BS 3HR 202:2009

BSI British Standards

AEROSPACE SERIES

Specification for nickel-chromium-cobalt-titanium-aluminium heat-resisting alloy sheet and strip (Nickel base, Cr 19.5, Co 18.0, Ti 2.5, Al 1.5)

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Contents

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Summary of pages
This document comprises a front cover, an inside front cover, pages i to ii, pages 1 to 4, an inside back cover and a back cover.

Foreword

Publishing information

This British Standard is published by BSI and came into effect on 30 November 2009. It was prepared by Panel ACE/61/-/48, *Heat resisting alloys*, under the authority of Technical Committee ACE/61, *Metallic materials for aerospace purposes*. A list of organizations represented on this committee can be obtained on request to its secretary.

Supersession

This British Standard supersedes BS 2HR 202:1973, which is withdrawn.

Information about this document

This is a full revision of BS HR 202. The principal change from the previous edition is that the requirements are stated in tabular format in accordance with EN 4500-1 and EN 4500-3.

Hazard warnings

WARNING. This British Standard calls for the use of substances and/or procedures that can be injurious to health if adequate precautions are not taken. It refers only to technical suitability and does not absolve the user from legal obligations relating to health and safety at any stage.

Use of this document

It has been assumed in the preparation of this British Standard that the execution of its provisions will be entrusted to appropriately qualified and experienced people, for whose use it has been produced.

Presentational conventions

The provisions of this standard are presented in roman (i.e. upright) type. Its requirements are expressed in sentences in which the principal auxiliary verb is "shall".

Commentary, explanation and general informative material is presented in smaller italic type, and does not constitute a normative element.

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1 Scope

This British Standard specifies requirements for nickel-chromium-cobalt-titanium-aluminium heat-resisting alloy sheet and strip.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

BS HR 100, *Procedure for inspection and testing of wrought heat-resisting alloys*

3 Technical requirements

Material to this standard shall conform to Table 1.

NOTE The format and symbols used in Table 1 are derived from EN 4500-1 and EN 4500-3.

Table 1 **Technical requirements for nickel-chromium-cobalt-titanium-aluminium heat-resisting alloy sheet and strip**

1	**Material designation**			**BS HR 202**							
2	**Chemical composition** %	Element		C	Si	Mn	S	Ag	Al	B	Bi
		Min.		—	—	—	—	—	1.0	—	—
		Max.		0.13	1.0	1.0	0.015	5 ppm	2.0	0.020	1 ppm
		Element		Co	Cr	Cu	Fe	Pb	Ti	Zr	Ni
		Min.		15.0	18.0	—	—	—	2.0	—	Base
		Max.		21.0	21.0	0.2	1.5	20 ppm	3.0	0.15	
3	**Method of melting**			Induction melted and cast in air; induction melted, vacuum refined and cast in air; consumable electrode remelted							
4.1	**Form**			Sheet and strip							
4.2	**Method of production**			Rolled							
4.3	**Limit dimension(s)**		mm	$0.25 \leqslant a \leqslant 3.0$							
5	**Technical specification**			Sections 1 and 5 of BS HR 100							

6.1	**Delivery condition**	Cold rolled, softened and descaled
	Heat treatment	$1\,100\ °C \leqslant \theta \leqslant 1\,150\ °C$ / $1\ min \leqslant t \leqslant 10\ min$ / AC or OQ or WQ
6.2	**Delivery condition code**	A
7	**Use condition**	Softened + precipitation treated
	Heat treatment	Delivery condition + $\theta = (750 \pm 10)\ °C$ / $t = 4\ h$ / AC

Characteristics

8.1	**Test sample(s)**			See Section 5 of BS HR 100					
8.2	**Test piece(s)**			See Section 5 of BS HR 100					
8.3	**Heat treatment**			Delivery condition	Use condition			Reference [1] (see line 29)	
9	**Dimensions concerned**		mm	—	$0.25 \leqslant a \leqslant 0.35$	$0.35 < a \leqslant 0.45$	$0.45 < a \leqslant 3.0$	—	
10	**Thickness of cladding on each face**		%	—					
11	**Direction of test piece**			—	L or LT			L or LT	
12	T	**Temperature**	θ	°C	Ambient	Ambient			—
13		**Proof stress**	$R_{p0.2}$	MPa	—	$\geqslant 695$	$\geqslant 695$	$\geqslant 695$	—
14		**Strength**	R_m	MPa	—	$\geqslant 1\,080$	$\geqslant 1\,080$	$\geqslant 1\,080$	—
15		**Elongation**	A	%	—	$\geqslant 15$	$\geqslant 20$	$\geqslant 25$	—
16		**Reduction of area**	Z	%	—				
17	**Hardness**				HV $\leqslant 250$	HV $\geqslant 280$			—
18	**Shear strength**		R_c	MPa	—				
19	**Bending**		κ	—	1.0; $\alpha = 180°$	—			—
20	**Impact strength**				—				
21	C	**Temperature**	θ	°C	—				870
22		**Time**		h	—				$t_R \geqslant 30$
23		**Stress**	σ_a	MPa	—				
24		**Elongation**	a	%	—				
25		**Rupture stress**	σ_R	MPa	—				140
26		**Elongation at rupture**	A	%	—				
27	**Notes** (see line 98)				[1]				

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Table 1 **Technical requirements for nickel-chromium-cobalt-titanium-aluminium heat-resisting alloy sheet and strip** *(continued)*

29	**Reference heat treatment**		Solution treated + precipitation treated θ = (1 080 $\pm$10) °C / t = 8 h / AC or OQ or WQ + θ = (700 $\pm$10) °C / t = 16 h / AC
44	**External defects**		See Section 5 of BS HR 100
95	**Marking**	—	See Section 5 of BS HR 100
96	**Dimensional inspection**	—	See Section 5 of BS HR 100
98	**Notes**	—	[1] Tests may be carried out on the sheet or strip or at a convenient stage prior to manufacture of the sheet or strip.

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Bibliography

Standards publications

For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 4500-1, *Metallic materials – Rules for the drafting and presentation of material standards – Part 1: General rules* [1)]

EN 4500-3, *Metallic materials – Rules for the drafting and presentation of material standards – Part 3: Specific rules for heat resisting alloys* [1)]

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