40 116400 HT HT<	Composition (s/o)	Alloy	Heat Treatment	Test Tenperature ('F)	Strain Rate (Outer Fiber) in/in/ain.	0.25 Offset Yield Strength(Kal)	Maximum Fiber Stream at Fracture (Kai)	Maximum Fiber Strain at Fractur (\$)
T1-3k1-L1Re- T1-51 Au-Forget RT 117.3 125.9 1.26 0.5%L2581 2200/1/Ac RT - 266.6 119.6 Nautic 75.01 70.1 RT - 266.6 119.6 Nautic 75.01 70.1 RT - 266.6 119.6 Nautic 75.01 70.1 114.3 114.3 114.5 2.25 550-2551 70.1 70.1 114.3 114.6 2.25 550-2551 70.1 70.1 114.3 114.6 2.25 550-2551 70.1 70.1 114.3 114.6 2.25 550-250 800 800 70.1 114.5 11.60 116-36 800 800 70.1 114.5 11.60 116-36 800 800 90.1 119.6 11.60 116-36 800 800 122.0 119.6 11.60 116-36 800 1136.6 <	Ti-24A1-1116- 5002551	11-50	Ås-Porged 2200/1/Ac	F8578	:	118.1 80.1 205.2	140.9 126.2 204.2 273.6	1.78 Plantic 1.37 Plantic
T1M1-LINe T1S2 Aa-Forged RT 114.3 147.6 2.25 .5Fe2551 2200/1/Ac RT 79.1 142.6 2.25 .5Fe2551 2200/1/Ac RT 79.1 142.6 2.25 .1.05 79.1 134.6 2.25 1.09 1.09 .1.05 800 800 90.1 134.6 1.09 .1.05 800 800 90.1 134.6 1.09 .1.05 800 800 193.9 1.09 1.09 .1.1-55AL-0He-LIB 71-50 134.6 1.09 1.09 .1.1-55AL-0He-LIB 71-50 134.6 1.09 1.09 .1.1<-55AL-0He-LIB	T1-24A1-11M5- 0.5M12581	15-11	As-Forged 2200/1/Ac	70 2 20 T		80.2 -	125.9 135.6 199.1 246.6	1.32 Plantic 1.40
T1-55A1-0m- T1-59 Aa-Forged RT - 150.9 1.09 LHF-, MC 2200/L/Ac RT 99.1 134.6 Plantic Z200/L/Ac RT 500 1222.0 193.9 1.97 T1-55A1-0m-LB T1-60 Aa-Forged RT 1.65.9 193.9 1.97 Z200/L/Ac RT 500 222.0 RT 1.34.6 1.97 Z200/L/Ac RT 2200/L/Ac RT 2200/L/Ac RT 1.39.6 113.4 1.00 Z1-55A1-0m-LB T1-60 Aa-Forged RT 2200/L/Ac RT 2200/L/Ac RT 2200/L/Ac RT 2200/L/Ac RT 2.43 1.00 1.30.9 11.00 Z1-55A1-0m2M T1-51 2200/L/Ac RT 2.43 2.43 2.43 2.43 Z1-55A1-0m2M T1-51 2200/L/Ac RT 2.43 2.43 2.43 Z1-25A1-0m2M T1-51 2.43 2.43 2.43 2.43	71-24A1-1110- .5Fe25S1	71-55	As-Forged 2200/1/Ac	F 38 F 3		1.411 1.67 -	147.6 142.2 213.4 248.3	2.25 Plantic 1.44 1.82
T1-25A1-Bite-15 T1-60 Aa-Forged RT - 113.4 1.00 2200/1/Ac RT 97.5 126.9 113.4 1.00 2200/1/Ac RT - 193.7 1.36 7 103.7 1.93.7 1.36 7 162.5 210.1 2.43 7 162.5 210.1 2.43 7 162.5 210.1 2.43 7 162.5 210.1 2.43 7 800 7 2.43 7 800 7 2.43 7 800 7 1.30.9 7 800 7 2.43 7 800 7 2.43 7 800 7 1.30.9 7 800 7 1.30.9 7 800 7 1.46 7 800 7 1.30.9 7 7 7 1.30.9 7	T1-25A1-816- 1H14C	T1- 59	As-Forged 2200/1/Ac	F 8 F 8		- 9-1 165.9 122.0	150.9 134.6 193.9 179.8	1.09 Plaetic 1.97 Plaetic
T1-25A1-Dim2mi T1-61 As Forged RT - 130.9 1.16 2200/1/Ac RT - 266.9 1.86 500 - 1.91	T1-25A1-8m-18	09- LL	As-Forged 2200/1/Ac	10 00 10 00 10 00 10 00 10 00 10 00 10 1		87.5 162.5	113.4 126.9 193.7 210.1	1.00 Plantic 1.36 2.43
	T1-25A1-8m-,2m	19-11	As Forged 2200/1/Ac	r 88 75 75 75 75 75 75 75 75 75 75 75 75 75		.5 	130.9 156.6 266.9 278.0	1.16 Plaetic 1.88 1.91

TABLE 5 (Cont'd)

Composition (a/o)	Alloy	Hast Prestment	Teat Teaperature (°F)	Btrain Rate (Outer Fibar) in/in/min.	0.2% Offaet Tield Strength(Kal)	Fiber Stress at Fracture (hei)	Mariaum Fiber Strain at Practure (\$)
Alpha two p'us Be	sta Bratana			:-			
all-1412-17	21	As-Porged	ŧ		105.8	128.8	2.08
			800		88.0	157.3	Plantic
			1000	_	0.00	6.90	Plastic
						22.3	Plastic
		3650/0/Ac			9.19	108.6	1.27
		27/20/1/Ac	12	_	0.461	179.2	2.77
			800	_	0.601	157.0	Plantic
71-25.241-10.18	11-12	As-Porged	Ł	·	102.3	130.6	2.17
36			e l		66.1	1.721	3.60
			800		65.3	103.6	Plastic
		2200/1/Ac	Ŧ		6.161	150.4	1.89
T1-25A1-1086-	21-10	As-Forged	ž		•	9.%	1.03
H			E		•	5.3	1.11
			80		83.8	100.9	1.55
			80		68.4	125.0	Plantic
		2200/1/AG	Ł	-	193.1	232.0	8-68
			80		149.7	239.9	6.30
			1200	_	101.9	9.141	Plastic
H-2541-15-1	A7	As-Pared	H		106.9	165.1	Plastic
		As-Torned	t		1.11.	168.9	3.8
		As-Forged	800		8:1	143.3	Plastic
		2200/1/Ac	t		249.0	292.1	5. N
		2200/1/Ac	800		228.5	283.4	3.44

TABLE 5 (Cont'd)

Composition (a/o)	Alloy Mumber	Haat Prestment	Test Temperature ('F)	Strein Rate (Outer Fiber) in/in/ain.	0.25 Offaet Tield Strength(Kal)	Maximum Fiber Stress at Fracture (Kai)	and Ther at Preture
Mined Haragaonal	and Cuble	Systems					
E12:14 HT/02:02	11-18	As-Forged	H	0.012	158.5	217.4	Mastic
A			00	0.0012	155.0	210.4	Plantic
			60	0.0010	152.0	200.9	Plantic
			900	0.0011	162.0	205.5	Flatte
			1000	6000.0	153.5	211.3	Flastic
25:75/H3M:213	11-11	As-Porged	1100	0.0012		106.1	1.22
5			1200	0.0012	90.06	102.9	1.72
75:25/THJA1:2r3	61-IT	As-Forged	100	0.0012	102.0	0.911	1 27
4			909	0.0018	111.5	146.8	06.0
			800	0.0011	100.0	150.1	2.74
			8.	0.0011	110.0	1/1.9	1.76
		2100/1/Ac	800	0.0006		218.4	1.50
95:5/T13A1:2r3	n-26	As-Porged	1000	0.0012		79.9	0.901
90:10/TH3A1:2r3	12-12	As-Forged	1000	0.0012	0.2II	125.5	1.50
Infra	121	As-?orged	F 00	0.0010	137.0	130.7	Plast 1c
25:75/113A1:223	11-22	As-Forged	800	1100.0		238.1	1.95
50:50/T13A1:ZF3	11-23	As-Forged	1000	0.0019	•	157.9	1.69

TABLE 5 (Cont'd)

Composition (s/o)	Alloy Manber	Nest and	Teat Teaperture ('F)	Strain Pate (Outer Filer) in/in/ain.	0.25 Offset Yield Strength(Kai)	Maximum Fiber Stress at Fracture (Keil)	Maximum Piber Strein at Fracture (5)
Erz: 11/52:51	11-24	As-Forged	٢ş	0.0019 0.0019	136.0 135.0	144.8	1.43 1.93
			88	0.0018	126.0	194.4 209.9	3.30 Plastic
75:25/H3M:2r3	54-57	As-Porged	E	0.0012	•	0.521	0.964
VI+SIA			89	1100.0	0.161	135.9	1.36
			8	0.0012	126.0	168.4	2.67
75:25/H3A1:253	(12-U)22	As-Porged	E,	•	ı	105.5	6.789
2		- Ken Man	81		101.3	165.8	Plantic o ada
		2200/1/Ac			• •	109.5	0.700
			ż		٠	129.2	1.36
		bn/005/259T	1 8	-	8.1	171.6	0.794 Plastic
75:25/HAVIEr	1+ Jes	A5-Porged	004			63.2	0.762
ALL ALL			800		99.0	130.8	0.707
75:25/11-11/22:57	1+ 256	As-Porest	ž			104 2	0.744
Sen J			800		149.9	175.2	2.37
		2650/0/Ac	Ŧ			96.1	0.610
		2200/1/Ac	٤I		•	6.1 2.2	0.510
		m/T/my	IN		•	×.1	66C.0
82.5:12.5/HJAI:	64	As-Porged			•	6.18	0.598
regul		ZZ00/J/Ac	Ł	+		2.171.5	1.15
			8		190.0	5.062	K.N

52

<u>34</u>.
TABLE 5 (Cont'd)

.1

Maxlaum Fiber Strain at Fracture (\$)	0.902 Flatic 1.17 2.58
Harlaum Fiber Stream at Fracture (Kai)	129.1 223.1 2.471 2.48.5
0.24 offset Tield Strength(Kel)	1247 205.9
Strain Rate (Outer Fiber) in/in/ein.	:>
Test Temperature (*)	F8F8
Heat Treatment	Aa-Forged 2200/1/Ac
Alloy	64-11
Composition (a/o)	75:25/T13M: Zr3A1+U8

ethese numbers represent total atrain

--Outer fiber strein rate 0.0007 to 0.0020 inch/inch/ainute

54.

respect to the baseline alloy. In the two (or more) element additions group, nickel results in a slight improvement in properties with respect to the baseline, but most other modifications tend to produce a wider and flatter ductility transition zone. For example, the addition of one atomic percent tungsten (Ti-38) results in an equivalent ductility value at 400°F to the baseline alloy at 800°F although "plastic" values are observed at nearly the same temperature. By increasing the base niobium contents to 8% in this class of alloys, considerable improvements are evident. For example, alloys Ti-54 through 58, containing a fourth transition element, show bend ductilities at room temperature equal to those at 800°F for the baseline alloy. Scaling up these alloys to the two-pound ingot level led to some reduction in properties in the as-forged condition, but these could be restored by heat treatment (again these differences can be traced to Section Size/Heat Treatment/Structure Effects discussed in more detail below).

Results from the Interactions Group, which contains examples of the higher niobium content alloys discussed in more detail below, conform in general to comparable alloys without additions of silicon, carbon, etc. As the aim of these additions was to modify creep rupture behavior, the retention of bend properties can be taken as an encouraging preliminary result.

Alloys from the third subdivision, Alpha Two Plus Beta Alloys, show the best bend ductility. For example, the Ti-24Al-11Nb alloys show bend values at room temperature equivalent to the baseline alloy at 1000°F. It would appear that the onset of good low temperature plasticity occurs between 6 and 11% Nb and these attractive characteristics are maintained up to 15% Nb. Further, the addition of small amounts of bismuth,

antimony or silicon do not change the ductility values at room temperature. Indeed the alloy containing antimony (#60) was the first example of an alloy with >4% bend ductility at ambient temperature. We shall deal with the effect of heat treatment on structure and tensile properties in the next section; it is sufficient at this stage to note that results in Table 5 indicate a strong effect. A summary of the improved ductility characteristics produced by increasing niobium content is given in graphical form in Figure 12.



Figure 12. Bend Ductility as a Function of Temperature in Ti-Al-Nb Alloys

The last group of alloys, mixed cubic plus hexagonal type, were evaluated before the alpha two plus beta systems discussed above. Initial results were encouraging in that the model system, Ti_3Al-Zr_3In , showed plastic behavior over the entire range of temperatures tested. Further, the results obtained on the $Ti_3Al:2r_3Al$ base alloy (#22, $(Ti_{0.75}Zr_{0.25})_3Al)$ showed good bend properties compared with the baseline alloy. Evidence of plastic behavior at room temperature in the heat treated condition was obtained. However, it was noted that the quite high zirconium content of the alloys tended to compromise the oxidation characteristics of the base alloy, for evidence of rapid oxidation at temperatures as low as 800° F was obtained. Reducing the zirconium content (e.g., alloy #49) improved the oxidation characteristics but bend ductility was reduced. Another discouraging feature was that all attempts to modify the properties of the $(Ti_{0.75} Zr_{0.25})_{3}$ Al base alloy by additions of a fourth element were unsuccessful. Indium, tin or lanthanum containing alloys showed lower ductility and the several heat treatments applied to these alloys did not produce any improvement. Thus, we have tended to de-emphasize these alloys in more recent studies.

C. Heat Treatment and Structure

As the program has proceeded, it has become increasingly clear that the structural modifications that can occur in various alloys have a critical effect on material properties. It should be noted at the outset that many of the kinetic and structural details of transformation in these alloys are imperfectly known. Much needed analysis by TEM and other techniques is in progress at the present time at Carnegie-Mellon University and the University of Florida. However, the general characteristics of transformation are known and especially in the Ti-Al-Nb system show many similarities with most dilute alloy systems.

A schematic phase section along the composition line Ti_3Al -(TiNb)₃Al is shown in Figure 1?, which also includes the approximate position of the martensitic transformation that occurs on quenching from the beta phase field. The characteristics of the martensite formed in Ti-Al-Nb alloys



Figure 13. Schematic Phase Section Along the Composition Line (TiNb)₃Al

(although with slightly different compositions) were studied by Williams and Blackburn. (7) It was shown that the transformation in the base Ti₃Al and dilute alloys was similar to that observed in pure titanium; large rather ragged plates of the alpha two phase forming on quenching. Although the ordering reaction could not be suppressed the domain size can be very small in quenched structures. At higher niobium contents (10) very fine martensitic structures are formed and at yet greater concentrations the beta phase is retained on quenching. Tempering of the quenched structures can lead to rather complex structures; there is a tendency in both the single and two-phase regions for a recrystallization type reaction to occur at the grain boundaries. An example is shown in Figure 14(a). Such transformations, if taken to completion, can convert a fine acicular structure to a coarse almost equiaxed condition, see Figure 14(b). As the niobium content increases the cendency to this recrystallization tends to diminish. The tempering reactions in the beta phase have not been studied in great detail to date, but it appears that the anticipated precipitation of the alpha two phase occurs in the form of fine lathes.

As we shall see, very rapid quenching of these alloys from the beta phase field is not a practical heat treatment method as it results in strong and rather brittle structures; further these structures may be unstable on tempering. The tendency to form cracks on quenching is another reason for avoiding such treatments.

Structures formed by less severe cooling rates are therefore of more interest from a practical standpoint. Here again the parallel with conventional titanium alloys is quite striking, including the dependence on initial structure. If a conventional alpha-beta alloy is worked in the two-phase



 (a) Initiation of reaction at grain boundaries in Ti-25Al-2.5Fe water quenched from 2050°F and tempered for one hour at 1400°F.



- (b) Completion of the reaction to form an equiaxed structure in Ti-25Al-5Nb water guenched from 2200°F and tempered for 87 hours at 1500°F.
- Figure 14. "Recrystallization" Reaction Produced by Tempering Some Martensitic Structures in Alpha Two Alloys

region, an equiaxed mixture of the two phases is formed and the beta phase may transform on subsequent cooling. Similar structures can be formed in alpha two alloys, examples are shown in Figure 15(a) and (b). Heat treatment or forging above the beta transus will result in acicular structures. In alpha two type alloys, these may range from a virtually unresolvable structure after quenching, Figure 16(a), to a coarse colony (groups or packets of plates with similar orientation) structure, Figure 16(b). Intermediate cooling rates produce a Widmanstatten arrangement of much smaller alpha two plates; an example is shown in Figure 16(c).

Compositional modification of a Ti-Al-Nb base alloy can change the phase equilibria, however, the evidence seems to indicate that these changes are reasonably straightforward. Transition elements tend to act as beta stabilizers, and it appears that the higher the group number, the greater is this tendency. Thus the addition of 1% of nickel can stabilize the beta phase in a Ti-25Al-5Nb alloy; this element may also influence the ordering tendency in the beta phase, but additional information is needed to prove this. It is possible that additional phases may be found as more is learned; for example, iron additions could lead to the formation of Ti₂Fe identified in Ti-Al-Fe alloys.

The Ti-Al-2r system and related alloys have not been as extensively evaluated in the present study. The anticipated lowering of the beta transus by increasing zirconium content was confirmed. Two-phase mixtures of the DO_{19} and Ll_2 phases were found in the Ti-Al-2r-In alloys and produced rather photogenic structures, an example is shown in Figure 17, and it appears that a rather small amount of Ll_2 structure can form in the $(Ti_{0.75} r_{0.25})_{3}$ Al alloy. In modifications of the latter alloy the phase structure ture becomes very complex and is not fully understood.



(a) Ti-24Al-llNb-0.5Ni-0.25Si forged near the beta transus showing equiaxed primary alpha two in a coarse transformed beta matrix.



- (b) Ti-25Al-5Nb-lNi worked low in the alpha-beta phase field showing predominantly equiaxed alpha two and grain boundary transformed beta.
- Figure 15. The Influence of Alpha-Beta Working on Alpha Two Alloy Structure



The Influence of Cooling Rate from the Beta Phase Field on Structure of Alpha Two Alloys Figure 16.



Figure 17. Transmission Electron Micrograph Illustrating the Heavily Faulted DO₁₉:Ll₂ Phase Mixture Observed in Alloy Ti-12.5Al-37.5Zr-12.5In, (Ti₃Al)_{0.5}(Zr₃In)_{0.5}

7. Mechanical Properties

A. Hardness

As can be seen from the above sections, a large number of hardness determinations have been performed during the course of these studies. In cases in which tensile properties have been measured subsequently, it has been found that the hardness (VDN) can be correlated with the room temperature yield strength (oy) through the following relationship.

$$\sigma y = \frac{VDN}{3.2}$$

Use of this equation has proved a quick and inexpensive method for assessing the mechanical property capability of the alpha two type alloys after heat treatment.

B. Tensile Testing

A much smaller number of alloys were selected for tensile testing and it must be noted that many tests remain to be completed. Table 6 lists the results obtained up to April, 1977. Again, a useful point of comparison are the tensile data obtained for the Ti-25Al-5Nb alloy presented in Section III. In nearly all cases, specimen blanks were heat treated prior to machining; the heat treatments selected were derived in part from the bend results cited above and also by an iterative process. It must also be noted at this point that oxygen content of this class of alloys may prove to have a dominant effect on ductility. As noted in II.4., these materials were prepared with a very low oxygen content in the 0.04 to 0.05% range.

TABLE 6

Tensile Results for a₂ Alloy Compositions

Com- position (a/o)	Alloy No.	Hyat Treat- ment	Test Temper- ature (17)	0.21 Cffset Yield Strength. (ksi)	Ultimate Tensile Strength (kg1)	S Elong- ation (Plastic)	S Reduction in Area
TigAL	22	1500/1/AC	RT RT 800	80.6 68.8	80.4 80.6 94.3	0,42	2.4
T1-25A1-5Nt-1Cu	33	2200/1/AC	RT 500 1200	83.5 73.2 68.8	97.8 122.6 85.1	1.4 2.1 5.4	2.3 9.3
T1-25A1-5N65N1-1W	55	22 00/1/A 2	RT 500 400 400	106.8 39.0 21.1 55.7	110.6 109.3 120.5 91.4	C.4 1.2 1.3 3.6	1.7 7.6 12.0
T1-25A1-5ND-1N1-1*	45	2200/1/AC	87 67 500 1200 1200	131.1 123.8 108.0 67.4 62.1	144.0 140.9 152.0 91.1 59.2	C.75 O.91 L.8 3.6 L.6	3.1
11-26.4A1-4.8T0-0.8Ft	29	2200/1/AC	RT 500	75.2	87.0 83.8	0.30 0.63	1.7
11-25A1-3m-17e	53	2200/1/30	RT 500 300 1200	89.5 71.8 70.1 62.9	89.9 85.0 102.5	0.L 1.1 3.8 5.5	1.6 2.5 9.2 6.4
11-25A1-7Nt8Fe	54	220C/1/AC	81 500 900 1200	100.0 81.1 65.9 77.9	109.0 121.7 111.2 107.0	0.6 4.4 5.3 9.2	0 6.5 11.2 9.3
TI-2 6A1-9.100445- 851	32	2200/1/AC	RT 500 1200	140.6 127.2 106.2	141.0 151.2 127.7	0.43 1.9 2.1	2.4 3.1
T1-24A1-11MD	42	As-Forged 2200/1/AC	RT RE 1200 RT	66.2 60.2 35.9 157.7	75.0 74.4 57.2 165.7	0.90 1.45 12.6 1.0	3.3 3.2 12.9 3.9
		2200/1/FC 1975/1/AC	RT RT	175.4 110.3 67.5	188.0 140.1 86.2	0.73 4.9 1.68	7.1 3.3
T1-24A1-11m25S1	52	2200/1/TC 2000/1/2/AC 2000/1/AC	RT 1200 RI RT	66.4 42.2 78.2 92.5	86.5 66.8 105.8 119.6	3.1 14.9 3.1 3.2	4.9 31.0 3.1 5.0
T1-25A1-15N	47	2200/1/ T C	RT 500	102.4 86.1 79.1	128.6 123.8	3.9	4.9 7.3

TABLE 6 (Cont'd)

Cir polition {b/c}	Alley R	heat Treat- ment	lest Temper- ature ('F)	Cffset Yield Strength (ksi)	Ultimate Tensile Strength (ksi)	5 Elong- ation (Plastic)	\$ Reduction in Area
71-29A1-5ND	38	2200/1/AC	57	50.4	67.2	0.3	2.8
11-15a1-072-14	50	2000/1/SC444:	a√ RT	115.7	138.3	0.95	-
T1-25AL-30-178	57	200° '1 /AC	PT	127.0	130.2	0.3	
T1-25A1-8W-1HS	· 53 ·	2050/1/SC 3 Min/AC	RT	130.4	·	(<0.2)	
11-2542-207-1V	• 59	2000/1,/AC	RT	150.3	•	(>0.2)	-+
Ti-2241-11NE15E	60	2000/1/AC	77	118.9	149.9	2.90	-
1-221-11Nb1Bi	61	2000/1/AC	RT	154.0	-	(-0.2)	

S.C. - Slow Cocl

S.Q. - Salt Quench

· · Eroke in Grip

+ - Broke in Fatensameter Ridge

The alloys based on Ti-25Al-5Nb with ternary and quarternary additions show limited ductility at room temperature, although the copper modification (#35) does show over 1% elongation and 2% reduction in area. Alloys containing nickel and tungsten uppear to have improved ductility at intermediate temperatures compared to the baseline alloy. Likewise, the modifications of the 8Nb base alloy show improved intermediate temperature characteristics. However, it can be seen that major improvements are available at higher niobium contents.

In the Ti-24Al-11Nb alloy, the ductility and strength can be related to the structure as is done in Figure 18. A rapid cooling rate results in a partially transformed structure with a high yield strength and finite but not large ductility. Intermediate cooling rates result in a fine Widmanstatten structure with good ductility and a strength level >100 ksi. Slow cooling rates give a colony type structure with associated low strength and ductility. Similar strength results were obtained for the same alloy modified with silicon but the ductility values showed less variation.

C. Creep Rupture

Testing to date has been performed at 1200°F/55 ksi for the majority of alloys. As a point of reference, the alloy Ti-25A1-5Nb (Ti-16A1-10Nb weight %) exhibited a life of 90 hours under these conditions which on a density corrected basis is equal to INCO 713C. Data for alloys tested to date in this program are given in Table 7, and it can be seen that large variations in creep capability are observed. In Ti-25A1-5Nb base alloys, both copper and nickel additions reduce creep rupture life; comparison of the lives of alloy #55 and #45 show that the lower the nickel content, the better the lives. On the other hand, iron additions may have much





TABLE 7

Creep Rupture Results for u_2 Alloy Compositions

Composition	Alley	jieat Treat- nent	Test Temper- ature	Stress	14 Creep	Time To Rupture	Elong- ation	Reduction In Area
a/o)	H.	('F/HRS)	(°F)	(ksi)	(Hrs)	(Hrs) _	(%)	(2)
75:25/Ti3A1:Zr3A1	ន	1800/1/AC	2021	2	•	;		
Ti-25A1-5hb-1Cu	33	2200/1/AC	1200	55	2.37	7.5	7.6	9.3
ri-24. 32A1-4.9805581-1.0%	4 · V	2200/1/AC	UDZT	ŝ	12.97	53.10	6.6	ć.6
ті-15А1-5776-1И1-1й	ţ,5	.r.Forged 2200/1/AC	1200	55 55	0.64 +	3.0	7.0	6.0
T1-26.4A1-4.8m8Fe	29	2200/1/AC	0021	55	101.1	345.0	4.9	,
T1-25A1-Bit-lfe	ß	As-Forged 2200/1/AC	1500 1200	15 55	1.83	25.0 ćn.a	21.6	71.0
T1-25A1-6tb-, 8FC	ĸ	As-Furged 2200/1/AC	1500 1200	15 55	1.35 3.26	25.4	20.6	60.4 17.2
ті-26а1-9. lid laf 8s:	32	2200/1/AC	1200	55	178.7	344.2	1.5	2.9
T1-24A1-1NG	42	As-Forged 2200/1/AC	1200	55 55	1.52	B.O.L.	32.1	33.3
12-11-12 12-11 12-11	25	2200/1/FC 2000/1/2/M 2000/1/AC	1200 1200 1200	55 55	0.0 3.37 3.08	5.5 61.4 68.1	14.4 9.4 9.2	23.2 12.5 4.2
T1-25A1-15Nb	14	2200/1/FC	1200	55	23.4	130.9	3.6	6.4

. • * •

less influence on life; in alloy #29, however, the aluminum content is slightly higher and this in itself may contribute to the excellent life of >340 hours. As the niobium content of the alloys is increased to 8% and in the presence of iron (#53 and #54), the creep rupture capability is close to the goal. Again in a similar base alloy with slightly higher aluminum content and small additions of hafnium and silicon, a threefold increase in life is obtained.

Further increases in niobium level into the range in which ambient temperature tensile ductility is achieved produces a marked change. The Ti-24Al-llNb alloy shows very poor life in the as-forged condition, which it should be remembered exhibits low strength. Even in the heat treated condition, however, the life capability is still about an order of magnitude less than the goal level. The addition of silicon (#52) improves the situation considerably bringing the life values back to about two-thirds of the required level. Surprisingly, the rupture life improves again in the Ti-25Al-15Nb alloy, indicating that low temperature ductility can be combined with adequate stress rupture properties.

In most of the alloys tested stress rupture ductility was adequate; if we take the nickel base alloy INCO 713C as the guideline about 5% elongation would indicate a useful goal. A slight trend to lower ductility can be detected for alloys with aluminum contents >25%. The other point of interest is the outstanding ductilities of the iron-containing alloys tested at 1500°F, although the rupture lives are poor. Earlier work at P&WA had indicated the beneficial effect of iron on ductility although the effect seems confined to the higher temperature range.

The one test performed on a Ti-Al-Zr type alloy resulted in

a very low life which could serve to reinforce the conclusion that this base system is not a good base for further alloy development.

Testing on the Ti-Al-Hf-C alloy (Tl-1) was conducted in the early stages of the study and the results demonstrated for the first time the superiority of beta processed structure. The test result at 1200°F showed a life improvement of five over goal properties, but this advantage was not maintained at higher temperatures.

8. Summary and Conclusions

From an initial "broad brush" attack on the problem of ductility in alpha two type alloys, the search for attractive alloys is narrowing to the T1-Al-Nb system. Even within the Ti-Al-Nb system, some property compromises are evident, for the achievement of ductility is accompanied by reductions in stress rupture capability. The situation can be represented schematically on a ternary diagram. as shown in Figure' 19, which includes both rupture lives and also indicates alloys in which ductility has been observed at room temperature. It can be seen that improved ductility and creep rupture properties can be achieved in alloys with high niobium contents (e.g., Ti-25A1-15Nb) which is an undesirable direction because the density increases. Another direction is to increase the aluminum content, a more desirable modification from a density veiwpoint, but indications are that . tensile ductility tends to be reduced by such modifications. A more complete study of the influence of Nb:Al ratio in these alloys is clearl warranted and will be undertaken in the third year of this program.

An alternative method of improving stress rupture properties,





without compromising discillity, is the addition of elements capable of introducing dynamic strain aging at high temperatures. One experimental alloy containing silicon has been tested and the results indicate that an improvement in creep rupture life has been achieved. It is probable that other elements or combinations may be necessary to produce improvements at higher temperatures (v1400°F; but, at present, this is speculation. This approach is derived directly from conventional high temperature titanium alloy practice; it will be interesting to see now far the parallels between these and the alpha two systems extend. For example, would zirconium be an effective addition to a silicon alloy modification?

Another direction of actor development that is being actively pursued is the replacement of some of the niobium in Ti-Al-Nb alloys by other transition alements. Depending on which element is selected, roductions in density could be accomplished by such modifications. There are indications that the strength levels can be markedly changed by the addition of the early transition elements, as the results from the Ti-25Al-8Nb series indicate. The latter transition elements, such as copper, iron and nickel, may produce some changes in ductility, but appear to reduce both elevated temperature tensile strength and stress rupture capability. The only problem with evaluating these potential effects are the large number of variables or compositional modifications that can be produced. Completion of the test program currently in progress may indicate some of the more promising directions.

One difference between the Ti-Al-Nb base alpha two alloys and conventional titanium alloys is in the influence of structure on properties. Beta processing of conventional alloys tends to produce both lower strength and ductility

while the reverse seems true in alpha two alloys. There are certain parallels in achieving creep rupture resistance batween both alloys, but even in this case the details seem to differ somewhat. Thus a fine Widmanstatten structure appears to produce the best creep rupture properties in alpha two alloys, whereas coarser colony accular structures are superior in conventional alloys. One of the most challenging aspects of the successful development of alpha two alloys is defining the optimum heat treatment. The efforts to do so have been discussed above and some progress can be claimed, however, thermal stability and other factors still need elucidation. The achievement of the desired structures in material of various section sizes is not a trivial problem and will be discussed in more detail in Section III.

The other alloys that have been studied, although offering some advantage in at least ductility over the base compound, do not seem to be as attractive as the Ti-Al-Nb base alloys discussed above. Although some of the model systems based on the Ti-Al-Zr system show attractive ductility characteristics, the alloys are impractical. Further attempts to perturb the $DO_{19}>Ll_2$ reaction towards the Ti_3Al composition have not been successful and this approach has been abandoned for at least the present. No other candidate ternary system has emerged from the studies.

Thus we conclude that the Ti-Al-Nb system appears to offer the best systems for achieving the goal properties in Ti₃Al base systems. Ductility at room temperature can be produced coupled with useful tensile strength levels. Heat treatment/ structural control are a critical element of controlling properties. The results obtained to date are promising and can be used to point the way to additional alloy development.

III. ALLOY JUALE-UP AND CHARACTERIZATION

1. Introduction

The objectives of this segment of the program were to produce sufficient quantities of high quality wrought product to conduct a detailed property evaluation. The mechanical property evaluations were performed using test techniques and conditions pertinent to the requirements of high temperature engine components.

In the first year of the program, one alloy was selected for evaluation. Although little background information was available at that point in time, it was decided to choose an alloy from the Ti-Al-Cb system; specifically, the alloy Ci-16Al-10Nb* (Ti-25Al-5Nb). Further a powder metallurgical approach to alloy fabrication was selected based on the success of this method for TiAl alloys at the Air Force and the Government Products Division of Pratt & Whitney Aircraft. The powder was consolidated by H1P and subsequently forged. After a screening program to determine the process cycle which gave the best combination of properties, this procedure was applied to sections of the forgings. A comprehensive mechanical and physical property evaluation was performed on this material.

Alloy selection for the second year effort was based on the results of the Alloy Development program described in Section II. Three alloys were chosen all based on the Ti-Al-Nb system

^{*} In this section the alloy compositions will be given in weight percent; the composition in atomic percent will be given in brackets the first time an alloy is cited.

as follows:

Ti-13.5A1-21.5Nb	(TI-24A1-11Nb)
Ti-13.5A1-21.5Nb-0.1Si	(Ti-24Al-11Nb-0.25Si)
Ti-15A1-16Nb-3.8Hf	(T1-25A1-8Nb-1Hf)

Ingots of these alloys were prepared by conventional consumable arc melting, conditioned and forged. A more limited mechanical property test program is in progress on material from these forgings. Emphasis is placed on the determination of tensile and creep rupture properties over a range of temperatures and a fatigue evaluation at 800°F.

2. Experimental Techniques and Results

First Year Program - The alloy selected for study in the first year's program was Ti-16A1-10Nb (Ti-25A1-5Nb atomic %). The planned characterization program is represented in Figures 20 and 21. Task I effort centered on the screening of process conditions to define the parameters for Task II characterization.

A. Material Procurement and Consolidation

Eighty-five (85) pounds of nominal Ti-16Al-10Nb rotating electrode powder produced by Nuclear Metals Corporation was supplied by the Air Force. Starting ingot for this powder was produced by Teledyne Titanium. The analysis of ingot and powder materials is shown in Tables 8 and 9.

Powder consolidation was performed by hot isostatic pressing using the following procedure. Four powder containers welded from 0.065" thick Ti-5Al-2.5Sn sheet stock, with the configuration shown in Figure 22, were fabricated. Net cylinder length prior to consolidation was approximately 9" with a







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Figure 21. Property Characterization

şa.

TABLE 8

Chemical Composition of Titanium Aluminide Alloy

Element	Spec. Max.	Cast Bar	Powder (Nuclear Metals)	Fowder (P&WA)
Ti		Bal.	Bal.	Bal.
AL	16.3	16.25	16.46	15.9
Съ		9.94	10.25	10.3
н	.01	.0089	.0041	.0019
N	.01	.0086	.0012	.01
0	.10	. <u>12</u>	.0839	60.
Za	.01	<.01	٢٥٠.>	<.01
с	.02	.010	.0070	.006
Cu	.02	.025	.01	<.01
Fe	.05	.065	.06	.04
S	.05	.025		<.002
w	.05	<.05	<.01	<.01
Ni	.01	.035	<.01	.01
Mg	.01	<.001	<.01	<.01
Mn	.01	<.001	<.01	.002
Мо	.02	<.001	<.01	<i>₹.</i> 1
Sn	.02	<.001	.04	.01
Si			.015	<.1

Heat 398 - T1-15.8A1-10Cb

TABLE 9

Nuclear Metals Reported REP Titanium Aluminide Powder Size Distribution

HEAT 398 - T1-15.8A1-10Cb

Percent Retained on Screen:

Mesh Size	Percent
35	0
45	0.1
60	5.4
90	49.5
120	23.1
170	13.3
230	5.8
325	2.2
Pan	0.5

Average particle si	ze:	185 microns	
Apparent density	:	2.67 gm/cm^3	
Top density	:	2.83 gm/cm3	

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Figure 22. Photo Showing Titanium Hot Iscstatic Press (HIP) Container After Can Filling and Sealing -Note "Dished" End Cover diameter of 5.75". All welds were produced by standard inert gas tungsten electrode techniques. Each container was checked with a helium leak detector to verify its integricy prior to filling. Powder was outgassed in a vacuum chamber at room temperature for 16 hours to a pressure of 2×10^{-5} mm Hg, followed by hot tumbling in vacuum for 4.5 hours at a temperature of 400°F to a pressure of 2×10^{-5} mm Hg prior to filling. Approximately 17.5 pounds of powder was loaded into each evacuated container and the fill tubes were crimped and TIG weld sealed while maintaining full vacuum conditions.

Hot isostatic pressing was conducted at Industrial Materials Technology Incorporated (IMT), Woburn, Massachusetts, under conditions of 2250°F (1232°C)/15,000 psi argon pressure for three hours. Containers were supported by a bed of 0.25" diameter Algo, balls during isostatic pressing. A conselidated powder billet is shown in Figure 23. Thermally induced porosity (TIP) tests were conducted on micro sections cut from the fill tube for each container. This test consists of micro-examination of the consolidated powder after high temperature-ambient pressure exposure and is designed to determine the general effectiveness of argon outgassing. If argon outgassing is unsatisfactory or if minor leaks occur during cold argon pressurization prior to hot isostatic pressing, argon "bubbles" occur at powder particle interfaces during the thermal exposure. TIP samples for each of the four consolidated containers were exposed to 2250°F for four hours. Microexamination showed no thermally induced porosity in any consolidation. Typical photomic:ographs after this test are shown in Figure 24.

Since all consolidation were sound and free from porosity, one container was selected at random and sectioned into three pieces for forging process evaluation. A phe-inch thick



Figure 23. Photo Showing HIP Container After Hot Isostatic Press at 2250°F/3 Hours/15 ksi #



Figure 24. Microstructure of Material Exposed to 2257%F/4 Hours Thermally Induce? Porosity Test

circular section was retained for "as-HIP" evaluation and two sections, approximately 2½" thick, were used to produce simple upset forgings.

B. Forging

The beta transus of the consolidated powder billet was determined by micro-examination of thermocoupled samples which were thermally exposed over a range of temperatures and water quenched. The beta transus temperature was determined to be in the range of 2150°F to 2175°F (1176°C to 1190°C). Figure 25 shows the microstructure of samples used for this determination.

Based on this information, a beta forging temperature of 2200F (1215°C) and alpha two plus beta forging temperature of 2050°F (1120°C) were selected. One upset hot die forging was produced for each of these conditions and the resultant forgings are shown in Figure 26. The forgings were completed on subscale GatorizingTM equipment in a chamber evacuated to 5 x 10^{-5} mm Hg and at a controlled strain rate of 0.05 inch/inch/minute. Billet sections were spray coated with boron nitride lubricant prior to pump down. The thermocoupled dies and work piece were equilibrated at the selected forging temperature with induction heating coils for one hour prior to deformation.

C. Screening Program

The completed forgings were sectioned and heat treated according to the schedule shown in Table 10. (Description of the specimen configuration and preparation procedures are given below.) Three tensile and two creep rupture specimens were machined for each processing condition. Standard tensile tests were performed at room temperature, 1200°F (649°C) and 1400°F



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 $\alpha_2 + \beta$ forged (q)

Isothermal Forgings Produced for Screening Evaluation Figure 26.

Phase I, Task I Process Screening Mechanical Properties of Ti-16Al-10Nb

Tensile

None Tentencie Za, work Za, work <th< th=""><th>Condition</th><th>Heat Treatment</th><th>Condit_ Jn</th><th>0.2 15 . 45:</th><th>1121</th><th>13,</th><th>¥4.</th><th>uile ans</th><th>Stre</th><th>12</th></th<>	Condition	Heat Treatment	Condit_ Jn	0.2 15 . 45:	1121	13,	¥4.	uile ans	Stre	12
2307 (1 kr.) 1-307 h at 1-306 h at<			800 Tenperature 1200 F 1400 F 1400 F 150 431	22,-30	15.25	3.6	1.23	auftrire an	6.5	F. 5
zöörf, arl 013 quent dom fam rature 1, w 20, w <		2230"5(1 hr) 011 Quent	1-20-1 481					Patraci	•	
220 I dri Air Joul - Ban Jenerate - Good Buy		22009(1 nr) 011 quencn - 1050°F (ë Hr) Atr Sool	Roun Centerature Lastrie Louis Constantine Louis Constantine Lastrie	41.00	8.4	9 3 6			ن در د ا	
 Zeoner I. Hari Numace [20] - Files Francis - 27, 10 251 1.10 4.1 Jáporr Ö Henel) Air 1991 1.10 - 27, 10 251 1.10 4.1 Jáporr Ö Henel) Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 - 27, 10 251 1.10 4.1 Zirright Henel Air 1991 1.10 4.1 		22% 1 Hr) Aur Joul - 10% 7 (2 Hrs.) Air Joul	30.4. Les *roure 12. 2. 5 12. 0. 7 12. 0. 7 1. 0. 7 61	-6. xiu	22.8)(•••			1	J •
2057 P.4 Mr.) Air Vool - Lar terjenning - 33,10 - 1 16507 (3 Are.) Air Vool 1		220°F I Hri Furnace 101 - Jósuf S Hre.) Air 101		21. 0		1. 2 8 8 8 -0 N				÷.
2 75 14 Mr Furnace but a dur affacture incomplete 155.7 (2 Mrs.) Aur but 14 15 12 10 12 10 10 10 10 10 10 10 10 10 10 10 10 10		207519'1 Mr.) Alr Cool - 155917 (3 Hrm.) Alr Judi				14 g				
		ë 75 ti din Punake jul - Lebrit je dre.) Air jul		12		7 - 1 7 - 1	• .•• ;			•

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TABLE 10 (Cont'd)

Stres Riture				
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Carl Tonelle (bai) (bai)	M. House States	27,900 Incomplete 27,000 33,400 Feet Deferred		
Pest Condition	Fom Tenjerature 12:00* 14:00* 12:00* 12:00* 15:00* 14:00*	Moon Temperature 1200'F 1400'F/55 ket 1400'F/50 ket		
ant from sent	2019°F (48 Mm.) ALF Cool • 1696°F (5 Mm.) ALF Cool	2015'F (40 Ers.) Purace 2001 + 1650'F (8 Ars.) Air 201	1 speciess	2.094 - 4.0091 2.669 - 4.0091 2.669 - 4.0091 2.867 - 4.0691 2.0511 - 4.6622 2.0511 - 4.6622
Porting Comittion	, Alphas - Beta 2050'F	~ 0 3	Neelble prior creck in	temperature convertions

(760°C) at a strain rate of 0.005 inch/inch/minute. Rupture tests were performed in conventional lever operated load frames at 1200°F/55 ksi and 1400°F/40 ksi. In each elevated temperature test, temperature was equilibrated for one hour prior to loading.

The microstructures of material given the various treatment cycles are given in Figures 27(a)-(f). In the as-oil quenched condition, an extremely fine martensite is produced which is extremely unstable upon subsequent aging at temperatures as low as 1200° F, Figures 28 and 29. As a result of this instability, the beta solution treated quenched and stabilized condition 2a (Figure 27), exhibits large apparent clpha two grains near prior beta grain boundaries and occasional large grain patches dispersed through the structure.

The mechanical property data for the screened structural conditions are given in Table 10 and it can be seen that only two treatments result in adequate tensile and stress rupture properties, conditions 2 and 3.

The tensile strength and stress rupture properties of the oil quenched and tempered condition are similar or slightly superior to those of the air-cooled condition 3, however, the tensile ductility of quenched material is significantly lower than that of air-cooled material. Because of the generally low tensile strengths at 1200 and 1400 °F, all other conditions exhibited poor stress rupture properties at these temperatures (Table 10). In fact, the ultimate tensile strengths were near to, or slightly lower than, the selected screening stresses for stress rupture testing. Tensile and stress rupture tests were conducted concurrently as a result of schedule limitations so no readjustment of rupture test stresses was possible for the screening effort.











Figure 29. Microstructure of Ti-16Al-10Nb Alloy, Beta Forged + 2200°F/1 Hour/OO + 1500°F/87 Hours/AC Showing Instability of Quenched Martensitic Phase

D. Test Program

Based on the results of the screening program, conditions were selected for the forging and heat treatment of the HIP'ed billets. Prior to forging the ends of three HIP'ed billets (the fourth billet was used in the process screening portion of the program), they were sectioned and the billet ends were machined flat and parallel. Protective tantalum sheets were spot welded to the end of each ingot to prevent billet/ die diffusion bonding. Isothermal forging was conducted at Ladish Company, Cudahy, Wisconsin, under the supervision of Fratt & Whitney Aircraft personnel. Forging was completed in their Production Gatorizing equipment on TZM molybdenum alloy tooling. Ingot sections and die surfaces were spray coated with boron nitride lubricant prior to pump down. Forging was conducted in vacuum at a pressure of 10⁻³ mm Hg and at a controlled strain rate of 0.1 inch/inch/minute.

The beta transus temperature was previously determined to be in the 2150°F to 2175°F (1176°C to 1190°C) temperature range. Based upon this information, an alpha two plus beta forging temperature of 2050°F to 2075°F (1120°C to 1135°C) was selected for processing in order to obtain a fine prior beta grain size in the resulting forging.

All billets were preheated in an attached vacuum furnace prior to being mechanically transferred, via air locks, to the Gatorizing chamber. The thermocouples dies and work piece were equilibrated at the forging temperature with induction heating coils for one-half hour prior to deformation. Subsequent to each forging run, the die surfaces were spray coated with boron nitride lubricant. Forgings were air cooled off the dies in all cases by means of air locks.

Table 11 summarizes the forging results for the three trials and Figure 30 shows a typical forged pancake. The processing sequence yielded a heavily worked equiaxed microstructure as shown in Figure 31.

Based on the processing screening effort, a beta phase field solution heat treatment (2200°F) was selected for the alloy char_cterization effort. In an effort to maintain the smallest possible prior beta grain size, an experiment was conducted to determine the grain size resulting from heating to 2200°F as a function of time between 15 minutes and 2 hours. Examination of polished micro-sections for all conditions showed a beta grain size of approximately 0.7 mm, indicating very rapid grain growth at a temperature only slightly above the beta transus.

TABLE 11 Isothermal Forging Results

Billet Number Temperature, *F Strain Pate, in/in/min	135 2050±25 0.1	136 2075±25 0.1	137 2075 0.1
inel Height, in	2.00 1.06	1.19	
Percent Reduction	62	36	2
Estimated Final Flow Stress, ksi	4.2	4.4	



Figure 30. Pancake Forging Configuration Produced for Ti-16A1-10Nb Alloy Characterization







Based on these results a solution treatment of 2200°F for one hour was selected to achieve uniformity in the full forging sections. The rapid beta grain growth characteristic during heat treatment obliterates the alpha-beta forging grain size.

The completed forgings were given a 2200°F/l hour/ran air cool solution treatment followed by a 1650°F/8 hours/air cool stabilization treatment. It was found that a fan air cool was necessary to produce an acicular microstructure throughout the approximately one-inch thick forging; an as-heat treated microstructure is shown in Figure 32. Subsequent to heat treatment, the forgings were sectioned for machining. Table 12 lists the specimens utilized in the characterization program. In most cases test specimens were prepared for the physical and mechanical property evaluation using conventional machining techniques for brittle materials, electrochemical machining (ECM), electrodischarge machining (EDM) and electrochemical grinding (ECG) were possible. Threaded specimens were eliminated also based on the restricted low temperature ductility of the material. Mechanical test specimens prepared by conventional machining techniques (notch rupture, thermal fatigue, FCHR, HCF, notched LCF and, in some cases, impact (toughness)) were given a vacuum stress relief at 1650°F for four hours. This stress relief treatment produced no observable effect on microstructure. After machining each specimen was examined by zyglo inspection techniques to reveal any surface cracks or imperfections. All subsequent mechanical tests were performed in siz.

1) Tensile Testing

The specimen used for tensile property evaluations is shown



100X

Figure 32. Microstructure of Ti-16Al-10Nb Pancakes Heat Treated at 2200°F/1 Hour/Rapid Air Cool + 1600°F/8 Hours/Air Cool

Tensile data for Ti-16A1-10Nb in the range in Figure 3. of room temperature to 800°F (427°C) to 1500°F (815°C) are shown in Table 12 and Figure 33. Considerable scatter in these data is apparent for test conditions where ductility is limited. Plastic deformation sufficient to define a yield strength is not consistently observed in this alloy until temperatures of 1000°F and above. The static modulus of elasticity determined from strain gaged tensile specimens was 19.5 x 10⁶ psi at room temperature. Two 800°F tensile tests were conducted for beta anneal (2200°F (1204°C)/ 1 hour/air cool) heat treatments without the addition of the 1650°F/8 hour stabilization originally selected as baseline for the characterization task. An increase in ultimate tensile strength was observed with the elimination of the stabilization step; however, there was no increase in ductility (Table 13).

2) Charpy Impact

Conventional Charpy impact tests were performed over the range from room temperature to 1600°F (871°C). The data are shown in Table 14 and Figure 34. Impact fracture energy increases significantly between 800°F (427°C) and 1200°F (649°C). This is the same apparent transition range observed for tensile ductility. This result is considered promising since it might have been expected that the general strain rate sensitivity of the material would cause the impact transition to occur at a significantly higher temperature than the tensile ductility transition. Impact toughness in the projected operating temperature range of 1200-1500°F is generally equivalent to advanced nickel-base alloy materials.

Summary of Phase I, Task II -Characterization Property Testing

Test Type	Test Specimen	Test Temperature (*F)	Number of Specimens	Machining Technique
Nodulus	Button Hend	70	4	800
Thermal Exp. Coef.	Ber	70 - 1500	1	Creventional
Specific Heat	Bar	70 - 1500	1	Conventional
Thermal Cond.	Bar	70 - 1500	1	Conventional and EDM
Tensile	Button Head with Extensometer Ridges		20	BCC.
Creep Rupture	Button Head with Extensioneter Ridges	1000 - 1500°F	20	206
Notch Rupture	MDL 2362	1000 - 1500°F	10	Convertional
Thermal Fatigue	NGTE Disk MDL 4694	Cyclic 1500" - 70"7	16	Conventional
Impact Toughness	MDL 2317	RT, 800, 1200	6	Conventional
FCPK	MDL 6197	800, 1200	2	Conventional and EDM
HCF	Martinehause MDI 9391		19	
Smooth Notched	Westinghouse MDL 2332	800, 1400	12	Conventional
ICE				
Smooth	AML 42-2-68	800, 1200	12	ELG .
Notched	(MERL 4) K12	ano, 1200	12	Conventional





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TABLE \3Tensile Properties for Ti-16A1-10Nb

Seat Freateant	Test Tesperadure 7	0.25 Yield Strength issi	Ultimate Strength ksi		Reduction in Area 5
22.0°7. 1 Hr. A.C. +	78	•	58.2	•	
	RT	•	53.9	0.05	•
	RT	•	34.0		•
- 1 - I - I - I - I - I - I - I - I - I	800	•	47.1		•
	900	•	49.6	0.15	
	800	48.4	58.9	0.58	2,4
	1000	51.6	58.4	1.6	3.8
	1200	14.5	56.5	3.1	4.2
- 1	1400	43.0	62.0	5.2	9.0
1	1500	43.8	55.9	3.1	5.3
22007, 1 Hr. A.C.	800	•	83.5		-
4050 7, 1 Hr. A.C.	9.00	47.9	63.8	0.90	-

"Specimens stress relieved: 1650"7, & Mrs., Vacuum

Charpy Impact Toughness of Ti-16A1-10Nb

Test Temperature (°F)	Charpy Impact Toughness ft. 1bs.
RT	1.03
RT	1.03
RT*	0.69
400*	1.32
800	2.1
800	1.7
800*	1.7
1200	4.9
1500*	. 8.8

*Specimens stress relieved: 1650 T, 4 Hr. Vacuum

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3) Creep Rupture

Specimens used for the creep rupture evaluation are shown in Figure 3. Smooth section creep rupture testing was conducted over the temperature range 1100-1800°F (393-982°C). Data are shown in Table 15 and Figure 35. Both 1% creep and stress rupture capability exceed original predictions by a significant margin. The data are consistent with a potential extension of the useful application temperature beyond the original estimate of 1500°F.

The notched K, 3.8 stress rupture capability for Ti-16A1-10Nb is inclcated in Table 16 and Figure 35. The alloy is generally not notch sensitive in the 1200 to 1500°F (648 to 815°C) temperature range at this notch acuity. There is a large noticeable tendency for notch stress rupture life to exceed smooth life by a larger margin as temperature increases. At lower temperatures (~1100°F), notch and smooth capability are about equal. Although an extended operating temperature range could be predicted from these results, the limit could be set by another criterion such as surface stability. Microstructural analysis of creep rupture test specimens showed interesting behavior related to long-time air exposure at elevated temperature. During exposure at 1200°F (649°C) and above, a thin oxygen enriched layer (alpha case) is formed on specimen surfaces which grows very slowly with time. At exposure times of 100 hours, this diffusion layer is less than 0.6 mils (1.5 x 10^{-3} cm) for test temperatures of 1200, 1300 or 1400°F (649, 704 or 760°C). As a result of the large creep strains occurring during stress rupture, small surface cracks are formed which extend to the depth of the alpha case (Figure 36). The cracks stop at this interface and only extend as the alpha case grows. At creep strains

		TABLE 1	15	
Creep	Rupture	Properties	for	Ti-16A1-10NE

Test Tesperature 	Stress ES1	Time to 15 Creep Hr.	Time to Rupture	Elongation	Reduction in Area <u>5</u>
0011	60.0	43.0	235.3	0.3	5.9
1200	50.0	24.5	379.6	7.4	7.3
1200	55.0	3.5	92.2	9.4	7.3
1300	35.0	126.0	803.5	9.8	10.5
1305	40.0	41.0	144	5.8	7.9
1300	45.0	8.3	84.2	9.1	7.5
1400	20.0	172	Wy Disc.	3.4	3.6
1400	30.0	33.0	335.1	22.9	22.3
1400	40.0	•	32.3	10.7	9.1
1500	10.0	244	306.3 Disc	. 1.3	3/1
1500	15.0	70.0	1654.8	26.7	51.4
1500	25.0	17.6	:38.5	15.4	19.0
1500	30.0	5.0	54.9	15.3	16.9
1600	10.0	38.5	526.4 Disc	e. 8.9	ó.3
1600	15.0	13.0	368.3	36.6	35.9
1600	20.0	9.0	81.0	23.3	20.1
1700	5.0	34.5	1030 (Runai	ing)	
1700	10.0	5.0	323.6	47.0	50.8
1800	7.0	3.0	208.3	57.9	57.5





Notched Stress Rupture Properties for Ti-16A1-10Nb

Test Temperature	Stress ksi	<u></u>	Time to Failure Hr.	Time to Failure for Smooth Specimen (Equivalent Condition) Hr.
1100	60	3.9		163.7 Running
1200	50		246.2	379.6
1200	10		24.3 Uploaded	
:200	20		23.7 Uploaded	
1200	30		23.9 Uploaded	
1200	40		14.0 Uploaded	
1200	50		73.7 Uploaded	379.6
1200	50		22.5 Uploaded	
1200	70		2.0 Aupture	8.0 (From Larson Hiller Curve)
1300	45		522.3	84.2
1400	30		1200 Amains	335.1
1500	10		336.8 Uploaded	306.3 Disc.
1500	30		144.7	54.9
1500	15		1670 Running	1654.8
1500	5.		705.4 Uploaded	
1600	10		1250 Running	(1575 From Larson Hiller Curve)



Longitudinal Cross Sections of T1-16Al-10Nb Creep Specimens Showing Alpha Case on Specimen Surface. Figure 36.

of less than 1%, these cracks apparently do not form at all. At higher temperatures and longer times the diffusion layers are somewhat deeper so that after $1500^{\circ}F$ ($816^{\circ}C$)/1655 hour exposure, the layer is approximately 2 mils (5 x 10^{-3} cm) thick. The surface cracking phenomena is again observed at very large creep strains, but the cracking is contained within the diffusion layer at high temperatures also (Figure 37).

4) High Cycle Fatigue (HCF)

High cycle fatigue tests at both 800°F (427°C) and 1200°F (649°C) were conducted for both smooth, K_t 1 and notched, K_t 3.8 specimens after 1650°F (899°C)/4 hours/vacuum stress relief. The low stress electrochemical grinding technique used for the majority of the other specimen configurations could not be used for the high cycle fatigue specimens since tooling was not available.

Conventionally machined notched HCF specimens were inspected by fluorescent penetrant which indicated that several specimens contained grinding cracks. In order to alleviate high residual grinding stresses, the specimens were stress relieved and specimens were again inspected by fluorescent penetrant; although no cracks were detected after this procedure, some specimens were found to contain very small tight craze cracks during post-HCF test microexamination. (Since these cracks were apparent in the grip area which has a very low applied stress during the fatigue test, they are assumed to have been present prior to testing.) Data from these potentially pre-cracked specimens were not used in estimating 10⁷ cycle fatigue capability.

The data for all HCF testing is shown in Table 17 and plotted



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Longitudinal Cross Sections of T1-16A1-10Nb Creep Specimens Showing Alpha Case on Specimen Surface Figure 37.

Westinghouse High Cycle Fatigue Data for Ti-16A1-10Nb

7 = -1

Tesc Temperature T Frequency Stress ksi Cycles to Failure Kt. 008 800 1.0 1800 30.0 1.0 x 107 Disc. and Uploaded 1.0 x 107 Disc. and Uploaded 800 1.0 1800 40.0 1800 1.0 x 107 Disc. and Uploaded 300 1.0 50.0 1800 1.5 x 106 800 1.0 60.0 1.0 x 107 800 1.0 1800 3.0 1.0 x 10⁶ Potential Crack 1800 45.0 600 1.0 7.0 x 106 1.0 1800 800 50.0 1300 9.5 x 105 800 1.0 50.0 300 1.0 1800 55.0 2.2 x 105 1.3 x 105 800 1.0 1800 60.0 1.3 x 10⁶ Potential Crack 1200 1.0 1800 40.0 1800 1.5 x 10⁵ Potential Crack 1200 1.0 40.0 1200 1.0 1800 45.0 6.5 x 10⁶ 6.0 x 106 1200 1.0 1800 50.0 2.2 x 105 1200 1.0 1800 55.0 3.0 x 105 1.0 1200 1800 60.0 3.8 1.0 x 107 Disc. 800 1800 15.0 800 3.8 1800 20.0 1.0 x 107 Disc. 1.0 x 107 Disc. 800 3.8 1800 25.0 1.0 x 107 3.9 1800 30 800 1.0 x 10⁷ Disc. 1200 3.8 1800 10.0 1.0 x 107 Disc. 3.8 1800 15.0 1200 1.7 x 10⁵ 1200 3.8 1800 20.0

in Figure 38. The smooth (K_t 1) HCF stress capability for 10⁷ cycle life for Ti-16A1-10Nb is estimated to be 45 to 50 ksi at 800°F and 40 to 45 ksi at 1200°F. Only runout (>10⁷ cycle life) data are available for K_t 3.8 specimens at 800°F, reflecting apparently unjustified conservatism in planning the first tests; however, a runout stress of 25 to 30 ksi was clearly evident. Limited K_t 3.8 testing at 1200°F suggests a runout stress of 15 ksi.

5) Strain Controlled Low Cycle Fatigue (LCF)

Strain controlled low cycle fatigue tests were performed at 800°F (426°C) and 1200°F (650°C) on specimens shown in Figure 39. The test results are given in Table 18 and Figure 40. The 1200°F tests show very little scatter and are fully comparable with behavior expected for nickel-base alloys such as Waspaloy^R and INCO 718 in this temperature range. Data for the 800°F condition show considerably more variability which is probably related to the limited tensile plasticity of the material at this temperature.

In spite of the limited plasticity at 800°F, there was evidence of some work hardening during the tests as shown by the load range versus cycle plot for the longer life tests (Figure 41). At 1200°F the work hardening behavior of the material was quite marked (Figure 42). An improved alloy composition with a lower ductile brittle transition temperature should markedly improve LCF characteristics for applications where very high tensile loads can occur at relatively low temperatures. Examination of overload surfaces showed considerable evidence of cleavage intermixed with local areas of ductile tearing (Figure 43(a)). Fatigue striations, similar to those observed in conventional materials, were clearly observed in the cyclic fracture



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Smooth Low Cycle Fatigue Properties of Ti-16A1-10Nb, Strain Controlled

Temperature	Longitudinal Strain Rarge	<u>Kt</u>	Frequency, cp	Cycles to Failure
800	0.0030	1.0	5	To be Run
800	0.0035	1.6	5	45
800	0.0035	1.0	5	1,270
800	0.0040	1.0	5	ó5
800	0.0040	1.0	5	9700
800	0.0050	i.0	5	1650
1200	0.0035	1.0	5	105,089 Disc.
1200	0.0060	1.0	5	1,655
1200	0.0075	1.0	5	691
1200	0.0100	1.0	5	103





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region as shown in Figure 43(b).

6) Notched (K_t 2.0) Low Cycle Fatigue

Notched (K_t 2.0) low cycle fatigue tests were performed at 800°F (427°C) and 1200°F (650°C) for stress relieved (1650°F/4 hours) specimens machined by conventional lathe turning techniques. The stress relief procedure was adopted based on fluorescent penetrant evidence of local cracking in the lathe turned notches of some specimens and the previous cracking observed in HCF specimens which were also not produced by low stress ECG techniques.

Data accumulated for these tests are shown in Table 19 and Figure 44. As with the notched HCF testing, considerable conservation was used in planning the initial tests and as a result a series of long life tests were produced. An uploading procedure was adopted to determine the range of proper test stresses. To date, it has been determined that stresses in the range of 40-45 ksi are appropriate for the 800°F tests and that the 1200°F stress should be in the range of 37.5 to 42.5 ksi for less than 100,000 cycle life. These stresses are considerably higher than might be expected for the material based on its limited plasticity at low temperatures.

Micro-examination of the notch area of the 800 and 1200°F load controlled specimens shows an equiaxed recrystallized layer, approximately 2 mils (5 x 10^{-3} cm) thick at the specimen surface (Figure 45). This condition was not present on the K_t 1 specimens used for the strain controlled tests and apparently resulted from the rather severe conventional lathe turning operation used to produce the specimen notches. The recrystallized layer may have produced




TABLE 19

Notched Low Cycle Fatigue Properties of Ti-16A1-10Nb

Test

Tempers ture	itzves <u>ksi</u>	frequency ton	Kt	Cycles to Failure
500	25.0	10	2.0	95,323 Disc.
300	27.5	10	2.0	106,510 Disc.
800	30.0	10	2.0	71,463 Disc. and Uploaded to:
900	35.0	19	2.0	109,760 Disc. and Uploaded to:
600	40.0	10	2.0	101,213 Disc. and Uploaded to:
ò00	45.0	10	.3	10.290 Failed
1200	25.0	15	2.0	134,326 Disc.
1200	27.5	10	2.0	104,757 Disc.
1200	27.5	10	2.0	92,213 Disc.
:200	32.5	10	2.0	67,941 Disc. and Uploaded to:
1200	37.5	10	2.0	5,501 Failed
1200	37.5	10	2.0	100,000 Disc, and Uplosded To:
1200	42.5	10	2.0	In Test







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the contrasting 800 and 1200°F behavior for smooth and notched conditions. In any case, it is not clear whether the recrystallized layer improved the 800°F notched life or reduced the 1200°F notched life.

7) Crack Growth Rate Testing

Crack growth testing was performed at both 800°F and 1200°F for precracked center notched panels, illustrated in Figure 46, which were machined from the original pancake forgings by conventional grinding techniques. Considerable surface cracking was observed on these panels prior to test similar to that found in the conventionally ground HCF specimens. Since limited material availability precluded replacing the specimens, it was decided to perform the tests noting that propagation of the surfac :racks could affect the data. Some surface crack propagation and link up were observed during both 800°F and 1200°F tests, however, the data obtained (Figure 47) appear to plot in a generally consistent manner. Because of the machining crack phenomena, these data should be considered as only preliminary indications of crack growth rate. An indication of material toughness was obtained from crack length and load at onset of unstable fracture. At 800°F, a Ko value of 15.7 ksi/inch was obtained. At 1200°F, the Ko was 21.3. These data also may be influenced by the presence of surface cracks.

8) Physical Properties

The thermal and electrical resistivity of Ti-16A1-10Nb in the range from room temperature to 1500°F are shown in Table 20 and specific heat is shown in Table 21. Table 22 gives data for the coefficient of linear thermal expansion. These data are slightly higher than the coefficients of



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Figure 46. Center Notched Panel for Fatigue Crack Growth Measurement



Figure 47. Crack Growth Rate for Ti-16A1-10Nb

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TABLE 20 Thermal and Electrical Resistivity of Ti-16A1-10Nb

Temperature		Electrical Resistivity	Thermal Copductivity			
		-80.00	and degk -	Btu in h"+ ft ieg?"		
25	77	173	7.0	42.5		
200	392	185	9.0	62.5		
400	752	. 188	11.5	79.5		
600	1112	187	14.1	97.5		
800	1472	187	16.6	115.0		

TABLE 21Specific Heat of Ti-16A1-10Nb

1'emp	erature	Specific Heat					
	<u> </u>	J kg ⁻¹ degK ⁻¹	Btu 1b ⁻¹ degF ⁻¹				
25	77	560	0,134				
200	392	610	0.146				
400	752	660	0.158				
600	1112	700	0,167				
800	1472	740	0.177				

TABLE 22

Coefficient of Linear Thermal Expansion of Ti-16A1-10Nb

TROPERATURE		TREBNAL EXPANSION	TENER	TURE	COEFFICI	TANSION
c		(3L/L0)x10 ⁴	c		10 desc-1	10 ⁵ der7
20	64	-	-	•	•	-
100	212	7.6	20 - 100	58 - 212	9.5	5.3
200	392	17.3	20 - 200	64 - 392	9.6	5.3
300	572	28.0	20 - 300	68 - 572	10.0	5.6
400	752	38.8	20 - 400	68 - 752	10.2	5.7
500	932	49.9	20 - 500	68 - 932	10.4	5.8
600	1112	62.6	20 - 600	68 -1:12	10.6	5.9
700	1292	73.6	10 - 700	68 -1292	10.8	6.0
800	1472	\$6.8	20 - 800	68 -1472	11.1	6.2
	1					
•		•				
	·					
	1					

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expansion of conventional titanium alloys such as Ti-6Al-2Sn-4Zr-2Mo, but are considerably lower than nickel-base alloys such as INCO 713C and Waspaloy^R, Figure 48. The relatively low thermal expansion coefficient for Ti-16Al-10Nb should favorably impact the thermal fatigue resistance of the alloy.

9) Thermal Fatigue

A series of thermal futigue tests were completed using standard NGTE disks with 0.020 and 0.040" edge radii. Considerable difficulty was encountered with machining cracks resulting from the conventional grinding operations used to produce these specimens as discussed in the previous section. An attempt was made to remove the machining cracks by a combination of electro-polishing and mechanical polishing prior to test, however, this was generally unsuccessful without modifying specimen edge geometry beyond acceptable limits. As a result, it was decided to perform the tests, even though small metallographically visible pre-cracks were present in all specimens, in order to determine the general tendency for cracks to propagate in thermal fatigue. The resulting test data are shown in Table 23.

The grinding cracks extended to the approximate 5 mil (1.3 $\times 10^{-2}$ cm) size, normally detected by fluorescent penetrant inspection as a pinpoint crack, within 50 to 100 cycles from 1500°F to rocm temperature for both 0.020 and 0.040" edge radius specimens. Growth to a 3/16" crack generally occurred after 200 to 450 cycles with the high stress 0.020" radius specimen and in greater than 700 cycles for the lower stress 0.040" edge radius specimen.

Second Year Program - The second series of alloys chosen⁴⁴ for more complete mechanical property characterization were



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TABLE 23 Thermal Fatigue Results for Ti-16Al-10Nb

	scontinuation	3/16 # 200	3/16 # 350	3/16 6 450	3/16 @ 200	017 . 31/6	3/32 - 1/8 0 150	3/16 e 1275
	3/16 01	200	350	450	200	1		
. To:	178		250		100-150		800	510
Cycle	7/35	;	ł	:		670		
	79/1					Lot	009-005	150
1	Pin Point	8	150	100	8	57	300	8
	Line ala	N	8	N	~	2	8	8
		N	N	N	N	~	~	~
	Treas.	1500	1500	1500	1500	1500	1500	1500
-	Ĩ	ŧ	t	t	¥	Ħ	¥	2
	(.11)	0.020	0.020	0.0%0	0.020	0.040	0.040	0.040

1

selected from the results of the Alloy Development Program described in Section II. Ingots prepared from the chosen alloys, forged to pancakes and heat treated prior to specimen preparation. A more limited test program was performed on these specimens, emphasis being placed on tensile and creep rupture property characterization together with a limited fatigue evaluation. To date, three alloys have been melted and forged, with aim composition as given below:

> Ti-13.5A1-21.5Nb Ti-13.5A1-21.5Nb-0.1Si Ti-14.5A1-16Nb-3.8Hf

Mechanical property testing is complete for the first alloy but is still in progress on the last two and results will be presented in later reports.

A. Characterization of Ti-13.5A1-21.5Nb Alloy

Based on the results of the subscale ingot program, an initial chemistry--Alloy #42, Ti-24Al-11Nb a/o, Ti-13.5Al-21.4Nb w/o--was selected for the scale-up evaluation. A 20-pound ingot was triple consumable melted by Titanium Metals Corporation of America (TMCA), Henderson, Nevada. In order to insure homogenaty, a Ti-Nb master alloy was used as starting stock for the 20-pound melt. The chemical analysis of the ingct is shown in Table 24.

Visual inspection of the cast product revealed the ingot to be sound and free of macroscopic cracking. The ingot top was also sound and no surface connected shrinkage porosity was observed. To improve product yield and integrity, hot isostatic pressing (HIP'ing) was conducted in the Pratt & Whitney Aircraft, East Hartford, Connecticut,

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TABLE 24

Chemical Composition of Titanium Aluminide Alloy TMCA Heat V5301, Ti-13.5Al-21.4Nb

		PSWA		
Element	TMCA*	Тор	Bottom	<u>Aim</u>
Ti	Balance	Balance	Balance	Balance
A1	13.3	14.7	13.7	13.5
ND	18.6	20.8	19.9	21.4
Fe	0.16	0.09	0.10	
0	0.19			
N	0.024			

* Average of top and bottom chemistry.

HIP unit under conditions of 2250°F (1232°C)/15,000 psi argon pressure for three hours. Subsequent to the HIP treatment, the ingot was x-rayed using an in-house facility to evaluate material integrity. Radiogravic analysis revealed a completely sound ingot which was free of any observable internal porosity.

Prior to forging, the ends of the ingot were machined flat and parallel and the ingot OD was turned smooth. Protective tantalum sheets were spot welded to the end faces of the ingot. The ingot was isothermally processed at 2000°F (1090°C) and 0.05 inch/inch/minute to 1" thick plate configuration. The isothermally forged pancake was furnace cooled subsequent to deformation. Forging results are summarized in Table 25 and the pancake configuration is shown in Figure 49. The processing sequence yielded a fine, ASTM 9-10, educated alpha and intergranesar beta morphology, typical of a structure forged low in the alpha-beta field, illustrated in Figure 50(a), with an as-forged Vickers hardness of 257. The beta transus was determined to be 2175-2000°F (1190-1204°C). This transus temperature is higher than anticipated based on the 1975-2000°F (1079-1093°C) transus determined for Alloy #42 (T1-13.5A1-21.4Nb w/o). However, the increase can probably be traced to the much higher oxygen content of the ingot material (0.19%) compared with the drop casting (0.03%). For future ingots, the oxygen level was controlled at <0.10%.

Several preliminary heat treatment trials were conducted on sections of the forging. As noted in the Alloy Development Section, the properties of the alloy are a function of the heat treatment and structure. It was found that the increased size of the ingot slices resulted in a different response (and structure) when cooled from

TABLE 25 Isothermal Forging Results

Material	Nominal Ti-24Al-11Nb a/o
Temperature	2000°F
Strain Rate, in/in/min.	0.05
Initial Height, in.	5.0
Final Height, in.	1.0
Percent Reduction	802
Final Flow Stress, Ksi	4.75



Figure 49. Pancake Forging Configuration Produced for the 20-Pound Ti-13.5A1-21.5Mb Alloy

the beta phase field compared with earlier experience on smaller sections. Screening studies showed that air cooling from a solution treatment temperature of 2200°F (1200°C) gave the required fine Widmanstatten structure, illustrated in Figure 50(b), and a hardness value of 305 VDN. The majority of tests were conducted on material in this condition, although this is one of a total of five heat treatment variations evaluated. Specimens used for the tests were the same as used in the first year program, shown in Figure 3. Tensile test results are presented in Table 26. The as-forged tensile values indicate a ductile-brittle transition temperature of about 500°F (260°C). As-forged strengths appear at least equivalent to the first year program alloy, Ti-16A1-10Nb, up to the 1200°F (650°C) test temperature. Subsequent to beta furnace cooling, strengths are somewhat increased and the ductile-brittle transition temperature appears to be lowered to RT.

The 0.2% yield strength, ultimate tensile strength and percent elongation versus temperature are illustrated in Figure 51 for the beta air cooled material. Examination of these results indicates additional improvements in strength and ductility values compared to the as-forged or furnace cooled material with RT yield strengths of approximately 110 ksi, ultimate tensile strengths of about 117 ksi and ambient temperature ductilities of approximately 0.65%. This is an improvement in the ductile-brittle transition temperature of about 800-900°F compared to the Ti-16A1-10Nb alloy. From Figure 51, it can be seen that the yield strength of the beta air cooled material drops off markedly between RT and about 500°F (260°C). At temperatures between 500°F (260°C) and 1000°F (540°C), yield strength is nearly constant, while above approximately 1000°F (540°C), yield strengths once again decrease. In contrast, ultimate



Microstructure of the 26-Pound Nominal Ti-13.5Al-71.5Nb Alloy Figure 50.

TABLE 26

Tensile Results for the Nominal Ti-13.5A1-21.5Nb 20-Pound Ingot

Rest	Test				
Trestment/	Tamper-	0.27 (115aet)	Claiman.		
	11124	Viels Strength	Ters(1)		
<u></u>	2(7)	<u></u>	Strenzth 1421	1 -	• • • •
11-7-7-7-					
· · · · · · · ·	11.000	•		•	-
A8+117491	<		1.55	1	•
A2+217311	651(1201)	-ć.:	e		•••
				+ ÷ • •	->+-
1200(2200)/1,70	RT	30.3	? é.3	0.53	1.7
	31		1.1.6	2.55	
	37	103.6			••7
1	2001-001	44 1	1.2	4.53	•
	2001:001			2.2	• • •
1	2001 000	=3.0	102.5	1.9	1
1	2010 2021	· · · ·	102.1	3.4	<u> </u>
	-23(200)	11.1	116.0	4 1	
	423(BX)	76.2	105 7	4 .	
	\$1.3(10001	74 5		6.3	1. 1
	Sult/ 1.1001		7.5	4. 7	2.5
	5.3/1000	G		7.0	11.1
	1 . L	72.7	100.0	5.2	
	152(1200)	36.2		3 1	
	550 1210	71.2	24	4	
1	76011-001				
7	212/10001	-10		2.2	
		-3.5	12.2	2.7	
	2-		••		
1 1 - 1 + 1 / 1 A OC \ /		•		C.25	-
		-2.2	25.9	2.1.	
•• A.	200(500)	59.3		3 5	• •
	650(1200'	41.0	71 7	2 2	·••
				5.4	





tensile strengths remain fairly constant between RT and about 800°F (425°C); above 800°F (425°C) ultimate strengths also decrease with increasing temperature. Although it is apparent that the data are rather variable, ductility levels can be seen to increase from a value of 0.65% at RT with increasing temperature. Considering the beta air cooled plus stabilized material, a decrease in both strength and ductility values is observed in the RT to 1200°F (650°C) temperature range compared to the unstabilized material. It can be noted that the furnace cooled and beta air cooled plus stabilized RT tensile results are quite comparable.

Creep rupture test results are presented in Table 27. As in the tensile evaluation, material has been screened in four heat treatment conditions. As-forged material was tested under conditions of 1300°F (700°C)/40 ksi and exhibited a poor rupture life of 0.4 hours, probably due in part to the low elevated strength of the material. The beta furnace cooled specimen exhibited a 1.3 hour rupture life under conditions of 1200°F(650°C)/55 ksi. This low value may also be attributed to a decline in the elevated temperature strength capability of the furance cooled structure, although no data exists to substantiate this at the present time. The creep rupture capability of the ingot material appeared significantly improved subsequent to a 2200°F (1200°C)/l hour/AC treatment. Material creep tested in this condition revealed a 1100°F (590°C)/60 ksi rupture life of 233.9 hours and a 1200°F (650°C)/55 ksi life of 44.7 hours. The former value is comparable to the Ti-16A1-10Nb alloy which exhibited a 1100°F (590°C)/60 ksi creep life of 235 hours, while the latter value is inferior to the first year program alloy which revealed a 92.2 hour creep life under condition of 1200°F (650°C)/55 ksi. These results may be rationalized by the fact that the strength

Heat Treatment/	Test		Time To 15	Time To		Reduction - a. Acea
Condition C(F)1 Hr.	ature C(F)	(ks1)	(Hrs.)	(Hrs.)	(£;	
As-Forged	700(1300)	40	0.03	0.4	5.6	14.3
1200(2200)/1/70	650(1200)	55	0.0	1.3	11.0	14.6
1200(2200)/1/AC	590(1100) 650(1200)	60 55	25.26	233.9	7.0	1
1200(2200)/1/AC+ 370 (1600)14/AC	590(1100) 650(1200)	50 55	23,55	605.9 23.1	3.6 9.0	5.7

TABLE 27

Creep Results for the Nominal Ti-13.5A1-21.5Nb 20-Pound ingot

values of the Ti-13.5Al-21.5Nb 20-pound ingot decrease rapidly above 1000°F (540°C), as discussed above, in contrast to the rather flat strength curves (at least up to about 815°C) observed for the Ti-16Al-10Nb alloy, as may be seen from Figure 33. Specimens were also creep tested subsequent to a beta air cool stabilization treatment. An excellent rupture life of 605.9 hours was revealed under conditions of 1100°F (590°C)/60 ksi and a life of 23.1 hours was exhibited under conditions of 1200°F (650°C)/55 ksi.

The high cycl 'atigue characteristics of the alloy were determined at 800°F (425°C). Smooth (K_t 1) Westinghouse HCF specimens were tested in a reverse bend (R = -1) high cycle fatigue machine with test frequency maintained at 7200 cpm. Specimens were run until rupture or discontinued at 10⁷ cycles with the results presented in Table 28 and illustrated in Figure 52. Material was solution treated at 2200°F followed by an air cool. The fatigue results indicate a runout stress (10⁷ cycles) of 50 ksi. These properties are slightly superior to the Ti-16A1-10Nb alloy studied during the first year of this contract.

B. Additional Heat Treatment Studies

It has become clear during this investigation that microstructural control is a key to obtaining a balance of mechanical properties. In order to produce the required structures in a production situation more stringent control of cooling rate will be needed than available in air or furnace cooling. Therefore, a series of trials are in progress to evaluate the effectiveness of salt quenching in producing the necessary structures without any tendency to quench cracking. To d_te, three trials have been conducted and the resultant structures analyzed. The conditions

TABLE 28

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High Cycle Fitigue Results for the Nominal Ti-13.5A1-21.5Nb 20-Pound Ingot

C (F)	Kt	Cycle Rate	Stress (ks1)	Cycles to Failure
425(900)	1.0	7200	50	1.0 x 10 ⁷ Runout
425(800)	1.0	7200	53	1.0 x 107 Runout
-25(800)	1.0	7200	- 14	1.0 x 10 ⁷ Runout
425(800)	1.0	7200	55	2.9 x 10 ⁶
425(800)	1.0	7200	55	4.9 x 10 ⁶
425(300)	1.0	7200	60	1.9 x 10 ⁶
-25(800)	1.0	7200	60	9.6 x 10 ⁵
415(900)	1.0	7200	65	5.2 x 105





were as follows:

1 2225°F Solution Treatment, quench into salt at 1400°F, hold for 15 minutes 1

- 2 2225°F Solution Treatment, quench into salt at 1000°F, hold for 15 minutes
- 3 2175°F Solution Treatment, quench into salt at 1400°F, hold for 15 minutes

Treatment 1 produced structures very similar to those observed in material forged above the beta transus. This indicates that the salt temperature must be decreased in order to produce the aim structure. Treatment 2 gave a structure virtually the same as that formed on air cooling from the beta phase field. Treatment 3, which was solution treated in the alpha plus beta phase field contains a uniform distribution of primary alpha in a relatively fine transformed beta structure.

3. Discussion

The program conducted on the Ti-16Al-10Nb alloy in the first year of this effort established process methods for handling reasonably large volumes of an aluminide alloy and generated extensive property data. The program demonstrated that powder metallurgical methods were applicable to this class of materials; consolidation by direct hot isostatic pressing yielded a sound product which was forged with no difficulty. Subsequent processing through heat treatment and the fabrication of a variety of specimens was also accomplished readily. However, closer examination of specimen surfaces prepared by conventional grinding and turning did reveal shallow surface cracks indicating that, at least in this alloy, not all finishing techniques could be used. In addition, machining techniques that resulted in the retention of residual stresses in the material surface resulted in thermally induced instabilities. Thus, during exposure to elevated temperature, such as during a test, the surface layers tended to recrystallize resulting in a structural change from an acicular to an equiaxed grain configuration. Results of a more detailed study on such surface instabilities will be found in Section III which also indicates that the phenomenon is alloy dependent.

With the above two reservations, it is clear that this study showed that alpha two aluminide alloys can be processed and finished using many of the techniques used for conventional titanium alloys. This in turn means that the fabrication of components should be possible without the development of radically new methods.

Analysis of the mechanical and physical property data acquired indicates that the alloy investigated in the first year of the program, namely Ti-16A1-10Nb, is superior in elevated temperature capability to current conventional titanium alloy, such as Ti-6A1-2Sn-4Zr-2Mo, by 300 to 400°F and is fully competitive with nickel-base superalloys on a strength to density basis. The fatigue properties of the material are generally excellent over the investigated temperature range of 800 to 1200°F, although indication of increased scatter was found for lower temperature LCF; this was probably related to the limited low temperature ductility for this alloy as observed by tensile tests. The high cycle fatigue results for the material generally do not show a debit at the lower temperatures possibly because of the more limited strain exposure inherent in the high cycle fatigue results as compared to that of low cycle fatigue tests. Evidence of strain hardening behavior was

observed in the low cycle fatigue tests at both 300 and 1200°F, although it was more pronounced at the higher temperature. The Charpy impact data for this alloy are relatively low at room temperature, but a considerable increase in ductility observed above this temperature. At the potential operating temperature for most titanium aluminide gas turbine applications (1200-1600°F), the material is competitive with alternate nickel-base alloys such as INCO 713C.

The second year program scaled-up alloys chosen from the Alloy Development Program and generated mechanical property data. Conventional titanium alloy melting practice was used to produce 20-pound ingots of the selected material and ingots of good quality were produced. HIP consolidation of the ingots was shown to be an effective method of scaling porosity and improving product yield in the forging step of the process cycle. This methodology was used for two ingots, the third was forged in the as-cast condition and no difficulty was encountered. Thus, in addition to the P/M methodology demonstrated in the first year of the program, it has also been shown that consumable arc melting technology is a viable method for aluminide production.

Mechanical property testing has been completed for the Ti-13.5Al-21.5Nb alloy and is in progress for the other two alloys. The alloy showed a ductility improvement over the first year alloy, useful plasticity was measured at temperatures above 500°F and small but finite ductility occurs below that temperature. However, it is clear that the results are inferior to those obtained on laboratory size ingots; the differences may be due to either scale-up factors and/or compositional deviations. Another obvious difference between the two materials are in the oxygen content which is 0.05 in the laboratory material and 0.2 in the 20-pound ingot. Further analysis is needed to pin down the reasons for the changes in plasticity observed.

The improved tensile ductility is accompanied by a reduction in the stress rupture capability of the material. Comparison of the present results with the first year alloy shows that the differences are slight at lower temperatures (~1100°F) but are quite marked at higher temperatures (~1500°F). It should be noted that a considerable advantage over conventional alloys is still apparent.

The improved ductility of the alloy leads to less scatter in HCF test results at 800°F and may also be responsible for the slight increase in runout stress value. It could be noted that the fatigue properties obtained at 800°F are rather similar to conventional high temperature titanium alloys, such as Ti-6A1-2Sn-42r-2Mo, and thus could be assumed to show no advantage. However, the critical point is that in these lower ductility materials, the properties at intermediate temperatures could act as a barrier to the material's use. Thus the fatigue results may be taken as a positive indication in the effort to apply these materials in gas turbine engines.

In summary, at this stage of the program the processing characteristics and the properties measured for alpha two type alloys can be considered encouraging. Scale-up to larger ingot sizes and continued evaluation of promising alloy compositions are planned for the future.

IV. MANUFACTURING FEASIBILITY STUDIES

1. Introduction

Broad acceptance of a new engineeirng material requires that it not only have attractive properties but that manufacturing techniques are available to produce a range of product forms. For the titanium aluminides in gas turbine engines, potential applications include components ranging from relatively small airfoils weighing less than a pound up to complex static structures, such as cases, which may weight over 100 pounds. Most components can be manufactured by alternative techniques; however, the cost and component capability resulting from various approaches are never equal. It is consequently highly desirable that a material's compatibility with a range of metal forming operations be understood.

with each material system, a unique set of properties can dramatically affect the ease or complexity of a given manufacturing approach. For example, it was well known that the aluminides were subject to severe cracking during conventional forging operations when they were first evaluated during the 1950's. At that time, forging appeared nearly hopeleus as a result of the material's limited plasticity and its relative strain rate sensitivity. With the development of isothermal techniques which allow excellent strain rate control, complex precision forgings were produced at Pratt & Whitney Aircraft with relative ease (Figure 53) .. The characteristics of this new manufacturing procedure allow even small pieces of metal to be maintained at high temperatures and within the plastic range of the aluminides, for the relatively long periods of time necessary to complete a forging at low strain rates. 54

Figure 53. Ti-16Al-10Nb Process Developments

Isothermally forged P/M pancake







TIG welded plate The property characteristics of the material now fit the capability of the forging technique, and forging can be considered an acceptable metalworking approach. This new technique has overcome a manufacturing difficulty, but it has done so at considerable added cost as a result of increased equipment complexity and much slower forging cycle time. The forgings which have been produced to date have been done by procedures which work; however, much remains to be done to determine the feasibility of reducing their cost and improving their properties. Cost is in part a function of production rate or cycle time, and if it were feasible to increase strain rate by selecting a different forging temperature, cost could be reduced. Selection of new forging parameters can also affect properties since microstructure can be changed by both temperature and strain rate.

The feasibility of manufacture by other techniques, about which even less is known, also requires evaluation. Small high temperature components, such as low pressure turbine blades, are one of the most important areas where aluminides can be used since the lightweight strongly impacts inherent body stresses in rotating components. As a result, the payoff for the use of these materials in rotating structures as a percent of component weight is much higher than for static structures. In addition, the lightweight of aluminide turbine blades reduces the required weight of the supporting disk structure and of the associated static structures, such as struts, bearing supports and cases. If the aluminides are used to produce static structures, a large total weight savings as a percent of engine weight is possible but this results from the large number and great weight of static components.

Application of these materials in low turbine blades and static structures may require greatly different manufacturing procedures. For example, in the past, turbine blades have classically been produced by casting techniques since great precision is possible by investment casting and this minimizes high machining cost on complex curved airfoil surfaces. In addition, the important mechanical properties of creep and stress rupture are superior for current turbine blade materials in the cast, as compared to the forged condition. Preliminary evaluation of the Ti₃Al base aluminide (Ti-16A1-10Nb) characterized in the first year of this Air Force sponsored program at Pratt & Whitney Aircraft has indicated that this material exhibits superior creep rupture properties with the high temperature beta annealed microstructure. This type of structure is present for the cast material and, consequently, both cost and property considerations suggest that casting capability may be important for some aluminide materials.

In static structures such as cases, the large component size makes it desirable to have available joining techniques to assembly a complete structure using smaller cast or forged sections. The type of joining required may depend on local joint stresses and properties of the joint area, but, in addition, the cost of the joining operation is critically important. Classically, welding is widely used in such operations; however, restriction of geometrical access or property requirements can dictate the use of diffusion bonding to achieve high microstructural nomogeneity, or the use of brazing in restricted access areas to reduce cost. The widest possible latitude in such manufacturing processes will result in optimum capability, and it is consequently important that the feasibility of a range of joining operations be defined. Casting of titanium aluminides can be expected to differ considerably from casting of other materials since the primary elements present are highly reactive; this can affect the choice of casting environment (air, inert gas or vacuum) as well as the choice of mold material. In this area, some information is applicable from conventional titanium alloy casting experience, but the higher aluminum content may be expected to affect mold reactivity such that advanced low reactivity mold systems could be required.

Beyond these basic metal forging, casting and joining operations, it is critically important that the applicability of various metal finishing operations, such as machining, be defined. Virtually all components require some form of machining operation in areas where very critical dimensions must be maintained. The surface properties resulting from machining operations are often critical to satisfactory component performance in gas turbine engines. In the Ti,Al alloy characterization phase of the first year of the Air Force program, it became apparent that the aluminides could be extremely sensitive to surface condition. Several specimens produced by conventional turning or grinding operations were found to have surface craze cracks in the as-machined condition, and this surface condition was found to decrease fatigue strength. Even when actual cracking was not present, tensile residual stresses reduced fatigue life so that stress relief improved specimen capability.

The aluminides are not basically different from conventional titanium base alloys in their surface sensitivity, although effects may vary in degree. Titanium base alloys, in general, have for some time required careful control of machining procedures to achieve satisfactory property capability. Parameters such as tool or grinding wheel

speed, depth of cut, type of lubricant and flow rate nave all been defined for conventional titanium alloy and reproducible production results are achieved on a normal basis. Similar investigation of machining technique feasibility and definition of parameters were considered necessary for the titanium aluminides.

The various program elements described below were undertaken to provide some of the basic information and process development needed to fabricate titanium aluminide alloys. Much of the work was conducted with the alloy Ti-16Al-10Nb as a reasonably large amount of high quality material had been produced in the first year of this program. More recently, additional studies have been performed on the Ti-13.5Al-21.5Nb alloy.

2. Joining Studies

A. Brazing

Brazing feasibility was studied by producing approximately one-inch square joints using a range of selected filler materials. Braze alloys, such as aluminum, Ti-Cu-Ni and Ti-Zr-Be, were examined metallographically to determine wettability and filler flow; similar evaluations were conducted after long time exposure at 1650-1800°F (899-982°C) to determine base alloy/filler metal interaction, structural stability and oxidation effects.

The base-metal samples, which consisted of two sections (nominally 3/8" and 3/4" diameter x 1/4" thick), were centerless ground to rod configurations and sections on a precision cut-off wheel. The specimen faces were polished flat and parallel through 400 grit silicon-carbide paper

and vapor blasted. The Au-Ni, Al-Si, pure Al and Ti-Cu-Ni braze materials were obtained in the form of 2 mil thick sheet and cut to sections approximately 20 to 30 mils larger in diameter than the titanium aluminide disks. The Au-Ni and Al-Si braze materials were of eutectic composition, nominally 82Au-18Ni and 88Al-12Si, by weight. The Al sheet was C.P. Grade at least 95% pure. The Ti-Zr-Be-Al braze was obtained in the form of -120/+325 (10% maximum -325) powder. Prior to each brazing trial, the Ti-16Al-10Nb materials and braze filler to be evaluated were degreased and cleaned in a methyl alcohol solution. The braze material was assembled between two titanium aluminide sections and placed in a tantalum element, resistance heated, vacuum furnace equipped with a tungsten-rhenium thermocouple in close proximity to the sample.

The Al Si braze trial (#4) and the pure Al trial (#5) were conducted with a local oxygen protective getter of Mg powder in an attempt to improve the wetting characteristics of these two braze materials. A pure Mg powder was employed as a gettering agent and applied to the upper surface of the bottom disk adjacent to the circumference of the joint.

An accryloid cement was used as a binder for the Ti-Zr-Be-Al powder. The braze was applied in the form of paste only to the periphery of the joint. To maintain proper specimen spacing, four small 1 to 2 mil thick C.P. titanium spacers were placed at 90° intervals under the circumference of the top section. This technique maintained proper specimen spacing and allowed the braze material to flow into the joint at temperature. The previous trials were conducted between 1100° F to 1825° F from 7 to 10 minutes at 10^{-5} Torr. Both the Ti-Zr-Be-Al and Ti-Cu-Ni trials were conducted at 1750° F for 10 minutes at 10^{-5} Torr (Table 29).
Parameters Used for the Titanion-Aluminide Brazing Study

Trial	Kase Material	Braze Naterial	Temperature (F)	Time (Minutes)	Pressure Ma Hg	Kesults/Comments
-	11-16A1-10Nb v/v	8244-1841 (AHS 4787)	1825 ± 25	21-1	10-5	Extensive wetting of both upper and lower disks.
~	T1-16A1-10Nb v/o	88A1-1254 (Full made to AMS 4185 Specification	1100-1110	11-1	10-5	Pour welling, did nut flow well.
-	TI-16A1-10N6 ~/0	C.P. AI ANS 4000	1220-1230	51-7	10-5	Irregular adheaton of Al braze to base acta
4	TI-16A1-10NL v/o	Al-Si (see trial No. 2) with Mg Pow	1100-1110 Jer	21-1	10-5	About same result as No. 2.
~	TI-16A1-10ND w/u	C.P. Al with M ₆ Puwler	0, 21-0221	21-13	2-0I	Slightly better wettle than result for Trial No. 3.
•	T1-16A1-10Mb w/.	T1-15Cu-15NE	1 /50	01	iu-5	Latensive wetting of buth disks.
-	TI-16A1-10NL V/V	T1-477r-58c-5Al Sular Braze C-6604	1750	10	10-5	Extensive welling wi both disks.

Following visual inspection of the braze product to establish bond integrity, general reactivity and degree of wetting, the joint was inspected by means of fluorescent penctrant. The product was then sectioned longitudinally, Ni plated to maintain edge definition, mounted and polished. Examination of the polished and etched (Kroll's reagent) cross section by means of optical microscopy revealed the degree of braze wetting, braze-base interaction, erosion and porosity in the joint.

A total of seven brazing trials were carried out as listed in Table 29. Macro-analysis of the Au-Ni brazed product revealed extensive wetting of both the upper and lower titanium aluminide sections. Examination by means of fluorescent penetrant revealed an apparent small crack in the joint area. Microexamination of a longitudinal cross section confirmed the extensive wetting, as illustrated in the optical micrograph, Figure 54(a). It can also be seen in Figure 54(a) that approximately 1.5 mils of the base material has been eroded by braze. Examination of the joint at 500X also revealed a number of significant features. Three intermediate phases can be observed subsequent to brazing with a dark etching "needle-like" phase revealed in the braze/base metal interface. Voids and oxide particles are also observed in the center of the joint, as shown in Figure 54(b); the former the result of the extensive affinity of the braze alloy for the base material while the latter caused by oxides being "washed" from the material surface.

The results for the Al-Si trial and pure Al trial are tabulated in Table 29. In both cases, the upper and lower specimens were joined, however, macro-analysis indicated that the Al-Si filler did not flow well and revealed





- Figure 54.
- (a) Au-Ni Brazed Ti-16Al-10Nb Joint Showing Wetting and Erosion of Base Metal
 (b) Micrograph of Joint Showing Phases Formed During Brazing
 Note Porosity and Oxides in Joint
 - - 161

extremely poor wetting, Figure 55(a). The pure Al material exhibited only irregular adhesion to the base aluminide as illustrated in Figure 55(b). Microexamination of longitudinal sections confirmed the poor adhesion for both trials and only minor interaction was observed in either case. The poor brazing characteristics of the Al based materials could result from the formation of a strong adherent oxide film preventing filler/base wetting.

Thus, additional Al-Si braze and pure Al trials were conducted with a local oxygen protective Mg wetter in an attempt to improve wetting characteristics. Macroexamination of the gettered Al-Si trial (#4) revealed no apparent improvement in wetting characteristics compared to the ungettered trial (#2). However, the pure Al trial run with Mg powder adjacent to the braze exhibited a somewhat improved wetting appearance. Unfortunately, microexamination of the longitudinal cross sections revealed no significant improvement in base metal/braze interaction for either of the above two trials.

Macro-analysis of the Ti-15Cu-15Ni brazed product, Figure 56(a), revealed extensive wetting of both the upper and lower titanium aluminide sections. Examination by means of fluorescent penetrant revealed an apparent crack-frae joint area. Microexamination of a longitudinal cross-section confirmed the extensive wetting, as illustreated in the optical micrograph, Figure 57(a). Note that the brazed specimen was nickel plated prior to sectioning, mounting and polishing to maintain edge definition. The original braze foil thickness (1.5 to 2 mils) is discernible in Figure 57(a) between an crosion zone of approximately 1 mil per side. Examination of the joint at 500X did not reveal the presence of voids, however, a phase was observed, which may be seen



4X

(a) Al-Si braze showing poor flow characteristics.



(b) C.P. Al braze showing irregular wetting.

4X

Figure 55. Results of TI-16A1-10Nb Brazing Trials



4%

4X

(a) 72-15Cu-15 Ni braze.



(b) Ti-472r-5Be-5Al braze.

Figure 56. Results of Ti-16A1-10Nb brazing Trials



(5)

(a) Ti-15Cu-15Ni Brazed Ti-16A1-10Nb
(b) Ti-47Zr-5Be-5A1 Brazed Ti-16A1-10Nb
Note Both Brazed Trials Conducted at 1750°F Figure 57. (a) (b)

in Figure 57(a), in the approximate center of the braze.

Macro-analysis of the Ti-47Zr-5Be-5Al braze trial revealed satisfactory wetting, Figure 56(b), although it is clear that an excess of braze material was applied. Inspection by means of fluorescent penetrant revealed a few pinpoint indications or voids in the joint region, however, it is felt that these voids are more related to the fact that the braze was applied as a paste as opposed to a chemical reaction. In contrast to the Ti-Cu-Ni braze trial, a diffusion zone (rather than erosion zone) slightly in excess of 1 mil may be observed in Figure 57(b), which were not observed in the braze at 500X; however, a number of phases were clearly revealed.

It was concluded on the basis of these trials that either the Ti-Cu-Ni or Ti-2x-Be-Al braze alloys may be satisfactory for producing aluminide joints for use at low temperature. However, the interdiffusion and erosion characteristics indicate that either or both of the following methods would be preferred for use in high temperature structures.

B. Diffusion Bonding

The parameters for diffusion bonding the Ti-16A1-10Nb alloy were established on a laboratory scale. Sections of the alloy were prepared pending trials conducted in a vacuum press. Bonding variables studied were time, temperature and pressure. The bonded sections were evaluated by radiography and optical metallography to determine the extent of bonding and level of residual bond line porosity.

Specimens used for the diffusion trials were centerless ground to 0.4" diameter cylinders and sectioned to 0.25"

thick wafers on a precision cut-off wheel. Specimen faces were lapped flat and parallel in an alumina slurry to within 0.001". Final polishing was with 0.3 micron alumina powder on a felt cloth. Bonding experiments were carried out in a vacuum hot press equipped with an alumina die to maintain alignment f specimens; temperature was monitored with a Pt versus Pt 10% rhodium thermocouple. Immediately prior to a diffusion bond trial, specimen faces to be bonded were etched (Kroll's reagent) and cleaned with a solution of methyl alcohol. The cylinders were diffusion bonded under vacuum of better than 10^{-5} mm Hg and under various pressure and time parameter conditions as presented in Table 30. Subsequent \Box each run, the joined samples were sectioned longitudinally, mounted and polished. Any microporosity in the bond line was established metallographically.

Eight diffusion bonding trials were run as listed in Table 30. A longitudinal cross section of the bond run at 1800°F/ 240 minutes/1,000 psi is shown in Figure 58(a), and indicates incomplete closure of bond surfaces with bond line porosity revealed, although a limited number of areas appear to be well bonded. The second bonding trial was run at 1900°F/240 minutes/3,000 psi. A longitudinal cross section of this bonded specimen appears in Figure 58(b). For these parameters it appears that complete closure of the bond surfaces has taken place and no microporosity was observed. Also of interest in this figure is the recrystallized layer of grains at the prior bond line.

Longitudinal cross sections of subsequent bond trials were examined metallographically for microporosity in the bond line. The specimen bonded at 1900°F/240 minutes/1,000 psi exhibited a bond line containing 20% voids. Each of sthe two bonds run at 1700°F also exhibited a degree of

Parameters Used for the Titanium Aluminide Diffusion Bonding Study

Results/Communits	Bond line observed.	Sound bond, no micro-porosity observed.	20% volds observed.	Muderate porosity.	Slight porosity
Surface Finish (Microns)	0.3	0.3	0.3	0.3	0.3
Pond Pressure (ps1)	1,000	3,000	1,600	5,800	7,009
Bond Time (Minutus)	240	240	240	180	300
Bond Temperature (F)	1800	1900	1900	1700	1700
Material	TI-16A1-10Nb v/o	T1-16A1-10Nb v/o	TI-15A1-10Nb v/o	T1-16A1-10Nb w/o	ti-16A1-10Nb v/o
Trial		~	c	4	Ś



(b) 1900°F/240 minutes/3,000 psi

Figure 58. Longitudinal Cross Section of Diffusion Bonded Ti-16A1-10NL Specimens - Note Bond Lien in (a) and Recrystallized Layer of Grains in (b) at Prior Bond Line microporosity in the bond line as indicated in Table 30.

It can be seen from Table 30 that in order to achieve a complete bond, a temperature of 1900°F and a pressure of 3 ksi applied for four hours is required. Reducing any of the time, temperature, pressure parameters results in inadequate bonding, although high pressures and long times at 1700-1800°F probably could produce dense bonds. It would seem that the most effective approach would be to increase the bond temperature to 2000-2100°F, at which temperatures the flow stress is considerably reduced (see Forging results). In this temperature range, the time and pressure requirements could probably be reduced to relatively small values. However, these gains would be offset, from a practical viewpoint, by tooling and contamination problems.

C. Weldment Evaluation

Freliminary attempts to weld Ti₃Al based alloys conducted at P&WA indicated susceptibility to weld and heat-affected zone cracking. The cracks observed were somewhat similar in appearance to those observed in many nickel and iron based alloys. While the cause of this cracking behavior has been fairly well established for nickel base alloys, the knowledge was generally lacking for Ti₃Al. The only information that has been obtained to date is that cracking can be prevented, at least under conditions of low heat input and low restraint, by preheating the sections to 500-900°F (260-482°C). Further studies were initiated in the program to investigate the weldability of Ti₃Al base alloys, specifically Ti-16Al-10Nb.

Titanium aluminide panels were prepared by the following two methods: (1) one sheet was rolled directly from an us-cast ingot section and (2) two sheets were rolled from HIP'ed powder. Gas tungsten arc (GTA) butt welding was the first method used in an effort to join these Ti-16A1-10Nb panels. Narrow strips cut from the panels were used as filler material.

Weldments were produced at preheat temperatures of 70, 300, 500 and 700°F, as shown in the following schedule.

		Preh	eat	
Sheet	Ambient	300°F	500°F	700°F
Ingot			х	х
HIP #1	х	X	х	х
HIP #2				х

Prior to welding, thermocouples were attached to the sheets to measure preheat temperature. Preheating was accomplished by feathering the welding arc on the panels until the selected temperatures were attained. Energy input was kept to a minimum but varied with the amount of preheat. One EB weld was run to join HIP #2 sheet panels. For this trial the panels were not preheated.

Large cracks were observed in all specimens except the HIP #2 specimen preheated to 700°F. This weld is illustrated in Figure 59(a). In all other samples, cracking occurred perpendicular to the weld and the appearance was typical of hot cracks, as shown in Figure 59(b). Apparently, HIP process parameters varied because a difference in weldability was observed between the two sheets produced from HIP'ed preforms. All HIP #1 specimens exhibited excessive weldment porosity, illustrated in Figure 59(c). Kadiography revealed extensive networks of porosity throughout the weld beads. Porosity was not discovered in any of the other



(a) HIP'ed sheet, preheat temperature - 700°F.



(b) HIP'ed sheet, preheat temperature - 500°F, showing typical cracking pattern.



(c) Longitudinal cross section of (b) showing porosity rim in weld bead.

Figure 59. Results of Ti-16A1-10Nb Welding Trials

specimens (e.g., HIP 2 or ingot).

More cracks were observed in the EB weld than in any of the GTA welds; however, the cracks were smaller, but the total length of cracks was about equal to that of the GTA welds.

The above experience may be attributable in part to the structure present in the sheet which was not optimum. Additional trials utilizing sections of the same thickness cut from forged and heat treated material did not show cracking after welding with a 700°F preheat temperature, examples are shown in Figure 53.

It is not clear if higher niobium content will make welding easier or more difficult. Unproved ductility could lead to a reduction in cracking tendency and also in preheat required. However, the higher niobium content may increase the welding difficulty--at least by analogy with conventional titanium alloys in which high bota stabilizing element content usually results in poor welding characteristics.

D. Forging Studies

Forging of the Ti₃Al base titanium aluminide materials had not received a systematic evaluation, although it is obvious from previous sections that an empirical body of forging parameters exists. Prior in-house experience had shown isothermal forging to be a tra able approach to forming this class of materials. Therefore, the hot die, or more correctly, isothermal *-chnique was studied in order to define the important process variables and explore their impact on subsriguent flow stress, microstructure and properties. This aspect of the program investigated such variables as forging temperature, strain rate and reduction

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ratios for titanium aluminide pancake forgings.

A 20-pound cast ingot of nominal Ti-16Al-10Nb, double consumably melted by Titanium Metals Corporation of America (TMCA), Henderson, Nevada, was procured for the forging evaluation. The chemical analysis of the ingot is given in Table 31. The ingot was hot isostatically pressed (HIP'ed) under conditions of 2200°F/15,000 psi argon pressure for three hours in order to close internal porosity. Subsequent to the HIP treatment, forging blanks nominally 1" diameter were EDM'ed from the ingot. The preforms were sections to about 2" lengths and the ends were machined flat and parallel prior to forging. Radiographic analysis revealed completely sound blanks free of any observable internal porosity.

Forging trials were conducted in the P&WA "Mini'Gator" isothermal forging press equipped with TZM molybdenum alloy tooling in vacuum and at controlled rates. The thermocoupled dies and billets were equilibrated at the forging temperature with induction heating coils for one-half hour prior to deformation. Also, prior to each forging run, the die surfaces and ingot were spray coated with boron nitride lubricant. Temperature and load were constantly monitored and recorded during deformation. Forged pancakes were furnace cooled subsequent to deformation.

Twelve subscale isothermal forgings were produced. Deformation parameters and the evaluation of these trials are summarized in Table 32 and photographs of the resulting pancake forgings are presented in Figure 60. Final forging thickness in each case was approximately 0.4°, equivalent to about 80% reduction in height. The flow stress-reduction in height relationships for the various conditions are

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Chemical Composition of Titanium-Aluminide Alloy TMCA Heat V-5123, Ti-16Al-10Nb

Ala	Balance 016.0 10.0 	yses.
THCA*	Balance 15.4 11.6 0.062 0.10 0.012	p and bottom anal
Element	I Z Q Z O X	t Average of to

•.

Parameters Used for the Titanium Aluminide Isothermal Forging Study

- 5-				1. T.		2. inter	ieru: •?	() 1 ⁰	· · · · · · · · · · · · · · · · · · ·	 5'	• • *	
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Az-Torgal Cornect Strib	27.2	5	2:3	510		252	53+	530	235	01 11 11	162	513
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1.100	76.0	Ê1.1	Sc. 2	i Ž	63.3	76.7	75.9	79.5	73.9	71.5	62.5	32.5
Forgas Staff Tast (1 tarte	0.61	0.23	0.75		<u>د.</u> ۳	0.1		0.03	0.1	0.5	1.1	0.5
70:34:1 	1913	1311	2003	2000	2000	5050		5255	2100	2100	22CD	22:0
NY LING	11-124-112						,	•••••				•



Figure	60.	Ti-16A1-	10Nb Forg	ing Trials (Left to Right)
		Top:	1900°F,	0.01 inch/inch/minute;
			1900°F,	0.05 inch/inch/minute
		Middle:	2000°F,	0.1 inch/inch/minute;
			2000°F,	0.5 inch/inch/minute
		Botton:	2200°F,	0.1 inch/inch/minute;
			2200°F,	0.5 inch/inch/minute "

shown in Figure 61. It is clear that a considerable reduction in flow stress is observed with increasing deformation temperature. Additionally, slower strain rates also result in flow stress reduction, particularly at lower forging temperatures. At the highest forging temperature (2200°F), a change in strain rate results in only a small effect on flow stress.

Visual examination indicated good results for forgings produced at 2200°F (above the beta transus of 2150-2175°F) for both low, 0.1 inch/inch/minute, and high, 0.5 inch/inch/ minute, strain rates. Similar results were also obtained at 2100°F for low, 0.05 inch/inch/minute, intermediate, 0.1 inch/inch/minute, and high, 0.5 inch/inch/minute, strain rates. Good forgeability was obtained at 2050°F for both intermediate, 0.1 inch/inch/minute, and high, 0.5 inch/inch/ minute strain rates, while the forging produced at 2000°F and a strain rate of 0.05 inch/inch/minute exhibited very slight cracking as can be seen in Figure 60.

Forgings produced at 1900°F exhibited considerable cracking while the billet run at 2000°F and 0.1 inch/inch/minute exhibited slight cracking compared to the extensively cracked pancake deformed at 2000°F and 0.5 inch/inch/minute. It is clear, at least at the 2000°F forging temperature, that the cracking tended to be more severe with increasing strain rate.

The Vickers hardness values and resulting microstructures for the twelve subscale forged products appear in Table 32. In almost every case, increasing strain rates tended to produce increased hardness values for a given forging temperature. The forgings produced at 2050°F appear to be the one exception to this trend. Additionally, increasing





forging temperatures, in general, yielded decreased hardness values; this trend is more obvious when the results for a specific strain rate are examined for a range of temperatures. Forgings produced at 1900°F yielded a fine equiaxed alpha two microstructure, while those produced at 2000°F and 2050°F yielded equiaxed alpha two plus intergranular beta (which transforms on cooling to room temperature) morphologies. Plate-like alpha two microstructures were observed for forging temperatures of 2100 and 2200°F (beta transus of approximately 2150°F) with an extremely coarse structure noted for the latter forging temperature.

Two tensile tests were performed for each of the forging trials produced at 800 and 1200°F with the results presented in Table 33. Although the data are limited, it can be seen that the trends discussed in the preceding paragraphs pertaining to hardness values are also observed in the tensile results. Increasing strain rates generally result in increased yield strengths for a given forging temperature. Low strength (and hardness values) are observed for forgings produced at temperatures above the beta transus, and 11 general, increasing forging temperatures resulted in reduced yield strength values for a given strain rate. Ductility values tend to be rather variable and show no clear-cut trend. From a practical viewpoint, a forging temperature in the alpha-beta phase field would seem the best selection as it will allow maximum flexibility and control in the selection of a subsequent heat treatment cycle.

E. Machining Studies

In spite of the extensive number of aluminide specimens produced to date, machining this class of materials continues

Tensile Results for the Titanium Aluminide Isothermal Forging Study*

Reduction- In-Area (\$)	¥ 1	9-1	•	0.0		5.8	2.4 6.6	•		
Elon- setion	4.1	0.8	0.65		1.2		8.0 8.7	1.1	0.4	
Ultimte Tensile Strength (kei)	72.1	50.8	6.6.5	67.0	72.5		71.5	9.4 %%	54.3 55.4	
0.25 Yield Strongth (hai)	63.9	20. 4	65.5 55.0	60.3	65.0	×	59.5	45.8	15.8 36.7	
Test -	600		800 1200	300	800 1200	800	1200	800 500	800 700	
As-Forged Mardness HV-10	112		55	22	5	286		234	248	
Portiae Strata Bete La/La/La	10.0		6.9	0.05	0.1	0.5		1.0	0.5	
Toreine time	1900	Ion	Ŗ	2000	2000	2000		3	5200	
laterial	401-1V91-12									

Tota: All specimens tested in an-forged condition

to be based primarily on experience; machining variables have not been explored in detail. This effort attempts to examine in detail the impact of limited low temperature ductility on a number of processes currently employed in the machining of aluminide materials. Specifically, such processes as conventional grinding, single point tool machining (turning) and electrochemical grinding (ECG) were studies in terms of speeds and coolants on subsequent surface finish, surface stress state, material soundness (as determined by metallographic and mechanical property examination) and the economics of each approach.

The HCF specimen was selected to evaluate material for the machining program because of (1) the range of techniques which may be employed to produce the desired configuration and (2) the high sensitivity to small surface imperfections in this type of test. A total of ten MDL 2329 (Figure 62) Westinghouse High Cycle Fatigue (HCF) specimens were machined for evaluation. Table 34 summarizes the various machining parameters used in this program. One specimen (#1) was machined using single point tool techniques (lathe turned) at a cutting speed of 200 rpm. A tungsten carbide tool was employed with an oil-based coolant. Two specimens (#2 and 3) were prepared by conventional grinding techniques, with one machined at 6,000 surface feet per minute (SFPM) and the second at 3,000 SFPM. A water soluble coolant was used in the grinding operation. Several specimens were machined by the electrochemical grinding technique (ECG) with five specimens polished through 600 grit silicon-carbide paper after grinding. A sodium nitrate: sodium chloride water-based solution was used as the electrolyte with a copperdyne (Cu-Al203) wheel rotating 1,750 rpm. Total ECG time was about 10 minutes per specimen.





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Parameters Used for the Titanium-Aluminide Machining Study



Subsequent to machining, all specimens were nondestructively inspected by means of zyglo fluorescent penetrant. In cases where zyglo indications were found, specimens were replicated to determine the exact nature of the indications.

Ancillary characterization tests were performed to determine the effect of peening the surface microstructure and subsequent high cycle fatigue life of Ti-16A1-10Nb. The basis of these experiments arose from the observation during the previous alloy characterization program of an equiaxed recrystallized layer approximately 2 mils thick in the notch of failed load controlled (cycled at 800°F and 1200°F) low cycle fatigue specimens. This condition was not present on K_t 1.0 specimens used for the strain controlled tests and apparently resulted from the rather severe conventional lathe turning operation used to produce the specimen notches.

In an effort to run a controlled experiment, circumferential sections of a Ti-16Al-10Nb rod were peened to known intensities. A section of the rod was left in the as-ground condition as a baselina. A total of four peening intensities were employed as follows--10N, 15N, 18N and 33N. The former two intensities were applied by means of glass bead peen while the latter two were applied by means of shot peening. Each of the peened sections (including the as-ground section) were divided into a number of sections by means of a precision cut-off wheel. Samples from each condition were thermally exposed at temperatures of 800 and 1200°F for 24 hours. Subsequent to treatment, the as-peened and peened plus exposed specimens were nickel plated to maintain edge definition and metallographically examined. Typical as-peened (10N, 15N, 18N and 33N) surfaces are illustrated in Figure 63. Of significance in this figure is that for increasing peening intensities, the depth and concentration of slip bands appear to be increased. Also stronger peening has been observed to result in a deformed specimen surface and in occasional microcracking, Figure 63.

Figure 64 illustrated the effect of elevated temperature exposure (1200°F/24 hours) on the microstructure of peened (10N and 33N) Ti-16A1-10Nb. For each of the two examples illustrated, a recrystallized layer is revealed on the specimen surfaces. Of interest is the increased depth of the recrystallized zone as a function of increased peening intensity.

Based on the results of the peening and elevated temperature exposure study, it was decided to fabricate and test smooth Westinghouse high cycle fatigue (HCF) specimens employing three different fabrication techniques in order to determine the effect of surface condition on HCF properties. A total of ten smooth HCF specimens were prepared by the electrochemical grinding (ECG) technique. Six of the ten specimens were selected at random for glass bead peening to an approximately 13N intensity. Three of the peened speciments were then given an elevated temperature exposure of 1200°F/24 hours to produce a recrystallized layer of fine equiaxed grains on the specimen surface. The four remaining specimens were evaluated in the as-ECG'ed condition.

The ten smooth HCF samples were cycled at a temperature of 800° F. A reverse bend (R = -1) high cycle fatigue machine was used with test frequency maintained at 1,800 cpm; a stress of 55 ksi was employed for all tests. Specimens were run until rupture or discontinued at 10^7 cycles. The





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(b) 53N - Exposed 1200°F/24 hours 200



results are presented in Table 35 and plotted in Figure 65, with the HCF results from the alloy characterization program. These results parallel the previous results (conventionally ground plus stress relieved) quite closely.

Fluorescent penetrant examination of as-machined trial specimens produced by various techniques revealed the following:

- The lathe turned specimen exhibited an indication in the gage section which replication revealed to be a crack originating from a machining mark.
- 2) The specimen ground at 6,000 SFPM revealed a small indication in the gage section while the gage section of the specimen prepared at 3,000 SFPM appeared clean. The indication in the former specimen was apparently related to a deep grinding mark.
- 3) One specimen examined in the as-ECG'ed condition (#9) revealed pinpoint zyglo indications in the gage section. Replication of this specimen revealed what appeared to be "pits" as opposed to cracks. All other specimens showed no indications of surface flaws.

Evaluation of failed low cycle fatigue specimen microstructure (#4) showed indications of surface recrystallization on lathe turned samples which could be correlated with variations in low cycle fatigue behavior at 800 and 1200°F. The recrystallization on lathe turned surfaces was postulated to occur as a result of the severe local deformation during the machining operation and exposure to elevated temperature, either as a direct result of machining during the stress relief treatment or during subsequent specimen test.

Westinghouse Cycle Fatigue Data for Ti-16Al-10Nb

r = -1

Cycles to Fallure	7.0 × 10	9.9 x 10 ⁰	1.0 × 10 ⁶	6.0 × 10 ⁶	3.0 × 10 ⁵
Stress (ks1)	07	45	50	50	55
Frequency (cpm)	1800			-	
Kt					-
Test Temperature (P)	800				
Machining Technique	ECG + Polished				-



The results of the ten Westinghouse HCF results are presented in Table 36. Although a significant amount of scatter is present in the data, it appears that the as-ECG'ed samples, taken as a group, may be slightly superior in comparison to the ECG + peened (13N) or ECG, peened (13N) plus thermally exposed (1200°F/24 hours) specimens. However, it is readily apparent that no significant differences exist between each of the three groupings.

Additional studies to more fully characterize turning characteristics of aluminide alloys have been performed. A set of Ti-16Al-10Nb bars fabricated by single point tool machining techniques were examined in both the as-machined and machined plus exposed for 24 hours at 1200°F conditions. All machining conditions examined revealed some degree of surface cracking. The best results appeared to be achieved using a small unameter rool, rotational speeds of 150-200 rpm and taking relatively heavy cuts. In several cases, the cracking present after machining was accentuated by the elevated temperature exposure. In no case did the exposure cause recrystallization, as had been previously observed in ground and peened surfaces.

Bars of Ti-13.5A1-21Nb and Ti-13.5A1-21Nb-0.15Si have been machined by single point turning using the parameters previously studied on the Ti-16A1-10Nb alloy. Ti-13.5A1-0.1Nb was machined with a rotational speed of 225 rpm and a 0.003" per pass feed, while Ti-24A1-11Nb-0.25Si was machined with a rotational speed of 357 rpm and the same feed. The surfaces of these two alloys were compared with the surface of Ti-16A1-10Nb which was machined under the same conditions. The Ti-13.5A1-21Nb and Ti-13.5A1-21Nb-0.1Si bars were inspected by zyglo and in metallographic sections.

Westinghouse High Cycle Fatigue Data for Ti-16A1-10Nb



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No crack indications have been found in either alloy, demonstrating a dramatic improvement in machinability over previous alloys such as Ti-16A1-10Nb, as illustrated in Figure 66. Sections of the machined bars were exposed at 1200°F to determine surface stability characteristics. The surface of the bars exposed at 1200°F exhibited essentially the same structure as the interior of the specimens and no crac's were formed as a result of exposure.

F. Casting Studies

Experiments designed to determine alpha two titanium aluminide casting fluidity relationships and metal-mold surface interaction have been performed. The fluidity experiments were conducted using a Leybold-Hereaus electron beam furnace with a vented, center pour spiral graphice mold maintained at room temperature. Length of pour into the spiral cavity w was used as a measure of fluidity. The initial trial employed a Ti-6Al-4V alloy as a baseline in order to compare results with two subsequent Ti-16Al-10Nb runs. For comparison of cast structures and surface reactivity, melts were prepared in alumina and zirconia molds and sectioned.

Three melting trials have been run employing Ti-6Al-4V as a baseline trial and Ti-16Al-10Nb for the following two runs. The spirals for the three casting trials are illustrated in Figure 67. Chemical analysis of the solidified product for aluminum content gave the following results:

Material	Weight of Aluminum
Ti-6Al-4V	3.3
Ti-16Al-10Nb	13.9
Ti-16A1-10Nb (Increased £B Power)	7.5


Figure 66. Surface Condition After Machining of Alloys



The casting conditions for the Ti-6Al-4V casting and Ti-16A1-10Nb (a) were the same--the degree of superheat being controlled by the EB gun power setting and assessed by the temperature of the exit cooling water from the crucible. Increasing the power setting, as was done in the third trial, Figure 67, did not increase the penetration of the molten charge. In fact, the length of the spiral is virtually independent of alloy and EB gun power setting. Of more importance is the compositions of the castings. Problems with melting alloys with high aluminum content can arise due to the high vapor pressure of this element in the hard vacuum environment used for melting. It is of some importance, therefore, that using a low EB power setting results in the loss of only 2% alumimum, a value for which may be possible to compensate by using melt chemistries with a higher starting aluminum content.

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Preliminary results of a surface evaluation of castings produced in various mold indicate that reaction is slight in both oxide and graphite molds. Alumina appears to be a superior mold material compared to zirconia (Figure 68).

3. Summary and Conclusions

This series of investigations of manufacturing techniques reflects clearly some of the problems in processing low ductility materials. The welding, machining and to some extent the forging results, all indicate cracking problems are associated with the processing of the Ti-16Al-10Nb alloy. There are indications that alloys with improved low temperature ductility can alleviate many of the undesirable characteristics. Conclusions that can be drawn at this stage of the investigation are as follows:

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Surface Reaction of Alloy Ti-16A1-10Nb with (a) Zirconia, (b) Alumina and (c) Graphite Mold Materials Figure 68.

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Only electro-chemical methods are capable of producing a sound and stable condition in the alloy Ti-16A1-10Nb. More severe machining or finishing operations not only produce surface cracking but may also produce surface structural instabilities on exposure to elevated temperatures. Improved machinability and possibly surface stability are exhibited by alloys with improved ductility at low temperatures. いる、「「「「「「「「」」」」

- Welding of the alloy Ti-16Al-10Nb is possible if sections are preheated to $\sim 700^{\circ}$ F. The starting structure of the material may also be critical.
- Castability of aluminide alloys appears to be similar to conventional titanium alloys. Electron beam melting only offers minor advantages over conventional melting methods, low superheat is mandated by the loss of aluminum from melts.
- Although successful brazing methods have been established, it is considered that joining by diffusion bonding or welding are preferable joining methods, if the joint is to be exposed to elevated temperatures.

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