

**PROCEEDINGS OF THE
9TH INTERNATIONAL SYMPOSIUM ON**

SUPERALLOY 718 **and Derivatives**

**ENERGY, AEROSPACE, AND
INDUSTRIAL APPLICATIONS**

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Preface

This conference marks the 9th International Symposium on Superalloy 718 and Derivatives. The legacy which started in 1989 in Pittsburgh, Pennsylvania, continues to provide a rich forum for a combination of industrial and academic technical papers, presentations, and posters on highly relevant, high-temperature, superalloy materials. The strength of this series is in its breadth of technical, geographic, demographic, and application coverage. Over the years, it has provided an event for all those interested in high-temperature materials and reaches well beyond the simple exchange of technical findings. It is regularly a reunion for the many who work together solving development and production challenges at a distance from one another through ever-increasing electronic-enabled collaborations.

This 2018 proceedings volume consists of 72 papers; topic coverage includes the traditional subjects of casting, forging, and mechanical properties as well as topics on microstructure, joining, and novel processing. In the most recent two conferences, the advent of novel processing technologies including additive manufacturing has begun to open new avenues of investigation in what is a very dynamic field of engineering and science. Across the range of technology areas, the use of advanced characterization and modeling continues to make significant advances in the field. Contributions in this year's conference have spanned a wide swath of the industrialized world from Canada to South Korea and from the USA to Japan; 60% of papers come from outside the USA. Authors represent academic institutions (44%), laboratories (17%), and companies (36%). Although from a great diversity of areas and backgrounds, many gather to discuss knowns and unknowns and to forge ahead with enriching the understanding of metallurgy and application of these materials.

Our volunteer team has worked to bring a high quality and broadly relevant conference to authors and conference participants. We hope that the conference and these proceedings continue to enrich the advancement of understanding and application of these materials now and in the years to come.

Eric Ott, Lead Editor
Xingbo Liu, Organizer

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Part I
Superalloy 718 & Derivatives: Keynotes

Age Hardenable Nickel-Based Alloy Developments and Research for New High Temperature Power Cycles



John P. Shingledecker and John A. Siefert

Abstract Advanced Ultrasupercritical (A-USC) steam Rankine cycles and Supercritical Carbon Dioxide (sCO₂) Brayton cycles are under intensive development to enable low carbon generation of electricity. These high-efficiency power cycles, aimed at fossil and in some cases renewable energy, require higher temperatures and pressures compared to traditional steam cycles for pressuring retaining components such as tubing, piping, heat exchangers, and turbine casings. Extensive research and development to produce and characterize age-hardenable nickel-based alloys containing Al, Ti, and Nb in judicious amounts have allowed designers to now consider supercritical fluid temperatures up to ~760 °C which is much greater than today's supercritical steam technology based on steel metallurgy up to ~610 °C. This paper will focus on the alloys developed around the world to enable these advanced power cycles, and a discussion on their key properties: long-term creep strength (100,000 h+), fabricability, and weldability/weld performance. Most of these alloys contain less than 25% gamma prime, such as alloy 740H, 263, and 282, due to the need for heavy section weldability, unique to these applications. While welding processes have now been developed for many of these alloys using a variety of filler metals and processes, key research questions remain on the applicability of processes to field power plant erection, the potential for cracking to occur during service, and the long-term weld creep and creep-fatigue performance.

Keywords Steam boilers • Steam turbines • Inconel[®] alloy[®] 740H Welding

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Introduction to Advanced Energy Systems Requiring Nickel-Based Alloys

National and Global Trends

In 2015, the electricity produced from coal and natural gas in the U.S. was approximately equal at 34% each, representing 68% of the total electricity generated with the remaining major sources being nuclear at 20% and all renewables (hydro, wind, solar, biomass, etc.) at 12%. In 2016, for the first time in the history of the U. S., electricity produced from natural gas exceeded that of coal generation 36 to 31% as shown in Fig. 1 [1]. Globally coal and natural gas continue to be the predominate fuels for the production of energy [2]. While future projection for the exact mix of fossil fuels remain uncertain both nationally and globally, the world is projected to need more electricity with fossil fuels being a major source of new generation [3]. In the US, the need for electricity continues to increase. As illustrated in Fig. 2, which shows the historical use of electricity as a percentage of the total energy use in the U.S., efficient electrification for residential, commercial, and industrial sectors has steadily increased for over 50 years as electrification is recognized as a key element of the future energy in the U.S. [4]. The need for environmentally responsible electricity through significant reductions in the emission of CO₂ coupled with these national and global drivers for continued use of fossil fuels necessitates the need for highly efficient and transformational fossil energy systems in the future. Various roadmaps, such as the Coal Utilization Research Council

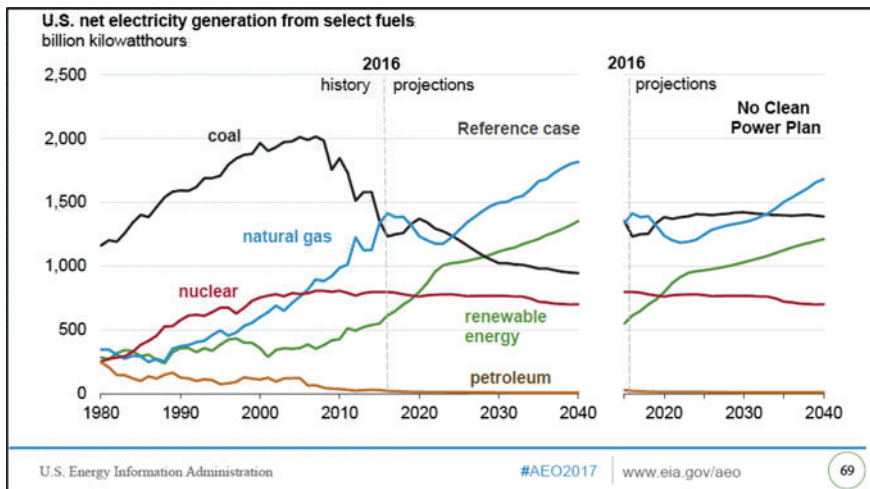


Fig. 1 Historical and projected U.S. electricity generation mix reported by U.S. Energy Information Administration including the reference case scenario (left) and a scenario without adoption of the Clean Power Plan (right) [1]

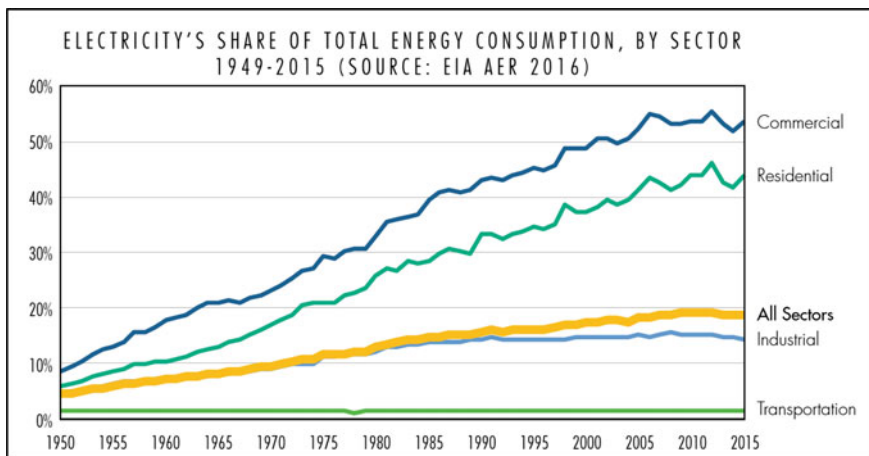


Fig. 2 Historical U.S. electricity use as a percentage of total energy for various sectors showing electricity use has grown faster than total energy for over 50 years [4]

(CURC)-EPRI roadmap [5] and the International Energy Agency (IEA) High Efficiency Low Emission (HELE) roadmap [2, 3] have identified technology pathways first based on maximizing the efficiency of today's technologies and then adopting new transformational technologies. EPRI's Integrated Energy Network (IEN) is a vision for the future in which all energy sources are more efficiently integrated through (a) producing cleaner energy, (b) using cleaning energy through efficiency and electrification, and (c) integrating energy resources [2]. A key aspect of the IEN is the production of cleaner energy through the introduction of new transformational fossil power systems which will lead to cost-effective low carbon fossil generation (likely with carbon capture and storage).

Fossil Power Generation Technologies

Two major technologies identified in the previously mentioned roadmaps are Advanced Ultrasupercritical (A-USC) steam cycles and Supercritical CO₂ (sCO₂) power cycles. These concepts are explored in this paper because, as will be shown, they share many similar structural materials needs and these cycles are required to fully enable future transformational systems, such as an oxygen-fired boiler (oxy-combustion) with carbon capture and an A-USC steam cycle.

Today's pulverized coal-fired (PC) power plants operate at ultrasupercritical (USC) conditions with steam temperatures up to ~610 °C. A-USC conditions generally refer to a steam cycle with steam temperatures of 700 °C and higher. The world-wide development of A-USC technology started initially around 1998 with a variety of European Projects [6]. In 2001, the U.S. Department of Energy in

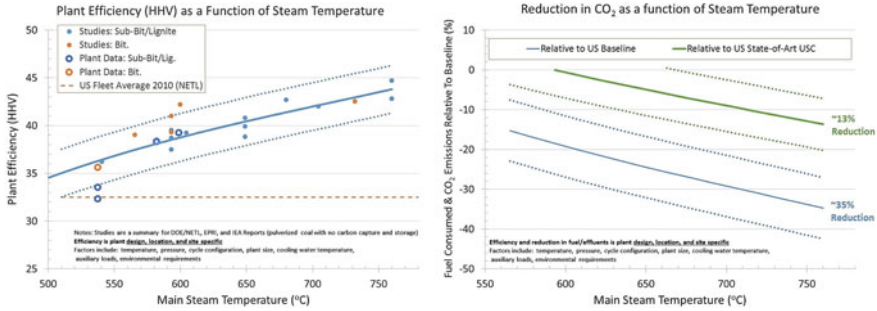


Fig. 3 Effect of steam temperature on pulverized coal-fired powerplant net efficiency (HHV basis) and corresponding reduction in CO_2 [8]

conjunction with the Ohio Coal Development Office (OCDO) and cost share from all the major U.S. boiler and turbine original equipment manufacturers (Alstom, B&W, Foster Wheel, Riley Power, GE, Siemens), the Energy Industries of Ohio (EIO), and the Electric Power Research Institute (EPRI) with support from Oak Ridge National Laboratory (ORNL) and the National Energy Technology Laboratory (NETL) Albany Research Center (ARC) and managed for DOE by NETL, began an ambitious pre-competitive research and development project that would lead to higher efficiency coal-fired power plants with reduced CO_2 emissions [7]. Figure 3 is a summary of pulverized coal-fired plant efficiency (HHV) and emissions reduction, as a function of steam temperature for various U.S. based modeling studies (solid symbols) with some current reported plant efficiency data (open symbols). There is considerable variation due to local conditions (cooling water temperature, fuel type, specific design considerations such as size and utilization of waste heat, etc.). However, when compared to the U.S. Fleet averages of 32.3–32.5% HHV, A-USC conditions are expected to raise efficiency up to 12.5 HHV% which corresponds to a 35% reduction in CO_2 emissions. Even when compared to today’s state-of-the-art USC unit operating at 600 °C (for US Conditions), A-USC offers a CO_2 reduction of ~13%. While an A-USC powerplant has yet to be built, numerous economic studies have shown that in the reduction in operating costs from fuel usage (increase in efficiency) for A-USC does not offset the increased capital cost of the plant, until carbon capture and storage is considered. A-USC becomes economically attractive for carbon reduction, as studies show it is more cost effective to not produce CO_2 in comparison to producing it and then capturing it through carbon capture and storage (CCS). In other regions of the world with more expensive fuel costs or lower labor costs, A-USC may be economically attractive without carbon constraints [9, 10].

Brayton power cycles with supercritical CO_2 (sCO_2) as the working fluid are undergoing intense development for a range of power systems including fossil energy, nuclear power, shipboard propulsion, geothermal energy extraction, and solar thermal power cycles [11]. Principle advantages of the sCO_2 cycle due to the physical properties of CO_2 include compact turbo-machinery, high efficiency, and

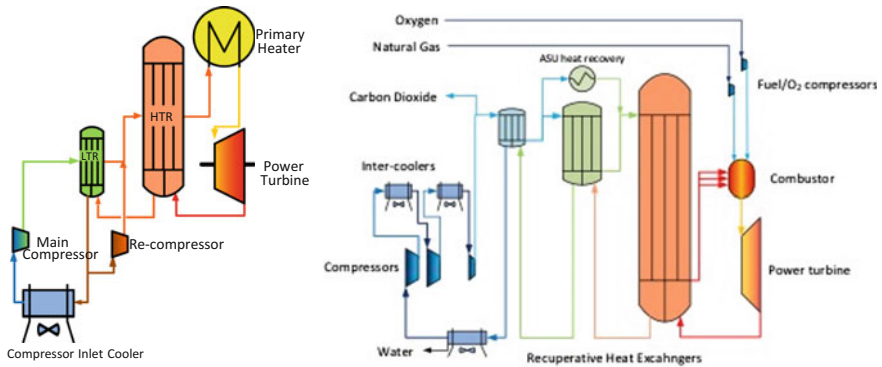


Fig. 4 Examples of general system arrangements for indirect (closed) system (left) and direct (open) cycle (right); note HTR = high temperature recuperator and LTR = low temperature recuperator

the ability to reject heat at higher temperatures when compared to traditional steam Rankine cycles. These advantages may lead to lower capital costs and higher efficiencies for future power systems [12]. Two general types of systems are being investigated as depicted in Fig. 4. Indirect cycles with a closed loop of $s\text{CO}_2$ are being considered for a range of application as the ‘heat-source’ could be coal, natural gas, molten salt, waste heat, etc. To achieve high cycle efficiencies, fluid temperatures of $700\text{ }^\circ\text{C}$ and pressures approaching 300 bar are being considered. Current commercial offerings are only available at smaller sizes $<10\text{ MW}$ and lower temperatures [13]. A more transformational cycle is the direct cycle (right of Fig. 4) which involves direct combustion of natural gas (or gasified coal) and oxygen into a high pressure $s\text{CO}_2$ system. The only byproducts of this approach are high pressure ‘sequestration ready’ CO_2 and water. A pilot plant testing this technology is currently under construction, and to achieve high efficiency the selected fluid temperature is $>700\text{ }^\circ\text{C}$ [13]. Some of the challenges of the $s\text{CO}_2$ system in comparison to a steam Rankine cycle are a narrow heat addition window, the need for extensive recuperation of heat, much higher working fluid recirculation volume, and sensitivity to pressure drop. Many small-scale pilot demonstrations are being investigated to develop these concepts for future power plant applications.

Background on Alloys, Materials Selection, and Completed R&D

Both A-USC and $s\text{CO}_2$ power cycles require materials to withstand high temperatures $> 700\text{ }^\circ\text{C}$ and pressures $> 300\text{ bar}$ for long times. In most cases, the materials for piping, tubing, valves, and heat exchangers are pressure boundary materials and subject to approval to the ASME Boiler and Pressure Vessel (B&PV) Code (or

similar code of construction), while turbine components have more flexibility in selection of materials based on the manufacturers detailed knowledge. At these fluid conditions, the ASME allowable stresses for design are based on the creep-rupture performance of the materials. As stated earlier, major materials development programs in the EU and USA (and later Japan, China, and India) have been working for over a decade to develop the underlying materials technology to make such components available [8]. Figure 5 shows the average 100,000 h rupture strength for various classes of materials. A line at 100 MPa denotes a first cut approximation at the relative temperature capability for materials typically used in today's boilers which shows martensitic/ferritic steels are limited to about 610 °C (highest steam conditions in today's USC power plants). Austenitic stainless steels have higher creep-rupture strength, but poor thermal conductivity and a high coefficient of thermal expansion limit their use to thinner wall components such as tubes due to the generation of thermal stresses in thick components such as boiler headers, turbine casings and discs. Nickel-based alloys are the only alloys available which meet the basic creep-rupture strength requirements for 700 °C+ service. However, there are a range of other properties which are critical for application to A-USC and sCO₂ components including formability, weldability, corrosion resistance, short-term strength, ductility, creep-fatigue performance, weld performance, and manufacturability often in very large section thicknesses. Piping, header, and casing components may require wall thicknesses approaching 100 mm, and there is a need

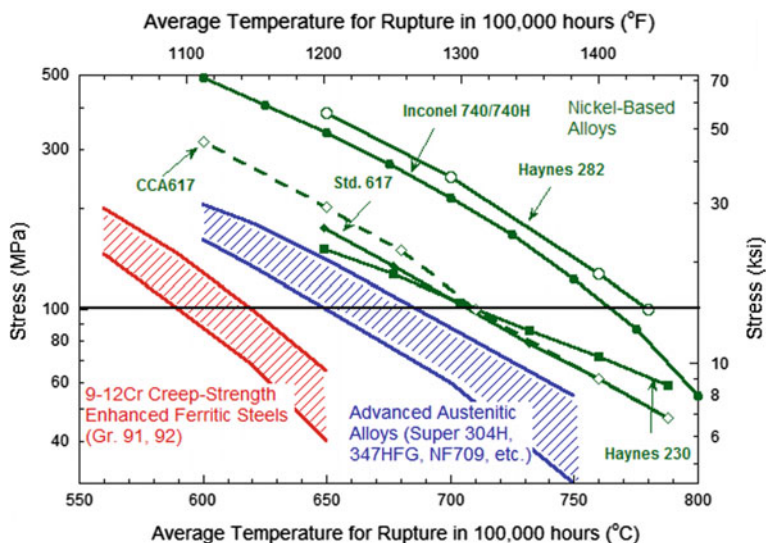


Fig. 5 100,000 average creep-rupture strength for various classes of alloys of interest to A-USC and sCO₂ power cycle application

for large forgings on the order of 1000 mm in thickness for steam turbine rotors. Conventional nickel-based alloys such as Waspalloy and Nimonic 105 which appear to meet the requisite basic creep strength requirements may be used for specific smaller non-welded components such as turbine blades (buckets) and bolting, but these alloys are not code approved nor do they have the weldability and formability for heavy-wall components due to large volume fractions of gamma prime. Similarly, alloys strengthened by gamma double prime such as 718 which have good processing characteristics lose their long-term creep strength above 650 °C, are not code approved, and won't meet creep and tensile strength requirements. Therefore, the main nickel-based alloys of interest to A-USC and sCO₂, shown in Fig. 5 (nominal compositions in Table 1), are either solid solution strengthened with basic temperature capability for approximately 700 °C or gamma prime strengthened with higher capability to about 760 °C. While Table 1 is not an exhaustive list of materials, the material identified have seen the most study predominately by the US and EU for A-USC applications. Currently, the highest-strength code approved alloy is Inconel[®] Alloy 740H[®] which has been successfully welded and fabricated into components up to about 80 mm in thickness. This is a significant technological achievement (along with similar studies and successes on alloys 617, 263, 230, and Haynes 282) in the processing of age-hardenable nickel-based alloys. Table 2 describes some of the research done on various components made with these alloys; more detailed alloy specific information and results from major government led developments is summarized in Ref. [8]. In addition to large section thickness and similar concerns for A-USC steam Rankine systems, sCO₂ Brayton cycles present additional unique nickel-based materials challenges. One challenge is the need for very large pipe diameters due to high recirculation requirements compared to steam; such pipe sizes can only be fabricated through forming and welding. A second consideration is the need to develop processing and performance data for compact heat exchangers with these materials. Compact heat-exchangers are currently made using specialized methods and designs based on combinations of etching, diffusion bonding, brazing, small tubes, fins, and wire meshes which will need to be developed for these nickel-based alloys [14].

A number of recent conferences [11, 22] and summary reports/papers are now available with extensive detail into the laboratory investigations, processing studies, fabrication trials, corrosion performance, and long-term creep behavior of A-USC alloys for boilers [23], turbines [24], and in-plant studies/component demonstration activities [15, 25]. As stated previously, the development of welding procedures for thick sections on age-hardenable materials including forgings, extrusions, and castings represents a significant technological advancement. Figure 6 shows just three examples of the progress made in welding large nickel-based components.

Table 1 Nominal compositions^a of some candidate Ni-based alloys for A-USC and sCO₂ application, wt%

Family	Alloy	ASME code case	C	Ni	Fe	Cr	Mn	Si	Mo	Co	Al	Ti	B	Others
Solid solution	Alloy 617	N06617	0.07	Bal.	0.5	22	0.3	0.3	9	12.5	1.0	0.40		
	CCA617 [*]	N/A	0.06	Bal.	0.3	22	0.1	0.1	9	12	1.2	0.40	0.003	
	Haynes ^b 230	N066230	0.10	Bal.	1.5	22	0.5	0.4	2	0.3	0.3		0.004	W: 14.0 La: 0.02
Gamma-Prime	NIMONIC ^c 263	N/A	0.06	Bal.	0.1	20	0.1	0.1	6	20	0.45	2.2	0.004	
	INCONEL ^c Alloy 740H ^c	2702	0.03	Bal.	1	24.5	0.3	0.15	0.1	20	1.35	1.35	0.001	Nb + Ta: 1.5
	Haynes ^b 282 ^b	N/A ^{**}	0.06	Bal.	0.2	20	0.05	0.1	8.5	10	1.5	2.1	0.005	

^aSulfur and Phosphorous limits omitted from Table^bHaynes, 230 and 282 are registered trademarks of the Haynes International^cINCONEL, NIMONIC and 740H are registered trademarks of the Special Metals Corporation^{*}CCA617 is also designated in literature as 617b or 617 mod^{**}Code Case in Development for Single Age (non-standard) heat-treatment

Table 2 Examples of component production and demonstrations on various A-USC and sCO₂ candidate materials

Material	Component (size or max thickness)	Manufacturing demonstrated	Evaluation method	Notes
CCA617 [15]	Piping system (50 mm)	Pipe and tube production; header component production; piping system fabrication, high-temperature valves	Comtes 700 A-USC Component Test Facility Operation: 20,000 h at 700 °C	Overall good performance and demonstrated many manufacturing and field erection methods, but numerous cracks and failures in thick section components subject to thermal cycles; concluded that all welds needed an additional heat-treatment to avoid stress relaxation cracking
CCA617, 740H [16]	Superheater tubing (10 mm)	Superheater manufacturing including similar and dissimilar metal welding	Steam-Cooled A-USC corrosion test loop: 4 years at 760 °C	Acceptable corrosion performance and no issues identified at welds (note: low operational stress)
740H [17]	Piping (80 mm)	Pipe extrusion and weldability	Destructive laboratory testing	Successful narrow groove welding, validated longer extrusion lengths than same 617 extrusion
740H [18]	Pipes and fittings	Small forgings (hydro-forming, hot forming), thin wall pipe production (rolled formed pipe)	Destructive laboratory testing and Installation in sCO ₂ pilot plant	Pilot plant operation planned for 2018 [19]
263 [8]	Rotor Forging (1000 mm)	Large forging demonstration and rotor welding proof of concept	Destructive testing	Limited data on performance available in literature; some suggestion that alloy optimization for structural stability is still needed

(continued)

Table 2 (continued)

Material	Component (size or max thickness)	Manufacturing demonstrated	Evaluation method	Notes
282 [20]	Rotor Forging (1100 mm disc)	Triple-melt production (2 heats), chemical homogeneity, and disc forging development	Destructive testing	Good processing characteristics suggested larger forging sizes are possible and optimization of grain structure for creep and fatigue were demonstrated
282 [21]	Turbine valve chest (8000 kg pour weight)	Sand casting for turbine cast components (valves and casings)	Destructive testing	First and largest known demonstration of heavy wall 282 casting, size range applicable to steam turbine casings, limited mechanical testing showed acceptable performance

Weldability and Weld Performance

Based on the successful welds made around the globe for A-USC materials, a comprehensive review was conducted by Siefert and colleagues on the fundamentals, weldability, and weld performance of A-USC nickel-based alloys [26, 27]. The major findings and recommendations for the materials listed in Table 1 are highlighted in the following sections, but the reader is encouraged to review references [26, 27] for a more thorough treatment of the subject matter.

Weldability

Nickel-based alloys considered for A-USC and sCO₂ applications may be susceptible to a range of potential weldability issues including: solidification cracking, heat affected zone (HAZ) liquation cracking, ductility dip cracking (DDC), and strain age cracking (SAC) which is also known as stress relaxation cracking. Quantitative ranking of candidate materials for each potential mechanism is problematic because the number of variables which need to be considered include: welding process, shielding gas (if applicable), weld metal composition, base metal composition, grain size, heat-treatment, degree of constraint, sample size/thickness,

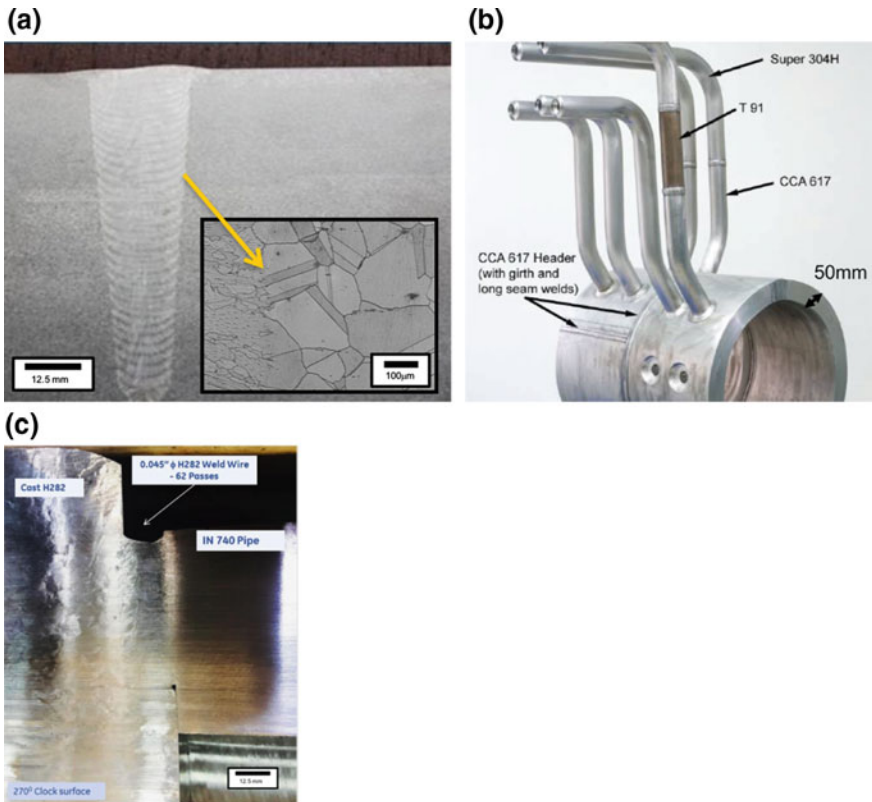


Fig. 6 Examples of successful welding demonstrations on A-USC materials including: **a** cross-sectional micrograph of a 75 mm thick alloy 740H pipe butt weld with no observed welding defects or cracks, **b** multiple orientations and welding processes for a 50 mm thick alloy CCA617 pipe and plate welds on a demonstration header, along with tube dissimilar metal welds, and **c** ~63 mm thick 282 casting to 740H piping weld with 282 filler metal, representing welding to a turbine casing [23, 24]

and welding residual stresses. Furthermore, there exist many non-standardized test methodologies which make comparisons of different studies challenging. However, comprehensive and careful review of the data (when reported) can identify key trends and provide practical mitigation methods if problems are encountered in service.

Fusion Zone Solidification Cracking

Solidification cracking, which occurs in the fusion zone of weldments, is of concern for the candidate alloys. Specifically, many studies have shown that the potential for solidification cracking is sensitive to a host of compositional factors even within the

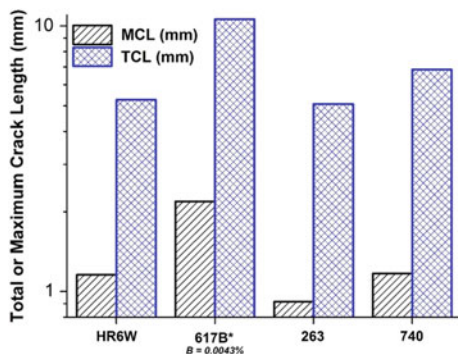


Fig. 7 Trans-varestraint test results for mean and total crack length (MCL and TCL), respectively, gas tungsten arc welding process with 3% loading strain for A-USC alloys after [27, 28]

specification range for the alloys. For alloys 617 and 230, the level of Boron (B) has been found to have a major effect. Figure 7 shows the data gathered for trans-varestraint testing in which a high B heat (0.004 wt%) of 617 exhibited a higher tendency to solidification cracking (as measured by crack length) compared to alloys 263 and 740. HR6 W, a laves phase strengthened Ni-Fe-Cr alloy with 6–8 wt%W and candidate A-USC temperatures <700 °C was included in this study as well. Figure 8 shows results for testing on Haynes 230 where B free heats exhibited fewer cracks compared to heats with 0.004–0.006 wt% B. In general B is added to improve high-temperature creep behavior and microstructural stability in nickel-based alloys, but care must be taken to ensure weldability challenges are minimized. In the case of Haynes 230 for example, matching filler metals are essentially free from B to reduce concerns over solidification cracking.

Liquation Cracking

Nickel-based alloys typically exhibit a wide melting and solidification range depending on alloying additions. In general, the wider the solidification range combined with specific alloying elements can lead to HAZ cracking in areas of the base metal near welds which may undergo partial melting during welding cycles. Liquation cracking was first identified in alloy 740 during microstructural examinations of thick section welding trials including base metal HAZ cracking as well as weld metal cracking. Figure 9 shows the ‘Nil Ductility Range’ (NDR) for a host of 740 and modified 740 compositions along with other nickel-based alloys [30]. Based on these results and other similar studies including computational thermodynamics to help understand how alloying elements segregated and created low-melting point locations in the material, an optimized 740H composition with reduced B, Si, and Nb was produced. Multiple welding trials (see Fig. 6) have shown this composition to be resistant to liquation cracking. Figure 9 also shows