

# CORROSION OF WELDMENTS



The Materials  
Information Society

# Contents

Preface .....	vii
<b>Chapter 1 Basic Understanding of Weld Corrosion .....</b>	<b>1</b>
Factors Influencing Corrosion of Weldments .....	1
Weld Microstructures .....	1
Forms of Weld Corrosion .....	3
Welding Practice to Minimize Corrosion .....	10
<b>Chapter 2 Corrosion of Carbon Steel and Low-Alloy Steel</b>	
<b>Weldments .....</b>	<b>13</b>
Classification of Steels and Their Welding	
Characteristics .....	13
Carbon Steels .....	13
Low-Alloy Steels .....	14
Corrosion Considerations for Carbon and Low-Alloy	
Steel Weldments .....	15
Corrosion of Carbon Steel Weldments .....	19
Influence of Weld Microstructure .....	19
Residual Stress .....	19
Geometrical Factors .....	19
Preferential HAZ Corrosion .....	20
Preferential Weld Metal Corrosion .....	21
Mitigation of Preferential Weldment Corrosion .....	21
Galvanic Corrosion .....	23
Environmentally Assisted Cracking (EAC) .....	24
Wet Hydrogen Sulfide Cracking .....	25
Stress-Corrosion Cracking .....	25
Hydrogen-Induced Cracking .....	33
Effect of Welding Practice on Weldment Corrosion .....	35
<b>Chapter 3 Corrosion of Austenitic Stainless Steel Weldments .....</b>	<b>43</b>
Grade Designations .....	43
Standard Grades .....	43
Nonstandard Grades .....	43
Properties .....	47
General Welding Considerations .....	48
Corrosion Behavior .....	48
Intergranular Corrosion .....	49

	Preferential Attack Associated with Weld	
	Metal Precipitates	52
	Pitting and Crevice Corrosion	53
	Stress-Corrosion Cracking	58
	Microbiologically Induced Corrosion	62
	Other Factors Influencing Corrosion of Weldments	66
<b>Chapter 4</b>	<b>Corrosion of Ferritic Stainless Steel Weldments</b>	<b>77</b>
	Grade Classifications	77
	Properties	79
	General Welding Considerations	80
	Corrosion Behavior	82
	Hydrogen Embrittlement	82
	Intergranular Corrosion	83
	Avoiding Intergranular Corrosion	84
	Example 1: Leaking Welds in a Ferritic Stainless Steel Wastewater Vaporizer	87
	Example 2: Weld Failure Due to Intergranular Corrosion and Cracking in a Heat-Recovery Steam Generator	89
<b>Chapter 5</b>	<b>Corrosion of Duplex Stainless Steel Weldments</b>	<b>99</b>
	Duplex Stainless Steel Development and Grade Designations	99
	Microstructure and Properties	100
	General Welding Considerations	103
	Corrosion Behavior of Weldments	105
	Corrosion Behavior of Alloy 2205 Weldments	109
<b>Chapter 6</b>	<b>Corrosion of Martensitic Stainless Steel Weldments</b>	<b>115</b>
	Grade Designations	115
	Standard Grades	115
	Nonstandard Grades	116
	Properties	117
	General Welding Considerations	118
	Corrosion Behavior	118
<b>Chapter 7</b>	<b>Corrosion of High-Nickel Alloy Weldments</b>	<b>125</b>
	Types of Corrosion-Resistant Alloys (CRAs)	125
	General Welding Considerations	130
	Welding Metallurgy of CRAs Containing Molybdenum	132
	Welding Metallurgy of Ni-Cu, Ni-Cr, and Ni-Cr-Fe CRAs	134
	Corrosion Behavior	134
	Phase Stability of Nickel-Base Alloys and Corrosion Behavior	137
<b>Chapter 8</b>	<b>Corrosion of Nonferrous Alloy Weldments</b>	<b>143</b>
	Aluminum and Aluminum Alloys	143
	General Welding Considerations	143
	Corrosion Behavior of Aluminum Alloy Weldments	144
	Copper and Copper Alloys	155
	General Welding Considerations	155
	Corrosion Behavior of Copper Weldments	155

Titanium and Titanium Alloys .....	156
General Welding Considerations .....	157
Corrosion Behavior of Titanium and Titanium Alloy Weldments .....	158
Zirconium and Zirconium Alloys .....	160
General Welding Considerations .....	161
Corrosion Behavior of Zirconium and Zirconium Alloy Weldments .....	162
Tantalum and Tantalum Alloys .....	164
General Welding Considerations .....	164
Corrosion Behavior of Tantalum and Tantalum Alloy Weldments .....	164
<b>Chapter 9 Corrosion of Dissimilar Metal Weldments .....</b>	<b>169</b>
Factors Influencing Joint Integrity .....	169
Corrosion Behavior .....	173
<b>Chapter 10 Weld Corrosion in Specific Industries and Environments ..</b>	<b>177</b>
Corrosion of Weldments in Petroleum Refining and Petrochemical Operations .....	177
Fabricability Considerations .....	177
Wet H <sub>2</sub> S Cracking .....	178
Hydrogen-Induced Disbonding .....	181
Liquid Metal Embrittlement .....	181
Stress-Corrosion Cracking of Weldments in BWR Service ....	183
BWR Piping Systems .....	183
Stress-Corrosion Cracking of Pipe Weldments .....	183
Model for IGSCC .....	184
Weld Residual Stresses .....	185
Mitigation of IGSCC in Boiling Water Reactors .....	187
Materials Solutions .....	188
Tensile Stress Reduction Solutions .....	189
Environmental Solutions .....	190
Corrosion in the Pulp and Paper Industry .....	191
Pulp Production .....	191
Corrosion of Weldments in Pulp Bleach Plants .....	196
<b>Chapter 11 Monitoring and Testing of Weld Corrosion .....</b>	<b>203</b>
Corrosion Monitoring .....	203
Direct Testing of Coupons .....	203
Electrochemical Techniques .....	206
Nondestructive Testing Techniques .....	207
Corrosion Testing .....	208
Tests for Intergranular Corrosion .....	209
Tests for Pitting and Crevice Corrosion .....	213
Tests for SCC .....	213
Tests for MIC .....	215
<b>Index .....</b>	<b>217</b>