



AEROSPACE INFORMATION REPORT

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Superseding AIR4394

Vacuum Investment Cast
PH13-8Mo Corrosion Resistant Steel

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FOREWORD

This report represents the combined effort of the membership of The Aerospace Metals Engineering Committee of the Aerospace Materials Division of SAE. Specifically, the contributions of the following are acknowledged:

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TABLE OF CONTENTS

1.	SCOPE	3
2.	REFERENCES	3
3.	PROCEDURE	3
3.1	Materials and Processing	3
3.2	Testing	4
4.	DISCUSSION	20
APPENDIX A	Statistical Analysis – Mechanical Property Results	21

LIST OF TABLES

Table 1	Material	3
Table 2	Tensile Test Results	6
Table 3	Room Temperature Fracture Toughness	7
Table 4	Fatigue Test Results, Cast Specimens, R=+0.1	7
Table 5	Fatigue Test Results, Machined Specimens, R=+0.1	8
Table 6	Crack Growth Data, Test 1	9
Table 7	Crack Growth Data, Test 2	10
Table 8	Crack Growth Data, Test 3	11
Table 9	Crack Growth Data, Test 4	12
Table 10	Crack Growth Data, Test 5	13

LIST OF FIGURES

Figure 1	S/N Curve for Unnotched Fatigue Behavior of PH 13-8 Mo (H1000)	5
Figure 2	Fatigue Test Results, Constant Stress Ratio, R=+0.1	14
Figure 3	Crack Growth Results, Test 1	15
Figure 4	Crack Growth Results, Test 2	16
Figure 5	Crack Growth Results, Test 3	17
Figure 6	Crack Growth Results, Test 4	18
Figure 7	Crack Growth Results, Test 5	19

1. SCOPE:

An industry-wide interest has arisen with regards to the properties and capabilities of investment cast PH 13-8Mo corrosion resistant steel. Specifically of interest are the structural applications in the aerospace industry for this product heat treated to the H1000 condition.

The objective of this AMEC cooperative test program was to generate and compile useful data for aerospace structural evaluation of investment cast PH 13-8Mo heat treated to H1000. The focus of the test program was the determination of overall mechanical properties, fatigue, fracture toughness, and crack growth data along with basic microstructural evaluation of the investment cast material.

Additional objectives included the evaluation of mechanical property variations between cast and machined tensile specimens and evaluation of microstructural constituents. All testing was performed to determine the suitability of PH 13-8Mo, H1000 investment castings for use in the aerospace industry.

2. REFERENCES:

AMS 5629 Bars, Forgings, Rings, and Extrusions, 13Cr-8.0Ni-2.2Mo-1.1Al, Vacuum Induction Plus Vacuum Consumable Electrode Melted, Solution Heat Treated, Precipitation Hardenable

3. PROCEDURE:

3.1 Materials and Processing:

The material tested was vacuum induction melted in two heats, having the following compositions conforming to AMS 5629 (see Table 1):

TABLE 1

Heat	C	Mn	Si	P	S	Cr	Ni	Mo	Al
1	0.018	0.0065	0.0052	0.0017	0.0016	12.70	7.97	2.11	1.11
2	0.024	0.0060	0.0063	0.0016	0.0016	12.59	7.98	2.13	1.15

The material was investment cast with a selective insulated wrap, poured under vacuum. Mold temperature was $2150^{\circ}\text{F} \pm 50$ and metal temperature was $2725^{\circ}\text{F} \pm 50$. Air cooling followed vacuum casting.

3.1 (Continued):

Thermal treatment processing of the material consisted of the following:

- a. Homogenize at $2100^{\circ}\text{F} \pm 25$ for 90 min in vacuum with argon gas fan cool to room temperature.
- b. Solution treat at $1700^{\circ}\text{F} \pm 15$ for 60 min in vacuum with argon gas fan cool followed by a water cool to below 60°F .
- c. Age at 1000°F for 4 h in air with rapid air cool.

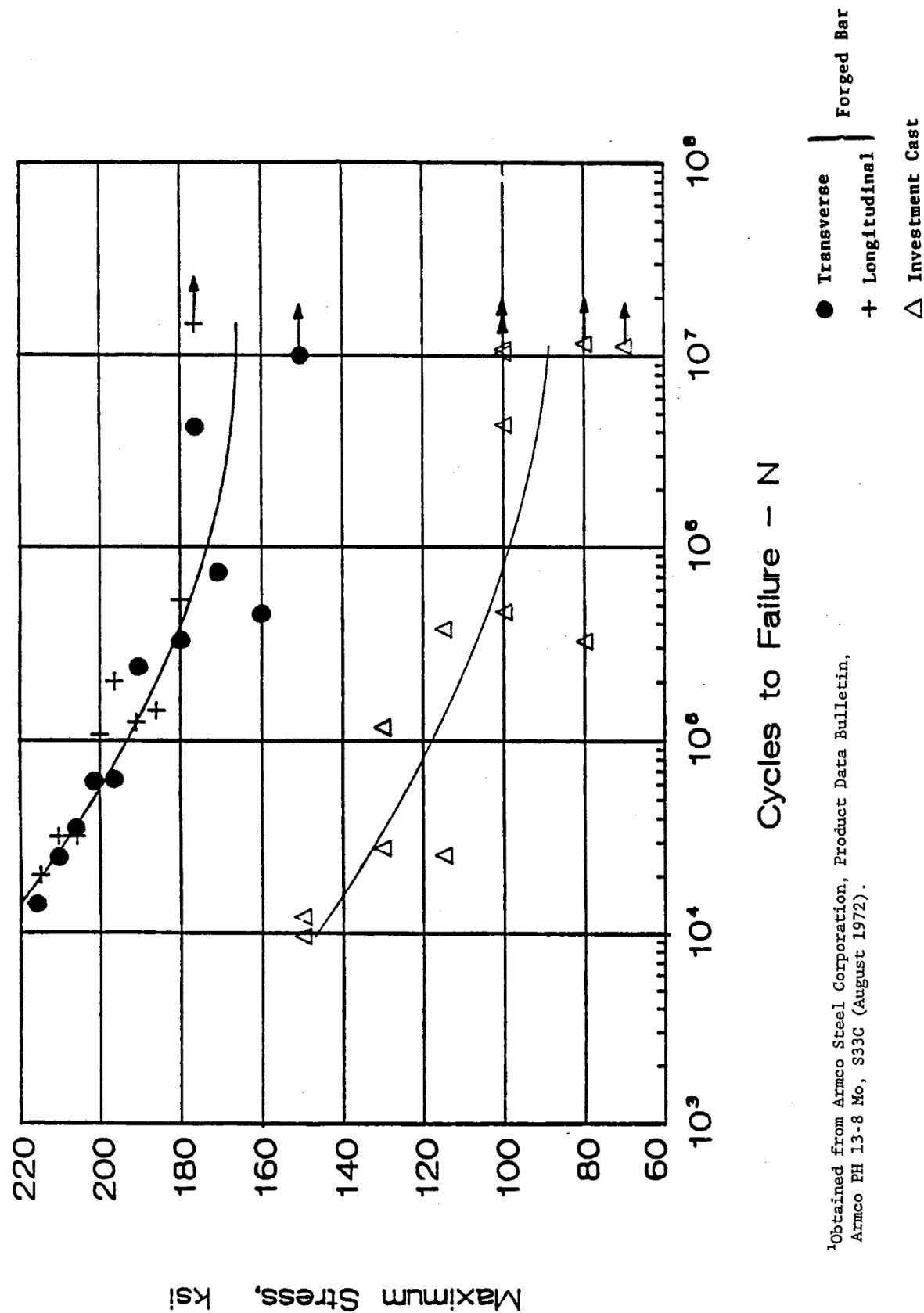
3.2 Testing:

Room temperature mechanical property tests were conducted on machined specimens and specimens which were cast to size for the purpose of establishing strength guidelines and for making a comparison between the two conditions. The results are presented in Table 2. The ultimate and yield strength properties of the cast-to-size and machined-to-size specimens were not statistically equivalent by a T-test comparison. However, since the values are slightly lower in both cases for the cast-to-size specimens, combining the data seems reasonable. The ductility of the two specimen types were statistically equivalent using an identical statistical analysis. However, due to the rather large standard deviations, the statistical minimums are very low. All statistical analyses of the mechanical property data are presented in Appendix A.

Plane strain fracture toughness was evaluated on five specimens primarily for information purposes. The results presented in Table 3 were relatively consistent for each test group.

A series of axial load fatigue tests were conducted. Stresses were selected so that cycles to failure ranged between 10^3 and 10^7 . A single test using as-cast specimens from heat 2 at constant stress-ratio, $R=+0.1$, was conducted on 22 specimens to develop a satisfactory S/N curve. A comparison was made with an S/N curve derived from 14 machined-to-size specimens. The constant stress-ratio results are presented in Tables 3 and 4 and plots of the data are combined in Figure 2. The fatigue curve developed from tests of machined-to-size specimens is also shown in Figure 1, for comparison with fatigue data on rolled bar as reported by ARMC0.

The final results presented are comprised of data from a series of compact tension tests performed on specimens machined from plate stock to develop representative crack growth data for PH 13-8Mo, H1000. Five individual tests were conducted. Results are presented in Tables 5 through 9 with their respective plots in Figures 3 through 7.



¹Obtained from Armco Steel Corporation, Product Data Bulletin, Armco PH 13-8 Mo, S33C (August 1972).

FIGURE 1 - S/N Curve for Unnotched Fatigue Behavior of PH 13-8 Mo (H1000) (Data includes longitudinal and transverse results for rolled bar¹ and for specimens machined from an investment casting.)

TABLE 2 - Tensile Test Results

Form	Heat	Yield Strength (ksi)	Tensile Strength (ksi)	Elongation (Percent)	Reduction of Area (Percent)
S	2	192.5	202.6	8.2	37.9
S	2	189.1	198.3	10.8	42.0
S	2	191.4	199.9	8.8	38.1
S	2	198.6	206.8	13.7	24.8
S	2	197.6	209.7	11.2	30.8
S	2	191.2	205.6	10.4	18.2
S	2	196.8	201.7	7.1	35.5
S	2	196.0	200.2	5.0	29.2
S	2	198.0	203.2	7.2	35.2
S	2	200.0	204.4	9.0	31.5
S	2	196.0	202.3	8.9	35.2
S	2	197.5	203.0	8.8	36.2
S	2	188.2	203.9	9.3	26.0
S	2	189.3	202.2	12.2	40.9
S	2	188.7	202.0	9.2	36.0
S	2	187.6	206.1	6.9	27.3
M	1	195.8	207.4	11.8	24.6
M	1	197.2	204.5	15.0	58.5
M	1	194.9	202.9	12.7	46.6
M	2	196.8	205.7	12.0	52.3
M	2	197.0	204.9	8.0	33.1
M	2	196.3	204.9	8.0	33.7
M	2	197.0	205.5	5.0	17.2
M	2	195.4	203.8	4.0	17.9
M	2	196.2	205.1	5.0	19.6
M	2	194.3	204.3	6.0	22.6
M	2	195.4	205.1	10.0	48.7
M	2	196.0	204.2	12.0	56.9
M	2	202.8	205.0	11.0	43.6
M	2	199.0	201.6	9.5	37.5

S - Specimens cast to size.

M - Specimens machined from any area of casting¹.

¹Note - Machined to size specimens from heat 1 were cut from 1 in x 2.5 in x 5.5 in cast plate while those from heat 2 were cut from 0.325 in x 6 in x 6 in plate.