

Subject Index

A

- ABBOR computerized test system, 222, 224, 226
- Aging, 344
 - in forging industry, 575–576
 - isothermal, 134
 - optimum temperature, 361
- Alloys (*See also* Steels)
 - high-temperature, 453–454
 - optimizing mechanical properties, 346–364
 - processing improvements, 19–25
- Alpha-gamma transformations, 419, 421 (illus), 424
- Alumina inclusions, 283
- Aluminum
 - additions, 283, 392, 395–396
 - in ESR forgings, 142, 525
 - fine-grained heats, 290
 - grain size and, 277, 281, 424
 - low, 37
 - nitride, 290
 - role, 42
 - shear stress of, 495, 497, 498–499 (illus)
 - treatment, 282–286, 290
- American Society of Mechanical Engineers (ASME)
 - Code Case 1943 for Grade 91, 315
 - Code Section I, 304
 - Code Section III, Div. 1, 445
 - Code Section VIII, 304
 - Divs. 1 and 2, 296–297
- Diamond Jubilee annual meeting, 19 standards, 276
- Anchor
 - body, 546–547
 - connector, 541
- Annealing, post-forging, 388
- Antimony content
 - embrittlement and, 165–167
 - limits, 38
 - role, 42
- Argon-oxygen decarburization (AOD), 36, 42, 306, 347
- AOD-vacuum arc remelting, 347, 354
- Arsenic content
 - embrittlement and, 165–167
 - limits, 38
 - role, 42
- Association of Technical Supervisory Bodies (TUV), 413
- ASTM Committee A-1 on Steel
 - Special Task Force on Large Forging, 20–21, 24
 - Subcommittee A01.06, 20, 573, 576, 578, 579, 581
- ASTM Standards
 - A 182–82a: 303
 - A 213–83: 303
 - A 262: 446
 - A 293: 13, 21
 - A 335–81a: 303
 - A 336–83: 533
 - A 370–77: 527, 576
 - A 387/A 387M–83: 303
 - A 388–55T: 578

ASTM Standards (*continued*)

- A 388-80: 553
- A 428-71 (1980): 554, 555 (illus)
- A 470-82: 21, 125, 204
- A 470-84: 579
- A 638-82: 533
- B 557-84: 349, 354
- E 8-85: 347
- E 45-81: 533
- E 399-83: 180, 204, 349, 527
- E 647-83: 205
- E 813-81: 180, 204, 316, 320, 527, 530

ASTM STP 463, 199

ASTM Symposia

- 68th Annual Meeting, 21
- Temper Embrittlement in Steels (STP 407)*, 24

ASTM-ASME Joint Committee on the Effect of Temperature on the Properties of Metals, 12

- Data and Publication Panel reports, 12-13

Austenite (*See also* Steels, austenitic)

- secondary, 148, 149
- transition, 168

B

- Bainite, 189, 201-202
- Basic-electric arc-furnace (BEF) process, 36-37, 42, 281
- Bore magnetic particle tests, 220, 224, 229
- Bore sonic tests, 224-229
 - development of, 25, 26, 222
- Bore visual tests, 220, 224, 229
- Brinell hardness, 160-162, 308, 309 (illus)
- British-Standards Institution (BSI) standards, 276, 282

C

- Calcium-argon blowing (CAB) process, 418, 420 (illus), 423

Carbides, 201-202

- chromium, 72, 539
- distribution and shape, 193, 194, 195 (illus), 196, 201
- effect of tempering temperature on, 191 (illus)
- grain boundary, 531
- inclusions, 334, 337 (illus)
- titanium, 539

Carbon

- check/ladle ratio, 217
- distribution, 49 (illus), 51 (illus), 405-406
- effects on embrittlement, 430, 431 (illus), 438
- extractive replicas, 334
- in flaws, 163
- segregation, 46, 51-53, 206-207, 296, 368, 380
- segregation ratio, 52-56
- variation in, 217-218

Carbonitrides, 277

Carbon-molybdenum rotor forgings, 157-177

Central zone remelting (CZR), 125

Charpy impact energy, 133-134, 310, 311 (illus), 326-327

Charpy impact tests, 131, 207, 308-311

- of hot forging dies, 585
- of nuclear reactor shell, 382, 383 (illus)

- of superconducting magnets, 530

Charpy V notch energy values, 102

- of new ingots, 375, 377 (table)

Check analysis/ladle analysis, 217 (table)

Chlorides, 259

Chromium (*See also* Steels, Cr-Ni-Mo)

- carbides, 72, 539
- content, 145-146, 148, 153, 241, 242

Cleavage, mixed mode (*See also* Cracks;

Flaws; Fractures), 585

Compression strength, 478-479, 480

Computer-controlled forging system, 459-462

preform, 469–472
 Cold expansion, 144, 250 (illus), 260, 269
 Coolant circuit (nuclear reactor), primary, 385–397
 Cooling rate, 91
 cracking during, 154
 critical, 193
 effects, 62, 66–67, 72, 93, 133, 196, 197
 FATT and, 102
 as function of forging properties, 193
 for large-diameter rotor forgings, 180
 toughness and creep strength and, 79
 Cooling transformation, continuous, 90, 111 (illus)
 Cooling treatment, step, 117–118, 134, 343
 Copper content
 control of, 141
 limits, 43–44
 Corrosion
 attack on nuclear cooling pump, 388
 behavior of 18-18-alloy, 266
 fatigue, resistance to, 243–244, 258–272
 tests, integranular, 446
 Corrosion-resistant alloys, 349–354, 359–364
 Corrosive agents, 259
 Crack initiation
 of 18-18 alloy, 266
 with start-stop cycles, 230, 231–233
 Crack propagation
 of 18-18 alloy, 266
 growth rates, 174, 210–211, 232
 rapid, 183
 resistance to in nuclear turbine forgings, 208
 from service-induced flaws, 158, 171, 173
 stable extension, 320
 transgranular, 172 (illus), 176
 Crack shrinkage, 391
 Crack size, critical, 233

Cracks, hydrogen-induced flake (*See also* Hydrogen, flake cracking), 407, 573–582
 Crank web, 511 (illus), 513, 515 (illus), 518
 Crankshafts
 connector inclination angle, 516–519
 forging operation, 506–509
 fully forged, 504–509
 long-stroke, 504–519
 Creep properties, 137–139
 ductility, 71–73, 137–138, 312
 of modified Cr-Mo forging, 313–315, 340–341
 rupture strength
 of Cr-Mo-Ni-W-V steel, 120–122
 of Cr-Mo-V steels, 108
 in HP rotor, 83, 85
 in HP-LP rotor, 59–73
 niobium and, 86
 temperature and, 78–79
 Creep rupture tests, 12
 of Cr-Mo-Ni-W-V steel, 120, 122
 of differentially heat-treated rotors, 82
 of HP-LP rotors, 62, 66, 70, 72, 73
 long-time, 142
 in retaining rings, 252
 Creep strength tests, 256
 Creep tests of saddle forging, 313–315
 Cryogenic mechanical properties, 523–539

D

DATAQ computerized boresonic system, 222, 224, 226
 Dehydrogenation, 281, 284
 Deoxidation (*See also* Sulfur, deoxidation; Vacuum carbon deoxidation), 392–396
 in electroslog refining, 442
 Deoxidizers, 283–286
 Dephosphorization, 44
 Desulfurization, 392, 394–396, 442, 446

Dies
 hot forging, 583–592
 types, 463
 Discontinuities, 558–572
 sources of, 17
 Disks, shrunk-on construction, 203
 Dome (nuclear), cover, 399
 Ductile-to-brittle transition, 148
 Ductility
 of 18-18 alloy, 260
 improvement in, 21–23
 in long-time creep tests, 142

E

Edelstahlwerke Buderus AG, 410, 413
 Electric Power Research Institute (EPRI)
 “Advanced Steelmaking Processes
 for Rotor Forgings,” 36
 “High Purity Steels for Utility Com-
 ponents,” 38
 Palo Alto workshop, 245
 San Antonio workshop, 200
 steering committee meeting (1982),
 111, 121
 Westinghouse Electric Corp. joint
 project, 125
 Electricite de France
 research program, 262–264
 standards, 276
 Electricity, cost of, 12
 Electroslog remelting (ESR), 36, 42,
 108, 245
 electrodes, 440–442
 equipment, 439–440
 facility, 28
 ingot production, 442–443
 large ingot, 439–449
 in manufacture of production rings,
 267–269
 in mechanical properties testing,
 125–127, 134, 136–139, 142
 of superconducting magnets, 524, 525
 under pressure, 247, 249–250, 256

Electroslog hot topping practice, 29, 36,
 42, 125, 443
 Elements, effects on “A” segregation,
 45–56
 Embrittlement
 from ferrite, 246–247
 hydrogen, 243–244, 573–582
 long-term, 119
 nickel content and, 214
 reducing level of, 24–25
 relaxation, 390
 service-induced, 159
 temper, 39–40, 42
 effects, 91–93
 of HP-LP rotors, 59
 parameters influencing, 426–434
 resistance to, 343, 345
 sensitivity, 66
 sensitizing to, 39, 43
 toughness and, 168–169
 from tramp elements, 165–167
 temperature-induced, 396
 Energy sources, 143
 Equivalent flat bottom hole (EFBH) di-
 ameters, 554–555, 557
 Erhardt process, 467
 Exothermic hot topping, 36
 Expansion tests, 241

F

Failure
 from flaws, 175
 of hot forging dies, 583–592
 in retaining rings, 242, 243
 in-service, 260
 Fatigue (*See also* Fatigue tests), 259
 corrosion (*See* Corrosion fatigue)
 crack growth rate, 210, 211 (*illus*)
 low-cycle behavior, 587–590
 properties
 high-cycle and low-cycle, 135–139
 of modified Cr-Mo forgings, 341
 Fatigue tests

- crack growth, 315–316
- low-cycle, 135, 205, 212 (illus), 587–588
- rotating beam high-cycle, 135
- Ferrites
 - austenetic, 253–255
 - chromium, 255
 - effect on embrittlement, 430 (table, illus)
 - proeutectoid, 168
- Ferroalloys, 247
- Ferrous oxide slag, 442–443, 446
- Finite-element method (FEM), 64, 65 (illus), 66
- Flanges, 399, 402 (illus), 404–405, 406 (illus), 408 (illus)
- Flaws (*See also* Cracks; Fractures; Inclusions)
 - critical size, 175, 231, 233
 - detectable size, 213
 - indication, 170–172
 - internal, 558–560
 - metallurgical analysis of, 157–177
 - service-induced, 158–159
 - size prediction, 163, 176, 177
- Forge material, shear resistance, 476–503
- Forge processing improvements, 19–25
- Forging
 - against rigid anvil, 497–499
 - automatic ring preform, 465–467
 - center core, 66, 69, 446–448
 - classification by process, 454, 455–456 (tables)
 - computer-controlled preform, 469–472
 - cooled down, 388
 - dies, 583–592
 - equipment, 453–475
 - of ERS ingot, 443–444
 - failure analysis, 583–592
 - force requirements, 476–503
 - hot dies, 583–592
 - isothermal and hot die, 456–462
 - of long-stroke crankshafts, 504–519
 - low-sulfur (*See* Low-sulfur melting practices)
 - machine, 501–503
 - mandrel, 543
 - nuclear reactor technology, 385–397
 - precision, 462–465, 592
 - preform, 465–467, 469–472
 - reverse extrusion, 543
 - single tool, 500 (illus), 501
 - solid, 543, 546
 - speed, 484–486, 502
 - techniques, 453–475
 - technology, 385–397
 - TR method, 504–519
 - warm die, 454
- Forging evaluation techniques
 - advances in, 25–28
- Forging presses (*See also* Forging, equipment; *specific presses*)
 - automatic cogging, 469
 - automatic preform, 469 (illus), 471 (illus)
 - high-speed energy screw-type, 473–475
- Forging Symposium in Terni, Italy, International, 386
- Forgings (*See also* Rotor forgings; Steels)
 - alloy steel
 - heat/corrosion resistant, 349–354, 359–361
 - specialty, 347, 354–358
 - stainless, 347–349, 358–359
 - cleanliness, 31
 - fabrication, 306–308
 - general industrial
 - equipment and process, 453–519
 - manufacture and application, 523–549
 - testing and assessment, 553–592
 - high-sensitivity, immersion testing of, 553–572
 - hydrogen in, 573–582
 - impression die, 454

Forgings (*continued*)

- heavy pressure vessel, 367–384, 402–409
 - modified 9Cr-1Mo steel, 303–327
 - nuclear reactor stainless steel, 439–449
 - for nuclear steam supply system components, 398–409
 - optimizing mechanical properties, 346–364
 - pressure vessel and nuclear processing, 367–449
 - seamless shell course forgings for, 275–300
 - steels for pressure retaining components, 303–364
 - sample, 66–68
 - for tension leg platform anchoring system, 540–549
 - turbine and generator
 - general retaining rings, 237–272
 - improvements in, 9–32
 - rotor assessment, 157–234
 - rotor manufacture, 59–103
 - rotor steel production processes, 35–44, 45–56
 - steels for rotors, 107–154
- Fractography, 583–585, 587–590
- Fracture appearance transition temperature (FATT), 24, 25 (illus)
- austenizing temperature and, 75, 78
 - in center core, 66, 69
 - cooling rate and, 62, 93
 - of Cr-Mo-Ni-W-V steel, 116–119
 - in generator rotors, 222, 232–233
 - grain size and, 117–118, 287, 288 (illus)
 - in high-risk rotors, 222
 - improving, 86, 98–99, 102, 395
 - impurities effect on, 94 (illus)
 - of nuclear turbine forgings, 207–208, 209 (illus)
 - shift, 142, 159
 - in tube sheet forgings, 413, 417, 418 (illus), 422–423, 438

- Fracture behavior, 585–592
- Fracture mechanics analysis, 159
 - of large generator rotor, 231–233
 - linear, 173–175
 - linear elastic, 229
 - of 3.5Ni rotor forgings, 183–187
- Fracture surface appearance, 583, 585–587
- Fracture toughness
 - of Cr-Mo-Ni-W-V steels, 121–122
 - of Cr-Mo-V steel, 134–135
 - effect of grain size on, 286–287
 - of 18-18 alloy, 164–166
 - of hot forging dies, 585–587
 - improvements in, 15, 30–31, 395
 - J-integral, 316–321
 - of 3.5Ni steel, 178–202
 - in nuclear reactors, 391, 392, 395
 - of retaining rings, 242–243, 264–266
 - specimen thickness and, 102–103
 - of superconducting magnets, 536–537, 538
 - after welding simulation, 287–290
- Fractures (*See also* Cracks; Flaws)
 - brittle, 169, 187
 - ductile dimple, 183
 - intercrystalline, 242, 585, 590
 - mixed-mode, 183, 187, 585
 - quasicleavage, 187
 - transcrystalline to intercrystalline, 242
- French laboratory Cr-Mo evaluation, 328–345
- French Nuclear Code (RCC.M), 382
- French Nuclear Program, 88
 - plants, 267
- Friction effects, 481–484, 502–503

G

- “Gatorizing” process, 457–459
- Generator (*See* Nuclear plants, generators; Retaining rings; Steam generators; Turbine-generators)

- Generator rotors, large
 - in-service inspection and evaluation, 219–234
 - service life, 219
 - tensile properties, 232
- Geothermic power stations, 143–154
- German Nuclear Committee (KTA), 391
- German specialty steel producers, 410–424
- Grain
 - austenitic growth kinetics, 286
 - coarsening, 79
 - fine-grain practice, 277, 299
 - growth, 419, 421 (illus)
 - refinement, 253, 392, 419
 - size, 321–327
 - controlling, 269, 282, 424
 - reducing, 86, 449
 - tensile properties and, 527
 - size effects, 60–61, 71, 81, 197, 288–289 (illus), 419, 525, 530–531, 536, 539
 - of FATT, 117–118
 - on toughness, 286–287

H

- Hardenability, 39–40
 - of Cr-Ni-Mo steel grade, 90
 - effect of nickel on, 75
 - effect of temperature on, 78
 - levels, 108
 - parameters influencing, 426–427, 431–434, 438
- Hardening
 - surface, 587–588, 589 (table)
 - through, 192–193
 - work, 479–480
- Hardness (*See also* Brinell hardness; Vickers hardness number)
 - of modified Cr-Mo forging, 308, 326
- Heat, geothermic, 143
- Heat-resistant alloys, 349–354, 359–364
- Heat stability test, 13
- Heat treatment (*See also* Thermal treatment)
 - of AF1410 alloy, 358
 - conditions, 62, 91
 - differential, 70, 74–86
 - for forged shells with heavy walls, 425–438
 - effect on mechanical properties, 63 (illus), 64, 68 (illus)
 - of HY80 steel alloy, 543–544, 546
 - mechanical properties and, 126–127
 - of nuclear components, 404–405
 - postweld (PWHT)
 - of anchoring system, 546
 - effects on mechanical properties, 91–93, 99 (table)
 - embrittlement due to, 95
 - final, 343
 - thermal cycle of, 89
 - quenched tempered (QT), 91, 93, 419, 423–424
 - of retaining rings, 242
 - simulation, 216
 - thick plate, 341–344
 - water-cooled tempering (WCT), 91, 93
- Heating ladle refining process (HLRP), 95, 97
- Heavy-section tube sheets, 410–424
- Heavy-wall reactor vessels (*See* Reactor vessels)
- High-sensitivity tests, 553, 560–572
- High-temperature tests, 14
- Hot tensile tests, 12
- Hot working, 269
- Hydraulic presses, 464
- Hydrogen (*See also* Embrittlement, hydrogen)
 - control, 578–579
 - determining content, 579–581, 582
 - elemental, 442
 - flake cracking, 407, 573–582
 - flaking, 558, 560, 562 (illus), 565 (illus), 566, 569, 571 (illus), 572

Hydrogen (*continued*)

- inclusions, 407
- low, 37
- role, 42
- in steel forgings, 573–582

I

Immersion tests, 553, 560–572

Impact properties

- in Cr-Mo forgings, 339
- in Cr-Mo-V steel, 129–135
- effect of impurities on, 95

Impact tests (*See also* Charpy impact tests), 14

- of Cr-Mo-Ni-W-V steel, 114–115, 120
- of Cr-Mo-V steel, 129
- on HP-LP rotors, 62

Impurities (*See* Steels, impurities)

Inclusions

- aluminum, 283
- analysis, 333–334
- content, 102
- frequency, 170
- hydrogen (*See also* Hydrogen), 407
- manganese-silicate, 175–176
- manganese-sulfide, 201–202
- nonmetallic, 169, 170–171, 172–173 (illus), 231, 292, 407, 558–560, 566
- oxide, 17, 334

Ingot

- cylindrical, 434–437
- in heavy pressure vessel forgings
 - conventional, 368
 - manufacturing, 400–402
 - mechanical properties, 407
 - new, 368–384
 - quality of, 405–408
- hollow, 291–292, 299, 371
 - chemical analysis, 378–381
 - mechanical testing, 382

- nuclear reactor shell from, 378–383, 434, 435 (illus)

large

- “A” segregation in, 45–56
- electroslag remelting, 439–449
- size and shape, 46–49
- solidification analysis, 17, 18 (illus)
- solidification shrinkage, 163–165, 175, 177

In-service inspection tests, 219, 223–234

- automated, 222
- historical development, 220–221
- of nuclear reactors, 399
- recommended procedure, 222–223
- trends, 223

Ion-nitriding, 587, 588

Isothermal aging, 134

Isothermal forging, 456–462

Isotropy, 245, 391, 418

J

Japan Steel Works

- Internal Pressure Bursting (JIB) test, 205, 210–211
- nuclear component forging processes, 399, 404 (illus)

J-integral tests, 527

K

Kerosene-and-whiting tests, 13

Kraftwerk Union (KWU), 399, 400, 410, 413

L

Ladle analysis, 217 (table)

Ladle furnaces (LF), 281

Ladle injection, 36, 42

Ladle refining furnace (LRF), 36–37, 42, 267

Ladle refining process, heating (HLRP), 431

Larson-Miller parameter (LMP) curves, 137, 138 (illus)
 Lawrence Livermore National Laboratory, 523
 Le Creusot Heavy Forge, 368–384, 426, 430, 431, 437
 Liquid melt, residual, 391
 Liquid penetrant examination, 536
 Longitudinal beam tests, 553, 558–562, 569–570
 Low-sulfur melting practices, 29, 126–127, 139–140

M

Magnetic particle tests, 13, 14
 of rotor center bore, 66
 Magnets, superconducting, 523–539
 Manganese levels
 decreasing, 37, 90
 effect on hardenability, 90, 91 (illus)
 effect on liquid density, 53–56
 embrittlement and, 429–430, 431 (illus)
 low, 44
 in retaining rings, 241, 242
 role, 38, 39–40
 Manganese-silicate inclusions, 175–176
 Manganese-sulfide inclusions, 136, 201–202
 degrading effects, 391
Manual of Open Die Forgings, 575
 Martensite
 microstructure, 343, 344
 tempered, 189, 192
 Mechanical properties (*See also under specific materials*)
 of advanced technology Cr-Mo-V forgings, 124–142
 cryogenic, 523–539
 improvement, 108
 Mechanical testing of anchor system, 544–546
 Melting media, 277

Metal Forming Institute, Poznan, 509, 519
 Microscopy (*See also* Scanning electron microscopy), 333–334
 Microstructure (*See also under specific materials*)
 effects of, 426–427
 investigations, 187–189, 190 (illus), 333–337
 Mirror fusion testing facility (MFTF-B), 523–524
 Molybdenum
 austenitic steels, 250–253
 carbides, 72
 effect on hardenability, 90, 91 (illus)
 effect on liquid density, 53–56
 Multiaxial presses, 465

N

Nickel (*See also* Steels)
 content, 145–146, 148, 153
 creep strength and, 75
 effect of addition, 60–64, 70, 72, 144
 embrittlement and, 214
 fracture toughness of, 178–202
 high, 38
 in retaining rings, 241, 242
 Niobium
 carbides, 62, 72
 creep strength and ductility and, 86
 effect of addition, 60–64, 70, 72
 inclusions, 334
 toughness and, 75
 Nitrates, 259
 Nitrogen
 as alloying element, 245–247, 249–255, 256
 inclusions, 334
 low levels, 37
 solubility in steels, 247–249
 Nondestructive tests, 220, 224, 231
 of ERS ingots, 444–445
 of superconducting magnets, 536–537

Nonmagnetic ring material (*See* Retaining rings, nonmagnetizable)

North Sea Hutton field, 540

Nuclear plants

generators, 258–272

German, 386

Obrigheim, 386

pressurized water reactor, 87–103

Stade, 386

Nuclear Regulatory Commission, 179

Nuclear steam supply system components, 398–409

Nuclear turbine forgings

fracture toughness, 208, 209–210 (illus)

integrity, 203–218

mechanical properties, 207–213

segregation in, 205–206

O

Oak Ridge National Laboratory (ORNL), 328

Offshore Structures—Det Norske Veritas 1977, Rules of Design Construction and Inspection of, 545

Oxygen

activity, 283–284

decreasing, 36–37

high, 44

Oxysulfides, 418

P

Periphery ultrasonic tests, 14, 26, 220–221, 229

Phosphorus content

chronological evolution, 97, 98 (illus)

distribution, 49 (illus)

effect on carbon segregation, 56

effect on ductility, 137

embrittlement and, 119, 429, 431

in flaws, 163

low, 21, 22 (table), 36–37, 95, 137
role, 40

segregation, 217–218

Pitting, 262

Porosity, 17

micro, 292

shrinkage, 231

in weldings, 256

Power generating industry, 237–257

corrosion resistance in, 258–272

heavy-section tube sheet technology, 410–424

Pressure vessels (*See* Reactor vessels)

Proof load tests, 537–538

Pump casing, integral forged, 385–397

Q

Quenching, 388

air and oil, 109, 122

liquid-medium, 160

R

Reactor vessels

boiling water reactor pressure vessel (BWRPV), 399

fabrication problems, 292–298, 299

forging processing and nuclear application, 367–449

heavy-wall, 275–300

new ingot applications, 367–384

pressurized water reactor pressure vessel (PWRPV), 399

specifications, 276–290

Reactors

components, 425

light water (LWR), 399

liquid metal fast breeder (LMFBR), 328–329, 340, 344

petrochemical, 425

pressurized heavy water (PHWR) vessel, 399, 400

primary coolant circuit, 385–397

steam supply system components, 398–409

“Recommended Practices for Ultrasonic Inspection of Large Rotor Forgings,” 20–21

Refining processes, secondary, 36

removal of sulfur in, 40

Retaining rings

- cold-expanded, 244
- corrosion-resistant, 258–272
- function and demands, 238–240
- future trends in, 271–272
- manufacture of, 267–269
- materials for, 237–257
- mechanical properties, 242–243, 269–271
- nonmagnetizable, 237–257, 259–260
- resistance to corrosion and embrittlement, 243–244
- service conditions, 259

Ring preform forging presses, 466

Rotor failure, technological impact, 35–36

Rotor forgings

- evaluation of, 80–84
- fracture toughness, 178–202
- high-pressure–low-pressure, integral, 59–73
- applications, 69–70
- high-temperature characteristics, 13
- manufacture, 79–80
- mechanical properties, 13
- metallurgical analysis of flaws in, 157–177
- microstructural investigations, 179, 187–189, 190 (illus)
- modern technology, 14–17
- 3.5Ni steel, 178–202
- simulated large diameters, 179–180
- specification trends, 35–44

Rotor steels, high purity, 37–38

Rupture ductility, trends in, 27 (illus)

Rupture strength, high-temperature trends, 27 (illus)

S

Scanning electron microscopy, 160

Segregation

- “A,” 45–56
- cleanliness, 129
- degrading effects of, 391
- high manganese-sulfide inclusions in, 125
- carbon (*See* Carbon, segregation)
- dendritic, 189
- in ERS ingots, 448
- macrosegregation, 291, 370–371, 373
- microsegregation, 392
- negative and positive, 51–52, 292, 380
- in nuclear turbine forgings, 205–206, 207 (illus)
- phosphorus, 217–218
- ratio, 48 (illus), 49, 50 (illus)
- sulfur, 127, 164, 217–218

Shear

- bidirectional, 495, 499–501
- distribution, 387, 490–494
- effect, 486–495
- failure, 495
- resistance, 476–503
- stresses, 488–494
- inside distribution of, 495–497

Shear-wave inspections, 553–555, 569–570

Shells

- flanges, 402, 404, 406 (illus), 408 (illus)
- forged, 425–438
- torus and, 399

Silicon

- decreasing, 37, 75
- deoxidation (SD), 23, 49–52, 139, 392, 395–396, 429–430
- effect on ductility, 137
- effect on embrittlement, 429
- effect on liquid density, 53–56

Silicon (*continued*)

- effect on tensile properties, 93–94, 296
- killing, 282–286
- low, 38
- modified alloy, 354
- role, 41

Simulation technique, 179–180, 194–195, 198–202

Solidification

- conditions, 368
- horizontal-oriented (*See* Solidification, LSD)
- of ingot, 46, 291
- liquid density change during, 53–56
- LSD (*Lingot a Solidification Dirigee*), 369–375, 384, 434–437
- shrinkage, 163–165, 175, 177
- vertical and horizontal-oriented, 369

Solution treatment, 269

Sonic tests (*See* Ultrasonic tests)

Spheroidization, 202

Spring collet, 542–546

Steam-turbine rating trends, 11 (*illus*)

Steel production (*See* Steelmaking process)

Steelmaking process

- advanced technology, 35–44
- effects on “A” segregation, 45–56
- effects on rotor specification trends, 35–44
- for heavy-wall reactor vessels, 276–290
- improvements, 17–19
- new processes, 28–31

Steels (*See also* Alloys; Forgings; *specific materials*)

- A286, 349–365
 - cryogenic mechanical properties, 523–539
- A-508 Class 2, 386, 390
- A-508 Class 3, 282–283, 388, 391, 414–415 (*illus*), 423–424
- acid open hearth (AOH), 13

AISI 329, 253–255

austenitic, 245–247, 250–255

austenitic Cr-Ni, 144, 388

basic open hearth (BOH), 13

bidirectional shear, 499–501

carbon, 14

segregation of, 51–56

carbon-molybdenum, 157–177

macrostructure and microstructure, 321–326

mechanical properties, 308–326

modified, 303–327

cleanliness, 35, 44, 75, 283, 296

Cr-Mn, 241–243

Cr-Mn-N, 241–243

Cr-Mo, modified

chemical composition, 329

evaluation by French laboratories, 328–345

hardness, 338–339

mechanical properties, 339–341

microstructure, 333–337

transformation points, 329–333

Cr-Mo-Ni-W-V, 107–123

Cr-Mo-V, 14, 28, 31

analysis, 24

compositions, 15–16

in differentially heat-treated forgings, 74–86

ductility, 21–23

mechanical properties, 124–142

nickel/niobium effects on, 62–64

toughness, 59

Cr-Ni-Mo

chemical composition, 150, 153

mechanical properties, 98, 99 (*table*)

soft-martensitic stainless, 143–154

specification requirements, 89

tensile properties, 152, 154

electric furnace (EF), 13

ferritic-austenitic, 253–255

ferritic chromium, 255

fracture toughness, 178–202

- heat/corrosion-resistant, 349–354, 359–361
- high-sensitivity, immersion, ultrasonic testing, 553–572
- high-temperature, 107, 119–122
- hot low-carbon, 499–501
- HY80, 543–549
- hydrogen effects on (*See also* Hydrogen), 573–582
- impurity levels, 36–37, 195, 375
 - effects of, 87–103
- Inconel 625, 349, 360
- mechanical property improvement, 108, 346–364
- metallurgical analysis of flaws, 157–177
- Mn-Cr-N (18-18 alloy), 259–272
 - corrosion behavior, 266, 267 (illus)
 - fracture toughness, 264–266
 - mechanical properties, 264
- Mn-Mo-Ni, 388, 391, 392
 - in nuclear power stations, 418–419, 423
- 0.5Mo-2.5Ni-V, 13
- 3.5Ni, 178–202
- Ni-Cr-Mo-V
 - creep rupture strength and temper embrittlement, 59
 - segregation in, 217
 - sensitizing to temper embrittlement, 39
 - toughness, 40–42, 214–215
- Ni-Mo-Cr, 390
- Ni-Mo-V, 13, 14, 29–30
 - analysis, 24
 - fracture toughness, 23
 - metallurgical analysis of flaws, 157–177
- nitrogen as alloying agent, 245–247, 249–255, 256
- nitrogen solubility in steels, 247–249
- nonmagnetizable, 240–243
 - for nuclear steam supply system components, 398–409
- optimization of grade, 87–103
- optimization of mechanical properties, 346–364
- quality, 35
- quenched and tempered, 189, 192–196
- retaining-ring, 245, 249–255
- SA 336 F22 grade, 373–377
 - chemical composition, 427–431
 - heat treatment, 425–438
 - microstructure, 426–427
- specialty, 347, 354–358
- stainless, 347–349, 358–359
- Type 304 stainless, 304, 439–449
 - cryogenic properties, 523–539
- Strain rate, 516–519
- Stress (*See also* Shear, stresses)
 - corrosion (*See also* Stress corrosion cracking), 259
 - flaking and, 576
 - in-service, 259, 542
 - relieving, 269, 390, 548, 575
 - residual, 83–84, 85
 - tangential, 231
 - thermal (*See also* Thermal cracking), 170, 173
 - transformation, 154
 - true, 478, 479 (illus), 501
- Stress corrosion cracking, 30, 154
 - of disks, 203
 - resistance to, 241, 243–244
- Stress corrosion tests, 260
- Stress intensity factor, 174
- Stress rupture, carbon-molybdenum rotor, 169–170, 176
- Stretched zone width (SZW) measurement, 590–592
- Sulfides
 - critical concentrations, 418
 - inclusions, 136
 - linear, 17

Sulfur content

chronological evaluation, 97, 98 (illus)

distribution, 448

effect on fatigue, 136

effect on liquid density, 55, 56

effect on mechanical properties, 126–127, 136, 139–140

in flaws, 163

grain growth and, 421 (illus), 423

low, 21, 22 (table), 36–37, 38, 95

print, 163, 167

reduction in, 392, 395–396

role, 40–41

segregation, 127, 154, 217–218

Superalloys, 238

Support struts fabrication, 523–539

T

Technischer Überwachungs-Verein (TUV) standards, 276

Temperature (*See also* Stress, thermal)

austenizing, 62–63, 64, 66, 67 (illus), 71–73

effect on FATT, 75, 78

effect on hardenability, 431–434, 438

effect, 480–481

on turbine rotor, 12–13, 75, 78–79, 108–122

failure, 590–592

hardening, 146

strength dependence on, 182

tempering, 146–148, 194, 196, 354, 356

transformation, 145, 149, 192–193

in modified Cr-Mo forgings, 329–333

suppression, 144

transition, 168

Tempering study, 347, 348 (table), 354

Tensile properties

in Cr-Mo forgings, 339–340

in Cr-Mo-V steel, 129–135

effect of silicon on, 93, 94 (illus), 296

of modified Cr-Mo forging, 311–313

Tensile strength

trends in, 27 (illus)

ultimate, 94 (illus), 271, 287, 296, 485

Tensile tests, 14

Tension leg platform anchoring system, 540–549

Tension testing standard, 576

Tension tests, 13

of Cr-Mo-Ni-W-V steel, 114

of Cr-Mo-V steel, 129, 154

of HP-LP rotors, 62

of 3.5Ni steel, 181–182

Thermal cracking (flaking) (*See also* Hydrogen, flaking), 573, 576

Thermal shock, 590

Thermal stability, 83, 85

Thermal treatment (*See also* Heat treatment), 347, 443–444

Thermomechanical processing, 346–364

Thickness and fracture toughness, 102–103

Tin content

embrittlement and, 119, 165–167

limits, 38

role, 42

Titanium, 525

carbide, 539

Toughness (*See also* Fracture toughness)

of HP-LP rotors, 59–73

of HY80 alloy, 547–548

properties, 108–109

TR method, 504–519

Trace elements (*See also* Tramp elements; *specific elements*)

embrittlement and, 119

reduction, 97, 108

Tramp elements (*See also specific elements*)

- role of, 42
- in temper embrittlement, 165–167
- Transformation structure, 413, 417–419, 424
- Trepanning equipment, center core, 25
- Tube sheets, heavy-section, 410–424
- Tubes, heavy-walled, 467–469
- Tufteride, 587–588
- Turbine rotors
 - Cr-Mo-V forgings, 124–142, 157–177
 - development programs, 14–15
 - differentially heat-treated, 74–86
 - failures, 14
 - mechanics of, 16–17
 - full-integral, low-pressure forgings, 203–218
 - high-pressure, 107–123, 165–170
 - analysis for flaw indication, 170–172
 - fracture mechanics of flaws, 173–175
 - mechanical properties, 166 (table), 167–168
 - low-pressure, 163–165
 - mechanical properties, 166 (table)
 - manufacture of, 149–153
 - metallurgical analysis of flaws in forgings, 157–177
 - soft-martensitic stainless Cr-Ni-Mo steel, 143–154
 - welded polyblock, 87–103
- Turbine-generators
 - history of, 9–12
 - modern steam, 9–32
 - in power generation, 238

U

- Ultrasonic tests, 20–21 (*See also* Bore sonic tests; Periphery ultrasonic tests)
 - of bore surface indications, 160, 162–163
 - of Cr-Mo-Ni-W-V steel, 11
 - detecting internal defects, 577–578
 - of ERS ingot forgings, 445, 447 (table), 448, 449
 - for flaw size, 160, 162–165, 171–172, 176, 177
 - high-sensitivity, immersion, 553–572
 - of large generator rotors, 229–230
 - of near-bore zone, 158
 - of rotor center bore, 66, 160
 - of steel forgings, 553–572
 - of superconducting magnets, 536–537

V

- Vacuum arc degassing (VAD), 373
- Vacuum arc remelt (VAR), 347
 - furnace, 28
- Vacuum carbon deoxidation (VCD), 23–24, 41–42, 125
 - effect on segregation, 49–56, 72
 - of forged reactor pump casing, 392–396
 - hardenability and, 86
 - impurities and, 93, 95
 - reduction of, 72
 - in mechanical properties testing, 125–140
 - in reactor forgings, 281–290, 299
 - temper embrittlement and, 75, 86
 - toughness and, 62
- Vacuum casting, 575–576
- Vacuum induction melted (VIM)–vacuum arch remelting, 347, 349
- Vacuum lift process, 578–579, 582
- Vacuum stream degassing (VSD), 37, 42, 281, 299
- Vanadium
 - carbides, 72
 - effect on carbon segregation, 46, 56
 - in grain size control, 424
 - Vickers hardness number, 546
- Voids, 164

Voids (*continued*)

irregularly shaped, 177
microshrinkage, 292

W

Water (as corrosive), 259
Welded polyblock turbine rotors,
87–103, 198
Welding problems, 256
Weldment examination, 547, 548

Y

Yield strength
effect, 189, 164, 196
of 18-18 alloy, 260, 261 (illus)
ratio to ultimate tensile strength, 271
of superconducting magnets, 536–537
in tube sheets, 413–417

Z

Zirconium, 283