

2 History of Duplex Stainless Steels

Duplex stainless steels, meaning those with a mixed microstructure of about equal proportions of austenite and ferrite, have existed for nearly 80 years. The early grades were alloys of chromium, nickel, and molybdenum. The first wrought duplex stainless steels were produced in Sweden in 1930 and were used in the sulfate paper industry. These grades were developed to reduce the intergranular corrosion problems in the early, high-carbon austenitic stainless steels. Duplex castings were produced in Finland in 1930, and a patent was granted in France in 1936 for the forerunner of what would eventually be known as Inconel 501. AISI Type 329 became well established after World War II and was used extensively for heat exchanger tubing for oil and sulfur service. One of the first duplex grades developed specifically for improved resistance to chloride stress corrosion cracking (SCC) was 38450. In subsequent years, both wrought and cast duplex grades have been used for a variety of process industry applications including vessels, heat exchangers and pumps.

These first generation duplex stainless steels provided good performance characteristics but had limitations in the as-welded condition. The heat-affected zone (HAZ) of welds had low toughness because of excessive ferrite and significantly lower corrosion resistance than that of the base metal. These limitations confined the use of the first-generation duplex stainless steels, usually in the unwelded condition, to a few specific applications. In 1968, the invention of the stainless steel refining process, argon oxygen decarburization (AOD), opened the possibility of a broad spectrum of new stainless steels. Among the advances made possible with the AOD was the deliberate addition of nitrogen as an alloying element. Nitrogen alloying of duplex stainless steels makes possible HAZ toughness and corrosion resistance which approaches that of the base metal in the as-welded condition. With increased austenite stability, nitrogen also reduces the rate at which detrimental intermetallic phases form.

The second-generation duplex stainless steels are defined by their nitrogen alloying. This new commercial development, which began in the late 1970s, coincided with the development of offshore gas and oil fields in the North Sea and the demand for stainless steels with excellent chloride corrosion resistance, good fabricability, and high strength. 2205 became the workhorse of the second-generation duplex grades and was used extensively for gas gathering line pipe and process applications on offshore platforms. The high strength of these steels allowed for reduced wall thickness and reduced weight on the platforms and provided considerable incentive for their use.

Note: Each stainless steel referenced by name or by industry designation in this text may be found in Table 1 or Appendix 1.



2205 continuous sulfate pulp dyer and impregnation forest, Södra Cell Mölndal, Sweden (Source: Kvaerner Pulp)

Like the austenitic stainless steels, the duplex stainless steels are a family of grades, which range in corrosion performance depending on their alloy content. The development of duplex stainless steels has continued, and modern duplex stainless steels can be divided into five groups:

- Super duplex such as 2304, which contains no deliberate Mo addition.
- Standard duplex such as 2205, the work-horse grade accounting for more than 80% of duplex use.
- 25 Cr duplex such as Alloy 255 with PREN* less than 40.
- Super duplex (PREN 40-45), with 25-28 Cr and increased Mo and N compared with the 25 Cr grades, such as 2507.
- Hyper duplex, defined as a highly alloyed duplex stainless steel with PREN in excess of 45.

*PREN = Pitting Resistance Equivalent Number
 $= \%Cr + 3.3(\%Mo) + 0.5(\%N) = 16\%$

Table 1 lists the chemical compositions of the second-generation wrought duplex stainless steels and of the cast duplex stainless steels. The first-generation duplex grades and the common austenitic stainless steels are included for comparison.

Use Of Duplex Stainless Steels In The Oil Refining Industry Second Edition

Zoia Duriagina



Use Of Duplex Stainless Steels In The Oil Refining Industry Second Edition:

Corrosion in the Petrochemical Industry, Second Edition ,2015-12-01 Originally published in 1994 this second edition of Corrosion in the Petrochemical Industry collects peer reviewed articles written by experts in the field of corrosion that were specifically chosen for this book because of their relevance to the petrochemical industry This edition expands coverage of the different forms of corrosion including the effects of metallurgical variables on the corrosion of several alloys It discusses protection methods including discussion of corrosion inhibitors and corrosion resistance of aluminum magnesium stainless steels and nickels It also includes a section devoted specifically to petroleum and petrochemical industry related issues Duplex Stainless Steels R Gunn,1997-10-21 Two very successful conferences in Glasgow and Beaune were held on duplex stainless steels during the first half of the 90s This book takes keynote papers from each and develops and expands them to bring the topics right up to date There is new material to cover grades specifications and standards and the book is fully cross references and indexed The first reference book to be published on the increasingly popular duplex stainless steels it will be widely welcomed by metallurgists design and materials engineers oil and gas engineers and anyone involved in materials development and properties The first reference book on this relatively new engineering material Based on keynote papers from major international contributors Covers grades standards and specifications *Heat Exchanger Design Handbook, Second Edition* Kuppam Thulukkanam,2013-05-20 Completely revised and updated to reflect current advances in heat exchanger technology Heat Exchanger Design Handbook Second Edition includes enhanced figures and thermal effectiveness charts tables new chapter and additional topics all while keeping the qualities that made the first edition a centerpiece of information for practicing engineers research engineers academicians designers and manufacturers involved in heat exchange between two or more fluids See What's New in the Second Edition Updated information on pressure vessel codes manufacturer's association standards A new chapter on heat exchanger installation operation and maintenance practices Classification chapter now includes coverage of scrapped surface graphite coil wound microscale and printed circuit heat exchangers Thorough revision of fabrication of shell and tube heat exchangers heat transfer augmentation methods fouling control concepts and inclusion of recent advances in PHEs New topics like EMbaffle Helixchanger and Twistedtube heat exchanger feedwater heater steam surface condenser rotary regenerators for HVAC applications CAB brazing and cupro braze radiators Without proper heat exchanger design efficiency of cooling heating system of plants and machineries industrial processes and energy system can be compromised and energy wasted This thoroughly revised handbook offers comprehensive coverage of single phase heat exchangers selection thermal design mechanical design corrosion and fouling FIV material selection and their fabrication issues fabrication of heat exchangers operation and maintenance of heat exchangers all in one volume Use of Duplex Stainless Steels in the Oil Refining Industry ,2015

Corrosion and Materials in the Oil and Gas Industries Reza Javaherdashti,Chikezie Nwaoha, Henry Tan,2016-04-19

The advancement of methods and technologies in the oil and gas industries calls for new insight into the corrosion problems these industries face daily. With the application of more precise instruments and laboratory techniques as well as the development of new scientific paradigms, corrosion professionals are also witnessing a new era in the way d

Stainless Steels and Alloys Zoia Duriagina, 2019-02-13 Materials science is the magic that allows us to change the chemical composition and microstructure of material to regulate its corrosion mechanical technological and functional properties. Five major classes of stainless steels are widely used: ferritic, austenitic, martensitic, duplex, and precipitation hardening. Austenitic stainless steels are extensively used for service down to as low as the temperature of liquid helium, 269°C. This is largely due to the lack of a clearly defined transition from ductile to brittle fracture in impact toughness testing. Steels with ferritic or martensitic structures show a sudden change from ductile safe to brittle unsafe fracture over a small temperature difference. Even the best of these steels shows this behavior at temperatures higher than 100°C and in many cases only just below zero. Various types of stainless steel are used across the whole temperature range from ambient to 1100°C. This book will be useful to scientists, engineers, masters, graduate students, and students. I hope readers will enjoy this book and that it will serve to create new materials with unique properties.

Handbook of Materials Failure Analysis with Case Studies from the Oil and Gas Industry Abdel Salam Hamdy Makhlouf, Mahmood Aliofkhazraei, 2015-09-01 Handbook of Materials Failure Analysis With Case Studies from the Oil and Gas Industry provides an updated understanding on why materials fail in specific situations, a vital element in developing and engineering new alternatives. This handbook covers analysis of materials failure in the oil and gas industry where a single failed pipe can result in devastating consequences for people, wildlife, the environment, and the economy of a region. The book combines introductory sections on failure analysis with numerous real world case studies of pipelines and other types of materials failure in the oil and gas industry, including joint failure, leakage in crude oil storage tanks, failure of glass fibre reinforced epoxy pipes, and failure of stainless steel components in offshore platforms, amongst others. Introduces readers to modern analytical techniques in materials failure analysis. Combines foundational knowledge with current research on the latest developments and innovations in the field. Includes numerous compelling case studies of materials failure in oil and gas pipelines and drilling platforms.

Encyclopedia of Chemical Processing and Design John J. McKetta Jr., 1995-11-14 Steam Reforming, Operating Experience to Storage Tank Measurement, Optical Method.

Fundamentals of Industrial Heat Exchangers Hossain Nemati, Mohammad Moghimi Ardekani, James Mahootchi, Josua P. Meyer, 2024-01-13 Fundamentals of Heat Exchangers: Selection, Design, Construction, and Operation is a detailed guide to the design and construction of heat exchangers in both a research and industry context. This book is split into three parts: firstly, outlining the fundamental properties of various types of heat exchangers and the critical decisions surrounding material selection, manufacturing methods, and cleaning options. The second part provides a comprehensive grounding in the theory and analysis of heat exchangers, guiding the reader step by step toward thermal design. Finally, the

book shows how to apply industrial codes to this process with a detailed demonstration designing a shell and tube exchanger compliant with the important but complex code ASME Sec VIII Div 1 Taking into account the real world considerations of heat exchanger design this book takes a reader from fundamental principles to the mechanical design of heat exchangers for industry or research Presents a full guide to the design of heat exchangers from thermal analysis to mechanical construction Provides detailed case studies and real world applications including a unique collection of photos sketches and data from industry and research Takes designers through the process of applying industry codes using a step by step demonstration of designing shell and tube heat exchangers compliant with ASME Sec VIII Div 1

Proceedings of the 2nd International Conference on Developments in Valves and Actuators for Fluid Control Peter Wood, Lorraine Grove, 2013-06-29 The flow of two phase mixtures through restrictions is a complex phenomenon that to date has not been fully described analytically It is an area that received a great deal of attention because of its application to nuclear reactor technology The majority of the work done in this area considered ideal geometries such as nozzles orifices and straight pipes In the area of control valves very little work has been done Brockett King 1 studied subcooled water Stiles 2 looked at subcooled freon Martinec 4 compared subcooled freon in valves with ideal geometries Sheldon Schuder 3 looked experimentally at air/water mixtures through valves that resulted in a sizing procedure Fagerlund 10 presented an analytical model that required use of the Sheldon Schuder data to establish the behavior of valves as opposed to more ideal geometries However the data used was limited to a single valve travel Fagerlund Storer 11 have expanded this to include several valve travels that further generalizes the technique It is the intent of this paper to summarize a practical approach to sizing valves for two phase service that may be reduced to either a graphical or calculator procedure

Discussion of Analysis A fundamental assumption in this method is that the quality remains constant between the inlet and the vena contracta For gas liquid flows it is obvious providing vaporization does not occur

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