Stainless Steel 303 Figures and Tables

- 83 References
- 96 Tables and Figures
- 12 pages Text

Listings of all the Tables and Figures in Stainless 303 Chapter

Table 1.3.1 Applicable specifications for 303 and 303Se stainless steels (Refs. 1, 2)

Table 1.4.1.1 AMS specified chemical compositions of various grades of 303 (Refs. 3-6)

Table 1.4.1.2 AMS specified chemical compositions of various grades of 303Se (Refs. 3, 4, 7)

Table 1.4.2.1 ASTM specified chemical compositions of various grades of wrought free-machining austenitic stainless steels including 303 and 303Se (Refs. 8-10)

Table 1.4.2.2 ASTM specified tolerances over the maximum or under the minimum limits of the chemical requirements for free machining austenitic stainless steels (Ref. 12)

Table 1.4.2.3 ASTM specified chemical compositions of CF-16F and CF-16Fa free machining austenitic stainless steel castings (Ref. 13)

Table 1.4.3.1 AISI 303Cu and similar commercial specified compositions (Refs. 14-18)

Table 1.4.3.2 Typical commercial high pressure water atomized compositions of 303 type stainless steel powders used in free machining powder metallurgy applications and the MPIF standard for 303L (Refs. 19-21)

Table 1.4.3.3 Oxygen, nitrogen, carbon, and sulfur analyses of sintered 303 and 304 type stainless steels produced from commercially available water atomized powders (nominal particle size of -100 mesh or <149 µm) that were compacted, delubricated in dissociated ammonia at 1022F for 20 minutes, and sintered in dry hydrogen at 2400F for 30 minutes (Ref. 19)

Table 1.5.1 Recommended annealing or solution treatments for wrought 303 and 303Se products (Refs. 1, 23-25)

Figure 1.5.2 Precipitation rates for $M_{23}C_6$ as a function of carbon content in 18-8 austenitic stainless steels (Ref. 25)

Figure 1.5.3 Stringer type MnS inclusions in sulfurized 303 type stainless steel (top) and mixed MnS and MnSe₂ inclusions in 303Se (0.21 % Se) type stainless steel (bottom), all as-polished (Ref. 26)

Figure 1.5.4 Typical as polished microstructure of 303 stainless steel plate showing elongated stringers of MnS inclusions (Ref. 30)

Figure 1.5.5 Optical micrographs in undeformed and deformed regions of SUSS303 stainless steel (18Cr-8Ni-0.2S) rectangular samples in the undeformed (annealed) condition, deformed in compression to ~6% strain, and heated for 1 h at 500, 650, and 800C (see Figures 1.5.6 and 1.6.1) with slip (shear) bands prevelant in the deformed steel indicative of strain induced α -Fe formation and stages of recrystallization, with 97% recovery to γ -Fe at 800C with small grain size of 1.86 µm (samples ground, polished, and etched for 30 sec in 5 g FeCl₃, 50 ml HCl, and 100 ml H₂O) (Ref. 31)

Figure 1.5.6 EBSD (Electron Backscatter Diffraction Analysis) of undeformed (annealed), deformed, and deformed and heated (800C/1h) samples of SUS303 stainless steel (18Cr-8Ni-0.2S) presented in optical micrographs in Figure 1.5.5 (also see Figure 1.6.1), showing the image quality map, crystal orientation map, and phase map (samples ground, polished, and etched for 30 sec in 5 g FeCl₃, 50 ml HCl, and 100 ml H₂O) (Ref. 31)

Figure 1.5.7 Optical microstructure of sintered 303L (compacted specimens delubricated in dissociated ammonia at 1022F for 20 min and sintering done in dry 100% hydrogen at 2400F for 20 min) showing porosity and sulfide precipitates present as fine globules (Glyceregia etch – 15 ml glycerol, 10 ml HCl, and 5 ml HNO₃) (Ref. 19)

Figure 1.5.8 Optical micrographs of conventional plate (top – a) and rapidly solidified/canned/vacuum degassed/consolidated/hot extruded AISI 303 SS bar (bottom – b) showing elongated MnS precipitates in the conventional 303 plate and fine MnS precipitates uniformly dispersed in the PM alloy, showing wrought alloy containing large precipitates (5-10 μ m in diameter) with grains typically 10-20 μ m in size, while powder metallurgy alloy has a duplex grain structure (see Figure 1.5.9) and significantly finer precipitates (light etch with a mixture of HCI:HNO₃:CH₃COOH in a volumetric ratio of 3:2:2) (Ref. 32)

Figure 1.5.9 Transmission electron microscopy bright field image of rapidly solidified/consolidated/hot extruded AISI 303 SS bar (longitudinal view) showing duplex grain structure comprising large grains of 5-10 μ m in size surrounded by smaller grains of 1 μ m in size with fine precipitates of 0.2-0.5 μ m in size uniformly distributed in the matrix (Ref. 32)

Table 1.5.10 Chemical compositions (mass %), rod diameters (mm), and volumetric sulfide contents (dA₁) of various 303 steels (average atomic formula of sulfides determined by EDX – $Mn_{0.88}Cr_{0.11}Fe_{0.07}S_{0.93}$) (Ref. 33)

Figure 1.5.11 Resulphurized austenitic SAE303 stainless steel hot rolled bar (50 mm diameter) treated with calcium (a) and without the calcium treatment (b) showing the effect of calcium treatment on reducing the size of sulphide inclusions in the matrix (Ref. 34)

Figure 1.5.12 Optical microstructure (oxalic acid etch, 100x) of as-cast CF-16F alloy bar (1 in. diameter) with a structure consisting of selenide particles (black), precipitated carbide particles, and fine ferrite islands in an austenite matrix (a), the same alloy bar but solution treated (annealed) at 2050F and water quenched showing that the precipitated carbide particles have dissolved and ferrite islands have re-formed while selenide particles were relatively unaffected by the solution treatment (b), and optical microstructure (electrolytic 10 N KOH, 500x) of the bar shown in (b) at higher magnification (Ref. 27)

Figure 1.6.1 Microhardness results from solution annealed SUS303 (18 Cr-8Ni-0.2S) stainless sample with 0.2% yield strength = 205 MPa (29.7 ksi), ultimate tensile strength = 520 MPa (75.4 ksi), and elongation = 40%, machined into rectangular blocks of $10 \times 10 \times 5$ mm, after severe local plastic deformation introduced by compression of a hardened (700 HV) carbon steel wire (1.0 mm diameter) at a compressive force of 10 kN and subsequent heating to temperatures indicated for one hour (see Figures 1.5.5 and 1.5.6): (a) – no heating, (b) – 500C (930F), (c) – 650C (1202F), (d) – 800C (1472F) (Ref. 31)

Figure 2.1.2.1 Schaeffler-Delong phase constitution diagram for stainless steels designed to show what phases are present in the as-solidified condition, thus applying to castings, continuously cast products, and weldments (Ref. 25)

Table 2.1.3.1 Thermal conductivity of various types of free machining 303-type stainless steels (Refs. 17, 23, 29)

Figure 2.1.3.2 Thermal conductivity of 303 and 303Se stainless steels compiled from various sources (Refs. 75, 76, 77, 78)

Table 2.1.3.3 Temperature dependence of thermal conductivity of 303 stainless steel (Ref. 40)

Table 2.1.4.1 Mean coefficient of thermal expansion of various types of free machining 303-type stainless steels (Refs. 23, 29, 35, 40)

Table 2.2.2.1 Temperature dependence of electrical resistivity of 303 stainless steel (Ref. 40)

Figure 2.2.3.1 Change in the relative permeability of 303, 304, and 305 austenitic stainless steel in relation to grade and different levels of strain hardening (Ref. 46)

Figure 2.2.4.1 Change in total hemispherical normal emissivity from measurements of relative flux intensities at various angles of incidence over the temperature range of a AISI 303 stainless steel test specimen heated in quiescent air (Ref. 47)

Table 2.2.4.2 Emissivity of 303 and other stainless steels as a function of surface condition (Ref. 48)

Figure 2.3.1.1 Optical micrographs of the surface (top) and of the cross section (bottom) of a 1 mm thick disc sample of a conventional wrought AISI 303 alloy after a 72 h immersion in a 1% FeCl₃ solution at room temperature demonstrating the pitting corrosion at sulfide inclusion sites (Ref. 32)

Figure 2.3.1.2 Potential-time plots for conventional wrought and rapidly solidified/hot extruded powder metallurgy (see Figure 1.5.8) AISI 303 alloy electrodes immersed in 1% FeCl₃ solution for 72 h, showing that the rapidly solidified alloy is significantly more noble in regard to pitting corrosion in this medium than the conventional alloy (Ref. 32)

Figure 2.3.1.3 Potentiodynamic polarization curves conducted at a scan rate of 0.1 mV/sec for conventional wrought AISI 303 and 304 stainless steels (303W and 304W) and rapidly solidified and consolidated AISI 303 stainless steel (303RS) in a 1 N H₂SO₄ deaerated solution, demonstrating the corrosion current of the wrought AISI 304 alloy from Tafel extrapolation was 50 μ A/cm² corresponding to a corrosion penetration rate of 0.6 mm/y, while the corrosion penetration rates for the rapidly solidified powder metallurgy 303 and wrought 303 alloy were, respectively, 0.1 and 36.0 mm/y (Ref. 32)

Figure 2.3.1.4 Passivation of a 303 stainless steel panel in a 50 vol. % HNO₃ aqueous solution for 60 min dissolved the MnS inclusions (see Figure 1.5.4) and left many pits behind, while micron-sized elemental sulfur particles, identified by EDXS (b), were redeposited back on the surface in the vicinity of these pits (a); precision cleaning that followed the nitric acid passivation (see Figure 2.3.1.5) could not remove these particles (Ref. 30)

Figure 2.3.1.5 Sulfur particles indicated by arrows redeposited during passivation of a 303 stainless steel panel in a 50 vol. % HNO₃ aqueous solution for 60 min (see Figure 2.3.1.4) did not significantly dissolve as a result of the subsequent hot DI water rinse (Ref. 30)

Figure 2.3.1.6 A soak in 5% NaOH at 160F for 30 min dissolved the sulfur particles and improved pitting corrosion resistance of 303 stainless steel panels after HNO₃ passivation (see Figures 2.3.1.4 and 2.3.1.5) (Ref. 30)

Figure 2.3.1.7 Micrograph of an unetched section through a 303 stainless steel valve exposed to an acidic soft drink (2.4-2.5 pH) in a vending machine showing localized corrosion along sulfide stringer inclusions at the exposed end grain surface of valve body causing hydrogen sulfide concentrations to rise in infrequent failures in the first cup of beverage after the machine was idle for a period, after which the beverage dispensed was discolored and unpalatable (N.B. a 304 stainless steel was recommended in place of 303 for this application , even if failures were infrequent) (100X) (Ref. 51)

Figure 2.3.1.8 Macroscopic and microscopic polarization curves measured in 0.1 M NaCl at 75F on annealed samples of 303 stainless steel rolled plate showing that, in the macroscopic polarization curve, current density gradually increase with increasing potential with initiation and growth of pitting being indistinguishable (because many pits initiate and grow continuously on a large electrode surface) while, in the microscopic polarization curve, MnS dissolution (0.3 V), metastable pitting (0.45-0.5 V), and stable pitting events (sharp increase in current at 0.5 V) are distinguishable (Ref. 53)

Figure 2.3.1.9 Polarization curves measured in 0.1 M NaCl at 75F on annealed samples of 303 stainless steel rolled plate using an electrochemical microcell with polarization measurements stopped after stable pit initiation (see Figure 2.3.1.10) and the final current (iF) of specimen D and E is, respectively, 5.0 and 1.1 µA (Ref. 52)

Figure 2.3.1.10 SEM images of MnS inclusions and pits formed at MnS inclusions in specimen D (a) and specimen E (b) after polarization measurements shown in Figure 2.3.1.9 with arrows indicating small polygonal pits (a synergistic effect of dissolution products of MnS inbclusions and chloride ions appear to attack the metal surface newly exposed by dissolution of the inclusions) (Ref. 52)

Figure 2.3.1.11 SEM micrograph of a polished and sterilized coupon of 303 stainless steel exposed for 10 days in a cultured medium containing Vibrio natriegens bacteria, commonly found in marine and estuarine environments, having a biological N₂-fixation capability that promoted the pitting and general corrosion of the 303 stainless steel (a conclusion supplemented by electrochemical impedance spectroscopy and potentiodynamic polarization studies) (Ref. 53)

Table 2.3.1.12 Effect of cathodic protection with potentials determined against a saturated calomel half cell on corrosion of 303 and 304 stainless steel propeller shafts exposed for 2 yr without rotation in quiescent seawater, during which time they became completely fouled with marine organisms (Ref. 50)

Table 2.3.2.1 Causative factors in CISCC of austenitic stainless steels (Refs. 54-56)

Figure 2.3.2.2 One example of a set of 303 stainless steel bolts after service in a marine environment exhibiting rust discoloration typical of all the bolts received in which the crevices created by the set screw holes and underneath the bolt heads allowed crevice corrosion and CISCC to occur (a), and a longitudinal cross section through the bolt head at the set screw showing branching cracks (arrows) in the threads (b) (Ref. 57)

Figure 2.3.2.3 Closer view of the typical SCC multi-branched cracks in Figure 2.3.2.2 (a), high magnification etched micrograph of (a) showing partial sensitization with arrows pointing to carbides at grain boundaries (b), and an etched view of the cross section in (a) showing attack at the inclusions with branching cracks progressing from the inclusions (c) (Ref. 57)

Figure .3.3.1 Kinetics of cyclic oxidation for three separate experiments: polished and cleaned 1 mm thick discs of PM consolidated 303 exposed to flowing oxygen gas at 1652F for periodic cycles represented by the data points, quenched in air after each cycle, and returned to furnace after each weighing to determine Δm divided by original area A of specimen – n.b., spallation yielded weight losses (Ref. 58)

Figure Note: PM 303 material consisted of a fine grained, rapidly solidified powder produced sieved to -140 mesh, enclosed in a stainless steel can, and consolidated by hot extrusion at 1652F at a 10:1 reduction to fully dense 1 in. diameter rod (extruded rod microstructure contained equiaxed fine MnS precipitates of ~0.01-0.2 μ m diameter at a volume fraction of ~1 per cent and a duplex grain structure of larger 5-10 μ m grains surrounded by small, heavily dislocated grains of <1 μ m).

Figure 2.3.3.2 Kinetics of cyclic oxidation for three separate experiments: polished and cleaned 1 mm thick discs of conventional wrought 304 rod of similar composition to the PM 303 rod (cyclic oxidation for 303 PM shown in Figure 2.3.3.1) exposed to flowing oxygen gas at 1652F for periodic cycles represented by the data points, quenched in air after each cycle, and returned to furnace after each weighing to determine Δm divided by original area A of specimen – n.b., spallation yielded weight losses significantly greater than for the 303 PM rod (ide scatter between tests due to spallation) (Ref. 58)

Figure 2.3.3.3 Comparison of SEM backscattered electron images of surface oxide after cyclic oxidation at 1652F in pure oxygen of a disc sample of 303 PM rod (see Figure 2.3.3.1) for 305 h and of a disc sample of conventional wrought 304 rod of similar composition (see Figure 2.3.3.2) for 298 h (Ref. 58)

Table 3.1.1.1 AMS specified mechanical properties for bars, wires, and forgings of 303 and 303Se grades of free machining 18Cr-9Ni austenitic stainless steels (Ref. 3)

Table 3.1.1.2 AMS specified mechanical properties for bars, wires, and forgings of free machining 18.5Cr-10Ni-0.22Se (SAE 30303Se) austenitic stainless steel (Ref. 7)

Table 3.1.1.3 AMS specified mechanical properties for free machining bars and forgings of 0.14S-18Cr-9.5Ni-0.50Mo-0.80A1 (303MA) austenitic stainless steel (Ref. 6)

Table 3.1.1.4 AMS specified mechanical properties for free machining bars, wire, and forgings of 18Cr-10.5Ni-0.26S-0.60Cb (UNS S34720) and 18Cr-10.5Ni-0.14P-0.25Se-0.60Cb (UNS S34723) (Ref. 7)

Table 3.1.1.5 AMS specified mechanical properties for free machining bars, wire, and forgings of 18Cr-9Ni-0.21Pb (303Pb) austenitic stainless steel (Ref. 6)

Table 3.1.2.1 ASTM mechanical property specifications for various products made from free machining wrought 303, 303Se, XM-2, and XM-5 austenitic stainless steels and CF-16 and CF-16Fa cast stainless steels (Refs. 8-13)

Table 3.2.1.1 Tensile properties of 303 and 303Se stainless steel bar at room temperature (also see Se Table ctions 3.3.1-3.3.4) (Ref. 35)

Figure 3.2.1.2 Tensile properties of 303MA stainless steel (equivalent to XM-2 per Tables 1.3.1 and 1.4.2.1) bars at room temperature (Ref. 36)

Figure 3.2.1.3 Effect of cold reduction on room temperature tensile properties of 303MA stainless steel (equivalent to XM-2 per Table 1.4.2.1): —— cold drawn, ----- as cold drawn and stress relieved at 750F for 4 hr. with ductility curves averaged for cold drawn and cold drawn plus stress relieved conditions, elongation measured in 4D of test specimen, and yield strength at 0.2% offset (Ref. 36)

Table 3.2.1.4 Typical mechanical properties of 303 Ugima® stainless steel bars (cold drawn, turned, and ground to SMQTM quality*) and escomatic (see Section 4.2) coils at room temperature (identical to regular 303 except to machinability and made by Ugitech/Schmolz + Bickenbach) (Ref. 61)

Table 3.2.1.5 Mechanical properties of CF-16F and CF-16Fa cast free machining austenitic stainless steels at room temperature (Refs. 13, 23, 29)

Table 3.2.1.6 Mechanical properties of sintered grades of PM 303L, 303LSC, and 303LCu (see Table 1.4.3.2) free machining austenitic stainless steels (Ref. 19)

Table 3.2.3.1 Typical Izod V-notch impact properties of annealed 303, 303MA, and 303Se austenitic stainless steel bar at room and cryogenic temperature (Refs. 36, 40)

Table 3.3.1.1 Engineering and true stress-strain tensile properties of AISI 303 stainless steel at room temperature (R.T.) and cryogenic temperatures down to -452F (Ref. 62)

Figure 3.3.1.2 True stress-strain curves for AISI 303 stainless steel at room temperature (R.T.) and cryogenic temperatures down to -452F (Ref. 62)

Figure 3.3.1.3 Tensile properties of annealed Type 303 at room and high temperatures (Ref. 83)

Figure 3.3.1.4 Tensile properties of annealed AISI 303 and 303SE at room and cryogenic temperatures (elongation measured in 2 in.) (Ref. 35)

Figure 3.3.1.5 Tensile properties of cold drawn (10%) AISI 303 and 303SE at room and cryogenic temperatures (elongation measured in 2 in.) (Ref. 35)

Figure 3.3.1.6 Engineering stress-strain tensile curves for annealed AISI 303 bar at room and cryogenic temperatures (Ref. 79)

Figure 3.3.1.7 Tensile properties of annealed AISI 303Se bar at room and cryogenic temperatures (Ref. 82)

Figure 3.3.2.1 Compressive yield strength and elastic limit at room and cryogenic temperatures for AISI 303 or 303Se stainless steel (Ref. 80)

Figure 3.3.3.1 Range and average values of Izod V-notch impact tests at high and low temperatures for annealed bars of AISI 303 stainless steel (Ref. 82)

Figure 3.3.3.2 Range and average values of Izod V-notch impact tests at high and low temperatures for annealed bars of AISI 303Se stainless steel (Ref. 82)

Figure 3.3.3.3 Izod V-notch impact properties of annealed AISI 303Se with 0.28 and 0.34% Se (Ref. 35)

Figure 3.4.1 Creep strength of 303 and 303Se for 1% elongation after 10,000 h at 1000-1500F (Refs. 76, 81)

Table 3.4.2 Creep strength of Type 303 (annealed condition) and CF-16F cast austenitic stainless steel at 900-1400F (Refs. 38, 83)

Figure 3.5.2.1 Specimen geometry (in mm) for uniaxial/biaxial low-cycle fatigue tests based on tension/compression with cyclic torsion carried out on a biaxial servo-hydraulic test machine of annealed AISI 303 austenitic stainless steel (top) and biaxial and axial/torsional fatigue loading strain paths including proportional and nonproportional ones (bottom) for data presented in Table 3.5.2.2 (Ref. 63)

Table 3.5.2.2 Low-cycle fatigue life for AISI 303 tests in biaxial and axial/torsional strain cycling (see Figure 3.5.2.1) (Ref. 63)

Figure 3.5.2.3 Cyclic stress-strain responses at the stabilized cycles of low-cycle fatigue (see Table 3.5.2.2) for six different loading strain paths of biaxial and axial/torsional fatigue (see Figure 3.5.2.1) of annealed AISI 303 (Ref. 63)

Table 3.6.2.1 Modulus of elasticity of AISI 303 and 303Se in tension and torsion (shear) at room temperature (Ref. 35)

Figure 4.2.1 Comparative machinability of AISI 303 (=303Se) to commonly used stainless steels and their free machining steel counterparts based on 100% for AISI 416 (martensitic type free machining stainless steel) (Refs. 64, 65)

Figure 4.2.2 Effect of sulfide size on machinability based on tool life (tool life measured as distance traveled along a 0.915 in. diameter bar until tool failure) of AISI 303 austenitic stainless steel (Ref. 64)

Figure 4.2.3 Effect of sulfide shape on machinability in a drill test for AISI 303 stainless steel (Ref. 64)

Figure 4.2.4 Effect of sulfide size on machined surface finish for a free machining stainless steel (unspecified grade) (Ref. 64)

Figure 4.2.5 Comparison of machined surface finish obtained for AISI 303 and AISI303Se austenitic stainless steels in a plunge machining test (Ref. 64)

Table 4.2.6 An approximate guide to grit size, average surface roughness, and achievable finish patterns on stainless steels upon abrasive grinding and finishing (Ref. 67)

Figure 4.2.7 Effect of cooling on roundness of SUS 303 stainless steel bars (26 mm diameter, 120 mm long – shown above) as a function of cutting speed and feed rate turned on a CNC machine using a PVD coated carbide cutting tool (Ref. 68)

Figure 4.2.8 Roughness (R_a – arithmetic mean, R_z – maximum height, R_q –a root-mean-square, and R_t – total height) of dry machined surfaces as a function of cutting speed of annealed bars (25 and 50 mm in diameter and 100 mm long) AISI 303, 304, and 310 stainless steel for face machining on a universal lathe using hard metal tools (side cutting edge angle = 160, rake angle = +60, and relief angle = 80) at a feed of 0.054 mm/rotation and cutting depth of 0.1 mm at rotation speeds given (Ref. 69)

Table 4.2.9 Machining technical data for 303 UGIMA® (Ugitech's 303 alloy, Smolz + Bickenbach) representing typical working ranges based on field and laboratory research, however, results vary based on hot parts are to be produced, equipment, and tooling utilized (Ref. 61)

Table 4.2.10 Machining technical data for 303 UGIMATM HD (Ugitech's low sulfur version of 303 UGIMA® alloy, Smolz + Bickenbach) representing typical working ranges based on field and laboratory research, however, results vary based on hot parts are to be produced, equipment, and tooling utilized (Ref. 61)

Table 4.4.1 Acid descaling (pickling) of all free machining wrought and cast stainless steel alloys in the fully annealed condition (Ref. 70)

Table 4.4.2 Acid cleaning and passivation of all free machining wrought and cast stainless steel alloys (Refs. 70, 71)

Table 4.4.3 Alkaline-Acid-Alkaline (A-A-A) passivation method developed by Carpenter Technology Corporation for free machining grades of stainless steels to remove residual acid in microscopic discontinuities at nonmetallic inclusions and improve corrosion resistance (see Figure 4.4.4) (Ref. 72)

Figure 4.4.4 Left test cone of free machining grade of stainless steel was passivated using the A-A-A method (see Table 4.4.3) and right test cone was passivated conventionally; both were exposed to salt spray to show differences in corrosion resistance (Ref. 72)

Figure 4.4.5 Effect of microwave plasma nitriding at 840F and varying power in a gas mixture of 40% N_2 and 60% H_2 at 4 torr for 60 min. on surface hardness of 303 stainless steel (polished and cleaned in acetone before plasma nitriding) (Ref. 73)

Figure 4.4.6 Antibacterial activity (24 h incubation of gram-negative E. coli) of a polished and cleaned 304 stainless steel surface (A) and a 303 polished and cleaned surface after plasma nitriding in a gas mixture of 40% N_2 and 60% H_2 at 4 torr for 60 min. at 700 W (b) (Refs. 73, 74)