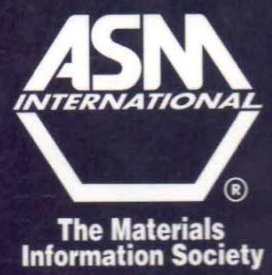


ASM SPECIALTY HANDBOOK

Nickel, Cobalt, and Their Alloys



Contents

Preface	v	Nickel-Chromium Alloys to Resist Fuel Oil Ash Corrosion...	62
Introduction to Nickel and Nickel Alloys	1	Nickel-Iron-Chromium Alloys	63
The Nickel Industry: Occurrence, Recovery, and Consumption	3	Nickel-Chromium-Iron Alloys	66
Elemental Nickel	3	Superalloys	68
Occurrence and Supply	4	General Background	68
Extraction and Refining.....	4	Processing	73
End Uses of Nickel	6	Properties and Microstructure.....	79
Uses of Nickel	7	Environmental Effects.....	85
Nickel in Ferrous Alloys.....	7	Special-Purpose Nickel Alloys	92
Nickel and Nickel-Base Alloys.....	9	Commercially Pure Nickel for Electronic Applications	92
Nickel Coatings.....	10	Resistance Heating Alloys.....	92
Nickel in Nonferrous Alloys.....	10	Thermocouple Alloys	94
Nickel Powders	10	Nickel-Iron Soft Magnetic Alloys.....	94
Wrought Corrosion Resistant Nickel and Nickel Alloys	14	Low-Expansion Alloys	96
Physical Metallurgy of Nickel and Nickel Alloys.....	14	Nickel-Titanium Shape Memory Alloys.....	101
Commercial Nickel and Nickel Alloys	15	Nickel-Beryllium Alloys.....	102
Properties of Wrought Nickel and Nickel Alloys	19	Ordered Intermetallic Alloys of Ni ₃ Al	104
Nickel 200	19	Nickel Coatings	106
Nickel 201	20	Nickel Plating	106
Nickel 270	21	Electroforming.....	114
Duranickel 301	22	Electroless Nickel Plating.....	115
Monel 400	23	Thermal Spray Coatings	120
Monel R-405	25	Weld-Overlay Coatings.....	120
Monel K-500	26	Solid-State Nickel Cladding	122
Inconel 600	27	Corrosion Behavior of Nickel and Nickel Alloys	125
Inconel 622	29	Corrosion Behavior of Nickel Alloys in Specific Environments.....	127
Inconel 625	30	Alloy Characteristics	127
Inconel 686	31	Effects of Major Alloying Elements	129
Inconel 690	32	Corrosion in Specific Environments	130
Inconel 718	33	Corrosion of Nickel and High-Nickel Alloy Weldments	137
Inconel 725	36	Stress-Corrosion Cracking and Hydrogen Embrittlement	
Incoloy 800	37	of Nickel Alloys	141
Incoloy 801	39	Physical Metallurgy of Nickel-Base Alloys	141
Incoloy 825	39	SCC in Halide Environments	143
Hastelloy B-2.....	41	SCC in Environments Containing Sulfur Species.....	147
Hastelloy B-3.....	42	SCC in High-Temperature Water and Dilute	
Hastelloy C-4.....	43	Aqueous Solutions.....	152
Hastelloy C-22.....	44	SCC in Caustic Environments.....	154
Hastelloy C-276.....	45	Cracking in Other Environments.....	157
Hastelloy C-2000.....	46	Hydrogen Embrittlement	157
Hastelloy G	47	SCC Testing Methods	160
Hastelloy G-3.....	48	High-Temperature Corrosion Behavior of Nickel Alloys	167
Hastelloy G-30.....	49	Oxidation	167
Hastelloy G-50.....	50	Carburization	172
Hastelloy N	51	Nitridation	173
Hastelloy S	52	Sulfidation	176
Hastelloy W.....	53	Halogenation	177
Hastelloy X	53	Hot Corrosion	182
Cast Corrosion-Resistant Nickel Alloys	55	Ash/Salt Deposit Corrosion.....	183
Standard Grades.....	55	Corrosion in Waste Incineration Environments	183
Nickel-Base Proprietary Alloys.....	57	Molten Salt Corrosion	184
Cast Heat Resistant Nickel-Chromium, Nickel-Iron-Chromium, and		Molten Metal Corrosion	186
Nickel-Chromium-Iron Alloys	62		

Fabrication and Finishing of Nickel and Nickel Alloys	189		
Forming of Nickel Alloys	191	Metallography and Microstructures of Nickel and Nickel-Copper Alloys	293
Factors Influencing Formability	191	Metallography and Microstructures of Nickel-Iron Alloys	294
Special Considerations for Heat-Resistant Alloys	191	Metallography and Microstructures of Heat Resistant Alloys	298
Lubricants	192	Specimen Preparation	298
Tools and Equipment	192	Microexamination	300
Shearing, Blanking, and Piercing	193	Microstructures of Wrought Heat Resistant Alloys	301
Deep Drawing	193	Phases in Wrought Heat Resistant Alloys	302
Spinning	194	Phase Diagrams of Binary and Ternary Nickel Systems	331
Bending Tube and Pipe	195	Introduction to Cobalt and Cobalt Alloys	343
Bending of Plate, Sheet, and Strip	196	The Cobalt Industry: Occurrence, Recovery, and Consumption	345
Expanding	196	Elemental Cobalt	345
Forming of Rod and Bar	196	Occurrence and Supply	345
Cold Heading and Cold Extrusion	197	Extraction and Refining	345
Straightening	197	End Uses of Cobalt	347
Cold-Formed Parts for High-Temperature Service	197	Uses of Cobalt	349
Forging of Nickel Alloys	198	Metallurgical Uses of Cobalt	349
Die Materials and Lubrication	198	Nonmetallurgical Uses of Cobalt	354
Heating for Forging	198	Phase Diagrams of Binary and Ternary Cobalt Systems	356
Cooling after Forging	199	Cobalt-Base Alloys	362
Forging Practice for Specific Alloys	199	Cobalt-Base Wear Resistant Alloys	363
Thermal-Mechanical Processing (TMP)	201	Cobalt-Base Heat Resistant Alloys	365
Isothermal Forging	202	Cobalt-Base Corrosion Resistant Alloys	367
Powder Metallurgy Processing of Nickel Alloys	203	Alloy Compositions and Product Forms	368
Production of Nickel Powders	203	Properties and Fabrication Characteristics of Cobalt and Cobalt Alloys	371
Sintering of Nickel and Nickel Alloys	211	Properties of Cobalt Alloys	373
Roll Compacting of Nickel and Nickel Alloys	214	AiResist 13 (AR-13)	373
Conventional P/M Superalloy Processing	215	AiResist 213 (AR-213)	373
Specialized P/M Superalloy Processing	220	AiResist 215 (AR-215)	373
Heat Treating of Nickel Alloys	230	Duratherm 600	374
Types of Heat Treatment	230	Elgiloy	374
Annealing	231	FSX-414	376
Process Control Factors in Annealing	232	Haynes 25 (L-605)	376
Stress Relieving	233	Haynes 188	377
Stress Equalizing	233	MAR-M 302	379
Age Hardening	233	MAR-M 322	379
Thermomechanical Processing	234	MAR-M 509	379
Machining of Nickel Alloys	235	MP35N	380
Machinability Categories	235	MP159	382
Basic Principles Applicable to All Machining Operations	236	Stellite 6B (Haynes 6B)	382
Recommendations for Machining	237	Stellite 6K	384
Welding and Brazing of Nickel Alloys	245	Ultimet	384
Welding Metallurgy of Corrosion Resistant Alloys	245	UMCo-50 (Haynes 150)	385
Welding Metallurgy of Corrosion Resistant Alloys Containing Molybdenum	251	X-40/X-45	386
Welding Metallurgy of Heat Resistant Alloys	255	Wear Behavior of Cobalt Alloys	387
Consumable Selection, Procedure Development, and Practice Considerations	257	Types of Wear	387
Brazing of Heat Resistant Nickel-Base Alloys	267	Wrought Alloy Wear Data	388
Cleaning and Finishing of Nickel Alloys	273	Hot Hardness Values for Wrought Alloys	392
Cleaning and Finishing of Corrosion Resistant Nickel Alloys	273	Wear-Related Applications for Wrought Alloys	393
Cleaning and Finishing of Heat Resistant Nickel Alloys	278	Wear Behavior of Cobalt-Base Hardfacing Alloys	393
High-Temperature Coatings for Superalloys	281	Corrosion Behavior of Cobalt Alloys	395
Coating Requirements	281	The Effect of Alloying Elements	395
Types of Coatings	281	Behavior of Cobalt Alloys in Corrosive Aqueous Environments	395
Methods of Applying Diffusion Coatings	283	Environmental Embrittlement of Cobalt Alloys	398
Properties of Diffusion Coatings	284	High-Temperature Corrosion of Cobalt Alloys	399
Practical Applications of Diffusion Coatings	286	Fabrication and Metallography of Cobalt Alloys	401
Methods of Applying Overlay Coatings	287	Heat Treatment	401
Thermal Barrier Coatings	287	Workability	401
Coating Performance	288	Joinability	402
Metallography, Microstructures, and Phase Diagrams of Nickel and Nickel Alloys	291	Machinability	403
Metallography and Microstructures of Nickel, Nickel-Copper, and Nickel-Iron Alloys	293	Metallography	404
		Subject Index	407
		Alloy Index	422