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NEW EUROPEAN PATENT SPECIFICATION

④⑤ Date of publication of the new patent specification: **10.10.90**

⑤① Int. Cl.⁵: **C 22 C 19/05, C 22 F 1/10**

②① Application number: **82301929.4**

②② Date of filing: **14.04.82**

⑤④ **Corrosion resistant high strength nickel-based alloy.**

③① Priority: **17.04.81 US 255158**

④③ Date of publication of application:
08.12.82 Bulletin 82/49

④⑤ Publication of the grant of the patent:
26.02.86 Bulletin 86/09

④⑤ Mention of the opposition decision:
10.10.90 Bulletin 90/41

③④ Designated Contracting States:
AT BE DE FR GB IT SE

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Description

The present invention relates to the use of nickel based alloys which have a combination of high strength and corrosion resistance.

Alloys having high strength, for example 689.5 MN/m², or advantageously even 1034 MN/m², are required in some applications for sustaining stress in load-bearing service in chemically adverse environments. Some plastic ductility is also needed for enduring or permitting modest amounts of deformation without sudden fracture, for example to safeguard against accidental bending, or to enable cold forming to be carried out. Alloys having this desirable combination of properties are particularly useful for use in petroleum production tubing for oil wells, in contact with chemically adverse media such as chlorides, acids and such compounds as hydrogen sulphide. The alloys must therefore exhibit resistance to corrosive pitting, stress corrosion cracking and hydrogen embrittlement, as well as high strength.

The prior art includes numerous disclosures, for example in GB—A—1 385 755 and GB—A—1 514 241, of age-hardenable nickel-iron-chromium alloys that are said to be very resistant to oxidation at elevated temperatures and to be suitable for fabricated parts such as aeronautical turbines or turbine casings.

INCONEL alloy 718, as disclosed and claimed in US—A—3 046 108, is an age-hardenable high strength alloy for service over a wide temperature range, from -250°C to 700°C, and offers good resistance to a wide variety of corrosive environments. Since the alloy also offers excellent stress rupture properties and fatigue strength, it has been used in down-hole service in oil-wells. However, the alloy has insufficient resistance to hydrogen embrittlement in the harsh environments found in "sour well" conditions and, although having high as-cold-drawn strength, has low ductility.

The present invention is based on the discovery that certain alloy compositions, developed from alloy 718, have an excellent combination of strength and ductility in the wrought and age-hardened condition and also excellent resistance to hydrogen embrittlement and chloride stress cracking.

According to the invention an alloy consisting, by weight, of from 15 to 22% chromium, 10 to 28% iron, 6 to 9% molybdenum, 2.5 to 5% niobium, 1 to 2% titanium, and up to 1% aluminium, the balance, apart from impurities and incidental elements, being nickel in a proportion of from 45 to 55% of the alloy, is used in the form of wrought and age-hardened articles and parts in highly corrosive conditions in sour oil or sour gas wells or in sulphur dioxide gas scrubbers. Further elements which may be present in small amounts include up to 0.1% carbon, up to 0.35% silicon, up to 0.35% manganese, up to 0.01% boron, and also residual small amounts of cerium, calcium, lanthanum, mischmetal, neodymium and zirconium such as can remain from additions totalling up to 0.2% of the furnace charge. Impurities present may include up to 0.5% copper, up to 0.015% sulphur and up to 0.015% phosphorus.

Commercial sources of molybdenum and niobium are often associated with tungsten and tantalum, which may be present at levels of about 0.1% tungsten and 0.1% tantalum. The tungsten must be controlled at a low level to avoid the formation of undesired phases such as Laves phase. Although tantalum may be substituted for niobium in equiatomic percentages, its presence is not desirable because of its high atomic weight.

The particular combination of the proportions of chromium, iron, molybdenum, niobium, titanium, aluminium and nickel gives rise to desirable properties of strength, ductility, fabricability and durability in highly corrosive environments. To optimise these properties, a preferred composition for use according to the invention contains from 18.5 to 20.5% chromium, 13.5 to 18% iron, 6.5 to 7.5% molybdenum, 1.3 to 1.7% titanium, 0.05 to 0.5% aluminium, balance (apart from impurities and incidental elements) nickel.

Advantageously, the titanium and niobium contents of the alloy are closely controlled such that

$$\%Ti + 1/2(\%Nb) \geq 3\% < 4\%.$$

Preferably the alloy contains 1.3% to 1.7% titanium and 3.6% to 4.4% Nb, and most preferably 1.5% Ti and 4% Nb.

The alloy has good workability, both hot and cold, for production into wrought articles such as cold rolled strip and extruded tubing. Appropriate process treatments may be used to enhance the strengths of articles manufactured from the alloy. Such treatments include cold working, age-hardening and combinations of the two. The alloy may be annealed at a temperature of 871°C to 1149°C, and aged at 593°C to 760°C, or even 816°C. Direct aging treatments of heating the cold-worked alloy at 649°C to 760°C for from 0.5 to 5 hours directly after cold working are particularly beneficial for obtaining desirable combinations of high strength and ductility.

Alloys of the present invention, after appropriate thermomechanical processing exhibit yield strength (0.2% offset) of in excess of 1034 MN/m², with an elongation of 8%, and preferred alloys have strengths of more than 1310 MN/m² and elongation of around 15%.

Some examples will now be given.

Example 1

Three alloys of the invention and a comparative alloy were prepared. The alloy compositions are set out in Table I.

TABLE I
Chemical analyses, weight percents

Alloy	Cr	Fe	Mo	Nb	Ti	Al	C	Mn	Si	B	Cu	Mg	Ni
1	20.09	17.55	7.06	3.02	1.49	0.13	0.03	0.18	0.26	0.006	NA	0.011	50.23
2	18.73	13.89	6.60	4.29	1.45	0.35	0.02	0.29	0.19	0.007	0.26	0.021	53.91
3	19.89	16.61	7.18	3.10	1.51	0.08	0.03	0.22	0.16	0.006	0.06	0.016	51.14
E	18.5	17.95	3.11	5.25	0.81	1.0	0.05	0.26	0.17	0.005	0.004	0.016	52.4

NA—Not Analysed

Cobalt, phosphorus and sulphur, when analysed, were found present in percentages of 0.011% or lower.
Niobium percentages include possible small proportions of tantalum.

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Alloy 1 was prepared by vacuum induction melting and was cast to ingot form. Ingots of alloy 1 were heated at 1121°C for 16 hours for homogenization and then forged flat from 1121°C. Flats were hot rolled at 1121°C to reduce about 4 mm (0.16 gauge), annealed at 1066°C for 1 hour and cold rolled to 2.5 mm (0.1 gauge) strip, which was again annealed at 1066°C for 1 hour. Separate portions of the annealed 2.5 mm strip were cold rolled different amounts to make 1.57, 1.8 and 2.11 mm sizes (0.062, 0.071 and 0.083 gauge respectively) and then each size (including the 2.5 mm size) was again annealed at 1066°C for 1 hour and cold rolled down to final gauge of about 1.27 mm (0.05 gauge) resulting in cold work reduction of about 20%, 30%, 40% and 50%.

Hardenability, including work hardenability and age hardenability, of alloy 1 was confirmed with hardness measurements, as shown in Table II, on specimens of the 1.27 mm (0.05 gauge) strip before and after heat treatments with temperatures and times referred to in the Heat Treatment Schedule (Table III).

TABLE II
Rockwell C hardness

Condition	20% CR	30% CR	40% CR	50% CR
ACR	35	38	38.5	40
CR+HT-1	40	40	40	40.5
CR+HT-2	40.5	40.5	41.5	41.5
CR+HT-3	37	40.5	41.5	42.5
CR+HT-4	42	44	44	45
CR+HT-5	45	47	47	44.5
CR+HT-7	39.5	—	—	—
CR+HT-8	41	—	—	—
CR+HT-9	39.5	—	—	—
CR+HT-10	31.5	—	—	—
CR+HT-11	37	—	—	—

ACR—As Cold Rolled

%CR—percent reduction of thickness by cold rolling (after last anneal).

Annealed hardnesses of 20% CR strip on Rockwell B scale after treatments of 954°C for ½ hour, 1038°C for 1 hour and 1149°C for ½ hour were 97, 93 and 78. Corresponding results with 40% CR strip were 23.5 Rc, 94 Rb and 78 Rb.

TABLE III
Heat treatment schedule

HT-1	1038°C for 0.5 hr AC+760°C for 8 hr FC to 649°C, hold 8 hr/AC
HT-2	954°C/0.5 hr AC+718°C/8—FC—621°C/8 hr AC
HT-3	621°C/1 hr AC
HT-4	760°C/1 hr AC
HT-5	718°C/8 hr—FC—621°C/8 hr AC
HT-6	760°C/8 hr—FC—649°C/8 hr AC
HT-7	649°C/5 hr AC
HT-8	704°C/5 hr AC
HT-9	760°C/5 hr AC
HT-10	1149°C/0.5 hr AC+HT-5
HT-11	1149°C/0.5 hr AC+HT-6

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Tensile specimens about 1.27 mm (0.05 gauge) strip of alloy 1 were evaluated for mechanical properties at room temperature in preselected thermomechanically processed conditions, including as cold-rolled conditions and cold-rolled plus heat-treated conditions, with results set forth in the following Table IV. With cold-worked embodiments of the alloy of the invention, "direct aging", whereby the alloy is heat treated at age-hardening temperature directly (without other heat treatment intervening between cold working and aging) following cold working, gave increased yield strengths of 1034 MN/m² and higher, with good retention of ductility; moreover, the 649°C direct age provided benefits of increase in both strength and ductility exceeding 1103 MN/m² and 20% elongation.

TABLE IV

Alloy 1			
Condition	Yield strength MN/m ²	Ultimate tensile strength MN/m ²	% Elongation (2.54 cm)
ACR-20%	1022	1121	15.5
ACR-30%	1216	1283	3.5
ACR-40%	1269	1312	4.5
ACR-50%	1352	1358	3.5
20% CR+HT-7	1127	1293	21.0
20% CR+HT-8	1115	1298	15.0
20% CR+HT-9	1063	1296	14.0

The endurance of ductility of alloy 1 in a variety of conditions when subjected to hydrogen charging was tested by holding restrained 25.4 mm width cold-formed U-bend specimens at stresses greater than 100% of yield stress while being cathodically charged in a 5% sulphuric acid solution at 10 milliamps total current for 500-hour periods. Successful survival throughout the 500-hour charging periods was shown with alloy 1 in twelve processing treatment conditions, as briefly stated below,

ACR 20%, 30%, 40% and 50%;

HT-1 following 20%, 30%, 40% and 50% CR;

20% CR plus HT-8; 20% CR plus HT-9;

20% CR plus HT-10; 20% CR plus HT-11.

In contrast, two restrained U-bend specimens of 20% cold rolled strip of alloy 1 in conditions resulting from long-time (in these instances, over 16 hours) direct age treatments HT-5 and HT-6 failed after unsatisfactorily brief survivals of 5 hours and 2 hours, respectively, when subjected to the same hydrogen charging conditions.

Good resistance to contact with acid chloride media at elevated temperature was confirmed with evaluations of weight loss and visual appearance of specimens of alloy 1 of 10.2 cm × 7.62 cm in the 40% cold-rolled condition. Two specimens were immersed in aqueous 10% FeCl₃+0.5 HCl solutions at 66°C for 24 hours. The weight losses were satisfactorily low values of 0.03 and 0.52 mg/cm². Visual inspection for appearances of pitting showed that only one pit occurred and confirmed that the alloy metal provided good resistance to the acid media.

Capability of the alloy to provide resistance against stress-corrosion cracking was shown by satisfactory survival of a cold formed, restrained, U-bend specimen of 50% cold-rolled alloy 1 during a 720-hour exposure in boiling 42% MgCl₂.

Example 2

Alloy 2 and alloy 3 were air induction melted and centrifugally cast with protection of an argon shroud in a metal mould having a 10.8 cm I.D. and 1300 rpm rotation speed to produce cast centrifugally solidified tube shells of alloy 2 and 3. Cast dimensions were 10.8 cm O.D. and 1.9 cm wall thickness. The shell was cleaned up to 10.2 cm O.D. and 1.11 cm wall thickness.

A leader tube was welded onto the shell and processing proceeded as follows. The tube shell was annealed at 1149°C, pickled and cold drawn (about 15.8%) to 9.525 cm O.D. × 0.99 cm wall, re-annealed at 1149°C and pickled, then cold drawn to 8.89 cm O.D. × 0.889 cm wall (also 15.8% reduction), re-annealed at 1149°C and pickled, then tube reduced to 6.668 cm O.D. × 0.762 cm wall (about 36.7% reduction in area).

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Mechanical properties were determined with sub-size round bar specimens taken longitudinally from the tube wall and are set out in Table V.

TABLE V

Condition	YS, MN/m ²	UTS, MN/m ²	% Elong (2.54 cm)	% R.A.	Hardness (Rc)
Alloy 2					
36.7% TR	1091	1157	22.0	51.0	30
36.7% TR+704°C/1, AC	1334	1365	13.5	39.8	38
36.7% TR+704°C/2, AC	1392	1438	14.5	42.0	40
36.7% TR+760°C/1, AC	1368	1415	12.6	33.4	39
36.7% TR+760°C/2, AC	1390	1422	12.5	33.9	40
36.7% TR+1038°C/1, AC+HT-5	1044	1351	31.6	50.5	34
Alloy 3					
36.7% TR	1042	1119	17.5	53.8	30
36.7% TR+704°C/1, AC	1234	1322	16.5	44.2	36
36.7% TR+704°C/2, AC	1255	1342	15.0	48.5	37
36.7% TR+760°C/1, AC	1244	1313	13.6	39.9	37.5
36.7% TR+760°C/2, AC	1278	1348	13.5	31.4	37.5
36.7% TR+1038°C/1, AC+HT-5	924	1286	28.6	49.2	32.0
R.A.—Reduction in Area					

Good combinations of strength and ductility are achieved with cold-worked and direct-aged articles of alloys 2 and 3, especially with one to two hour direct ages at 704°C to 760°C.

A transverse specimen taken from the extruded and 704°C direct aged product of alloy 3 was of ASTM grain size No. 3½; optical microscopy of the specimen showed an absence of intergranular carbides and indicated that the extruded, cold-reduced and heat-treated microstructure did not contain any intragranular phases resolvable at 1000×.

Example 3

Alloys 2, 3 and E were melted, and centrifugally cast to tube shells and processed to 6.67 cm O.D. tube with 0.762 cm wall thickness by the process described in Example 2. Table VI compares chloride stress corrosion cracking data for these alloys at 177°C and 204°C. The alloy samples were prepared as stressed C-ring specimens and subjected to a simulated deep sour gas well environment comprising a 25% solution of sodium chloride plus 0.5% acetic acid and 1 g/l sulphur, the solution saturated with hydrogen sulphide to an H₂S overpressure of 861 KN/m².

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TABLE VI

Alloy	Temperature °C	MN/m ² Test stress	Life (days)	Material condition
E	177	1220 ⁽¹⁾	45—57	37% cw
3	177	1275	* > 68	37% cw + 760°C/2 hr, AC
E	204	986	< 22	37% cw + Anneal + Age ⁽²⁾
2	204	1089	> 42	37% cw
2	204	1248	> 65	37% cw + 649°C/1 hr, AC
3	204	1275	> 42	37% cw + 760°C/2 hr, AC

⁽¹⁾ This test was run at 90% of 0.2% offset yield strength at RT. All others were run at 100%.

⁽²⁾ 1038°C/1 hr AC + 718°C/8 hr FC at 55.6°C/hr to 621°C/8 hr AC.

* > denotes test discontinued at number of days shown with no failure.

The test conditions chosen for alloy E were those considered to be less prone to hydrogen embrittlement than the cold worked + aged samples of alloys 2 and 3. Despite testing at lower stress the comparative alloy failed earlier than alloys of the invention.

Hydrogen embrittlement tests were carried out on stressed c-ring specimens of the alloy coupled to steel in solution of 5% sodium chloride + 0.5% acetic acid, saturated with hydrogen sulphide. Results are shown in Table VII.

TABLE VII

Alloy	Test stress MN/m ²	% of R.T. Yield strength	Life (days)	Condition
E	1289	95	< 3	37% CW
E	1206	90	< 6	37% CW
3	1275	100	> 42	37% CW + 760°C/2 hrs, AC
3	1206	100	> 42	37% CW + 788°C/1 hr, AC.

The room temperature tensile data corresponding to the above corrosion data is summarised in Table VIII.

TABLE VIII
Room temperature tensile results

Alloy No.	Condition	Hardness Rc	0.2 Yield strength MN/m ²	Tensile strength MN/m ²	Elong. %	R.A. %
E	37% CW	37.5	1358	1413	8	31
E	37% CW+anneal+age ⁽¹⁾	34	986	1289	24	41
2	37% CW	30	1089	1158	22	51
2	37% CW+649°C/1 hr, AC	—	1248	1351	19	50
3	37% CW+760°C/2 hr, AC	37	1344	1344	13	31
3	37% CW+788°C/1 hr, AC	36	1206	1296	16	35

⁽¹⁾ 1038°C/1 hr, AC+718°C/8 hr FC at 55.6°C/hr to 621°C/8 hr, AC.

It will be observed that the commercial alloy E has very high as cold drawn strength and low ductility, and this was why alloy E was tested in corrosion tests at a stress less than 100% of RT yield strength.

It will be noted from the comparison between alloys 2, 3 of the present invention and the commercial alloy E that the special correlation of composition of the present invention gives rise to enhanced corrosion resistance in respect of chloride stress corrosion cracking and hydrogen embrittlement. At the same time however the alloys of the invention exhibit a desirable combination of strength and ductility.

Alloys of the present invention are useful for tubes, vessels, casings and supports, needed for sustaining heavy loads and shocks in rough service while exposed to corrosive media, and particularly for production tubing to tap deep natural reservoirs of hydrocarbon fuels. In deep oil or gas well service, possibly in off-shore installations, the alloys are beneficial for resistance to media such as hydrogen sulphide, carbon dioxide, organic acids and concentrated brine solutions sometimes present with petroleum. Also, the alloys provide good resistance to corrosion in sulphur dioxide gas scrubbers and are useful for seals, ducting, fans and stack lines in such environments. Articles of the alloy can provide useful strength at elevated temperatures up to 648°C and possibly higher.

Claims

1. The use of an alloy consisting, by weight, of from 15 to 22% chromium, 10 to 28% iron, 6 to 9% molybdenum, 2.5 to 5% niobium, 1 to 2% titanium, up to 1% aluminium, up to 0.1% carbon, up to 0.35% silicon, up to 0.35% manganese, up to 0.01% boron, with or without residual amounts not exceeding 0.2% in total of cerium, calcium, lanthanum, mischmetal, magnesium, neodymium and zirconium, the balance, apart from impurities, being nickel in a proportion of from 45 to 55% of the alloy, in highly corrosive conditions in sour oil or sour gas wells or in sulphur dioxide as scrubbers in the form of wrought and age-hardened articles and parts.

2. The use for the purpose of claim 1 of an alloy as defined therein in which the amount of titanium and niobium are correlated according to the relationship:

$$\%Ti + 1/2(\%Nb) \geq 3\% < 4\%.$$

3. The use for the purpose of claim 1 of an alloy as defined in claim 2 containing 1.3 to 1.7% titanium and 3.6 to 4.4% niobium.

4. The use for the purpose of claim 1 of an alloy as defined in any preceding claim that contains from 18.5 to 20.5% chromium, 13.5 to 18% iron, 6.5 to 7.5% molybdenum, 1.3 to 1.7% titanium and 0.05 to 0.5% aluminium.

5. The use for the purpose of claim 1 of an alloy as defined in any preceding claim that has been hot- or cold-worked and heat treated to develop a yield strength (0.2% offset) in excess of 1034 MN/m² and an elongation greater than 8%.

6. The use for the purpose of claim 1 of an alloy as defined in claim 5 that has been heat treated by annealing at a temperature in the range 871 to 1149°C and aging at a temperature in the range 593 to 816°C.

7. The use for the purpose of claim 1 of an alloy as defined in claim 5 that has been cold-worked and aged thereafter at a temperature in the range 649 to 760°C for from 0.5 to 5 hours.

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8. The use of an alloy as defined in any preceding claim for wrought and age-hardened production tubing for deep sour oil and gas wells.

Patentansprüche

1. Verwendung einer Legierung, welche in Gewichtsprozent aus 15 bis 22% Chrom, 10 bis 28% Eisen, 6 bis 9% Molybdän, 2,5 bis 5% Niob, 1 bis 2% Titan, bis zu 1% Aluminium, bis zu 0,1% Kohlenstoff, bis zu 0,35% Silizium, bis zu 0,35% Mangan, bis zu 0,01% Bor, und gegebenenfalls verbleibenden Restbeständen von insgesamt 0,2% Cer, Kalzium, Lanthan, Mischmetall, Magnesium, Neodym und Zirkon besteht, wobei der Rest, abgesehen von Verunreinigungen, Nickel mit einem Anteil von 45 bis 55% der Legierung ist, in hochkorrosiven Bedingungen in sauren Öl- oder sauren Gasquellen oder in Schwefeldioxidgaswaschern, in Form von geschmiedeten und alterungsgehärteten Gegenständen und Teilen.

2. Verwendung einer Legierung nach Anspruch 1 für den dort definierten Zweck, wobei zwischen den Anteilen an Titan und Niob die folgende Beziehung besteht:

$$\%Ti + 1/2(\%Nb) \geq 3\% < 4\%.$$

3. Verwendung einer Legierung nach Anspruch 2 für den Zweck nach Anspruch 1, mit der Maßgabe, daß sie 1,3 bis 1,7% Titan und 3,6 bis 4,4% Niob enthält.

4. Verwendung einer Legierung nach einem der vorhergehenden Ansprüche für den Zweck nach Anspruch 1, mit der Maßgabe, daß sie 18,5 bis 20,5% Chrom, 13,5 bis 18% Eisen, 6,5 bis 7,5% Molybdän, 1,3 bis 1,7% Titan und 0,05 bis 0,5% Aluminium enthält.

5. Verwendung einer Legierung nach einem der vorhergehenden Ansprüche für den Zweck nach Anspruch 1, mit der Maßgabe, daß sie kalt oder warm verformt und wärmebehandelt wurde, um eine Streckgrenze (0,2% Verformung) oberhalb 1034 MN/m² und eine Bruchdehnung von über 8% zu erzielen.

6. Verwendung einer Legierung nach Anspruch 5 für den Zweck nach Anspruch 1, mit der Maßgabe, daß sie durch Glühen bei einer Temperatur im Bereich von 871 bis 1149°C und Altern bei einer Temperatur im Bereich von 593 bis 816°C wärmebehandelt wurde.

7. Verwendung einer Legierung nach Anspruch 5 für den Zweck nach Anspruch 1, mit der Maßgabe, daß sie kalt verformt und dann bei einer Temperatur im Bereich von 649 bis 760°C während 0,5 bis 5 Stunden gealtert wurde.

8. Verwendung einer Legierung nach einem der vorhergehenden Ansprüche für geschmiedete und alterungsgehärtete Förderrohre für tiefe saure Öl- und Gasquellen.

Revendications

1. Utilisation d'un alliage comprenant, en poids, de 15 à 22% de chrome, de 10 à 28% de fer, de 6 à 9% de molybdène, de 2,5 à 5% de niobium, de 1 à 2% de titane, jusqu'à 1% d'aluminium, jusqu'à 0,1% de carbone, jusqu'à 0,35% de silicium, jusqu'à 0,35% de manganèse, jusqu'à 0,01% de bore, avec ou sans quantités résiduelles ne dépassant pas 0,2% au total de cérium, calcium, lanthane, mischmetale, magnésium, néodymium et zirconium, le complément étant, outre les impuretés, le nickel en une proportion de 45 à 55% de l'alliage, sous la forme d'articles et de pièces travaillés et durcis par vieillissement dans des conditions extrêmement corrosives, dans des puits de pétrole acide ou de gaz acide ou dans des épurateurs à l'anhydride sulfureux.

2. Utilisation selon la revendication 1 d'un alliage tel que défini dans celle-ci, selon laquelle les quantités de titane et de niobium sont en corrélation conformément à la relation:

$$\% Ti + 1/2 (\% Nb) \geq 3\% < 4\%.$$

3. Utilisation selon la revendication 1 d'un alliage tel que défini dans la revendication 2, contenant 1,3 à 1,7% de titane et 3,6 à 4,4% de niobium.

4. Utilisation selon la revendication 1, d'un alliage tel que défini dans l'une quelconque des revendications précédentes qui contient de 18,5 à 20,5% de chrome, de 13,5 à 18% de fer, de 6,5 à 7,5% de molybdène, de 1,3 à 1,7% de titane et de 0,05 à 0,5% d'aluminium.

5. Utilisation selon la revendication 1, d'un alliage tel que défini dans l'une quelconque des revendications précédentes, qui a été travaillé à chaud ou écroui et traité par la chaleur pour obtenir une limite élastique (0,2% de formation de plus de 1034 MN/m² et un allongement de plus de 8%.

6. Utilisation selon la revendication 1, d'un alliage tel que défini dans la revendication 5 qui a été thermiquement traité par recuit à une température entre 871 et 1149°C et par vieillissement à une température de 593 à 816°C.

7. Utilisation selon la revendication 1, d'un alliage tel que défini dans la revendication 5 qui a été écroui et ensuite vieilli à une température de 649 à 760°C pendant 0,5 à 5 heures.

8. Utilisation d'un alliage selon l'une quelconque des revendications précédentes pour la production par forgeage et durcissement par vieillissement de tubes pour les puits profonds et acides de pétrole et du gaz.