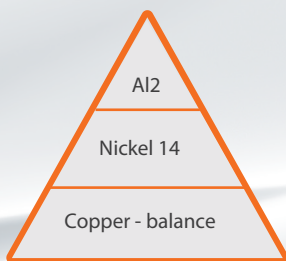
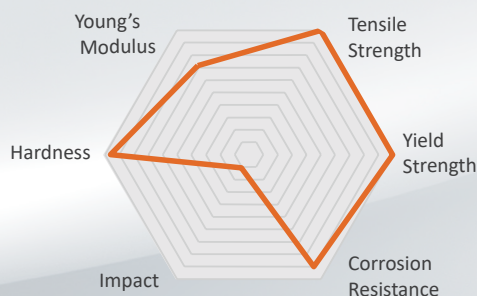


CAL T-1000

Composition %



Combination of Properties



THE BENEFITS OF CAL T-1000

- > Extreme mechanical strength
- > High hardness
- > Outstanding resistance to sea water corrosion both general and pitting corrosion
- > Lack of selective phase attack
- > Immune to hydrogen embrittlement and stress corrosion cracking in sea water
- > High resistance to impingement/erosion/cavitation/pitting in sea water
- > Good resistance to stress corrosion cracking in hydrogen sulphide conditions
- > Low relative magnetic permeability
- > Anti-bio-fouling (lack of marine growth)
- > Anti-galling against stainless steel
- > No loss of properties at cryogenic temperatures
- > High modulus of elasticity compared with other copper-based alloys
- > Low relative magnetic permeability - virtually non magnetic
- > Easily machined to a high surface finish and dimensionally stable
- > Non-sparking
- > Uniform fine grain structure permits volumetric inspection using ultrasonic techniques
- > Cost-effective

PHYSICAL PROPERTIES

Extreme Strength Copper-Nickel-Aluminium Alloy CAL T-1000
CuNi14Al2

Table 1 - Physical Properties

Properties	Metric	Imperial
Melting point	1,070-1,120°C	1,958-2,048°F
Density	8,500 kg/m ³	0.3070 lbs/in ³
Specific Heat	0.416 J/(g.K)	0.0993 Btu/(lb.°F)
Thermal Conductivity @ 20°C	45 W/(m.K)	26 Btu ft/hr/ft ²
Electrical Conductivity %ACS at 20°C	11	11
Electrical Resistivity at 20°C	0.17 μ.Ω.m	6.7 μ.Ω.in
Magnetic Permeability (μr)	< 1.01	< 1.01
Coefficient of linear expansion (20-100°C)	16.0 x 10 ⁻⁶ /°C	8.89 x 10 ⁻⁶ /°F
Coefficient of linear expansion (20-200°C)	12.0 x 10 ⁻⁶ /°C	6.67 x 10 ⁻⁶ /°F
Coefficient of static friction against mild steel	0.22	0.22
Young's Modulus, Modulus of Elasticity	143,000 N/mm ²	20,740 ksi
Compressive Strength σdB	2,350 N/mm ²	340.8 ksi
Poisson's Ratio	0.33	0.33
Torsional Modulus 25mm dia. bar	53 x 10 ³ N/mm ²	7,687 ksi
Fatigue reversed bending σbw 20 x 106	190 N/mm ²	27.56 ksi

Additional information can be provided upon request.

ALLOYS

CAL T-1000



Extreme strength wrought Cupro Nickel alloy CuNi14Al2 (compliant with generic alloy DIN 2.1504).

Highest strength and hardness within the suite of Elite Marine Alloys, with tensile strengths over 1000MPa possible.

BACKGROUND

T-1000E is amongst the strongest copper based alloys available anywhere.

This extremely high strength wrought cupro nickel is used in a variety of marine applications including the oil and gas and defence sector, for its outstanding corrosion resistance combined with extreme strength and hardness. This material is also highly resistant to wear, has a low magnetic permeability, resists galling against stainless steel and does not suffer from marine growth (bio-fouling) or hydrogen embrittlement.

The main strengthening mechanism involves the precipitation of an extremely fine nickel-aluminium Ni3Al phase. Our deep metallurgical understanding of this mechanism and our advanced manufacturing techniques enable us to induce industry-leading properties unavailable anywhere else.

This material is available in two strength versions. T-1000S (Table 3 standard material) and T-1000E (Table 4 enhanced version). The enhanced version T-1000E is only available in bars (square/flat/round/shapes) to around 70mm ø.

COMPOSITION

Our team of experienced metallurgists exercise precise control over alloy composition and using our advanced melting and casting techniques, produce high quality ingots and slabs for converting into an extensive variety of wrought products.

Our highly calibrated laboratory ensures we are consistently fully compliant with material composition requirements. Traceability from source to customer guaranteed.

Table 2 - Composition requirements weight %

CAL T-1000 (Extreme Strength Copper-Nickel-Aluminium Alloy)							
Cu	Ni	Al	Fe	Mn	Zn	Si	Total Others
Remainder	13.0 - 16.0	2.0 - 3.0	1.5 max	1.0 max	0.3 max	0.1 max	0.5 max

Related Specifications

DIN WL 2.1504

ASNA 6127A

NFL 14-702

UN14A2

GAM MM11 CuNi14Al3

FORMS AVAILABLE

Copper Alloys Ltd can provide the largest ingots and heaviest-section forged products available anywhere due to industry-leading process technology that ensures a large total forging reduction and a uniform fine-grain wrought structure in the finished product.

Our capacity continues to evolve and widen as we service ever increasing customer demands

- Bars (square / flat / round) from 10mm to 500mm (0.375"-20") in section
- Forgings (to 25,000Kgs): Blocks / Rings to 2400mm (8ft) outer ø / Shafts to 7000mm (23ft) long / Discs to 1270mm (50") ø
- Proof machined or finished components built to print

INSPECTION AND CERTIFICATION

Full chemical analysis performed on every cast to ensure compliance with Table 2. Each batch (same size / same cast / same process-run) is mechanically tested to ensure compliance with minimum mechanical property requirements in Tables 3 and 4, which exceed the generic specification requirements. 100% ultrasonic inspection can be applied - most test standards and acceptance criteria can be accommodated.

Certification provided as standard in both wet-signed and electronic form (soft-copy) in accordance with EN 10204 type 3.1 (3.2 Certification can also be provided).

APPLICATIONS

Marine applications requiring extreme strength and high hardness coupled with excellent marine corrosion resistance combined with low magnetic permeability and anti-galling properties against stainless steel. Valve and pump bodies including internal components (stems / shafts / balls / seals). Actuators, pressure housings, clamps and fasteners, bushings, bearings and sonar equipment. The materials ability to resist bio-fouling (lack of marine growth) is another important feature of this alloy.

Aerospace components such as landing gear bushings, sleeves and highly stressed aero frame parts, refuelling connectors, noting its non-sparking properties.

Maximum service temperature ~ 250°C / 482°F (long term) ~ 280°C / 536°F (short term exposure); above these temperatures the material weakens and becomes less ductile.

CAL T-1000

ELITE ALLOYS

CAL T-1000

MECHANICAL PROPERTIES T-1000S (STANDARD)

CAL T-1000S Standard Version
 Extreme Strength Copper-Nickel-Aluminium Alloy
 CuNi14Al2
 Exceeds the requirements of DIN 2.1504

Table 3 - Guaranteed Minimum Mechanical Properties

Product	Bars - round, square, flats, hexagon, shapes Forgings - discs, blocks, shafts, rings, tubes			
	Material section-size (minor dimension)			
Property	Below 25mm	25mm to 50mm	50mm to 80mm	Over 80mm
Ultimate Tensile Strength Rm MPa	900 (131Ksi)	880 (128Ksi)	850 (123Ksi)	820 (119Ksi)
0.2% Proof Stress Rp0.2 MPa	750 (109Ksi)	720 (104Ksi)	700 (102Ksi)	600 (87Ksi)
% Elongation after Fracture 5.65 √ So %	10	10	10	10
Hardness Brinell HB 10/3000	260	255	255	240
*Typical Impact J	*10-16 (7-12ft lbf)	*10-16 (7-12ft lbf)	*10-16 (7-12ft lbf)	*10-16 (7-12ft lbf)

MECHANICAL PROPERTIES T-1000E (ENHANCED)

CAL T-1000E Enhanced Version
 Extreme Strength Copper-Nickel-Aluminium Alloy
 CuNi14Al2
 Exceeds the requirements of DIN 2.1504

Table 4 - Guaranteed Minimum Mechanical Properties

Product	Bars - round, square, flats, hexagon, shapes Forgings - discs, blocks, shafts, rings, tubes	
	Material section-size (minor dimension)	
Property	Below 40mm	Over 40mm to 70mm
Ultimate Tensile Strength Rm MPa	1000 (145Ksi)	940 (136Ksi)
0.2% Proof Stress Rp0.2 MPa	940 (136Ksi)	920 (133Ksi)
% Elongation after Fracture 5.65 √ So %	7	5
Hardness Brinell HB 10/3000	280	270
*Typical Impact J	* 5-15 (4-11ft lbf)	* 5-15 (4-11ft lbf)

* For reference only - does not form part of the acceptance criteria unless agreed.

CORROSION DATA

A tenacious oxide film at the surface, which progressively thickens over time offering increased protection, makes this material highly resistant to attack in atmospheric and sea water environments, including polluted and brackish water.

The material is highly resistant to pitting and crevice corrosion which is common in multi-phase alloys and stainless steels. High inherent bio-fouling resistance to attachment by micro/macroulous (e.g. seagrasses and molluscs) living in the sea water, which cause accelerated corrosion and reduced functionality.

ALLOYS



CAL T-1000



Table 6 - Comparison of Corrosion Resistance Between Marine Alloys

Material	CAL Elite Marine Alloys				Other commonly used Marine-Alloys (also offered by CAL)							
	Extreme Strength Cupro Nickel	High Strength Copper-Nickel-Manganese-Aluminium Alloy	Wrought Copper-Nickel-Chrome (CNC) Alloy	Wrought Nickel Aluminium Bronze (NAB)	Cast Nickel Aluminium Bronze (NAB)	70/30 Cupro Nickel	90/10 Cupro Nickel	Naval Brass	Nickel-Copper Alloy	Nickel-Copper-Aluminium-Titanium Alloy	Stainless Steel	Stainless Steel
Base composition	CuNi14Al2	CuNi15Mn4Al1Fe	CuNi30Cr1MnFeSiZrTi	CuAl9Ni5Fe4	CuAl9Ni5Fe4	CuNi30Mn1Fe	CuNi10Fe1Mn	CuZn37Sn1	NiCu30Fe2Mn1	NiCu30Al-3Fe1MnTi	FeCr18Ni-12Mo2	FeCr18Ni9
Specification Property	CAL T-1000 (DIN 2.1504)	CAL T-850 (Def Stan 02-835)	CAL CNC-1 / CNC-2 (Def Stan 02-886 / Def Stan 02-824)	Def Stan 02-833 NES 833 DGS 1043 CW307G	Def Stan 02-747 NES 747 CC333G	Def Stan 02-780 NES 780 CN107 / C71500 CW354H	Def Stan (NES) 779 / CN102 / C70600 / CW352H	CZ112 / CW712R / C46400	NA13 / UNS N04400	NA18 / UNS N05500	316 Stainless	304 Stainless
General corrosion rate per year	0.02mm / 0.0008"	0.025mm / 0.001"	0.02mm / 0.0008"	0.025-0.05mm / 0.001-0.002"	0.07mm / 0.002"	0.03mm / 0.001"	0.03mm / 0.001"	0.05mm / 0.002" (4 x at 60°C)	0.03mm / 0.001"	0.03mm / 0.001"	0.07mm / 0.003"	0.025mm / 0.001"
Crevice corrosion rate per year	<0.02mm / 0.0008"	<0.025mm / 0.001"	<0.02mm / 0.0008"	0.5mm / 0.02"	0.5mm / 0.02"	0.025-0.13mm / 0.001-0.005"	0.025-0.13mm / 0.001-0.005"	0.15mm / 0.006"	0.5mm / 0.020"	0.05mm / 0.002"	0.5mm / 0.02"	0.25mm / 0.010"
Selective Phase Corrosion per year	None	None	None	0.5-1.0mm / 0.02-0.04"	1.1mm (0.04") typical 1.4mm (0.055") observed	None	None	0.15mm / 0.006"	None	None	1.1mm (0.04") typical 1.4mm (0.055") observed	None
Impingement resistance limit m/second	3.7m/s (1.2ft/sec)	3.7m/s (1.2ft/sec)	6-8m/s (20-26ft/sec)	4.3m/s (1.4ft/sec)	4.3m/s (1.4ft/sec)	4.6m/s (1.5ft/sec)	3.7m/s (1.2ft/sec)	3.05m/s (10ft/sec)	>9.1m/s (>30ft/sec)	>9.1m/s (>30ft/sec)	4.3m/s (1.4ft/sec)	>9.1m/s (>30ft/sec)
Corrosion Potential in Seawater V_{sce}	-0.18	-0.19	-0.18	-0.19	-0.19	-0.18	-0.20	-0.24	-0.12	-0.12	-0.19	-0.08
Marine bio-fouling resistance	Highly resistant	Highly resistant	Highly resistant	Partially resistant	Partially resistant	Resistant	Highly resistant	Partially resistant	Not resistant	Not resistant	Not resistant	Not resistant

