

LION® alloy 901 (UNS N09901/W.Nr. 2.4662) is an age-hardenable Ni-Fe-Cr superalloy with significant additions of molybdenum, titanium and aluminum. The alloying route for this high-performance material may include combinations of vacuum induction melting, vacuum arc remelting and electroslag remelting, according to the final application and the customer's specification. Typically, the alloy is used for gas turbine engine discs, shafts, rings, casings and seals with a maximum service temperature of around 600°C (1100°F).

Table 1 - Nominal Chemical Composition, %
(not for specification purposes)

Nickel	42.5
Chromium	12.5
Molybdenum	5.75
Titanium	2.9
Cobalt	1.0 max.
Copper	0.5 max.
Manganese	0.5 max.
Silicon	0.4 max.
Aluminum	0.35 max.
Carbon	0.1 max.
Sulfur	0.03 max.
Iron	Balance*

*Reference to the balance of the alloy composition does not guarantee this is exclusively of the element mentioned but that it predominates and others are present only in minimal quantities.

Heat Treatment

The heat treatment for LION alloy 901 forged bar is a three-stage process involving a solution treatment followed by two age-hardening stages. The recommended procedure is 3h/1090°C (1994°F)/WQ + 4h/775°C (1427°F)/AC + 24h/705-720°C (1301-1328°F)/AC.

Physical Properties

Some physical properties for LION alloy 901 are listed in Tables 2-4. Thermal expansion data in Table 3 were determined on fully heat-treated material. The data are subject to a variation of approximately ±5% according to processing variables. The dynamic modulus data in Table 4 were obtained from fully heat-treated cylindrical specimens vibrated in the flexural mode. The recommended heat treatment is quoted above.

Table 2 - Physical Properties

Density, Mg/m ³	8.14
lb/in ³	0.294
Melting Range, °C	1280-1345
°F	2336-2453
Specific Heat, J/kg•°C	431 at 20°C
Btu/lb•°F	0.103 at 68°F
Electrical Resistivity, μΩ•cm	112 at 20°C
ohm/circ•mil•ft	674 at 68°F

Table 3 - Mean coefficient of linear thermal expansion

°C	°F	μm/m•°C	10 ⁻⁶ in/in•°F
20-100	70-200	13.5	7.50
200	392	14.2	7.89
300	572	14.3	7.94
400	752	14.5	8.06
500	932	14.8	8.22
600	1112	15.0	8.33
700	1292	15.3	8.50
800	1472	16.1	8.94
900	1652	17.5	9.72
1000	1832	19.9	11.06

Table 4 - Dynamic Young's Modulus

Temperature		GPa	10 ³ ksi
°C	°F		
20	68	201	29.2
100	212	198	28.7
200	392	192	27.8
300	572	185	26.8
400	752	179	26.0
500	932	172	24.9
600	1112	166	24.1
700	1292	159	23.1
800	1472	150	21.8
900	1652	138	20.0
1000	1832	126	18.3

LION® alloy 901

alloy 901

Mechanical Properties

Tensile properties for forged bar over a range of temperatures are shown in Figure 1. Creep-rupture properties for forged bar are shown by Larson-Miller presentation in Figure 2. Impact properties, at room temperature and at high temperatures, are shown in Tables 5 and 6. For the impact data, the test pieces, taken in circumferential direction, were V-notched.

Available Products and Specifications

LION alloy 901 is designated as UNS N09901 and Werkstoff Number 2.4662. Alloy 901 is available as flat or round bar, extruded section and forging billet.

Rod, Bar, Wire and Forging Stock - BR HR 55, SAE AMS 5660, SAE AMS 5661, AECMA PrEN2176, AECMA PrEN2177, ISO 9723, ISO 9725

Others - AECMA PrEN2178

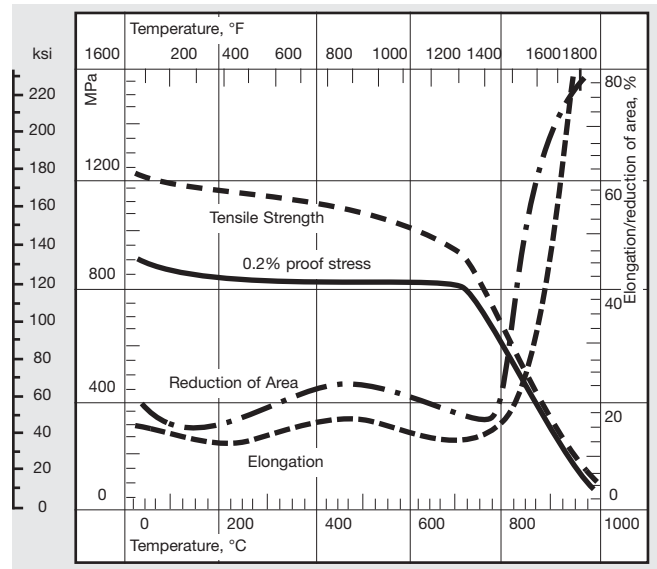


Figure 1. Tensile properties of vacuum refined, extruded and forged bar.

Table 5 - Room-Temperature Impact Properties of LION alloy 901, J (ft•lbf)

Soaking time, hours	Soaking Temperature				
	550°C (1022°F)	600°C (1112°F)	650°C (1202°F)	700°C (1292°F)	750°C (1382°F)
30	58 (42.8)	44 (32.5)	49 (36.2)	41 (30.3)	50 (36.6)
100	47 (34.7)	50 (36.6)	45 (33.2)	32 (23.6)	27 (19.9)
300	47 (34.7)	57 (42.1)	37 (27.3)	18 (13.3)	14 (10.3)
1000	41 (30.3)	38 (28.0)	14 (10.3)	12 (8.9)	5 (3.7)
3000	42 (31.0)	47 (34.7)	12 (8.9)	-	5 (3.7)
10,000	41 (30.3)	15 (11.1)	12 (8.9)	5 (3.7)	5 (3.7)

Table 6 - High-Temperature Impact Properties of LION alloy 901, J (ft•lbf)

Soaking time, hours	Soaking and Test Temperature				
	550°C (1022°F)	600°C (1112°F)	650°C (1202°F)	700°C (1292°F)	750°C (1382°F)
0	60 (44.3)	50 (36.9)	56 (41.3)	42 (31.0)	50 (36.6)
30	49 (36.2)	41 (30.3)	37 (27.3)	46 (34.0)	27 (27.3)
100	45 (33.2)	41 (30.3)	45 (33.2)	34 (25.1)	42 (31.0)
300	44 (32.5)	45 (33.2)	34 (25.1)	41 (30.3)	31 (22.9)
1000	73 (53.9)	49 (36.2)	26 (19.2)	28 (20.7)	24 (17.7)
3000	47 (34.7)	41 (30.3)	20 (14.8)	-	15 (11.1)
10,000	52 (38.4)	22 (16.2)	22 (16.2)	12 (8.9)	18 (13.3)

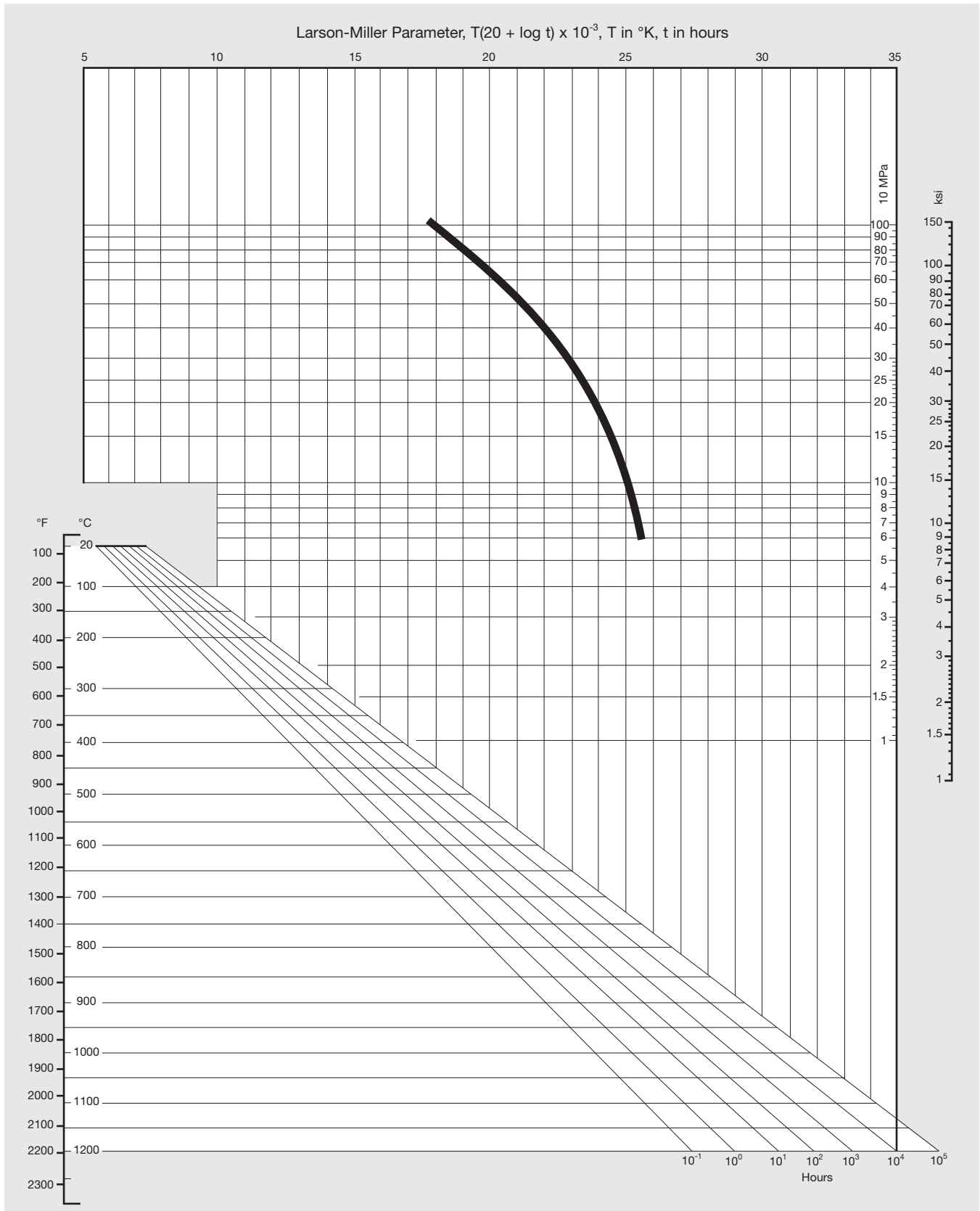


Figure 2, Creep-rupture properties of LION alloy 901 forged bars.