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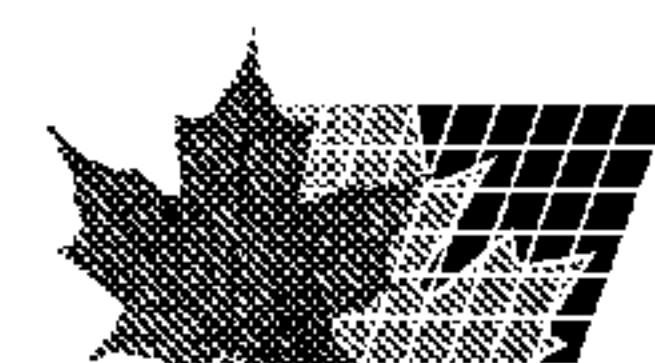
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(54) **Titre : ARTICLE EN TITANE PRESENTANT UNE RESISTANCE ACCRUE A LA CORROSION**
(54) **Title: FABRICATED TITANIUM ARTICLE HAVING IMPROVED CORROSION RESISTANCE**

(57) **Abrégé/Abstract:**

A titanium article having improved corrosion resistance resulting from a direct or indirect attachment of a platinum group metal or alloy thereof or incorporation of this metal or alloy thereof into a minor surface portion of the article.



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(54) Title: FABRICATED TITANIUM ARTICLE HAVING IMPROVED CORROSION RESISTANCE

(57) Abstract: A titanium article having improved corrosion resistance resulting from a direct or indirect attachment of a platinum group metal or alloy thereof or incorporation of this metal or alloy thereof into a minor surface portion of the article.

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FABRICATED TITANIUM ARTICLE HAVING IMPROVED CORROSION RESISTANCE

BACKGROUND OF THE INVENTION

Field of the Invention

[002] This invention relates to a titanium article wherein improved corrosion resistance is achieved by the integral incorporation of a platinum group metal or alloy thereof directly or indirectly attached to a minor surface portion of said article.

Description of the Prior Art

[003] Titanium, being a reactive metal, relies on the formation and stability of a surface oxide film for corrosion resistance. Under stable conditions, titanium can demonstrate remarkable corrosion resistant behavior. The reverse is also true, however, in that when the film is destabilized, extremely high corrosion rates may result. These conditions of instability are generally at the two extremes of the pH scale. Strongly acidic or alkaline solutions can create instability in the titanium oxide film.

[004] Typically, in accordance with prior art practice, when using titanium in an area of uncertain oxide film stability, alloying elements have been added to the titanium to enhance the oxide film stability, thus increasing its effective usefulness at the pH extremes. This practice has proven most effective for the acid end of the pH scale. Several alloying elements have shown success in this regard, such as molybdenum, nickel, tantalum, niobium and precious metals. Of this group, the platinum group metals (PGM) offer far and away the most effective protection against corrosion. The platinum group metals are platinum, palladium, ruthenium, rhodium, iridium and osmium.

[005] Stern et al. demonstrated this in 1959 in a paper titled "The Influence of Noble Metal Alloy Additions on the Electrochemical and Corrosion

Behavior of Titanium". They found that as little as 0.15% Pd or Pt alloying additions greatly enhanced the stability of the oxide film on titanium, and thus the corrosion resistance, in hot reducing acid medium. Consequently, for many years the ASTM grade 7 titanium (Ti-.15Pd) has been the standard material for use in severe corrosive conditions where unalloyed titanium is subject to corrosion. More recently, ASTM grade 16 (Ti-.05Pd) and grade 26 (Ti-.1Ru) have been used as direct replacements for grade 7 because they are more economical and provide a level of corrosion resistance close to that of grade 7. Thus, they tend to be considered equivalent in less drastic corrosion applications.

[006] The mechanism of protection afforded by platinum group metal additions to titanium is one of increased cathodic depolarization. The platinum group metals afford a much lower hydrogen overvoltage in acidic media, thereby increasing the kinetics of the cathodic portion of the electrochemical reaction. This increased kinetics translates to a change in the slope of the cathodic half reaction, leading to a more noble corrosion potential for the titanium. The active/passive anodic behavior of titanium allows for a small shift in corrosion potential (polarization) to effect a large change in the corrosion rate.

[007] Prior work on the polarization behavior of titanium was performed by Stern and Wissenberg in 1959. In this work, titanium was galvanically coupled to other metals to observe the effects on the corrosion rate of titanium in sulfuric acid media. The researchers found that titanium coupled to platinum could exhibit a reduction in corrosion rate of up to 100 fold, as seen in the present invention. However, they were not directly attaching the platinum onto the titanium and thus did not realize the extraordinary benefits seen in the present invention. In order for Stern and Wissenberg to achieve a 100 fold reduction in corrosion, they found that the surface area of the platinum had to be 4 times the area of the titanium. Thus, their surface area ratio of Ti/PGM was $\frac{1}{4}$. In fact, at a 35/1 Ti/PGM surface

area ratio, the authors saw no benefit from the platinum coupling whatsoever. This was clearly not advantageous in terms of cost and thus, it is presumed the researchers then pursued alloying as the means of enhanced environmental behavior, as disclosed in U.S. Patent 3,063,835. In the present invention using a direct or indirect attachment or integral incorporation practice, the 100 fold corrosion rate reduction is observed at all Ti/PGM surface area ratios, even to ratios thousands of times larger than Stern and Wissenberg's.

[008] Although the above-described prior art practices are effective for enhancing the corrosion resistance of titanium in severe corrosive conditions, alloying additions of precious metals and especially the platinum group metals are extremely expensive.

SUMMARY OF THE INVENTION

[009] The invention of the instant application provides, in place of bulk alloying, a relatively low cost and easy to apply practice for achieving improved corrosion resistance of titanium subjected to severe corrosive applications, and thus is advantageous in this regard when compared to the prior art practices discussed above.

[010] In accordance with the invention, it has been determined that a simple direct or indirect application or integral incorporation of a small amount of a platinum group metal (PGM) or alloy thereof onto the titanium surface can protect a large surface area of the titanium. The PGM or alloy thereof is not intentionally alloyed with the titanium but instead, plated, resistance welded, fusion welded, mechanically attached, or vapor deposited to achieve direct or indirect attachment or integral incorporation to a minor surface portion of a titanium article. In accordance with the invention, a titanium article having improved corrosion resistance comprises a titanium substrate having a direct or indirect attachment to a minor surface portion thereof, or integral incorporation of a platinum group metal or alloy thereof present in an amount effective to produce an article that exhibits better corrosion resistance than

the article without the attachment or integral incorporation. The PGM attachment or integral incorporation is present in an area thereof less than 1% (excluding 0) of the article surface area to be protected. A ratio of the surface area of the article to the area of the attachment or integral incorporation of greater than 10 to 10000 or greater than 50 to 10000 may be used in accordance with the invention. Although any desired practice may be used for the direct or indirect attachment, preferred practices include plating, resistance welding, fusion welding, mechanically fastening, and vapor deposition. The PGM or alloy thereof can also be integrally incorporated into the titanium article, becoming part of the article. This could be accomplished by any number of means including, but not limited to, welding an appliqué into an article thus making it part of said article, using the PGM or alloy thereof as weld filler metal during fabrication of the article or later as an addition or repair or enhancement of an existing article, or using the PGM or alloy thereof as a pre-fabricated component that becomes then attached to the article. The preferred PGM is platinum and the preferred PGM alloy is an alloy containing 0.3-15% Pd or 0.3-15% Pt. The level of PGM in grade 7 titanium (0.15% Pd) was shown to be insufficient to offer any benefit when used as an appliqué on grade 2 titanium (see Table 3). An effective platinum group alloy for use in the practice of the invention may include Ti-0.3 to 15% Pd or Pt or 1% Pd or Pt.

DESCRIPTION OF THE PREFERRED EMBODIMENTS AND SPECIFIC EXAMPLES

[011] In experimental work leading to the invention, general corrosion testing was performed with varying surface area ratios with excellent results. The polarization effect (change in corrosion potential) was observed over a significant distance. As shown in Tables 1 and 2, the practice of the invention can be more effective than either grade 16 or grade 26 in boiling HCl at substrate to appliqué surface area ratios as great as 5000.

Table 3 demonstrates the effectiveness of incorporating a Ti-PGM alloy as weld wire onto a titanium grade 2 substrate.

Table 1 - Corrosion Rates in Hydrochloric Acid

Test Material	Solution (@ boiling)	Area Ratio (Ti Gr2/ PGM)	Max. Distance from PGMA (in)	Corrosion Rate (mpy)
ASTM Grade 2	5% HCl	--	--	~1000
ASTM Grade 7	5% HCl	--	--	4.7
ASTM Grade 16	5% HCl	--	--	5.4
ASTM Grade 26	5% HCl	--	--	12.2
Grade 2 with Pt ¹	5% HCl	66/1	2	4.3
Grade 2 with Pt ²	5% HCl	110/1	2	4.9
Grade 2 with Pt ²	5% HCl	220/1	2	5.4
Grade 2 with Pt ²	5% HCl	440/1	2	4.9
Grade 2 with Pt ²	5% HCl	440/1	4	5.2
Grade 2 with Pt ²	5% HCl	2000/1	8	4.0
Grade 2 with Pt ²	5% HCl	5100/1	10	4.2
Grade 2 with Pt ¹	5% HCl	1000/1	4	4.3
Grade 2 with Pd ²	5% HCl	66/1	2	4.7
Grade 2 with Rh ²	5% HCl	66/1	2	5.6

Footnotes: 1 - PGM was plated onto surface.

2 - PGM was resistance welded onto surface as a sheet.

Table 2 - Corrosion Rates for PGM Alloy Appliqué in Hydrochloric Acid

Test Material	Solution (@ boiling)	Area Ratio (Ti Gr2/ PGM Alloy)	Corrosion Rate (mpy)
ASTM Grade 2	5% HCl	--	~1000
ASTM Grade 7	5% HCl	--	4.7

ASTM Grade 16	5% HCl	--	5.4
ASTM Grade 26	5% HCl	--	12.2
Grade 2 with Ti-0.5%Pt	5% HCl	125/1	9.5
Grade 2 with Ti-1%Pt	5% HCl	125/1	5.8
Grade 2 with Ti-1%Pt	5% HCl	250/1	6.9
Grade 2 with Ti-1%Pt	5% HCl	500/1	1060
Grade 2 with Ti-0.5%Pd	5% HCl	125/1	10.9
Grade 2 with Ti-1%Pd	5% HCl	125/1	4.8
Grade 2 with Ti-1%Pd	5% HCl	250/1	8.9
Grade 2 with Ti-1%Pd	5% HCl	500/1	940

Table 3 – Corrosion Rates for PGM alloy Weld Wire Incorporation in HCl

Test Material	Solution (@ boiling)	Area Ratio (Ti Gr2/ PGM Alloy)	Corrosion Rate (mpy)
ASTM Grade 2	5% HCl	--	~1000
ASTM Grade 7	5% HCl	--	4.7
Grade 2 with Ti-0.15%Pd	5% HCl	125/1	153
Grade 2 with Ti-0.5%Pt	5% HCl	32/1	6.8
Grade 2 with Ti-1%Pt	5% HCl	125/1	5.9
Grade 2 with Ti-0.5%Pd	5% HCl	32/1	5.6
Grade 2 with Ti-1%Pd	5% HCl	83/1	6.2

[012] Likewise, the corrosion rates can be lowered in oxidizing acids as well. This is demonstrated in Table 4 in concentrated nitric acid. In this instance, the titanium with the Pt appliqué actually performed better than documented rates for grade 7.

Table 4 - Corrosion Rates in Nitric Acid

Test Material	Solution	Area Ratio	Corrosion Rate (mpy)	Comments
ASTM Grade 2	40% @ Boiling	--	24.1	96 Hr. Exposure
ASTM Grade 7	40% @ Boiling	--	25	From data archive
ASTM Grade 12	40% @ Boiling	--	15	From data archive
Grade 2 with Pt	40% @ Boiling	66/1	6.7	96 Hr. Exposure

[013] It was also determined in crevice corrosion testing that the titanium metal within a crevice can be effectively protected by application of the PGM appliqué on the titanium substrate outside of the crevice, as shown in Table 5. Once again, the results confirmed that the grade 2 titanium with a PGM appliqué could exhibit equivalent corrosion behavior as that of grade 7 titanium.

Table 5 - Crevice Corrosion Results

Test Material	Solution	Area Ratio	Max. Distance from PGMA (in.)	Severity of Crevice Corrosion
ASTM Grade 2	5% NaCl, pH 3	--	--	Moderate Attack
ASTM Grade 7	5% NaCl, pH 3	--	--	No Attack
ASTM Grade 12	5% NaCl, pH 3	--	--	Minor Attack
Grade 2 with Pt	5% NaCl, pH 3	120/1	3	No Attack
Grade 2 with Pt	5% NaCl, pH 3	120/1	5	No Attack
ASTM Grade 2	5% NaCl, pH 1	--	--	Severe Attack
Test Material	Solution	Area Ratio	Max. Distance from PGMA (in.)	Severity of Crevice Corrosion
ASTM Grade 7	5% NaCl, pH 1	--	--	No Attack
ASTM Grade 12	5% NaCl, pH 1	--	--	Moderate Attack
Grade 2 with Pt	5% NaCl, pH 1	120/1	3	No Attack
Grade 2 with Pt	5% NaCl, pH 1	120/1	5	No Attack
ASTM Grade 7	5% NaCl + 1000ppm Fe ³⁺ pH 0.5	--	--	No Attack
ASTM Grade 12	5% NaCl + 1000ppm Fe ³⁺ pH 0.5	--	--	Severe Attack
Grade 2 with Pt	5% NaCl + 1000ppm Fe ³⁺ pH 0.5	120/1	3	No Attack
Grade 2 with Pt	5% NaCl + 1000ppm Fe ³⁺ pH 0.5	120/1	5	No Attack

[014] The method of application of the PGM or the alloy thereof does not affect the performance as long as the attachment or incorporation is directly or indirectly attached to the titanium substrate. This effect was observed with different PGM metals, such as platinum, palladium and rhodium. The extent of protection does vary somewhat with different platinum group metals and alloys thereof, depending upon the corrosive media; however, in all cases significant corrosion resistance was achieved.

[015] The strength of the polarization effect of an appliqué of PGM was tested by several means. Simultaneous tests in boiling acid utilizing various Ti/PGM area ratios were performed. In addition, samples of the same area ratio but with varying distances between the farthest edge of the titanium test coupon and the appliqué were also studied. As an example, in one instance, the ratio was set at 250/1; however, one set of coupons were twice the length of a second set. Thus, the distance over which the PGM appliqué was forced to protect (polarize) was doubled. This distance difference had no effect on the protective polarization of the test coupon. In both instances, the appliqué was applied to only one side of the test coupon; however, the polarization effect did not suffer from one side of the specimen to the other.

[016] As may be seen from the experimental work above described in hot reducing acid environments, the titanium sample with the appliqué or incorporation can exhibit the same corrosion behavior as ASTM grade 7 (Ti - .15Pd).

[017] The cost benefits of the invention over conventional practices are huge. Specifically, at only a 500/1 surface area ratio, the incremental cost of the PGM appliqué over the base cost of the titanium is about \$0.50/lb at a titanium thickness of 0.125 in and drops to \$0.25/lb at a thickness of 0.25 in. By contrast, the incremental cost of grade 7, which is titanium alloyed with 0.15% palladium, over grade 2 commercially pure titanium, is on the order of \$15/lb. This will not change with metal thickness since it is an alloying addition, so at 0.125 in gauge, the appliqué offers roughly a 96% cost

reduction while at 0.25 in titanium metal thickness, the cost reduction is more on the order of 98%.

[018] Similarly, using a Ti-1% Pd alloy as the appliqué or incorporating it as weld metal into a titanium article, at a 125/1 ratio, the incremental costs would be about \$0.13/lb. at a thickness of 0.125 in. and only \$0.07/lb. at a 0.25 in. thickness. Thus, in this example, the cost reductions versus use of grade 7 are greater than 99%.

[019] The invention also provides significant advantages with respect to delivery and availability of the corrosion resistant material. Specifically, companies do not normally inventory titanium alloys containing a PGM due to the cost of inventorying these high cost metals. Thus, these grades tend to be less available than standard grades of titanium that do not contain an alloyed PGM. Consequently, delivery times tend to be longer since manufacturers are generally required to work these melts into their melting schedule as time permits. Whereas, normal grades of titanium are in production on a routine basis and additional melts may be added without time delays.

[020] The invention offers great versatility in that it may be used by the manufacturer, the fabricator or at a facility of an end user. Specialized equipment or specialized skills are not necessary.

[021] The invention may be specifically targeted to areas of process equipment that will be used in environments more susceptible to corrosion. This could further reduce the overall cost of utilizing the invention. In this regard, the practice of the invention would allow for in-situ repair of existing titanium equipment that begins to suffer from corrosion.

[022] The practice of the invention allows for selection of the most appropriate PGM or PGM alloy for a specific environment in order to maximize corrosion performance and reduce cost. This is not the case with PGM alloyed grades of titanium where the PGM alloying addition is fixed in the alloyed article.

[023] The term “titanium” as used herein in the specification and claims refers to elemental titanium, commercially pure titanium and titanium base alloys. The term “platinum group metals” (PGM) as used herein in the specification and claims refers to platinum (Pt), palladium (Pd), ruthenium (Ru), rhodium (Rh), iridium (Ir), and osmium (Os). The term platinum group metal (PGM) alloy as used herein in the specification and claims refers to the use of an alloy whose minor constituent consists of a PGM or an alloy thereof comprised of 2 or more platinum group metals. The term “corrosion” as used herein in the specification and claims is defined as the chemical or electrochemical reaction between a material, usually a metal, and its environment that produces a deterioration of the material and its properties.

The embodiments of the present invention for which an exclusive property or privilege is claimed are defined as follows:

1. A titanium article having improved corrosion resistance, comprising a titanium substrate having an indirect attachment attached by an indirect mechanism to a minor surface portion thereof, said indirect attachment comprising a titanium-based platinum group metal alloy, or having an integral incorporation of a titanium-based platinum group metal alloy, wherein titanium-based platinum group metal alloy is present in an area less than 1% (excluding 0) of the surface area to be protected, whereby said article exhibits better corrosion resistance than said article without said attachment or integral incorporation, and wherein said platinum group metal is platinum, palladium, ruthenium, iridium or osmium.
2. The titanium article of claim 1, wherein said attachment or integral incorporation is present in an article surface area to an attachment or integral incorporation ratio of 10 to 10000.
3. The titanium article of claim 1, wherein said attachment or integral incorporation is present in an article surface area to attachment or integral incorporation ratio of 50 to 10000.
4. The titanium article of claim 1, claim 2, or claim 3, wherein said titanium-based platinum group metal alloy comprises platinum.
5. The titanium article of claim 1, claim 2 or claim 3, wherein said titanium-based platinum group metal alloy includes 0.3-15 wt. % Pd or 0.3-15 wt. % Pt.
6. The titanium article of claim 1, claim 2 or claim 3, wherein said titanium-based platinum group metal alloy includes 1 wt. % Pd or 1 wt. % Pt.
7. A titanium article having improved corrosion resistance, comprising a titanium substrate having an indirect attachment to, or having an integral incorporation of a minor surface portion thereof, said attachment or integral incorporation comprising a titanium-based platinum group metal alloy, wherein said indirect attachment or integral incorporation is present in an area less than 1% (excluding 0) of the surface area to be protected, whereby said article exhibits better corrosion resistance than said article without said attachment or integral incorporation.

8. The titanium article of claim 7, wherein said attachment or integral incorporation is present in an article surface area to attachment or integral incorporation ratio of greater than 10 to 10000.
9. The titanium article of claim 7, wherein said attachment or integral incorporation is present in an article surface area to attachment or integral incorporation ratio of greater than 50 to 10000.
10. The titanium article of claim 7, claim 8 or claim 9, wherein said platinum group metal in the titanium-based platinum group metal alloy comprises platinum.
11. The titanium article of claim 7, or claim 8 or claim 9, wherein said titanium-based platinum group metal alloy composition range includes 0.3-15 wt. % Pd or 0.3-15 wt. % Pt.
12. The titanium article of claim 7, claim 8 or claim 9, wherein said titanium-based platinum group metal alloy includes 1 wt. % Pd or 1 wt. % Pt.
13. A titanium article having improved corrosion resistance, comprising a titanium substrate having an indirect attachment to a minor surface portion thereof, said attachment comprising a plating of a titanium-based platinum group metal alloy wherein said indirect attachment is present in an area less than 1 % (excluding 0) of the surface area to be protected, whereby said article exhibits better corrosion resistance than said article without said attachment, and wherein said platinum group metal is platinum, palladium, ruthenium, iridium or osmium.
14. The titanium article of claim 13, wherein said attachment is present in an article surface area to attachment ratio of greater than 10 to 10000.
15. The titanium article of claim 14, wherein said attachment is present in an article surface area to attachment ratio of greater than 50 to 10000.
16. The titanium article of claim 13, claim 14 or claim 15, wherein said platinum group metal is platinum.
17. The titanium article of claim 13, claim 14 or claim 15, wherein said titanium-based platinum group metal alloy includes 0.3-15 wt. % Pd or 0.3-15 wt. % Pt.

18. The titanium article of claim 13, claim 14 or claim 15, wherein said titanium-based platinum group metal alloy includes 1 wt. % Pd or 1 wt. % Pt.

19. A titanium article having improved corrosion resistance, comprising a titanium substrate having indirect attachment to a minor surface portion thereof, said attachment comprising a vapor deposited titanium-based platinum group metal alloy, wherein said indirect attachment is present in an area less than 1 % (excluding 0) of the surface area to be protected, whereby said article exhibits better corrosion resistance than said article without said attachment, and wherein said platinum group metal is platinum, palladium, ruthenium, iridium or osmium.

20. The titanium article of claim 19, wherein said attachment is present in an article surface area to attachment ratio of greater than 10 to 10000.

21. The titanium article of claim 19, wherein said attachment is present in an article surface area to attachment ratio of greater than 50 to 10000.

22. The titanium article of claim 19, claim 20 or claim 21, wherein said platinum group metal is platinum.

23. The titanium article of claim 19, claim 20 or claim 21, wherein said titanium-based platinum group metal alloy includes 0.3-15 wt. % Pd or 0.3-15 wt. % Pt.

24. The titanium article of claim 19, claim 20 or claim 21, wherein said titanium-based platinum group metal alloy includes 1 wt. % Pd or 1 wt. % Pt.

25. A titanium article having improved corrosion resistance, comprising a titanium substrate having indirectly attached to or having an integral incorporation of a minor surface portion thereof by means of a mechanical fixture comprising a titanium-based platinum group metal alloy, wherein the titanium-based platinum group metal alloy is present in an area less than 1 % (excluding 0) of the surface area to be protected, whereby said article exhibits better corrosion resistance than said article without said mechanical fixture, and wherein said platinum group metal is platinum, palladium, ruthenium, iridium or osmium.

26. The titanium article of claim 25, wherein said mechanical fixture is present in an article surface area to mechanical fixture ratio of greater than 10 to 10000.

27. The titanium article of claim 25, wherein said mechanical fixture is present in an article surface area to mechanical fixture ratio of greater than 50 to 10000.
28. The titanium article of claim 25, claim 26 or claim 27, wherein said platinum group metal is platinum.
29. The titanium article of claim 25, claim 26 or claim 27, wherein said titanium-based platinum group metal alloy composition range includes 0.3-15 wt. % Pd or 0.3-15 wt. % Pt.
30. The titanium article of claim 25, claim 26 or claim 27, wherein said titanium-based platinum group metal alloy includes 1 wt. % Pd or 1 wt. % Pt.
31. The titanium article of claim 25, claim 26 or claim 27, wherein said mechanical fixture comprises a prefabricated component containing the titanium-based platinum group metal alloy.