

High-Strength Aluminum Alloys

Yuly V. MILMAN

***Institute for Problems of Materials
Science, Kiev, Ukraine***



e-mail: milman@materials.kiev.ua

Report Documentation Page				Form Approved OMB No. 0704-0188	
Public reporting burden for the collection of information is estimated to average 1 hour per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington VA 22202-4302. Respondents should be aware that notwithstanding any other provision of law, no person shall be subject to a penalty for failing to comply with a collection of information if it does not display a currently valid OMB control number.					
1. REPORT DATE 18 MAR 2004		2. REPORT TYPE N/A		3. DATES COVERED -	
4. TITLE AND SUBTITLE High-Strength Aluminum Alloys				5a. CONTRACT NUMBER	
				5b. GRANT NUMBER	
				5c. PROGRAM ELEMENT NUMBER	
6. AUTHOR(S)				5d. PROJECT NUMBER	
				5e. TASK NUMBER	
				5f. WORK UNIT NUMBER	
7. PERFORMING ORGANIZATION NAME(S) AND ADDRESS(ES) Institute for Problems of Materials Science, Kiev, Ukraine				8. PERFORMING ORGANIZATION REPORT NUMBER	
9. SPONSORING/MONITORING AGENCY NAME(S) AND ADDRESS(ES)				10. SPONSOR/MONITOR'S ACRONYM(S)	
				11. SPONSOR/MONITOR'S REPORT NUMBER(S)	
12. DISTRIBUTION/AVAILABILITY STATEMENT Approved for public release, distribution unlimited					
13. SUPPLEMENTARY NOTES See also ADM001672., The original document contains color images.					
14. ABSTRACT					
15. SUBJECT TERMS					
16. SECURITY CLASSIFICATION OF:			17. LIMITATION OF ABSTRACT UU	18. NUMBER OF PAGES 49	19a. NAME OF RESPONSIBLE PERSON
a. REPORT NATO/unclassified	b. ABSTRACT unclassified	c. THIS PAGE unclassified			

Acknowledgements

This work was supported partially by
Air Force Research Laboratory, USA
and the **Science and Technology Center of Ukraine**
(Project P061).

Author would like to thank **Drs. D.Miracle**
and **O.Senkov** (Air Force Research Laboratory, USA)
and **Drs. D.Lotsko, A.Sirko, N.Korzhova, O.Neikov**
(IPMS NANU, Ukraine)
and other who takes part in scientific work of this
project
for co-operation and help in the preparation of this
presentation.

Outline

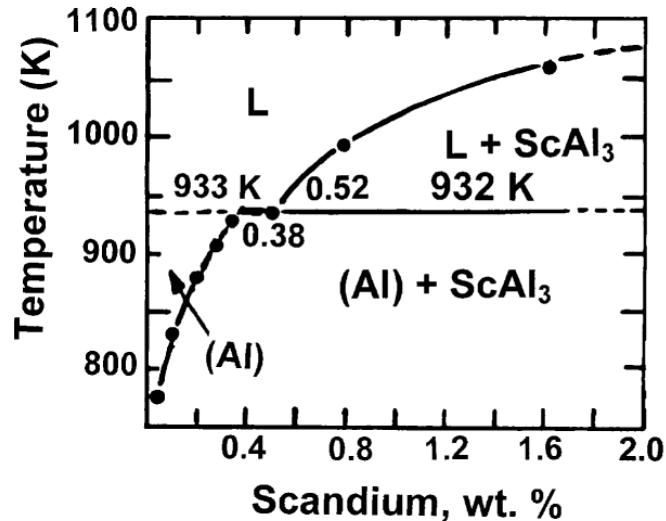
1. Introduction.
2. "Sc effect" of improving mechanical properties in aluminum alloys.
3. High-strength Al - Zn - Mg - Cu alloys, additionally alloyed by Sc.
4. Aluminum alloys hardened by quasicrystalline particles for elevated temperature.
5. High-strength cast eutectic aluminum alloys.
6. Cast eutectic aluminum alloys containing $L1_2$ phase.

Mechanical properties of structural **light alloys**

[M.Ashby & D.Jones, 1992]

Alloy	Density ρ [Mgm ⁻³]	Young's modulus E [GPa]	Yield strength σ_y [MPa]	$\frac{E}{\rho}$	$\frac{E^{1/2}}{\rho}$	$\frac{E^{1/3}}{\rho}$	$\frac{\sigma}{\rho}$	$\frac{\sigma_y^{2/3}}{\rho}$	$\frac{\sigma_y^{1/2}}{\rho}$	Creep temperature [°C]
Al alloys	2.7	71	25 – 700	26	3.1	1.5	9 – 260	3.2 – 29	1.9 – 9.8	150 – 250
Mg alloys	1.7	45	70 – 270	25	4.0	2.1	41 – 160	10 – 24.5	4.9 – 9.7	150 – 250
Ti alloys	4.5	120	170 – 1280	27	2.4	1.1	38 – 280	6.8 – 26.1	2.9 – 7.8	400 – 600
Steels	7.9	210	220 – 1600	27	1.8	0.75	28 – 200	4.6 – 17.2	1.9 – 5.1	400 – 600

«Sc effect» of strength increasing in Al alloys



Positive effect of Sc on the mechanical properties of Al is stipulated by the disperse hardening, generated by the Al_3Sc intermetallic compounds.

Sc is also characterized by the *modifying effect*, decreasing the *grain size* in as-cast state and the sensitivity to the *recrystallization*.

Content of Sc in the α solid solution is 0.5; 1.2 and 3.0 mass.% at cooling rates $v = 10^2$; 10^3 and 10^5 K/s.

The quenching temperature is 620 – 640 °C and the decomposition of solid solution after quenching occurs at 250 – 400 °C.

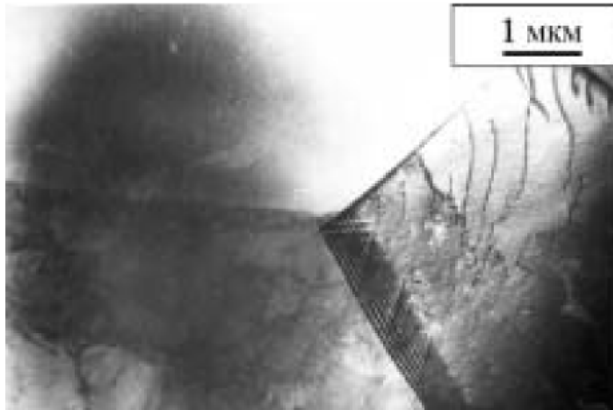
Al_3Sc phase is characterized by high structural and dimensional match with the aluminum matrix.

$$\frac{\Delta\sigma_s}{\Delta C_{at}} = 1000 \frac{\text{MPa}}{\text{at}\%}$$

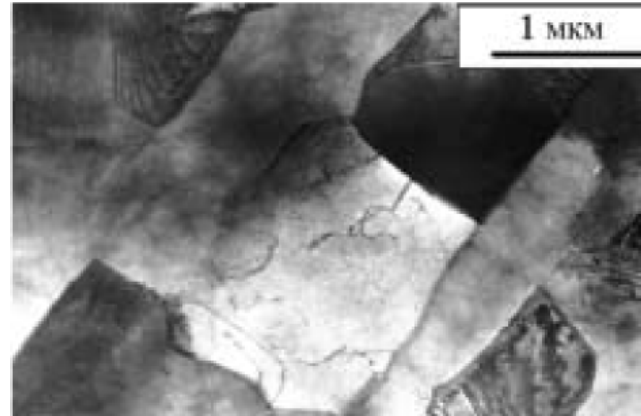
$$\delta = \frac{\Delta a}{a} = 1.2 \%$$

that is much greater than for other elements in Al_5

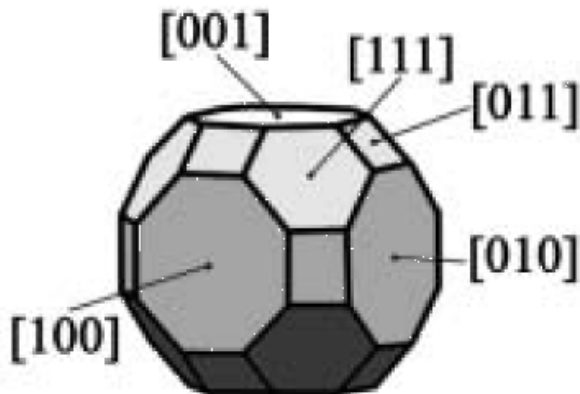
Dislocation cells in **Al alloys**



Al – 4.9%Mg



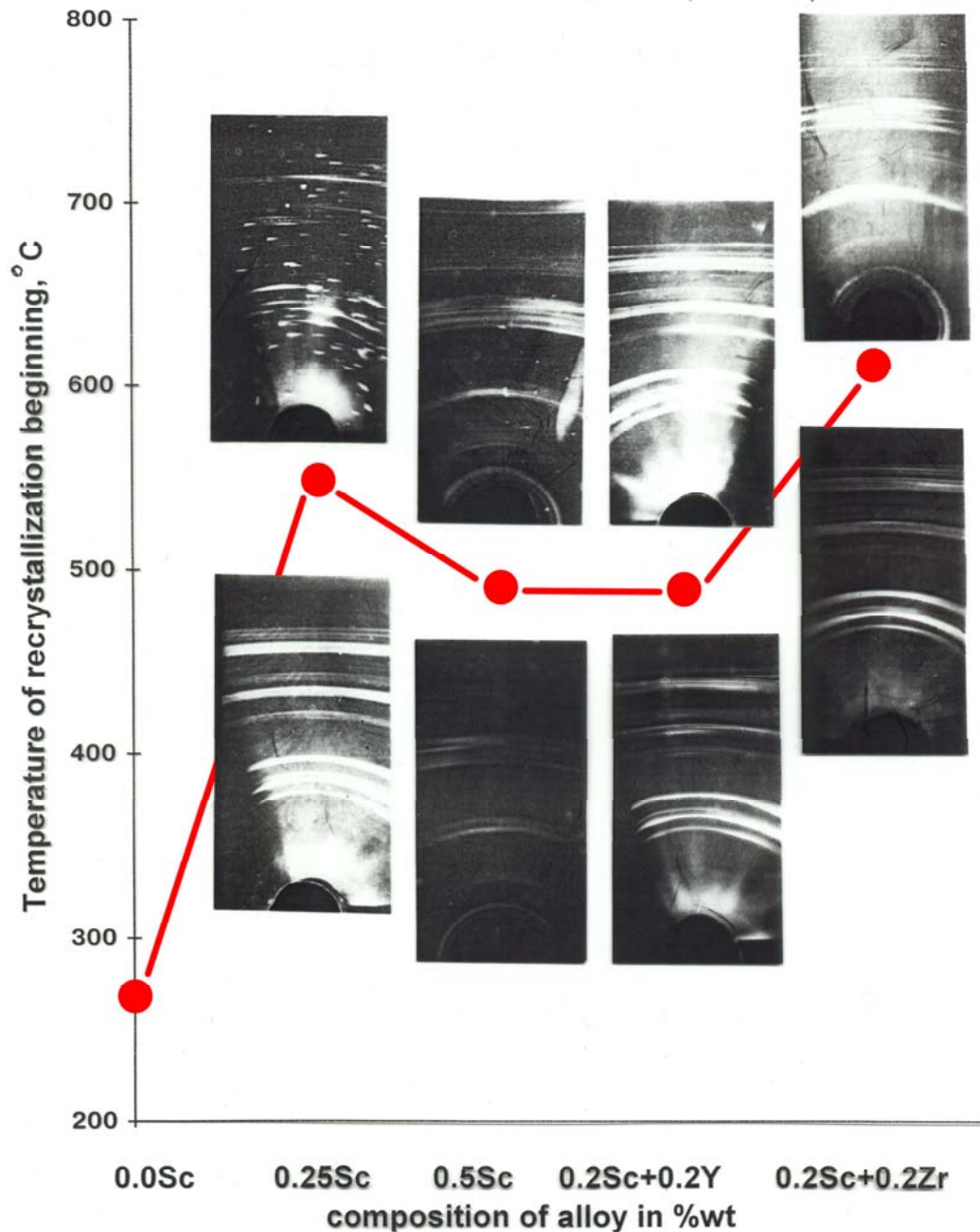
Al – 5.2%Mg – 0.3%Sc



The shape of **Al₃Sc** precipitate
[*E.A.Marquis & D.N.Seidman,*
2001]

Element	Sc	Mg	Si	Cu	Zn
<i>U, eV</i>	0.35	0.29	0.26	0.20	0.18

The binding energy between
vacancy and soluble elements in
 α -Al

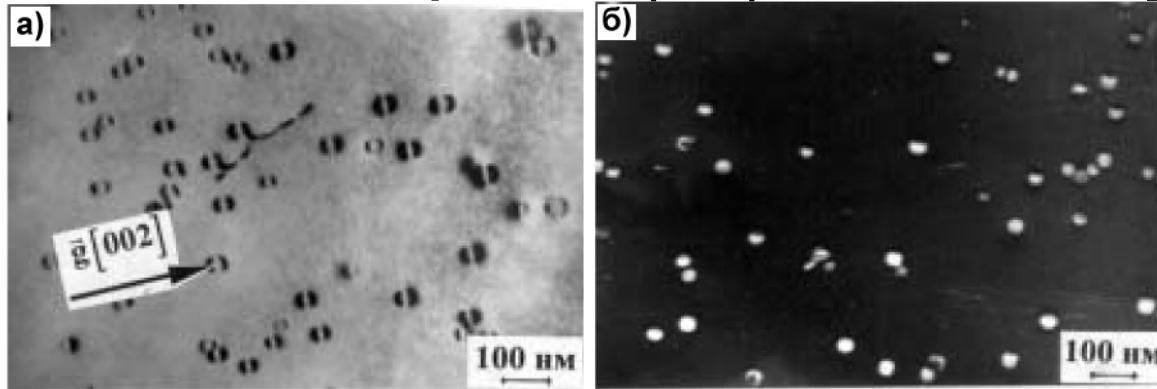


The increase of the temperature of recrystallization beginning in **Al-Sc** alloys with the additions of **Zr** and **Y** ($\varepsilon = 80\%$)

$\text{Al}_3(\text{Sc}_{1-x}\text{Zr}_x)$ particles in the cast alloy Al-6.8Zn-1.3Mg-0.12Zr-0.05Sc (wt.%) homogenization 470°C, 3 h (TEM):

a) bright field, the foil plane is (110), the reflection [002];

b) dark field, the foil plane is (110), the reflection [002]



The temperature of the recrystallization T_r for Al alloys with Sc

Composition of alloys (wt.%)	T_r , °C
Al	100-200
Al-0.26Sc	540
Al-0.2Sc-0.18Zr	610
Al-7Zn-2Mg-0.14Zr-0.2Sc	Recrystallization is absent up to the melting point
Al-6Mg-0.14Zr-0.2Sc	Recrystallization is absent up to the melting point

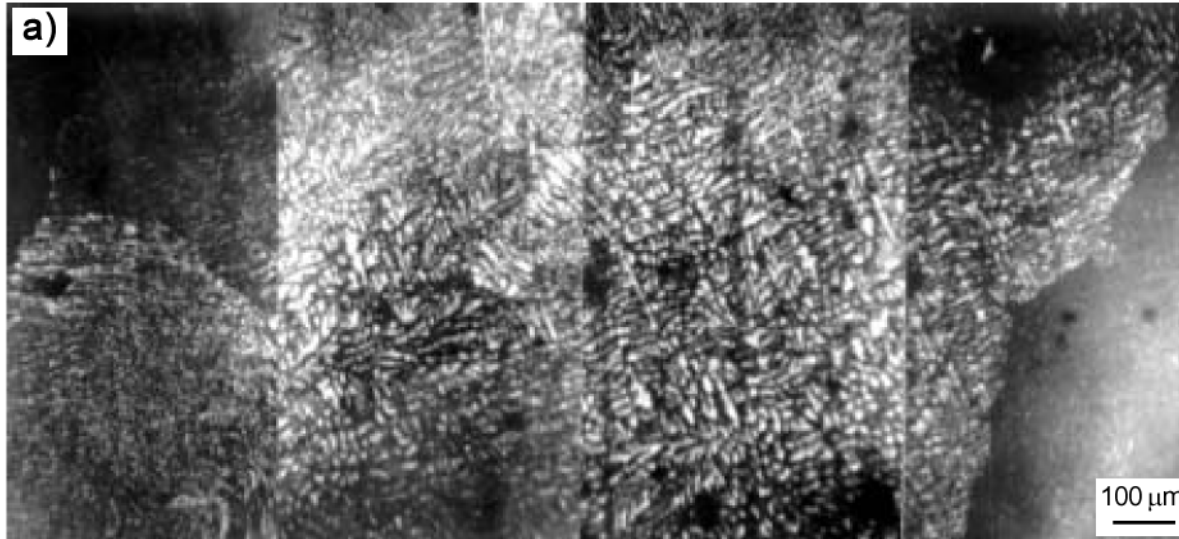
“Sc effect” on the workability of cast alloys in rolling from 60 mm to 1 – 3 mm in thickness (without extrusion)

Alloy	Production output [%]		
	0 % Sc	0.2 % Sc	0.5 % Sc
6061: Al-1.0Mg-0.6Si-0.2Cr-0.28Cu	100	100	100
2195: Al-4.1Cu-1.05Li-0.4Mg-0.14Zr	50	75	90
7075: Al-5.6Zn-2.5Mg-1.6Cu-0.23Cr	20	30	100
2618: Al-2.3Cu-1.5Mg-1.1Fe-1.1Ni-0.15Si	50	75	95
2024: Al-4.3Cu-1.5Mg-0.6Mn	15	50	100

Influence of scandium on the modification of **cast alloy** structure

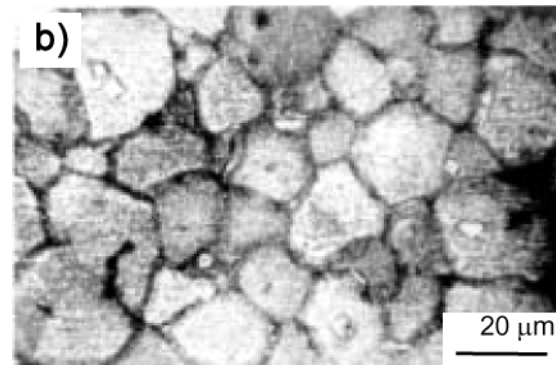
Alloy	Grain size [μm]		
	0 % Sc	0.2 % Sc	0.5 % Sc
2195: Al-4.1Cu-1.05Li-0.4Mn-0.14Zr	72	55	30
2024: Al-4.3Cu-1.5Mg-0.6Mn	60	45	22
7075: Al-5.6Zn-2.5Mg-1.6Cu-0.23Cr	60	53	15
2618: Al-2.3Cu-1.5Mg-1.1Fe-1.1Ni-0.15Si	36	16	14

Microstructure of ingots of **Al – 9.5Zn – 3Mg – 1.2Cu – (Zr, Sc)** alloys, longitudinal section



a – alloy 1 (**baseline = Al–9.5Zn–3Mg–1.2Cu**)

b –
alloy 3 (**baseline + Zr + Sc**)



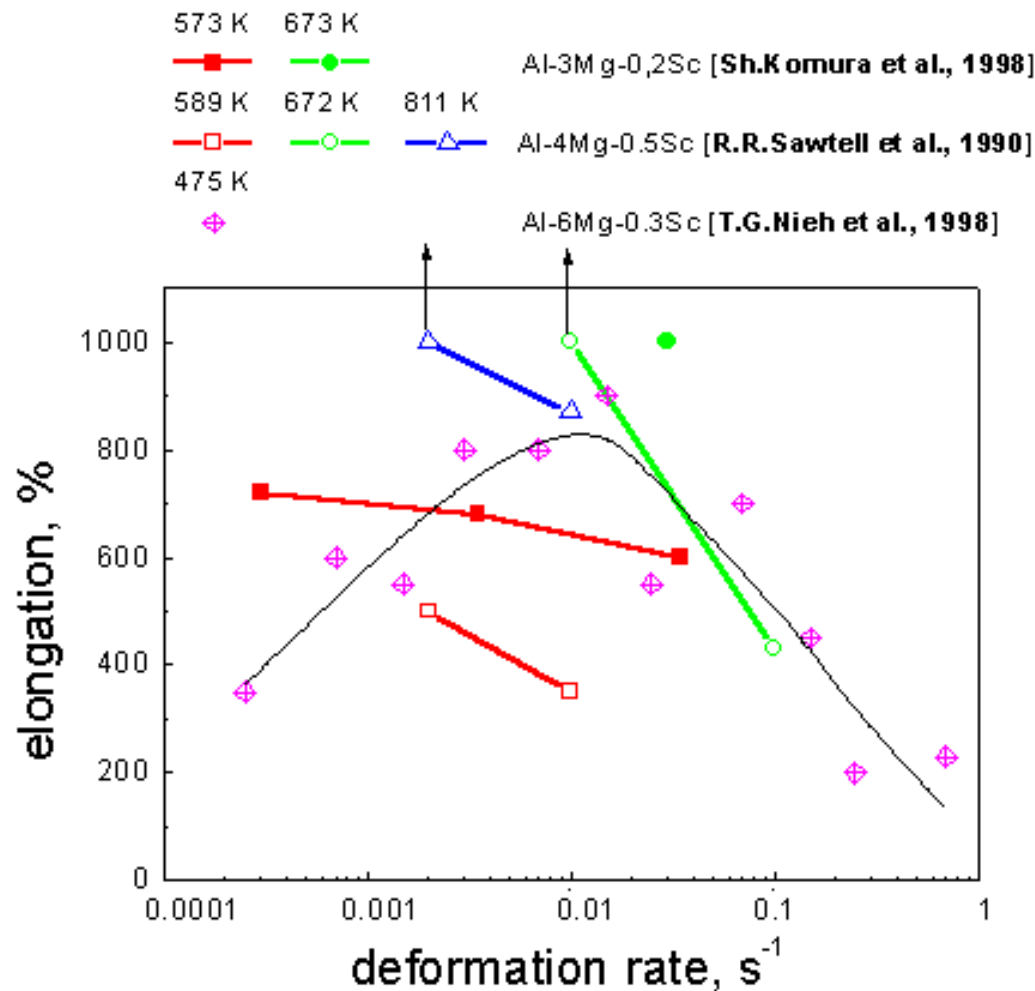
Classification of the alloying elements in relation to the «Sc effect» in Al alloys

The character of the phase equilibrium diagram Al-Me and Sc-Me (Me is the alloying element) has been selected as a basis for the present classification.

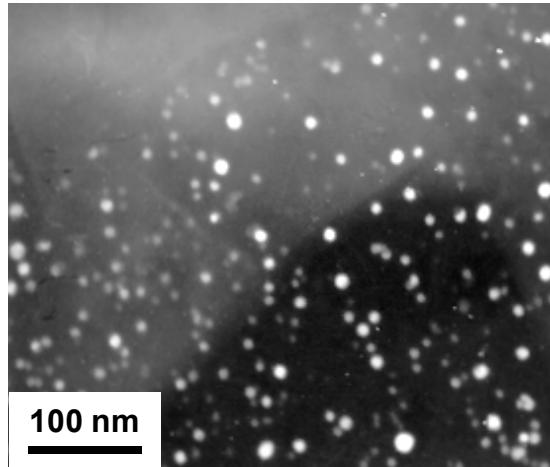
1. Elements which increase or don't decrease significantly the solidus temperature of aluminum T_s and don't form with Sc strong intermetallics distributed in aluminum solid solution (Ti, Zr, Hf, V, Nb, Ta, Mn, Cr, Mo, W, Re, i.e. mainly transition metals);
2. Elements which lower T_s , but have high solubility in Al at the temperature of ageing by Sc (about 300 °C). They are in the first line Zn, Mg, Li;
3. Elements which lower T_s and have low solubility at the temperature of ageing by Sc (Cu and Si);
4. Elements which form strong compounds with Sc and exclude Sc from hardening process (Fe, Co, Ni, and Cu and Si at high concentrations as well);
5. Elements which partially substitute Sc in Al_3Sc and lower the consumption of Sc with the preservation of hardening effect (Zr, Y and rare-earth elements).

Some elements (Zr, Cu, Si et al.) may have the properties of several groups.

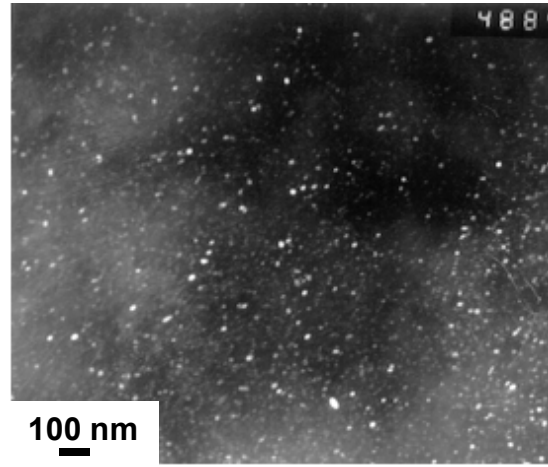
The influence of the deformation rate on plasticity to fracture for **Al-Mg alloys, containing Sc**



Secondary particles in rods of the alloy **Al-Zn-Mg-Cu-Sc-Zr** after T6 treatment



a



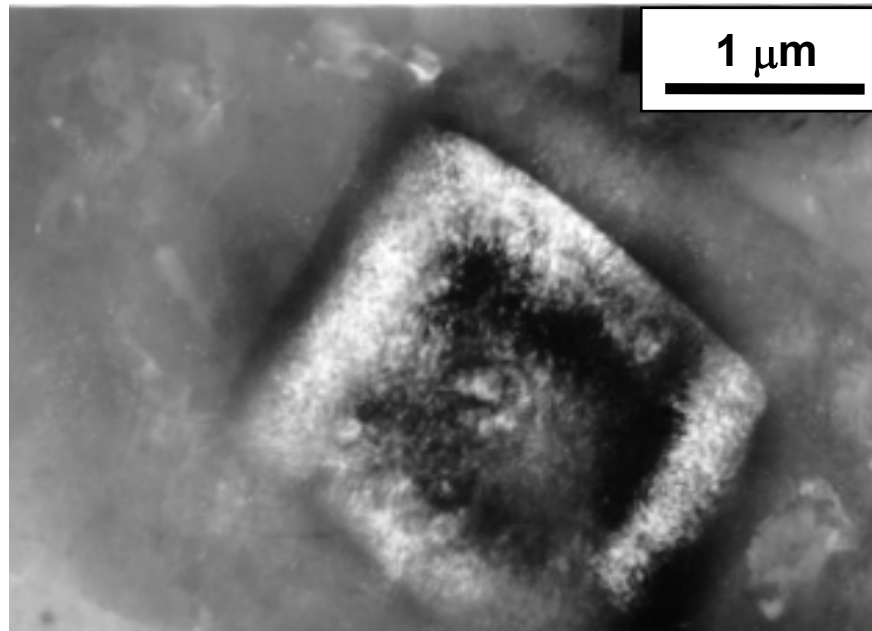
b



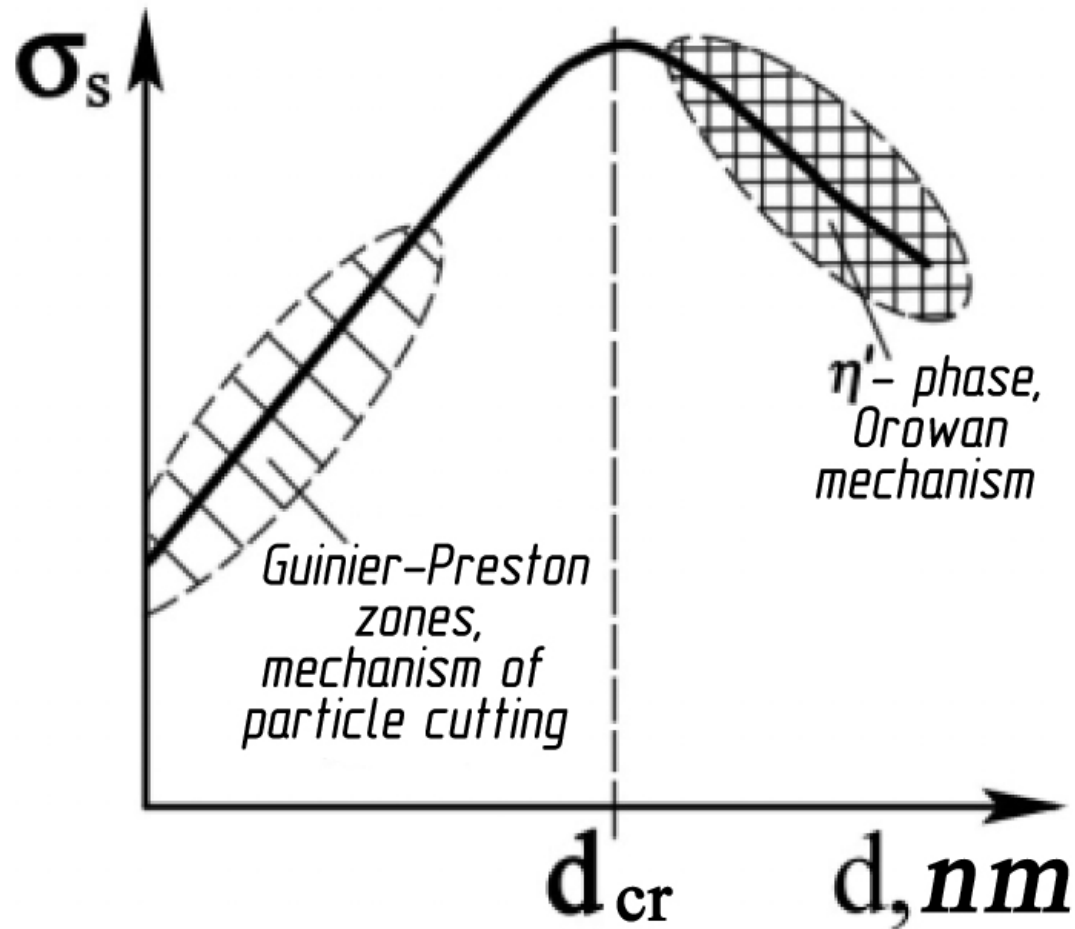
c

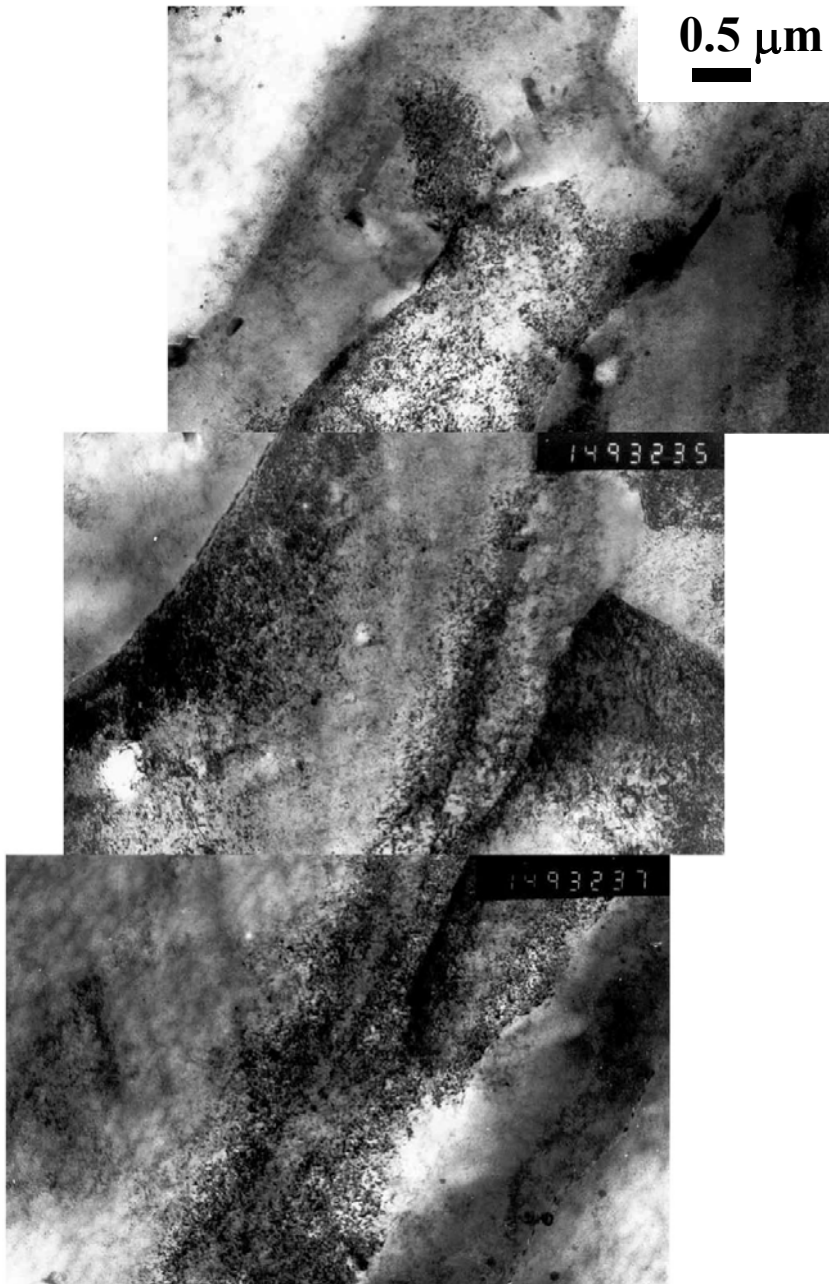
(a) dark field image of **Al₃Sc_{1-x}Zr_x** particles after quenching from 460 °C and aging at 120 °C 24 h [001];
(b) dark field image of MgZn₂ particles in the same alloy obtained in reflections in the ring (c)

A primary particle $\text{Al}_3\text{Sc}_{1-x}\text{Zr}_x$ in the extruded rod from
cast alloy,
dark field image in (001) reflection of Al_3Sc



Scheme of the dependence of the yield stress σ_s on the average size of second phase particles in **Al - Zn - Mg alloys [Kováč et al., 1980]**

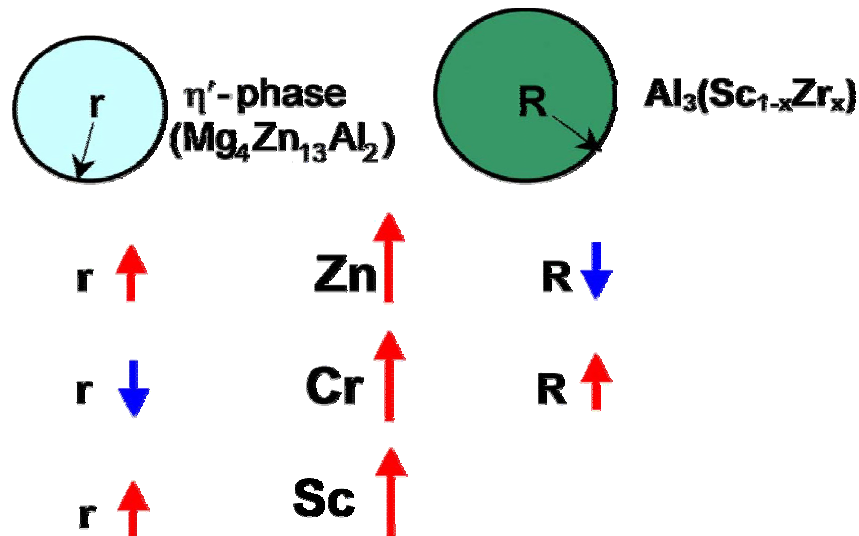




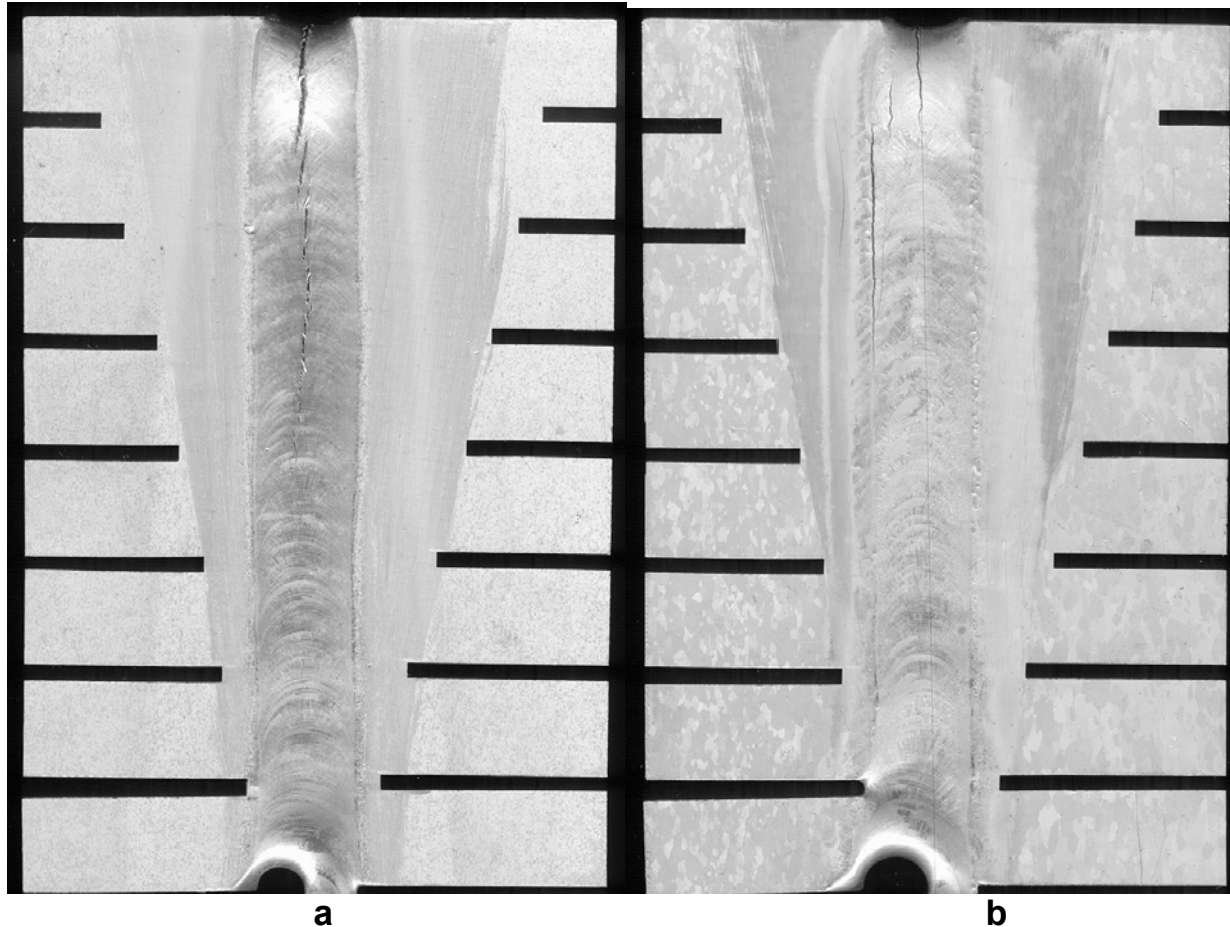
The band of localized deformation in the working part of specimen after the tension test of alloy **Al – Zn – Mg – Cu system in T6 condition**

Structural parameters of extruded rods (after T6 treatment) of **Al - Zn - Mg - Cu** alloys additionally alloyed by **Zr, Sc** and **Cr**

Alloy #	Content of Zn, %wt.	Transverse size of dislocation cell, μm	Longitudinal size of η' -phase particles, μm	Size of $\text{Al}_3(\text{Sc}_{1-x}\text{Zr}_x)$ particles, μm
Л10	10	1.8	8.2 (Zr)	-
Л13	10	1.3	9.6 (Zr, Sc)	5.7
Л11	10	1.0	2.9 (Zr, Cr)	-
Л12	10	1.3	3.5 (Zr, Cr, Sc)	11.8
Л14	10	1.7	6.2 (Zr, Mn)	-
Л15	10	1.6	12.5 (Zr, Mn, Sc)	6.6
Л16	12	1.5	6.6 (Zr, Mn, Sc)	8.5
UM27	5	1.9	2.2 (Zr)	13.5 (Al_3Zr)
UM28	5	1.0	(Zr, Cr, Sc)	12.0
UM29	5	1.5	3.17 (Zr, Sc)	11.2
UM30	5	2.0		

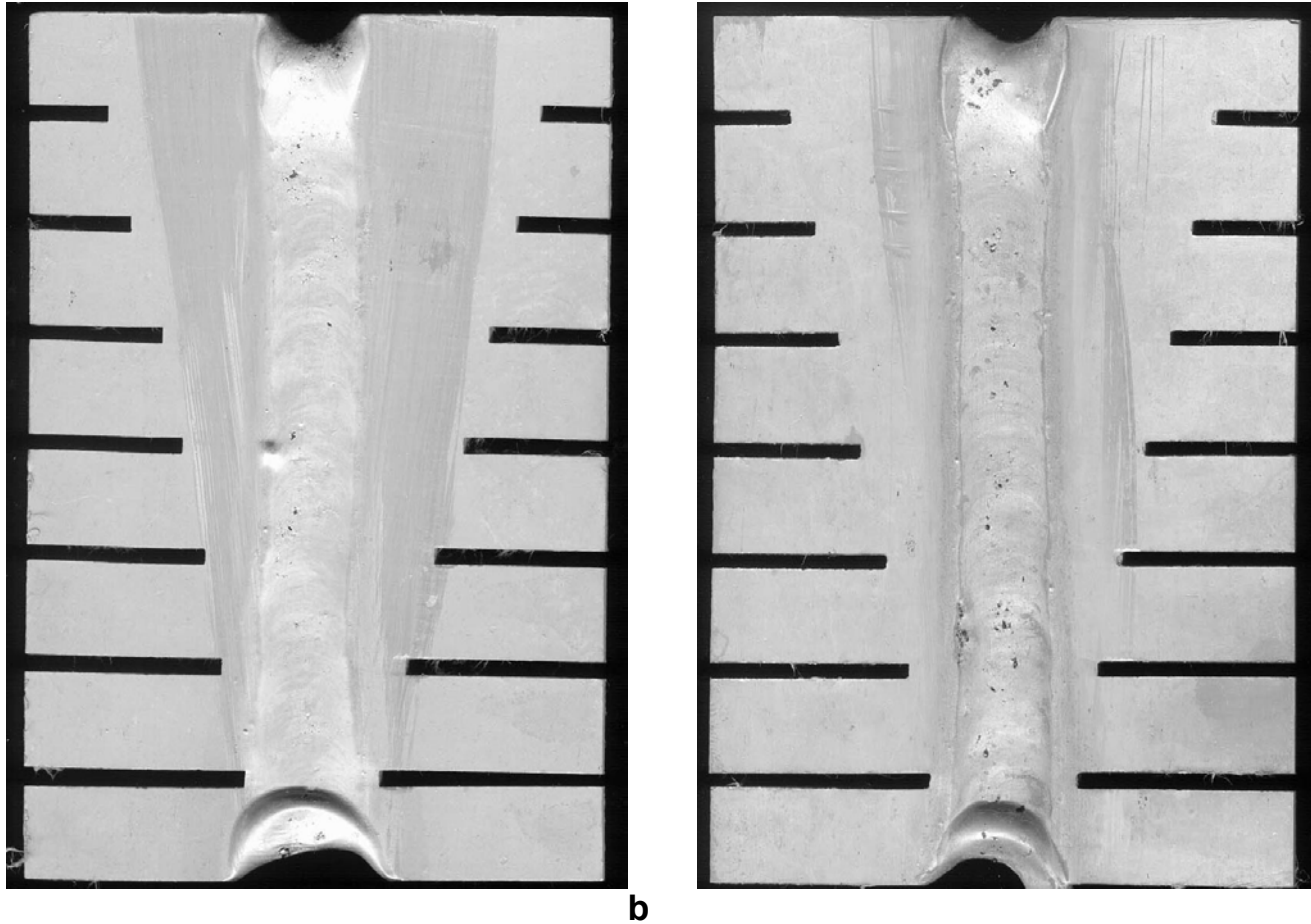


Houldcroft tests for hot cracking susceptibility



Types of weld cracking in arc welding of **Al - Zn - Mg - Cu alloys without Sc**
a – in weld center; b – in different weld zones

Houldcroft tests for hot cracking susceptibility



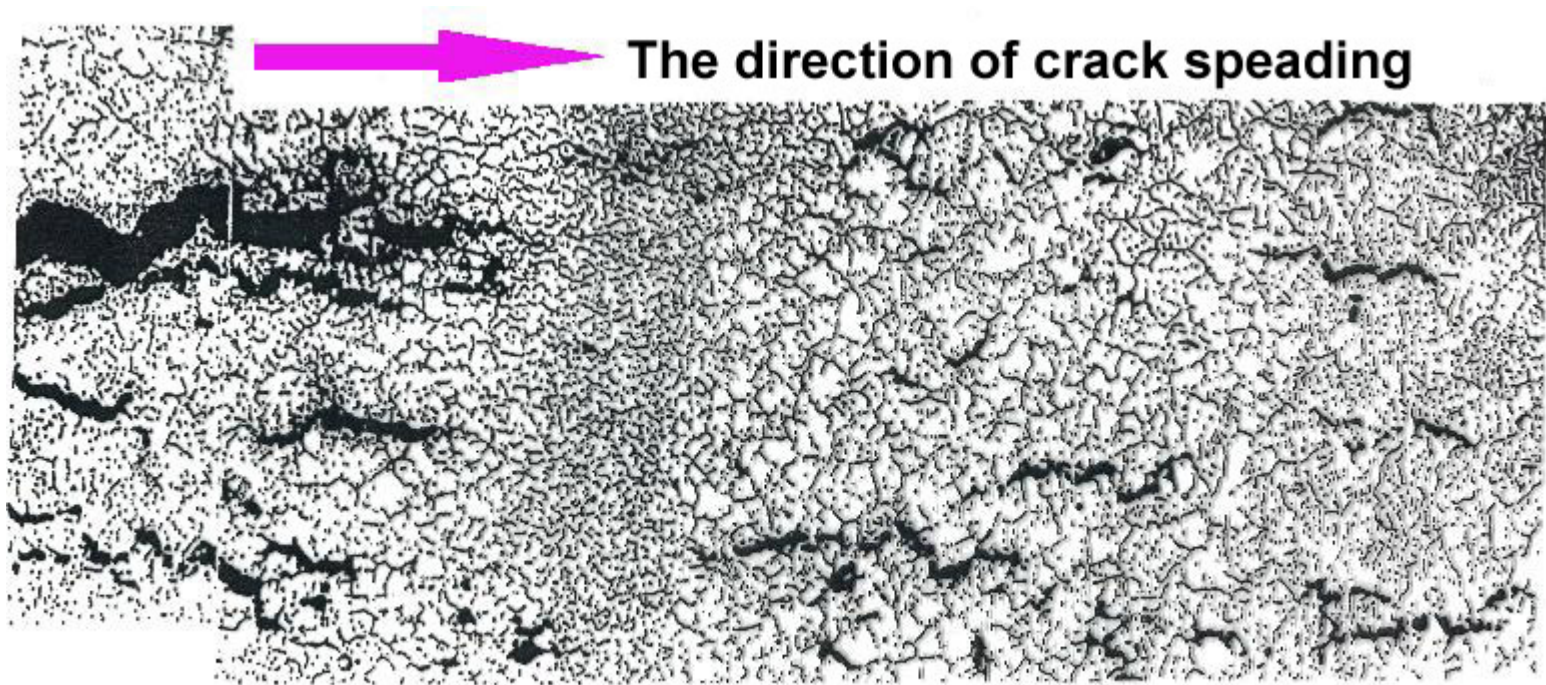
Appearance of the technological samples in arc welding of test alloys without a filler:

a – alloy L2 ($\text{Al-8.0\%Zn-2.3\%Mg-2.0\%Cu-0.1\%Mn-0.1\%Cr-0.2\%Zr-0.4\%Sc}$);

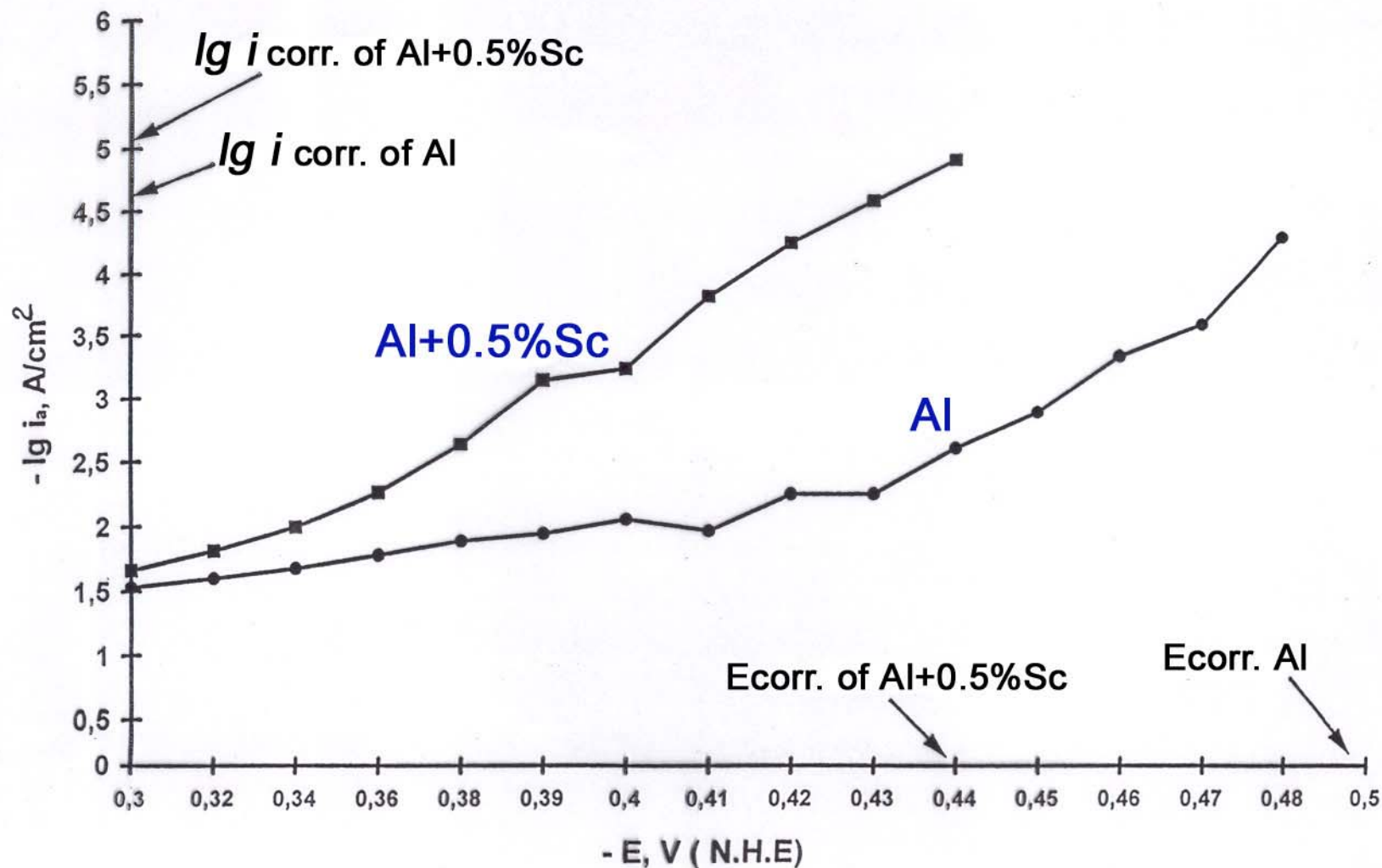
b – alloy L3 ($\text{10.0\%Zn-3.5\%Mg-3.0\%Cu-0.2\%Zr-0.3\%Sc}$).

No cracks found

An example of stopping a hot crack in the area of the weld with subdendrite structure stipulated by the presence of $S_c > 0.3 \%$; x100



Effect of Sc on corrosion and electrochemical properties of Al in water solution 3 % NaCl, 25 °C



The influence of alloying elements on the mechanical properties of **Al - 9Zn - 3Mg - 2.3Cu** alloy in T6 condition

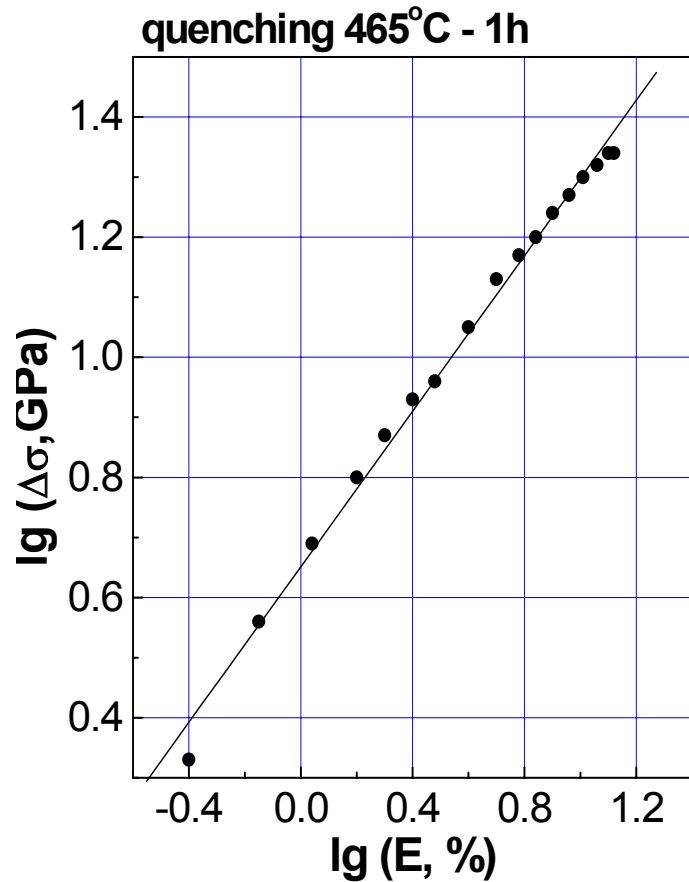
Alloy		Elements	Mechanical property of rods $\varnothing$ 6 mm in T6 conditional		
			YS, MPa	UTS, MPa	El,%
UM10= UM 8 + Sc	UM 8 = UM 7.2 + Zr	UM 22 Al-9Zn-3Mg-2.3Cu	530	619	20.4
		+Mn	548	636	17
		+ Zr	545	621	13.8
		+ Sc	696	789	12.3
	UM 7.2 = UM 22 + Mn				
UM 10 + TM and RE metals		+V	717	767	7.3
		+Ni	735	807	10.2
		+Nb	722	824	11.4
		+Ce	744	809	10.0
		+Cr	725	804	10.2
		+Hf	700	810	14.1
		+Ti	718	779	10.3
		+Fe	741	802	9.3
UM 8 + Ti		+Ti	654	707	7.2

Mechanical properties of **Al-Sc alloys**

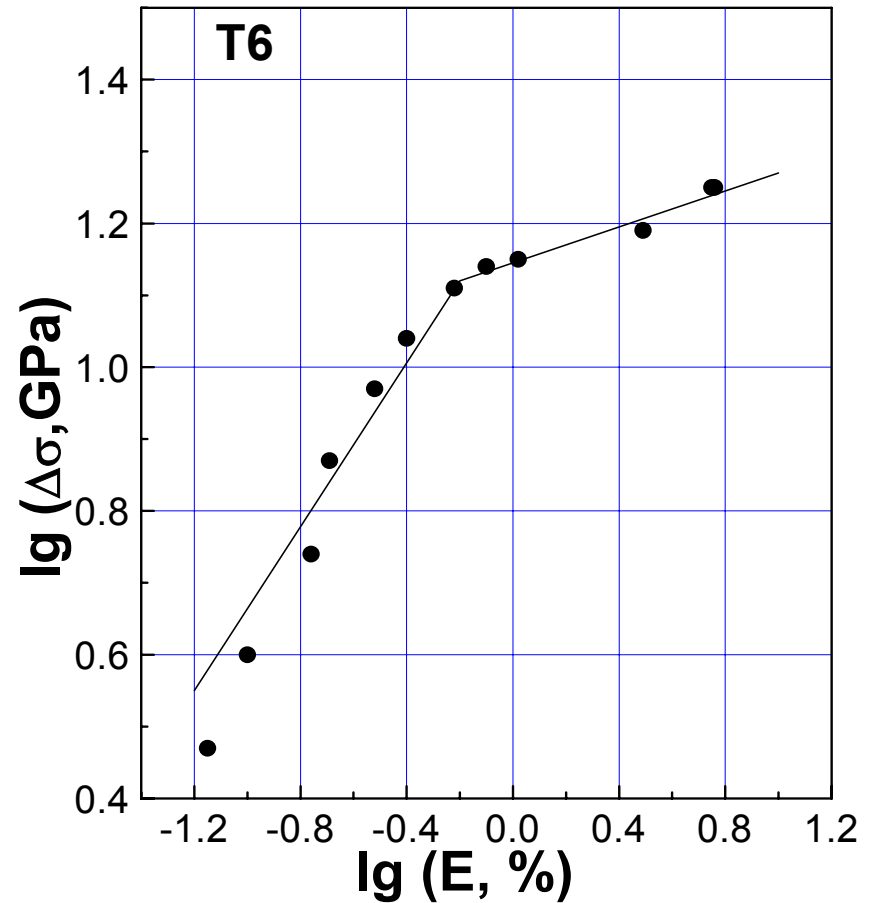
Designation of alloy	Standard alloys			New alloys, alloyed by Sc in additions					
	Yield stress [MPa]	UTS [MPa]	δ [%]	Cast technology			PM technology		
				Yield stress [MPa]	UTS [MPa]	δ [%]	Yield stress [MPa]	UTS [MPa]	δ [%]
Al – Zn – Mg									
1915 (rod)	350	400	10	520	570	13	700	770	9
1915 (sheet)	280	360	11						
7046 (rod)	427	469	13						
7046 (sheet)	379	414	13						
Al – Zn – Mg – Cu									
B95 (7075) (rod)	550	580	8	740	810	10	750	800	8
B95 (7075) (sheet)	480	530	11						
B96L1 (8055)	620	650	6						
Al – Mg									
AMr 5M (5056)	180	300	20	480	520	10	510	570	8
AMr 5H	320	420	10						
AMr 6HH	340	420	8						
Al – Mg – Li									
1420	290	440	11	540	590	6			

Hardening $\Delta\sigma$, versus deformation E of rod sample alloy 4 **Al-10.3Zn-2.85Mg-1.19Cu-0.15Zr**

a – quenching from 465 °C after 1 h holding; b – after T6 treatment



a



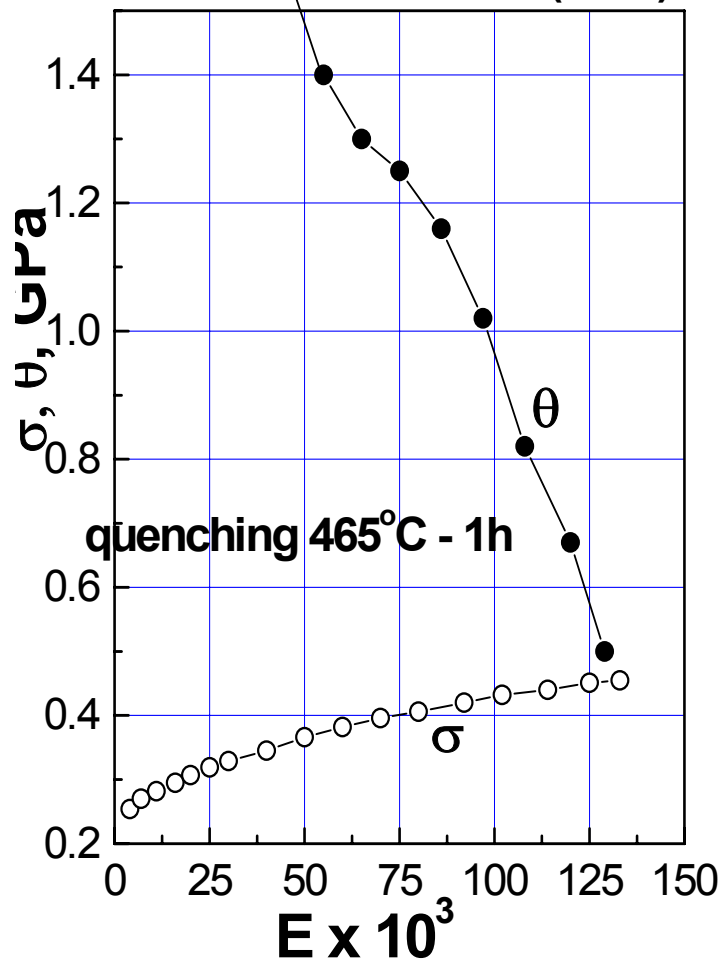
b

True stress σ and strain hardening coefficient θ for rod samples

alloy 4 **Al-10.3Zn-2.85Mg-1.19Cu-0.15Zr**

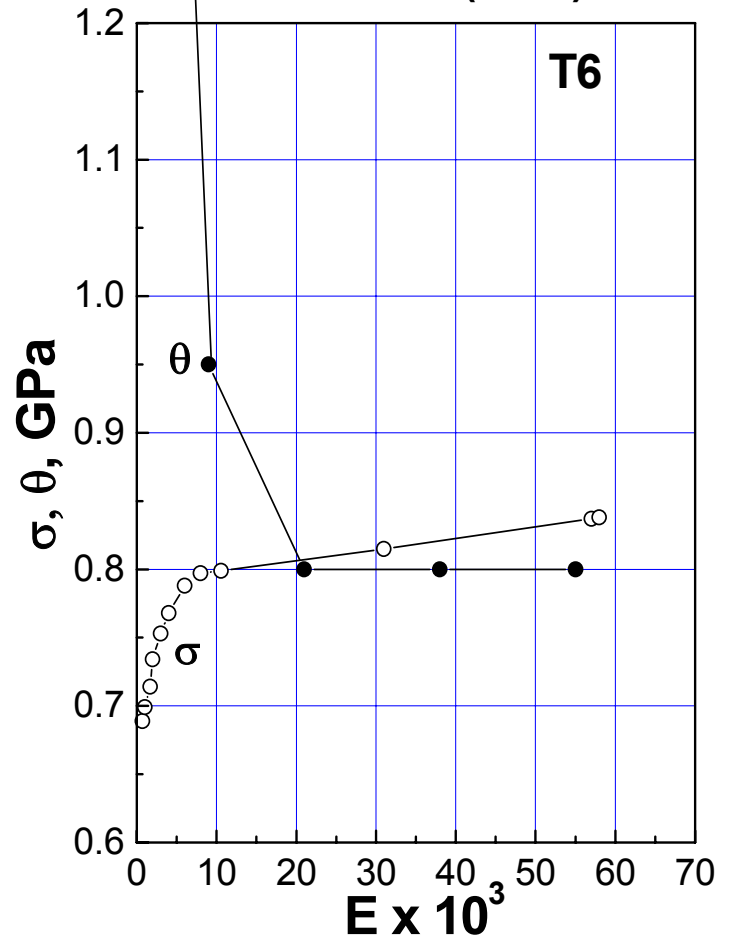
c – quenching from 465 °C after 1 h holding; d – after T6 treatment.

$\theta = 5.33 \text{ GPa}$ at $E = 0.005(0.5\%)$



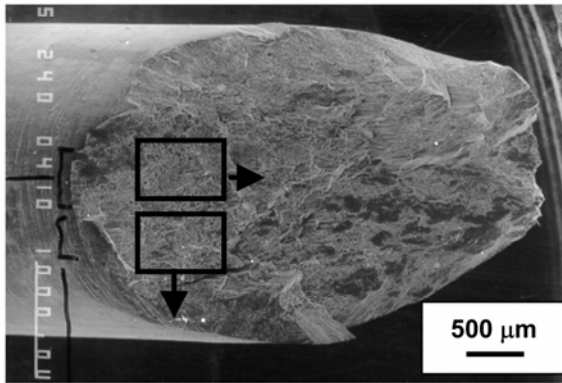
c

$\theta = 34.6 \text{ GPa}$ at $E = 0.001(0.1\%)$

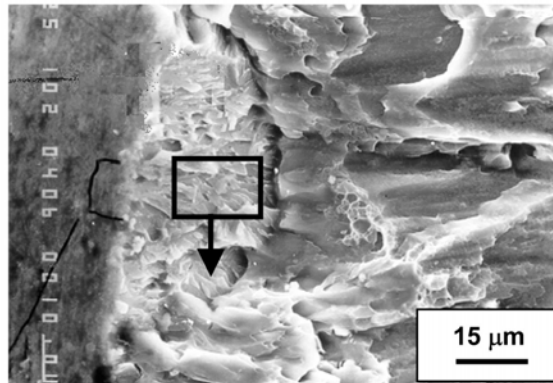


d

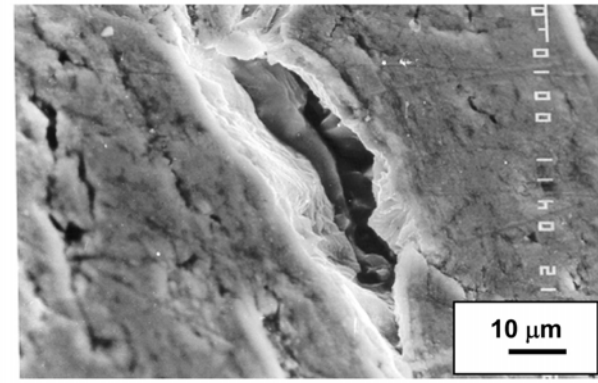
Fracture surface of the rod from alloy 4
(**Al – 10.3Zn – 2.85Mg – 1.19Cu – 0.15Zr**)
after T6 treatment (aging at 120 °C, 24 h)



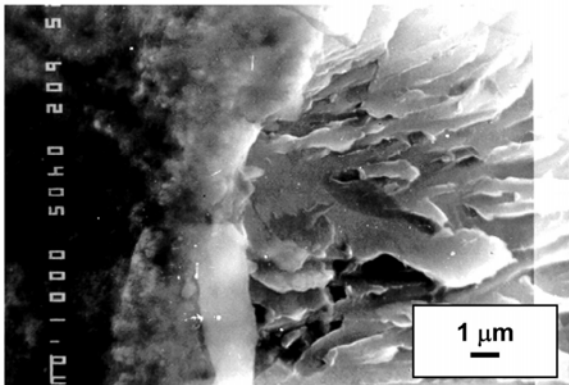
a



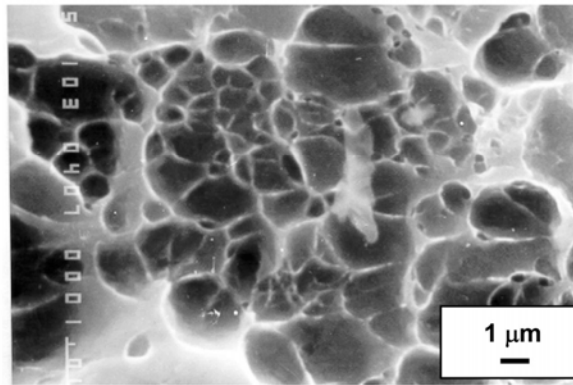
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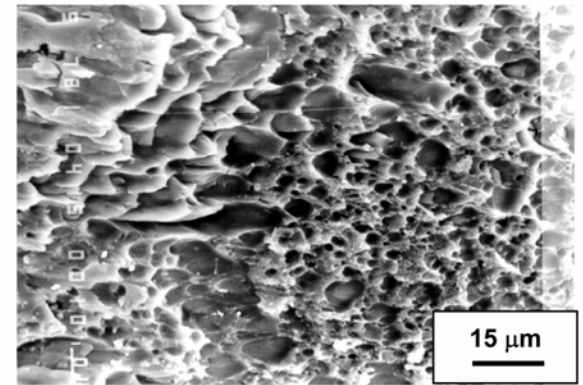
c



d



e

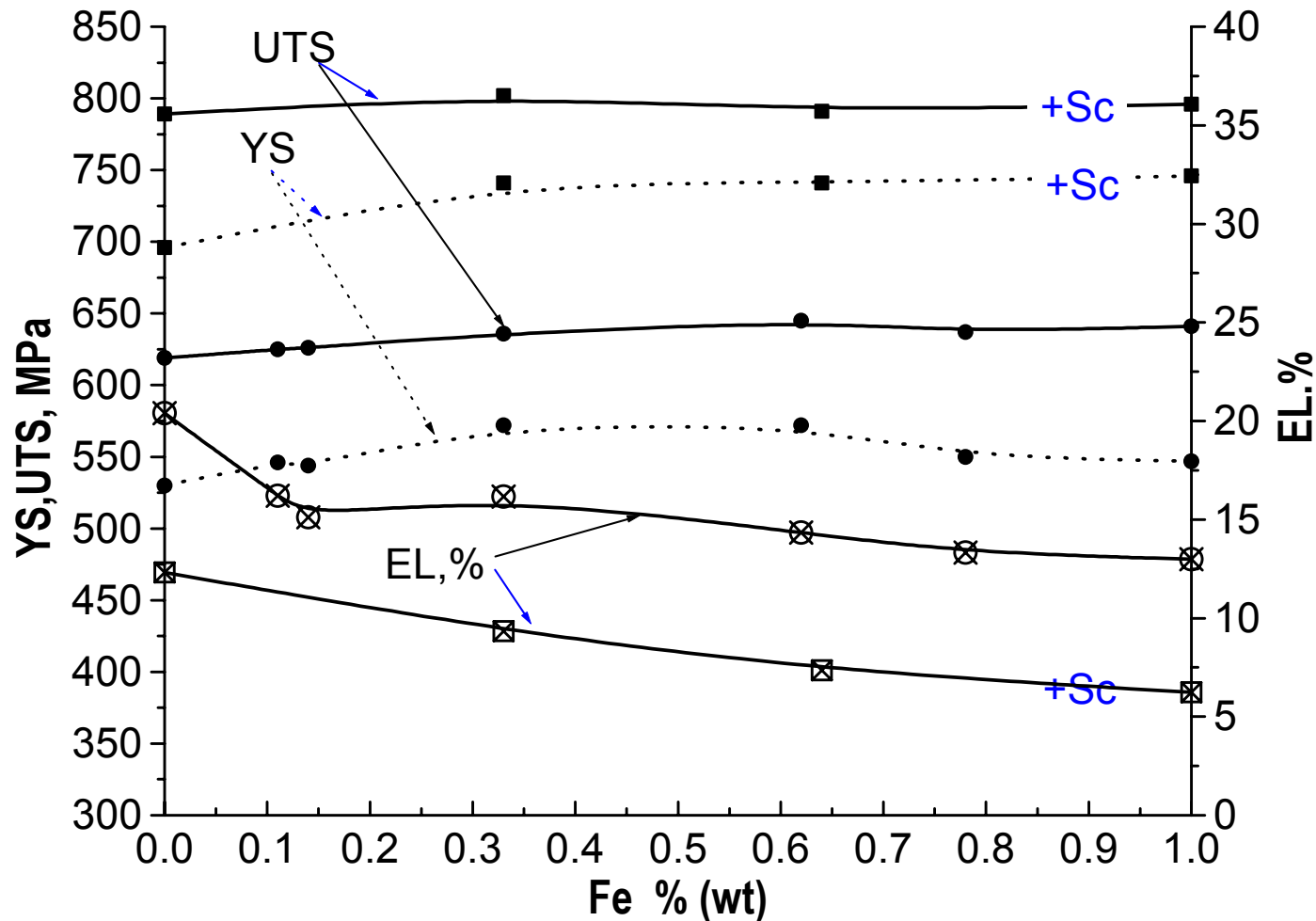


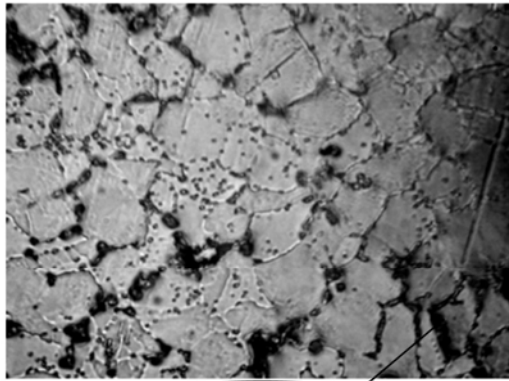
f

The influence of iron concentration on the mechanical properties of rods $\varnothing$ 6 mm (μ =17.7) **Al - Zn - Mg - Cu** alloys in T6 conditions.

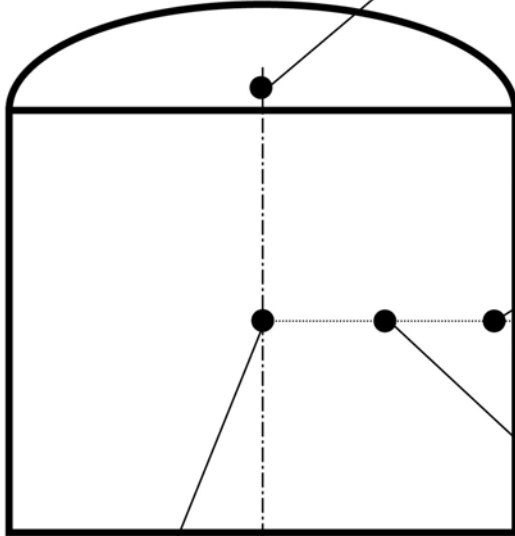
Alloys obtained by casting. Alloy 1: **Al - 9Zn - 3Mg - 2.3Cu + (x)Fe**;

alloy 2: **Al - 9Zn - 3Mg - 2.3Cu - 0.3Mn - 0.15Zr - 0.3Sc + (x)Fe**

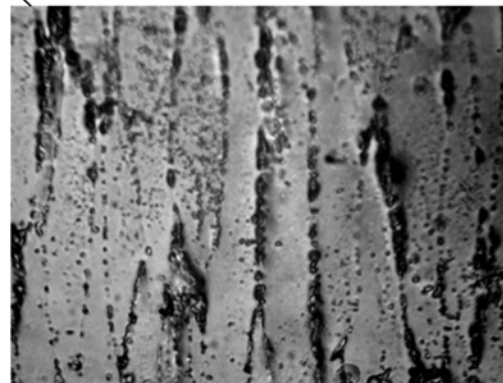




Mechanical properties	YS, MPa	UTS, MPa	EL, %
Extrusion with $\lambda=18$, T6 treatment	675	710	9
Upsetting with $\varepsilon = 80\%$, T6 treatment	500	578	19
Extrusion with $\lambda=4$, T6 treatment	683	725	12
Upsetting with $\varepsilon = 80\%$, T6 treatment	656	702	10.2

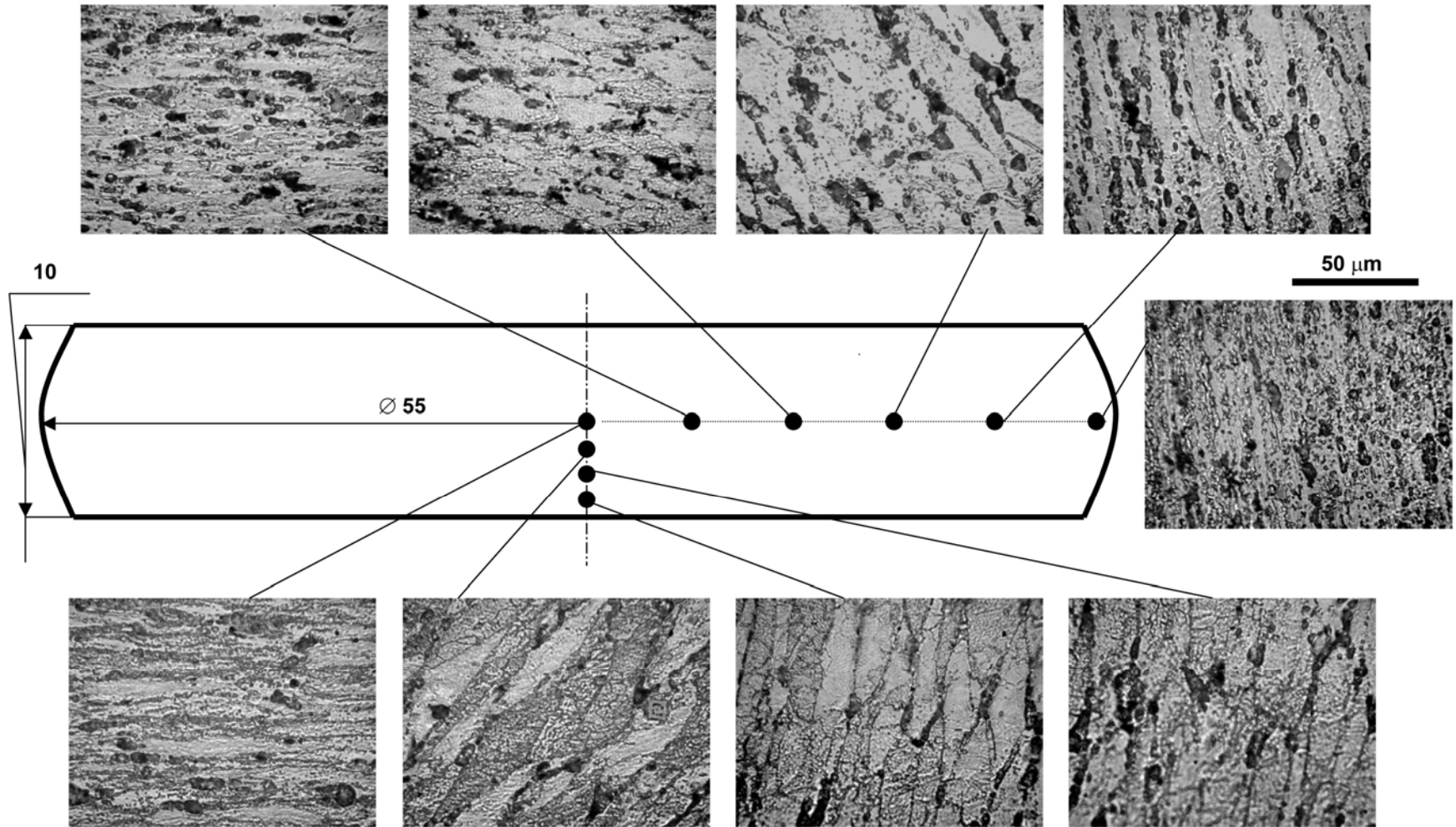


50 μm

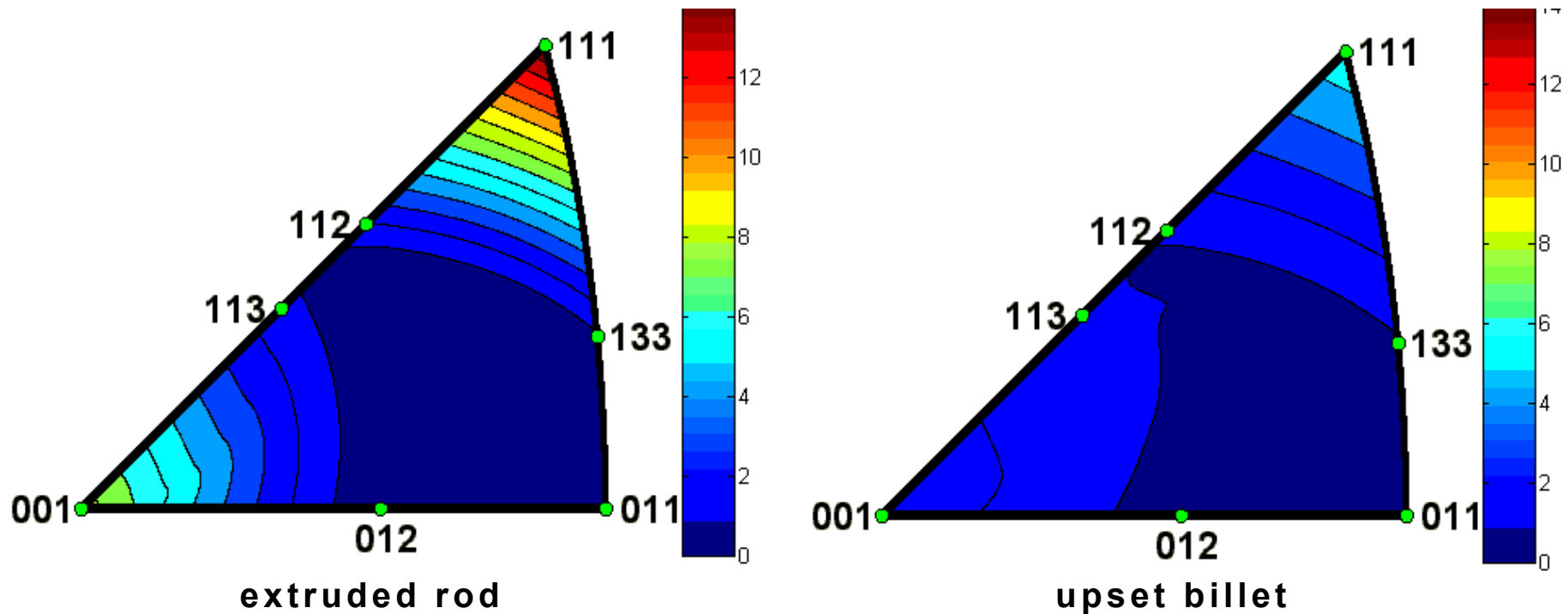


**Structural texture
of the extruded
rod of 25 mm in
diameter of the
**Al-9Zn-3Mg-
2.3Cu-0.3Mn-0.3Sc**
alloy**

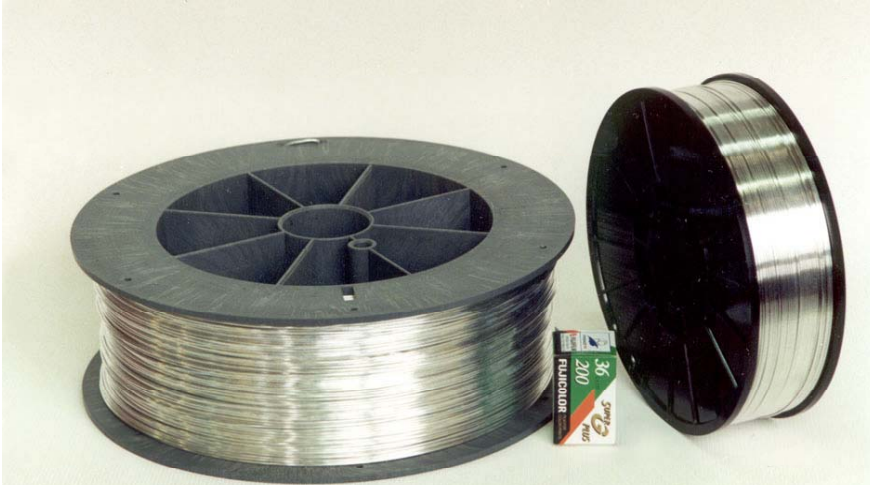
**Structural texture in section along the axis of the upset billet
(obtained from the extruded rod)
of **Al-9Zn-3Mg-2.3Cu-0.3Mn-0.3Sc** alloy ($\varepsilon = 80\%$)**



**Inverse pole figures of the extruded rod and of the upset
billet (obtained from this extruded rod)
of the $\text{Al-9Zn-3Mg-2.3Cu-0.3Mn-0.3Sc}$ alloy**



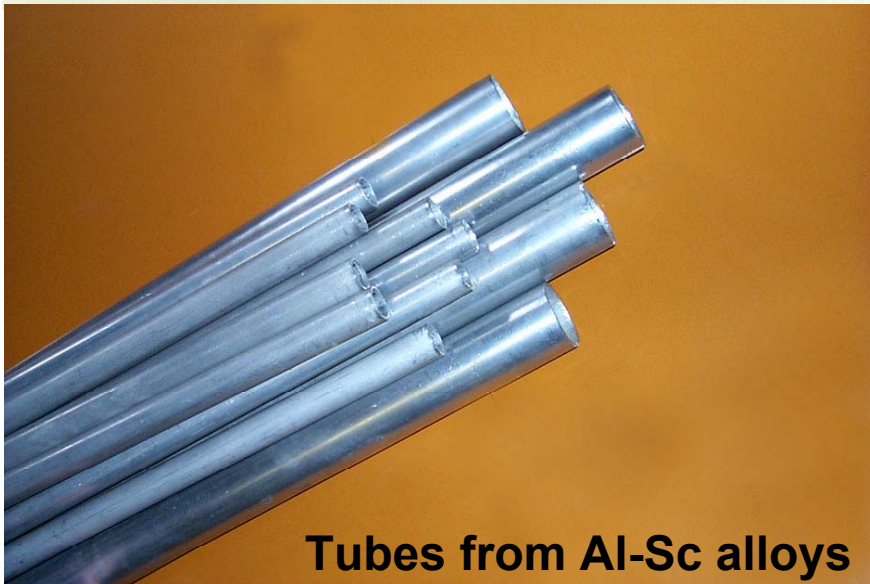
Samples of articles from **Al-Sc alloys**



Al-Sc wire for welding



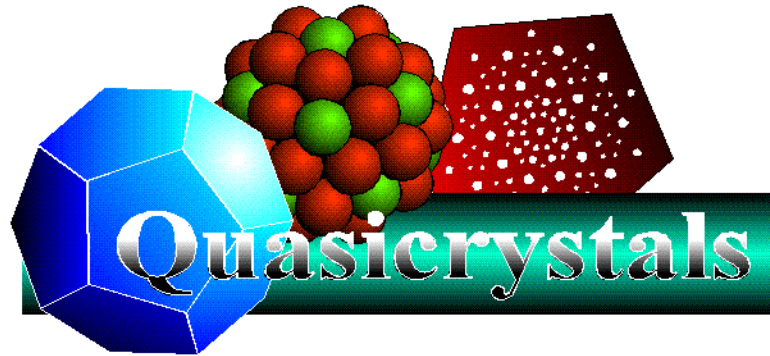
Baseball club from Al-Sc alloys



Tubes from Al-Sc alloys



Balloon from Al-Sc alloys



Quasicrystals are new perspective materials, in which

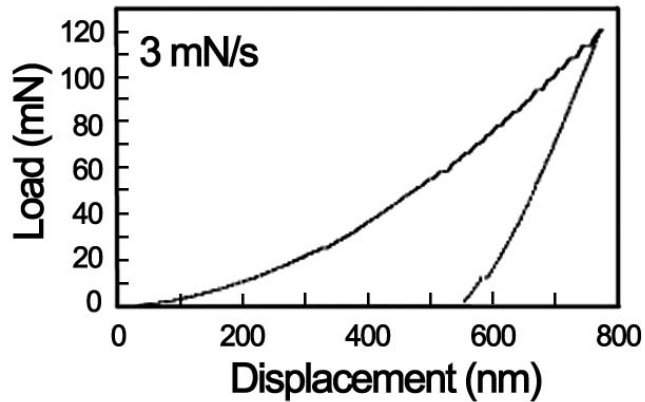
- ◆ the translational long-range is absent;
- ◆ there is a rotational symmetry with 5-, 8-, 10- or 12-fold axes (that is forbidden in crystalline materials);
- ◆ high hardness (up to 10 GPa), brittleness while standard testing and plasticity at local loading are observed.

It was shown in previous works of authors that the plasticity at local loading is a result of the phase transition to a crystalline structure. It is proved by:

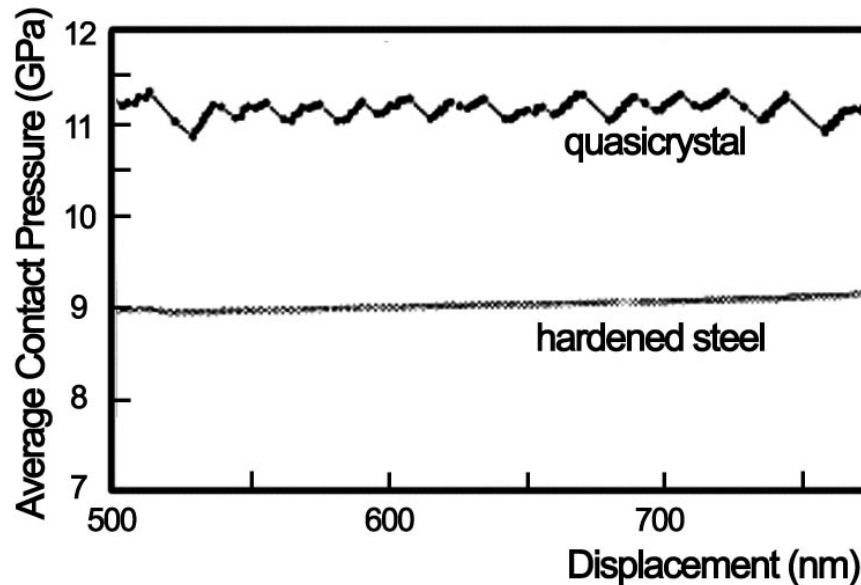
- serrated yielding during nano-hardness measurement;
- extrusions of ductile phase around the indent;
- special shape of the indents.

***A.Inoue* has shown that Al alloys with disperse strengthening by metastable intermetallic phases with a quasicrystalline structure can be produced by rapid solidification.**

Nanohardness of $\text{Al}_{63}\text{Cu}_{25}\text{Fe}_{12}$ quasicrystal



Extrusion from
indentation print
 $P=5\text{N}$,
ambient temperature



New direction in powder metallurgy:

**producing powders by the technique of rapid crystallization of the melt
with the formation of non-equilibrium metastable structures
(the solidification rate to 10^6 °C/s)**

Techniques of producing powders:

- manufacturing powders by atomizing the melt with high-pressure water or by gas atomization;
- manufacturing flakes and ribbons by spinning on a rapidly turning metallic wheel.

Techniques of powder consolidation:

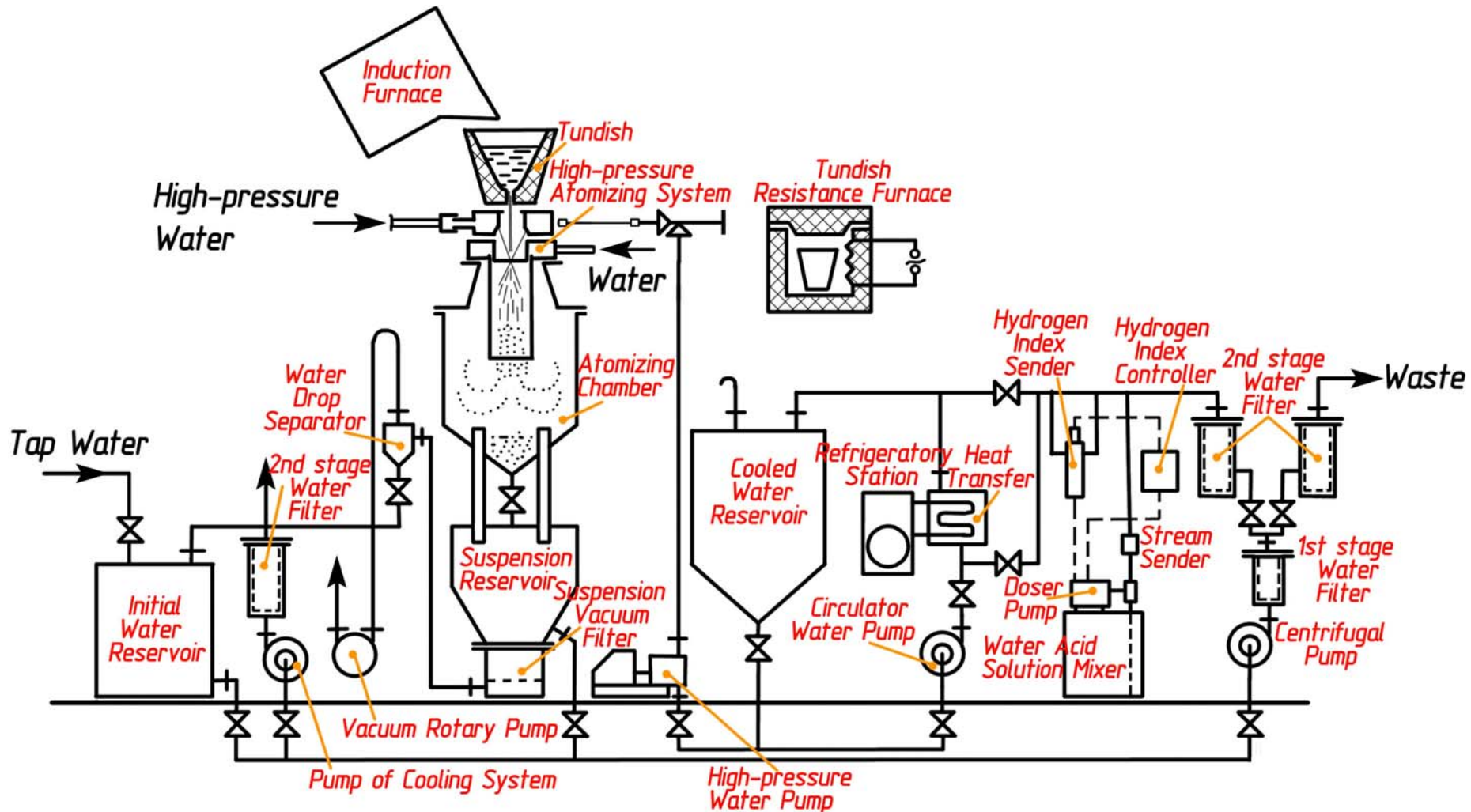
- ❖ isothermal pressing and extrusion of pressed billets in hermetic capsules;
- ❖ vacuum forging and extrusion of forged billets.

**Powder consolidation is carried out by means of severe plastic deformation
without sintering process**

Advantages:

- a possibility of increasing the concentration of alloying elements, lowering the grain size, eliminating the liquation → improving mechanical properties;
- dissolution of harmful admixtures in the solid solution (e.g., Fe in Al that allows to use the recycled Al for producing high-strength Al alloys);
- creating new structural states: amorphous and quasicrystalline phases.³⁴

Schematic representation of the **Al-alloys** **Water Atomization Unit**





1. Atomization of melted Al alloys (upper floor)

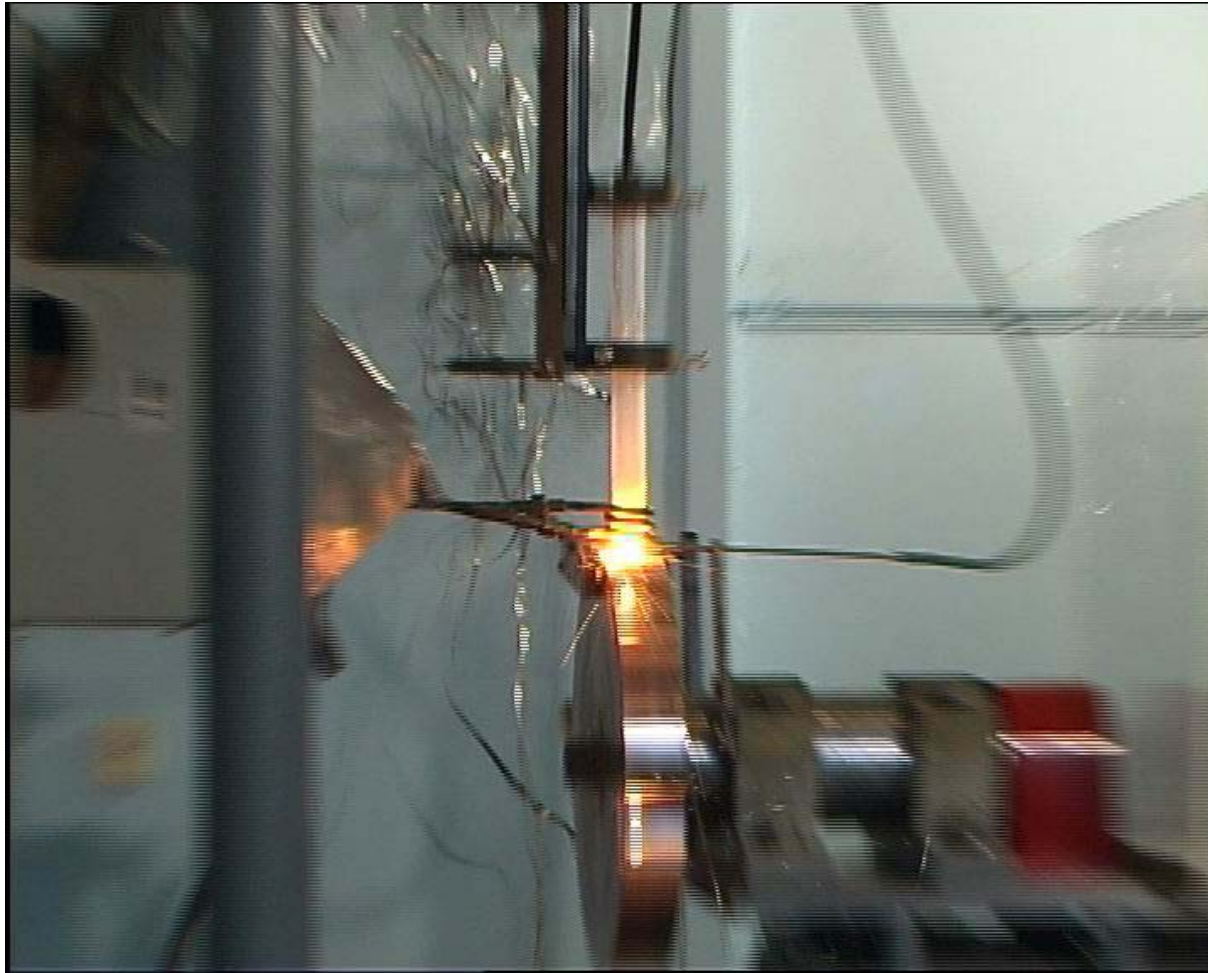


2. New high-pressure water pump (lower floor)

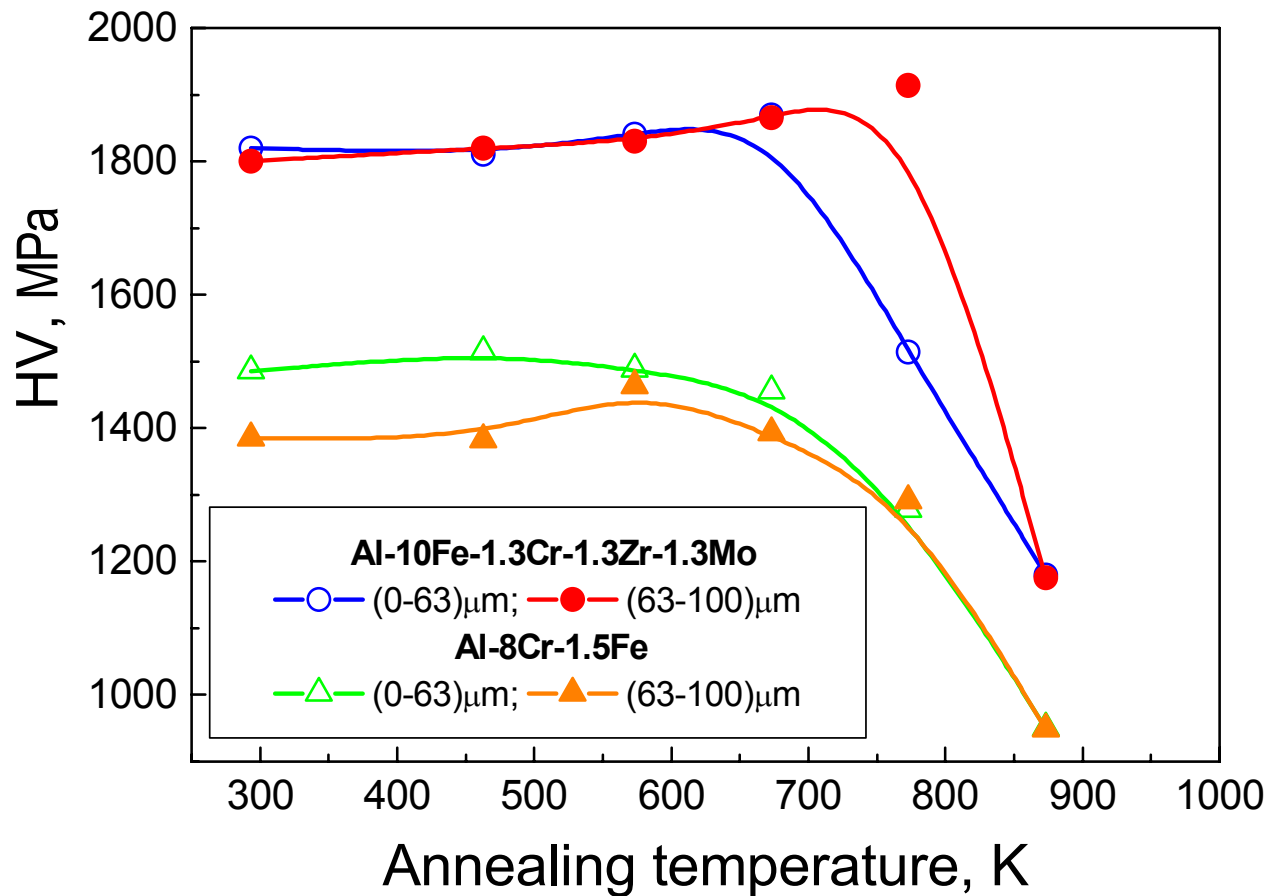


3. Hydrogen Index Controlled System and Cooled Water Reservoir

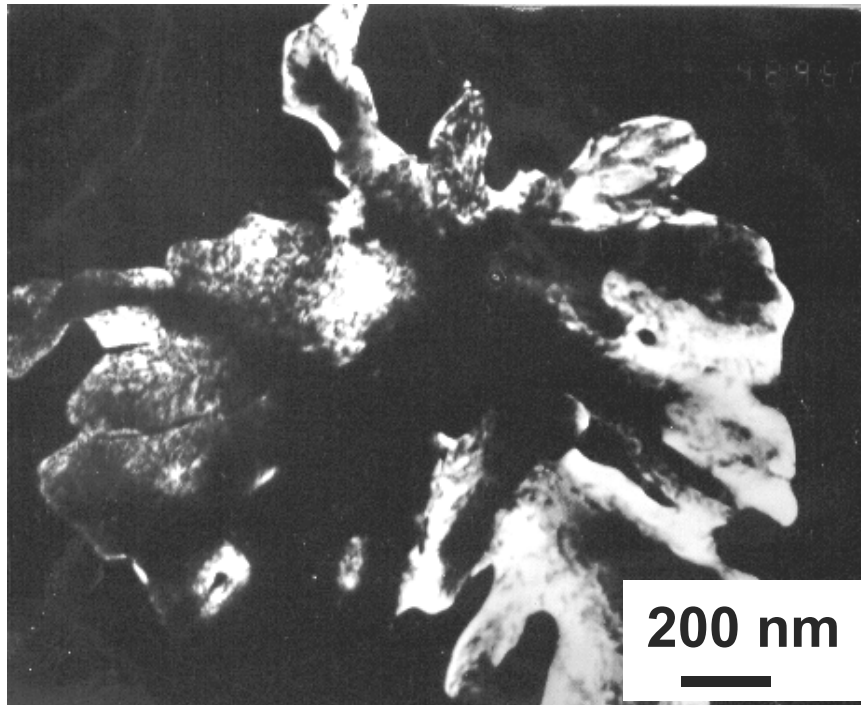
Production of melt-spun ribbons



Change of hardness of **PM extruded rods** after isochronous annealing at various temperatures, holding time of 100 h



Structure, dark field image (a)
and electron diffraction pattern of 5-fold symmetry (b)
of an i-phase particle in ribbon $\text{Al}_{84.2}\text{Fe}_7\text{Cr}_{6.3}\text{Ti}_{2.5}$



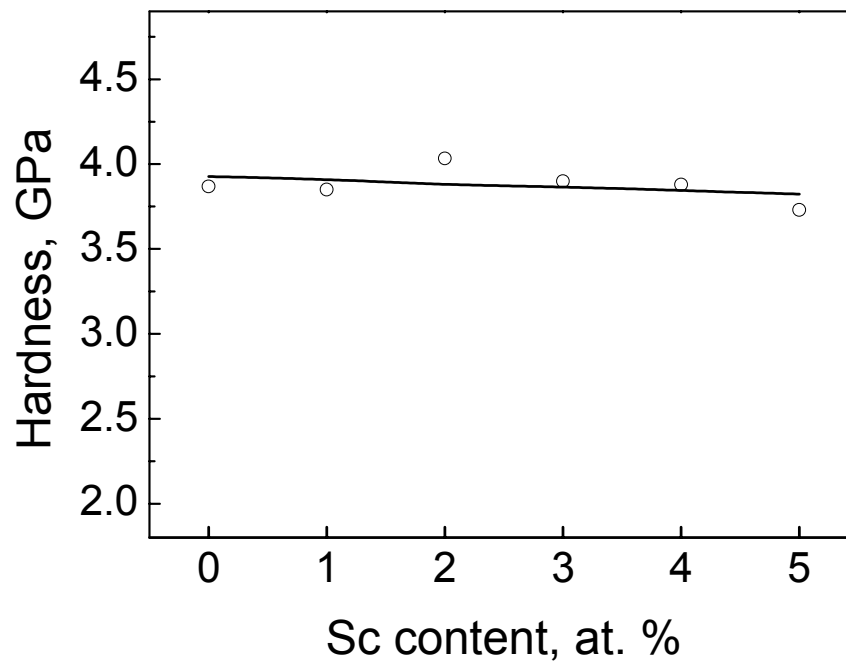
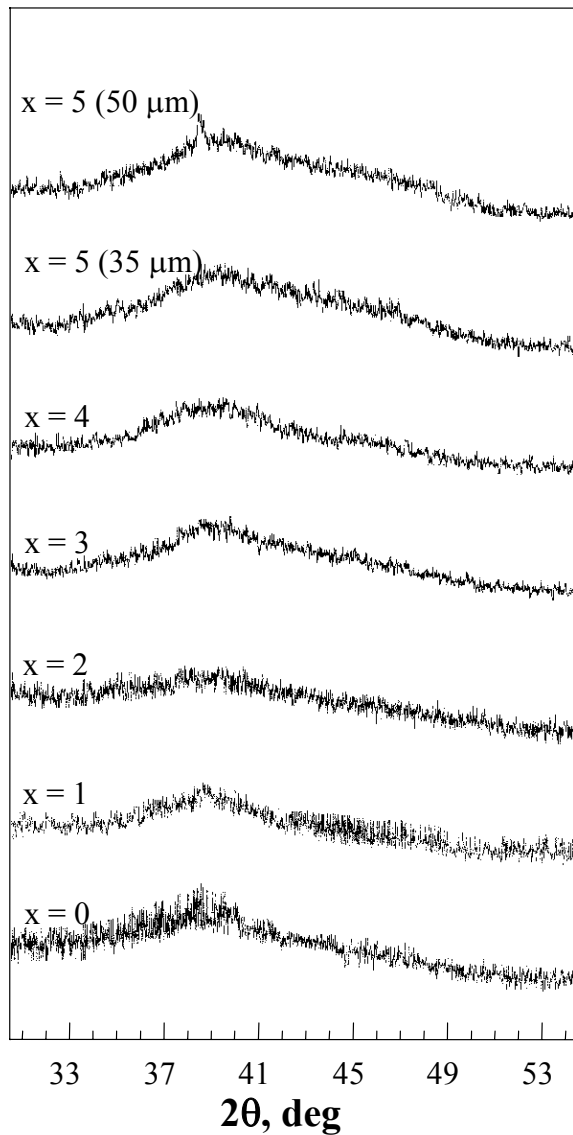
a



b

Alloys $\text{Al}_{85}\text{Ni}_{10}\text{Ce}_{5-x}\text{Sc}_x$

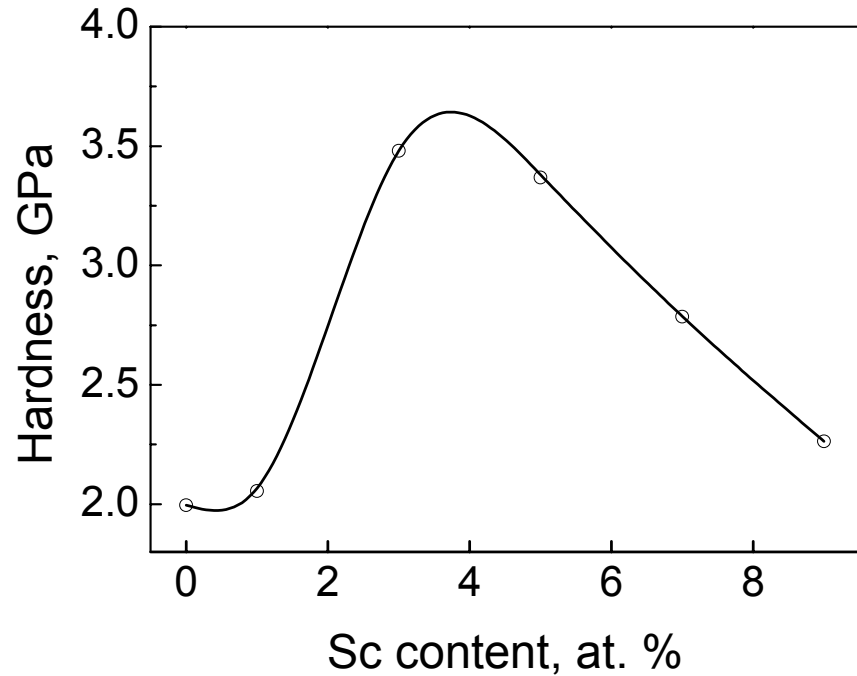
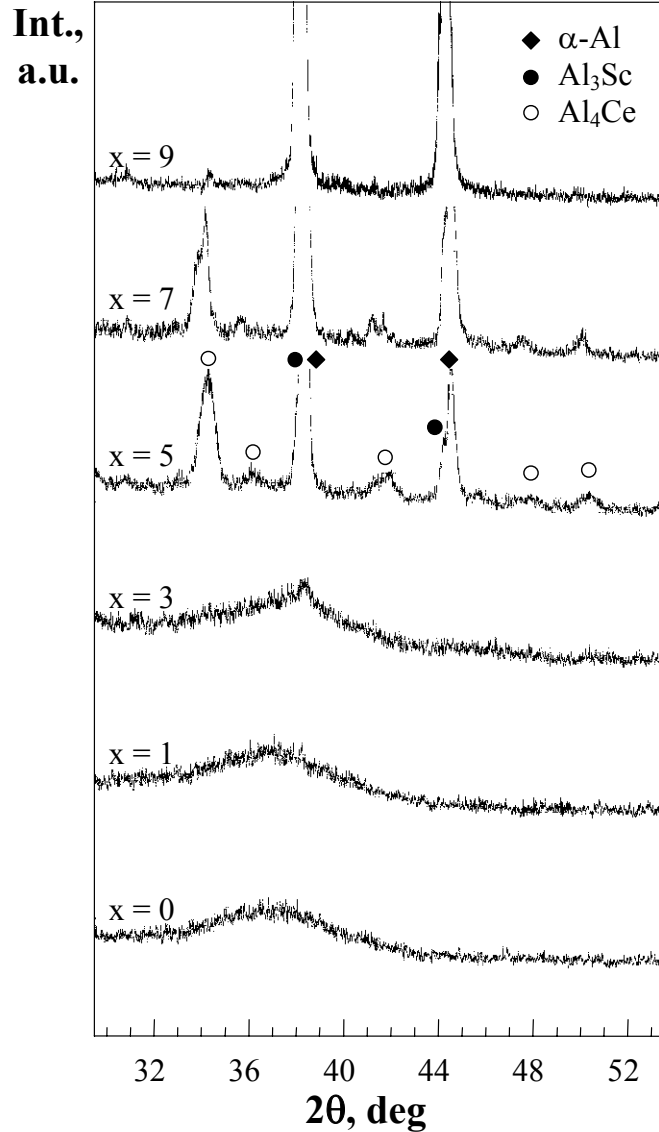
Int.,
a.u.



Hardness of melt-spun
 $\text{Al}_{85}\text{Ni}_{10}\text{Ce}_{5-x}\text{Sc}_x$ ribbons of about
 $35\ \mu\text{m}$ in thickness

X-ray diffraction patterns of rapidly solidified $\text{Al}_{85}\text{Ni}_{10}\text{Ce}_{5-x}\text{Sc}_x$ alloys.
The thickness of ribbons with $x=0\div 4$ was of about $35\ \mu\text{m}$

System Al - Ce - Sc



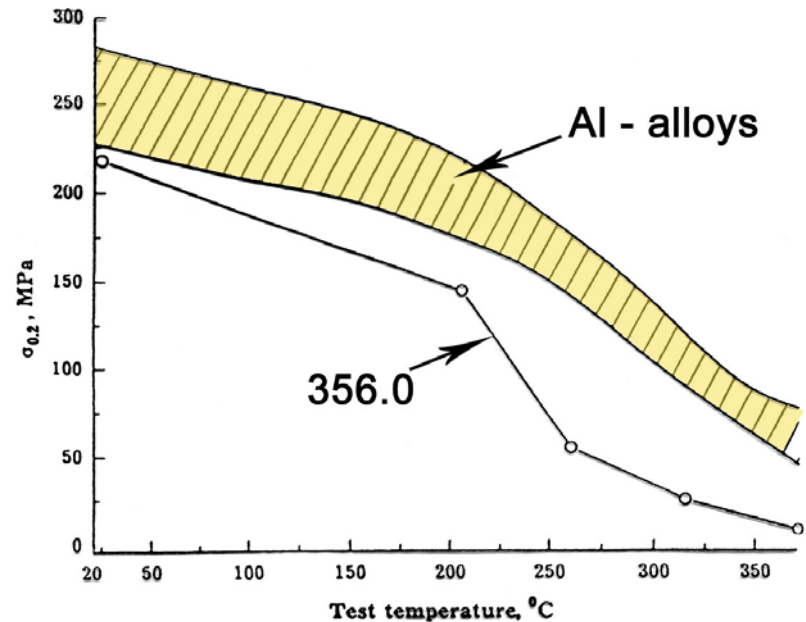
**Hardness of rapidly solidified
 $\text{Al}_{91}\text{Ce}_{9-x}\text{Sc}_x$ alloys ($P = 0.5 \text{ N}$)**

**X-ray diffraction patterns of rapidly
solidified $\text{Al}_{91}\text{Ce}_{9-x}\text{Sc}_x$ alloys**

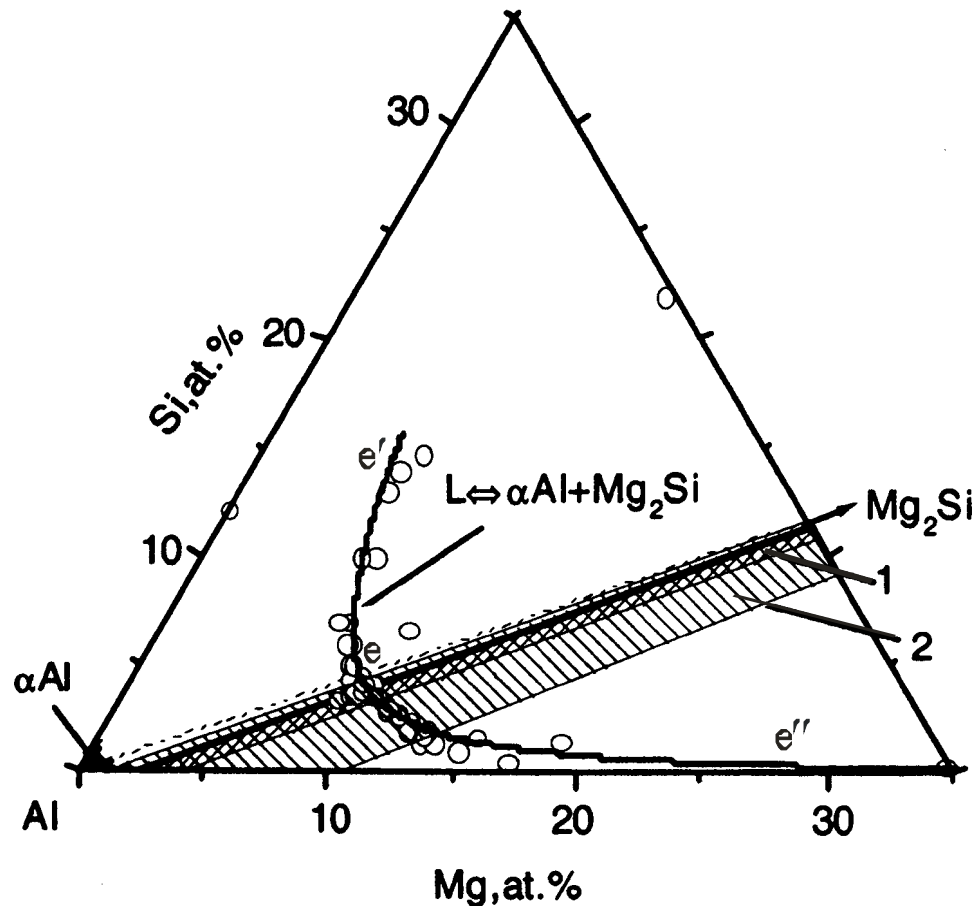
New High-Temperature Scandium-Containing Cast Aluminum Alloys of Eutectic Type



Microstructure of the cast eutectic alloy



Temperature dependence of yield stress of the developed alloy (cross hatched region) and prototype alloy 356.0



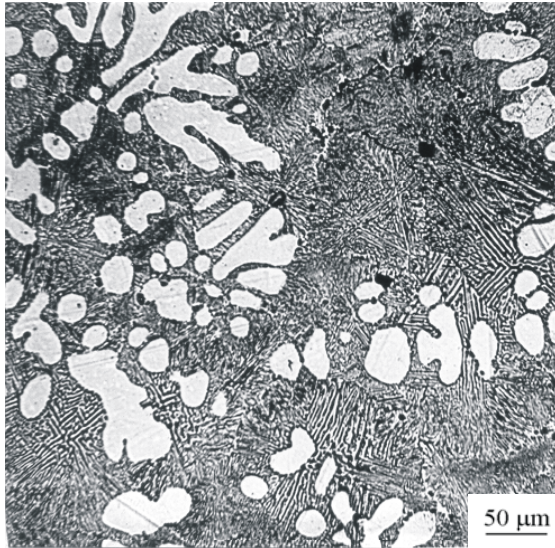
Fragment of the phase diagram of the **Al - Mg - Si** system:

experimental line $e'e''$ of the monovariant eutectic transformations $L \leftrightarrow \alpha\text{-Al} + \text{Mg}_2\text{Si}$ (solid line). Thick straight line represents the quasi-binary section and dash line represents the stoichiometric section.

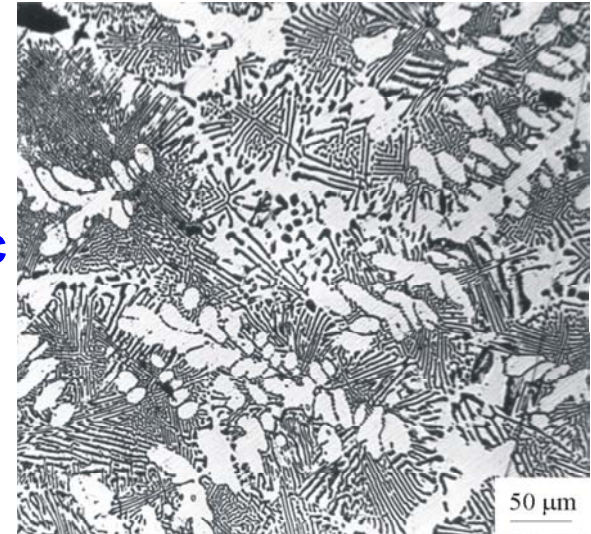
1 is the area of $\alpha\text{-Al} + \text{Mg}_2\text{Si}$ binary after annealing alloys,
and 2 is the area of $\alpha\text{-Al} + \text{Mg}_2\text{Si}$ binary at crystallization alloys

The influence of **Sc** and **Zr** additions on the structure of eutectic **Al – Si – Mg** alloys

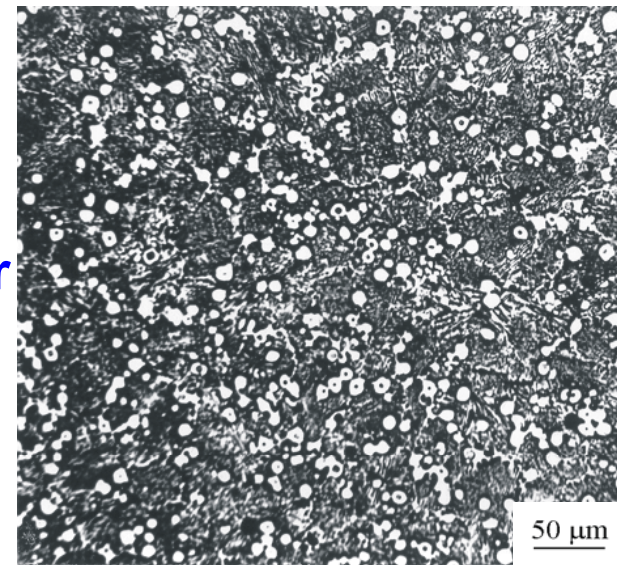
Al-Si-Mg



Al-Si-Mg + Sc



Al-Si-Mg + Sc, Zr



Mechanical properties of new **cast eutectic aluminum alloys**

Alloys for operation up to 150°C

Alloy	Tensile properties			Hardness HV (MPa)	Heat treatment
	σ_{ys} (MPa)	UTS (MPa)	δ (%)		
Al - Mg – Si without alloying	210	320-370	3-5	971-1037	aging
Al - Mg - Si with complex alloying	300-430	370-530	0.5-1.5	1100-1500	quenching + aging
Al - Ge – Mg with complex alloying	490-620	540-660	1-2	1460-1860	quenching + aging

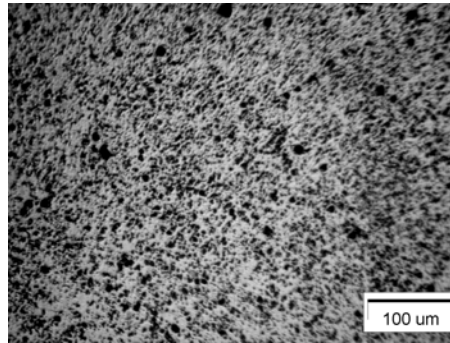
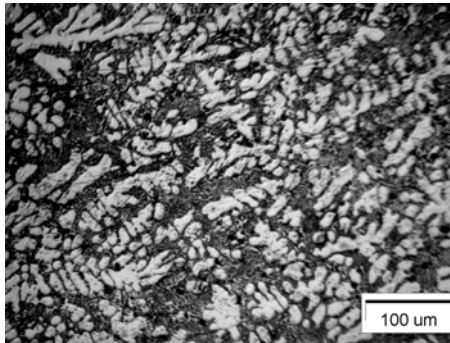
Alloys for high-temperature application

Alloy and Prototype	Tensile properties		Tensile properties			ΔT_c ($^{\circ}C$)	Heat treat-ment
	Time at temperature (h)	At indicated temperature ($^{\circ}C$)	σ_{ys} (MPa)	UTS (MPa)	δ (%)		
Al - Mg - Si (with complex alloying + dispersion particles Al_3Sc)							
ASM1	100	260	146-164	180-203	5-10	595-	aging
ASM2	100	315	91-115	102-130	13-15	599	
354.0	100	260	65	80	35	-	T61
	100	315	35	40	85		
356.0	10000	260	35	53	35	555-	T61
	10000	315	21	28	60	615	

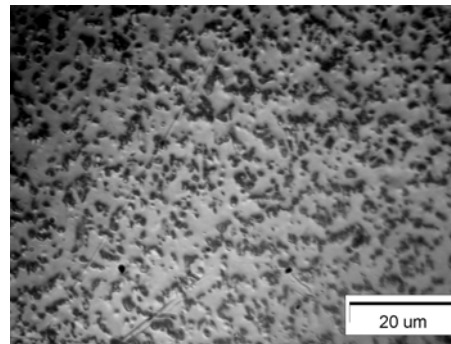
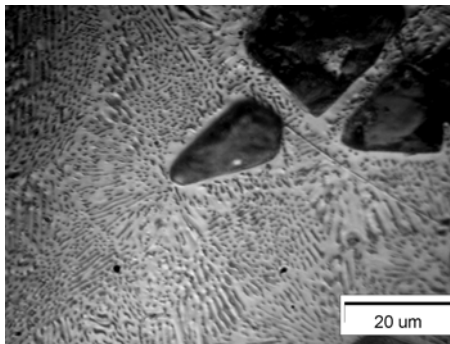
THE STRUCTURE AND MECHANICAL PROPERTIES OF CAST ALUMINUM ALLOYS BY FRICTION STIR PROCESS (FSP)

before FSP

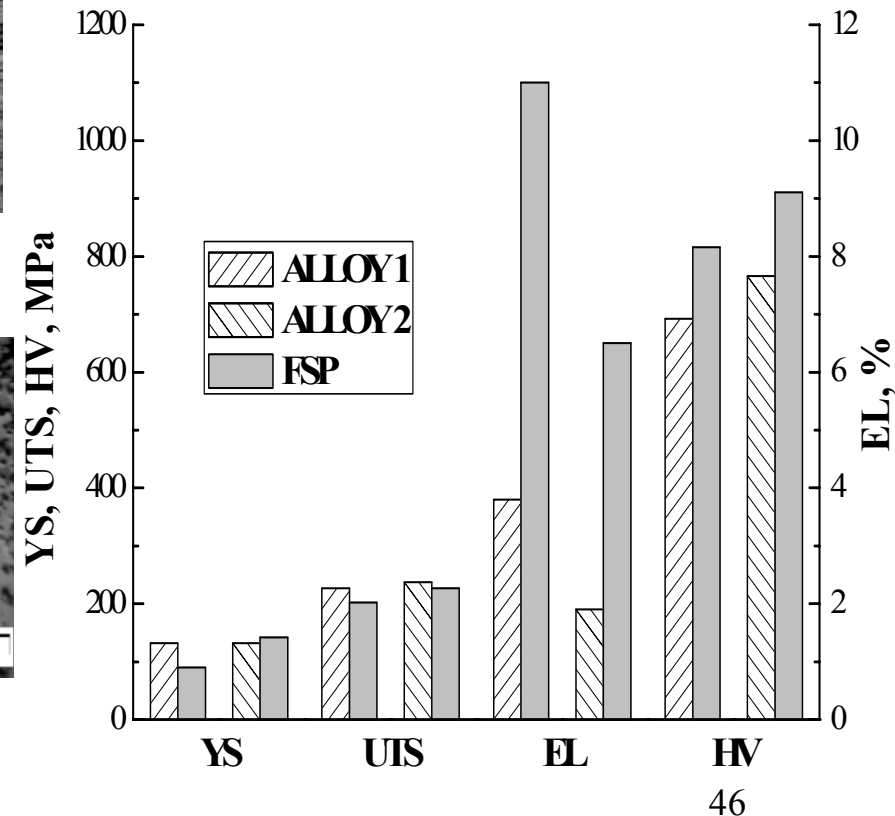
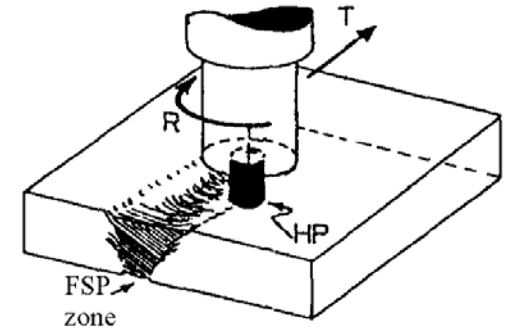
after FSP



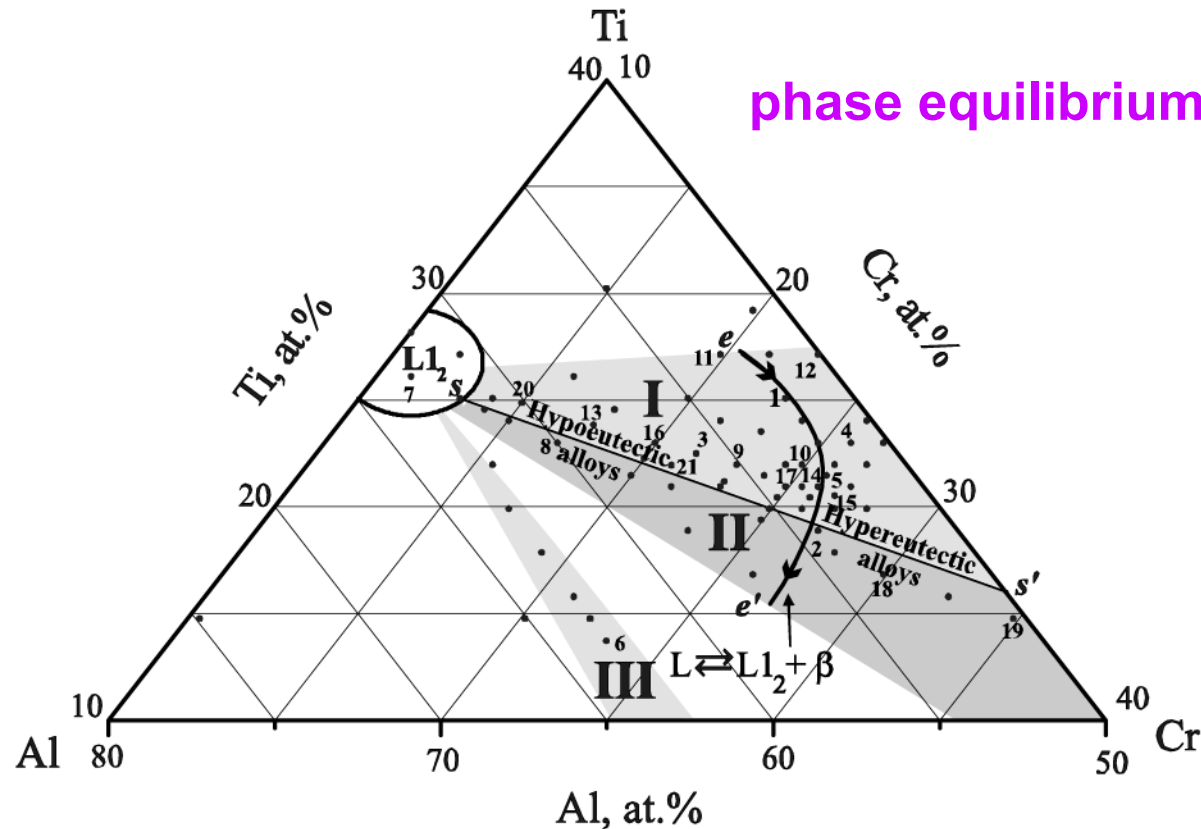
hypoeutectec alloy 1



hypereutectec alloy 2



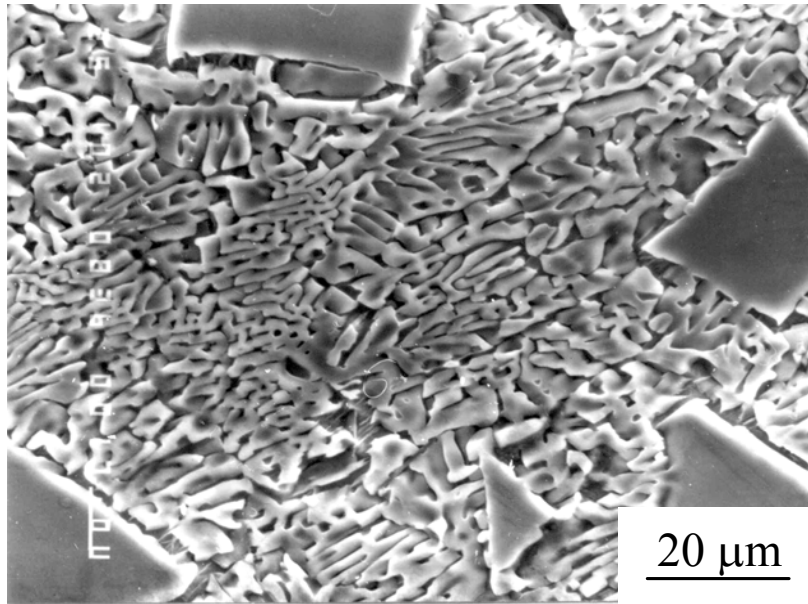
Development of elevated temperature eutectic cast alloys on the base of intermetallic phases



Portion of the liquidus surface at the Al-rich corner of phase diagram **Al-Ti-Cr** system

In the ternary **Al - Ti - Cr** system experimentally a large compositional region has been established, in which the eutectic transformation of a melt into two solid phases is realized: $L \leftrightarrow L_2 + \beta$. This transformation is univariant and occurs in a narrow temperature interval from 1275 °C to 1250 °C, and the temperature interval of this transformation does not exceed 10 °C.

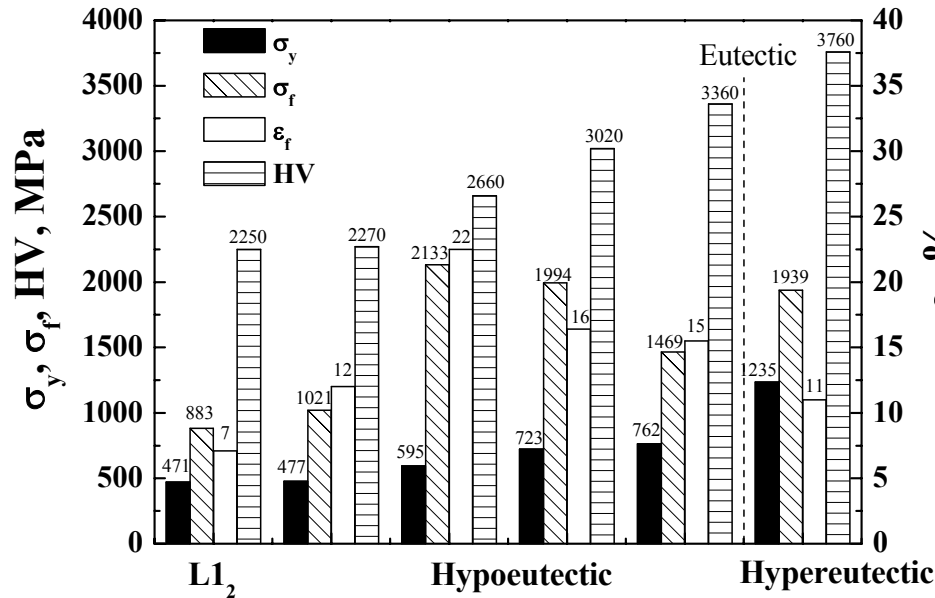
Development of elevated temperature **eutectic cast alloys** on the base of intermetallic phases



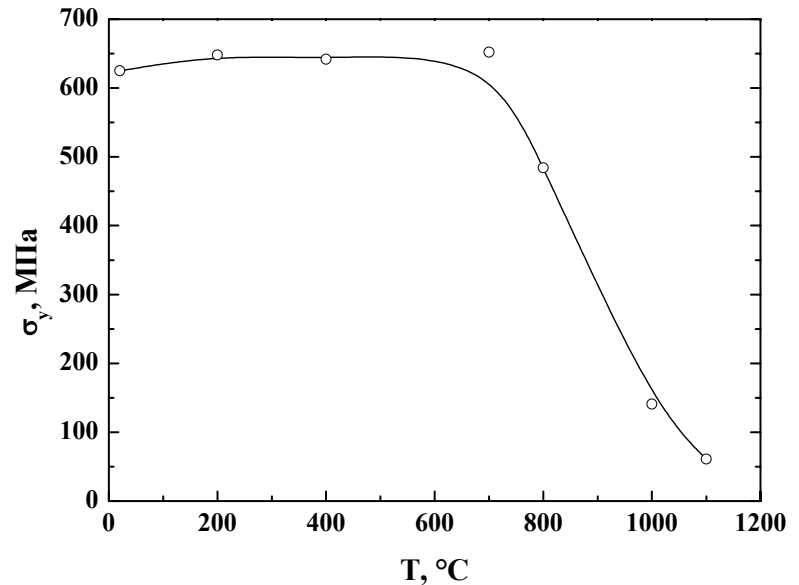
**microstructure of
hypoeutectic (L₁₂ + β) alloy**

The periodic structure of eutectic (L₁₂ + β) alloys is formed by alternate lamellae and/or fibers of two phases: L₁₂ and β. Primary dendrites of these phases have different forms: in hypoeutectic alloys, primary dendrites of the phase L₁₂ are crystallized in the faceted form, but dendrites of the β-phase are unfaceted in hypereutectic alloys

Development of elevated temperature **eutectic cast alloys** on the base of intermetallic phases



Mechanical properties in compression tests and hardness of as-cast alloys



Temperature dependence of yield stress

Alloys containing two cubic phases $L1_2$ and β have high mechanical properties, exceeding that of single-phase $L1_2$ alloys: Young's modulus up to **190 GPa**; hardness up to **3000 MPa** in the temperature interval of 20-800 °C; compressive and bending strength up to **2000 MPa** and **600 MPa**, respectively; deformation before fracture ϵ^c up to **22%**