

CONTENTS

PREFACE

| | | |
|---|---|----|
| I INTRODUCTION | DESCRIPTION OF THE HIP PROCESS | 1 |
| Page 1 | HISTORICAL PERSPECTIVE | 2 |
| | POWDER CONSOLIDATION | 2 |
| | HEALING OF CASTING DEFECTS | 3 |
| | HIP EQUIPMENT | 4 |
| II CONSOLIDATION OF POWDERS BY HIP | DESCRIPTION OF THE HIP CONSOLIDATION PROCESS | 5 |
| Page 5 | GENERAL APPROACH | 5 |
| | PRECOMPACTION METHODS | 7 |
| | Cold Isostatic Pressing 7, Shaped Metal Cans 8, Vitreous Containers 8, Ceramic Mold Process 12, Filled Billet Technique, 12 | |
| | HIGH-SPEED TOOL STEELS | 12 |
| | METALLURGICAL CONSIDERATIONS | 15 |
| | IMPROVED THERMAL RESPONSE | 16 |
| | PERFORMANCE OF PM TOOL STEELS | 18 |
| | HIGH ALLOY GRADES | 19 |
| | CEMENTED CARBIDES (CERMETS) | 20 |
| | HIP OF CARBIDES | 20 |
| | APPLICATIONS OF HIP CARBIDES | 24 |
| | BERYLLIUM | 24 |
| | NET SHAPE DEVELOPMENT | 25 |
| | Cold Isostatic Pressing of Beryllium 26, HIP of Large Beryllium Structures 29, Metallurgical Developments 30 | |
| | SUPERALLOYS | 31 |
| | PM PROCESSING OF SUPERALLOYS | 32 |
| | Description of Processes 32, Prealloyed Powder Production 33, Activation of Powders 34 | |
| | SHAPE MAKING | 34 |
| | PROCESS ECONOMICS | 34 |
| | TITANIUM ALLOYS | 37 |
| | POWDER PRODUCTION | 37 |
| | FABRICATION OF SHAPES | 38 |
| | PROCESS ECONOMICS | 39 |
| | PROPERTIES OF HIP TITANIUM ALLOYS | 40 |

| | | |
|---|--|----|
| III. HOT ISOSTATIC PRESSURE (HIP) WELDING GAS-PRESSURE BONDING | NUCLEAR REACTOR COMPONENTS | 44 |
| Page 43 | FUEL ELEMENTS | 44 |
| | NON-NUCLEAR COMPONENTS | 46 |
| | GAS TURBINE COMPONENTS | 48 |
| | ROCKET ENGINE COMPONENTS | 51 |
| | SPECIAL MATERIALS AND STRUCTURES | 51 |
| | MULTILAYER GUN BARRELS | 52 |
| | COMPOSITE TUBE-TRUSS STRUCTURES | 53 |
| | ALTERNATOR ROTOR | 53 |
| | HEAT RESISTANT COATINGS | 53 |
| IV HEALING OF CASTINGS BY HIP | ALUMINUM ALLOYS | 55 |
| Page 55 | SUPERALLOYS | 58 |
| | TITANIUM ALLOYS | 61 |
| | COPPER-BASE ALLOYS | 64 |
| | STEEL | 65 |
| V HIP SYSTEMS | COMPONENTS | 70 |
| Page 69 | PRESSURE VESSEL CONSTRUCTION | 71 |
| | COMPRESSION SYSTEMS | 74 |
| | CONTROL SYSTEMS | 75 |
| | HIP FURNACE | 77 |
| | SYSTEMS CONSIDERATIONS | 77 |
| | PREHEATING TECHNIQUES | 77 |
| | REQUIREMENTS FOR PARTS PROCESSING | 78 |
| | EXAMPLES OF MANUFACTURING SYSTEMS | 80 |
| VI FUTURE PERSPECTIVE | INCREASED METALLURGICAL FREEDOM | 85 |
| Page 85 | ELIMINATION OF STRESS-INDUCED DAMAGE | 86 |
| | HIGH-RELIABILITY/PERFORMANCE STRUCTURES | 88 |
| | HYBRIDIZED STRUCTURES | 88 |
| | INCREASED SIZE CAPACITY | 89 |
| | REFERENCES | 90 |