Development and Processing Improvement of Aerospace Aluminum Alloys—Development of AL-Cu-Mg-Ag Alloy (2139)

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Development and Processing Improvement of Aerospace Aluminum Alloys—Development of AL-Cu-Mg-Ag Alloy (2139)

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This final report supplement in presentation format describes a comprehensive multi-tasked contract study to continue the development of the silver bearing alloy that was initiated under the original contract study before modification. The initial contract activity included two commercial scale ingots rolled in one inch gauge plate, now registered as aluminum alloy 2139 by the Aluminum Association. It did not include characterization of the rolled product in thicker gauges, or correlation of processing, metallurgical structure, and properties of such thicker gauges. This supplement presents the additional work conducted in this endeavor. The study was funded by the Advanced Space Transportation Programs Office and managed initially by the Metals and Thermal Structures Branch and more recently by the Advanced Materials and Processing Branch, Structures and Materials Competency. Mr. John A. Wagner served as the Technical Representative of the Contracting Officer. The primary contractor was Analytical Services and Materials Inc. and the program manager was Mr. W. Barry Lisagor, a senior scientist with AS&M. The major portion of the experimental work completed under this supplement was conducted by ALCAN Rolled Products LLC., as a principal sub-contractor and the principal investigator was Dr. Alex Cho, a senior scientist with ALCAN Rolled Products.

Under the task supplement on aluminum alloy 2139, considerable progress has been achieved in raising the technology readiness level of this promising new alloy to near application status.

The additional two commercial scale ingots were processed into nominal plate gauges of two, four and six inches, and were extensively characterized in terms of metallurgical and crystallographic structure, and resulting mechanical properties. Emphasis was focused on durability and damage tolerance as well as strength and resistance to environmental degradation.

Alloy 2139 is processed by conventional stress relieve and artificial aging practices but does not require the cold deformation processing to develop attractive combinations of strength, toughness, and fatigue crack growth resistance as do conventional 2XXX alloys. This is due primarily to the fact that the strengthening phase, omega, is homogeneously precipitated upon aging, compared to theta prime in more conventional alloys which is heterogeneously precipitated and requires cold work to develop initiation sites for the aging process.

This report includes comparisons of the property combinations for this alloy and 2XXX and 7XXX alloys more widely used in high performance applications. It shows the dramatic improvement in all combinations of properties, including ballistic impact
performance which cannot be overlooked in this potentially important application. Moreover, the properties of this alloy are retained in all gauge thicknesses, contrary to typical reductions observed in thicker gauges of the other alloys in the comparison. The advancements achieved in this study are expected to result in rapid, widespread use of this alloy in a broad range of ground based, aircraft, and spacecraft applications.
Development of Al-Cu-Mg-Ag Alloy (2139)

Alex Cho

Alcan Rolled Products
Ravenswood WV

NASA Contract No. NNL04AB64T
with AS&M Inc.
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

Contents

I. Background

II. Metallurgical attributes of the Al-Cu-Mg-Ag alloy system

III. Development of 2139 (Al-Cu-Mg-Ag alloy) wrought product
   - Effect of dispersoid forming elements

IV. Development of 2139 thick gauge plate product

V. Summary & Conclusion
I. Background

Three Alloy Groups for Aerospace Applications

- 2xxx-T8xx (T6xx)
- 7xxx-T7xx (T6xx)
- 2xxx-T3xx

Each of these groups of alloys has unique benefits and shortcomings.

For predominantly damage tolerant applications, 2xxx-T3xx products are commonly used, despite numerous shortcomings as follows:
Damage Tolerance Capability of 2xxx alloys

Limitations of –T3xx type temper

a. Limited Product Thickness
   - poor SCC resistance for thick plate (Slow Quench)

b. Limited Product Forms
   - Very large amount of cold work by “cold rolling” is available only for thin plate

c. Limited Fabrication Process
   - Age Forming cannot be utilized.
   - Cannot be processed to “O-temper” product
     Formability of –O temper (annealed) is not available

- Therefore, it would be desirable to develop a 2xxx alloy in an artificially aged temper (T6 or T8 type temper) having DT capabilities of T3xx type temper product.
II. **Metallurgical benefits of Al-Cu-Mg-Ag alloy system**

Goal: 2xxx alloy in an artificially aged temper (T6 or T8 type temper) having Damage Tolerance (DT) and Durability (D) capabilities of T3xx type temper product.

<table>
<thead>
<tr>
<th>element</th>
<th>Si</th>
<th>Fe</th>
<th>Cu</th>
<th>Mn</th>
<th>Mg</th>
<th>Ag</th>
</tr>
</thead>
<tbody>
<tr>
<td>wt.%</td>
<td>0.1</td>
<td>0.15</td>
<td>4.5 - 5.5</td>
<td>0.20 - 0.6</td>
<td>0.20 - 0.8</td>
<td>0.15 - 0.6</td>
</tr>
</tbody>
</table>

**Metallurgical Attributes of Alloy 2139**

Major strengthening phase is $\Omega$(Al2Cu) phase
- $\Omega$ phase nucleates homogeneously in the grain matrix without cold work
- This leads to less GB precipitation and reduces propensity for intergranular fracture

Contains **no Zr** as a dispersoid forming element
- Reduces GB precipitation

Contains **Mn** as a dispersoid forming element
- Reduces Planar slip to improve Toughness

*note:This part has been published in the proceedings of The 10th International Conference of Aluminum Alloys at Vancouver, Canada, June 2006
Addition of small amounts of Mg and Ag to Al-Cu alloys promotes the nucleation of plate-like precipitates known as $\Omega$ (Al$_2$Cu) phase.

<table>
<thead>
<tr>
<th>alloy system</th>
<th>example alloys</th>
<th>strengthening phase</th>
<th>nucleation mode</th>
<th>cold work?</th>
</tr>
</thead>
<tbody>
<tr>
<td>Al-Cu</td>
<td>2219,2519</td>
<td>$\theta'$ (Al$_2$Cu)</td>
<td>heterogeneous</td>
<td>yes</td>
</tr>
<tr>
<td>Al-Cu-Mg</td>
<td>2024,2014</td>
<td>$S'$ (Al$_2$CuMg)</td>
<td>heterogeneous</td>
<td>yes</td>
</tr>
<tr>
<td>Al-Cu-Mg-Ag</td>
<td>2139</td>
<td>$\Omega$ (Al$_2$Cu)</td>
<td>homogeneous</td>
<td>no</td>
</tr>
<tr>
<td>Al-Zn-Mg</td>
<td>7039,7108</td>
<td>$\eta'$, $\eta$ (MgZn$_2$)</td>
<td>homogeneous</td>
<td>no</td>
</tr>
<tr>
<td>Al-Zn-Mg-Cu</td>
<td>7050,7075</td>
<td>$\eta'$, $\eta$ (MgZn$_2$)</td>
<td>homogeneous</td>
<td>no</td>
</tr>
</tbody>
</table>

*Homogeneous nucleation mechanism of $\Omega$ phase*

- achieve high strength without high level of cold work prior to artificial age.
- more uniform distribution of precipitates without relying on dislocations, sub-grain and grain boundaries as nucleation sites.
- less prone to intergranular and intersubgranular fracture after artificial age
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

III. Effect of dispersoid forming elements in 2139 – T8**

Optimization of Dispersoid Forming Element – Why Mn?

The experiments were conducted with industrial scale trials using full plant size ingots (13,000 lbs. ingots)

Comparison I
Dispersoid forming Elements; Mn vs. Zr

<table>
<thead>
<tr>
<th></th>
<th>Cu</th>
<th>Mg</th>
<th>Ag</th>
<th>Mn</th>
<th>Zr</th>
</tr>
</thead>
<tbody>
<tr>
<td>Alloy A (Mn)</td>
<td>4.90</td>
<td>0.46</td>
<td>0.38</td>
<td>0.32</td>
<td>0.002</td>
</tr>
<tr>
<td>Alloy B (Zr)</td>
<td>4.81</td>
<td>0.45</td>
<td>0.39</td>
<td>0.01</td>
<td>0.14</td>
</tr>
</tbody>
</table>

Comparison II
Dispersoid forming Elements; Mn vs. Mn + Zr

<table>
<thead>
<tr>
<th></th>
<th>Cu</th>
<th>Mg</th>
<th>Ag</th>
<th>Mn</th>
<th>Zr</th>
</tr>
</thead>
<tbody>
<tr>
<td>Alloy S (Mn)</td>
<td>4.95</td>
<td>0.45</td>
<td>0.34</td>
<td>0.26</td>
<td>0.001</td>
</tr>
<tr>
<td>Alloy P (Mn+Zr)</td>
<td>4.93</td>
<td>0.43</td>
<td>0.34</td>
<td>0.20</td>
<td>0.09</td>
</tr>
</tbody>
</table>

**note: This part has been published in the proceedings of The 10th International Conference of Aluminum Alloys at Vancouver, Canada, June 2006

Alex Cho (304-273-7038), Alcan Rolled Products LLC, December 8, 2006 NASA Contract no. NNL04AB64T with AS&M Inc.
Alloy A with Mn shows higher combination of Strength and Fracture Toughness

Effect of Dispersoid: Mn vs. Zr

1 inch ga 2139-T8 plate CT specimen B=1 in. W=3 in.

Effect of Dispersoid: Mn vs. Zr

1 inch ga 2139-T8 plate, M(T) specimen B=0.25 in. W=16 in.
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

Difference in Fracture Toughness between alloy A(w/Mn) and alloy B(w/Zr) becomes more pronounced at −65 deg F which is the service environment for aircraft flying at high altitude.

Fracture Toughness of 0.28 inch plate
Product Ga.; 0.28 inch, 16 inch wide panel test - center notched

![Fracture Toughness Graph](image-url)

- Alloy A (Mn)
- Alloy B (Zr)
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

SEM Fractography after fracture tests at –65 deg F

ALLOY A: Al-Cu-Mg-Ag-Mn alloy

ALLOY B: Al-Cu-Mg-Ag-Zr alloy

Figure 1. Fractography of A sample tested at -65°F (showing ductile fracture mode)

Figure 2. Fractography of B sample tested at -65°F (showing many areas with brittle fracture mode)

Alex Cho (304-273-7038), Alcan Rolled Products LLC, December 8, 2006 NASA Contract no. NNL04AB64T with AS&M Inc.
Alloy A(w/Mn) shows better ballistic performance, compared to Alloy B(w/Zr).

**Effect of Dispersoid on Ballistic Performance**

1 inch ga 2139-T8 plate are tested per MIL-DTL-46192C

![Graph showing ballistic performance](image)

- **Note:** FSP; Fragmented Shrapnel Penetration tests
- AP; Armor Piercing tests
Adding Zr to Al-Cu-Mg-Ag-Mn alloy lowers Fracture Toughness

- This indicates that Zr containing dispersoids could be detrimental to Damage Tolerance of Al-Cu-Mg-Ag alloy in T8 temper
Large particles of Mn containing dispersoids in Al-Cu-Mg-Ag-Mn alloy

Note: Both figures are under identical magnification.
Zr-containing particles at (sub)grain boundaries provide nucleation sites for Cu-containing particles

Fig. a) BF image of $\theta'$ phase ($\text{Al}_2\text{Cu}$) formed at $\text{Al}_3\text{Zr}$

Fig. b) DF image shows $\theta'$ in the matrix and $\text{Al}_3\text{Zr}$ by using $\theta'$ reflection

Note: Fig. a and Fig. b are under identical magnification.
Zr-containing particles at (sub)grain boundaries provide nucleation sites for Cu-containing particles.

- This would weaken grain boundaries by further promoting boundary precipitation and PFZ’s.

Alloys with weak g.b. strengths are more prone to intergranular fracture at very low service temperatures or at extremely high deformation rates typical of ballistic impact.
Schematic Diagram of Deformation Mode for G.B. Failures
Homogeneous deformation requires both cross slip and planar slip mechanisms

Cross slip mechanism
- Thermally activated process
- Relying on diffusion kinetics

At Low Temp. or At Very High Deformation rate
- Cross Slip mechanism is less favored
- Planar Slip mode becomes dominant
Damage Tolerance Capability of 2139 plate can be evaluated by comparing to the commonly used Damage Tolerant Al alloys in Aerospace and Military Applications

2324-T39; Lower wing plate for large commercial Airplanes (1-1.5”)
   - best fatigue resistant Al alloy

2124-T8151; Ribs & Spars for Fighter plane (1”- 6”)
   - best fracture toughness in 2xxx-T8xx product

7475-T7351; Lower Wing for Small Airplanes (1.5” - 4”)
   - best fracture toughness in 7xxx-T7xx product

7050-T7451; Ribs & Spars for all aircraft (1.5” - 8”(10”))
   - most commonly used alloy for thick gauge application for good combined properties

2519-T87; Armor plate application (1” – 6”)
   - best ballistic performance
Property Summary of 1“ ga. 2139-T8 Plate

- **Plane Stress Fracture Toughness in L-T**
  - M(T) B=0.25 in.(6.3mm) W=16 in.(406mm)
  - 2139-T8; W=30 in., T= - 65 F

- **Corrosion Resistance**
  - SCC: Passed at 30, 35 & 40 ksi for 20 days when tested in ST per ASTM G47 by ASTM G-38
  - EXCO = EA @ T/2, EB @ T/10, when tested per ASTM G34
### Property Summary of 1" ga. 2139-T8 Plate

**Double Open Hole Axial Fatigue Tests on 1.0 in. ga. 2139-T8 Plate**

L -dir. at T/2  
Max. Stress; 20 ksi, R-Ratio; 0.1  
Freq.; 15 Hz

<table>
<thead>
<tr>
<th>S.N.</th>
<th>Cycle to Fail</th>
<th>Fail. Loc.</th>
<th>S.N.</th>
<th>Cycle to Fail</th>
<th>Fail. Loc.</th>
<th>S.N.</th>
<th>Cycle to Fail</th>
<th>Fail. Loc.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1,500,000</td>
<td>Discont.</td>
<td>1</td>
<td>599,342</td>
<td>A-Hole</td>
<td>1</td>
<td>953,753</td>
<td>B-Hole</td>
</tr>
<tr>
<td>2</td>
<td>1,500,000</td>
<td>Discont.</td>
<td>2</td>
<td>260,582</td>
<td>B-Hole</td>
<td>2</td>
<td>224,820</td>
<td>A-Hole</td>
</tr>
<tr>
<td>3</td>
<td>1,500,000</td>
<td>Discont.</td>
<td>3</td>
<td>249,950</td>
<td>A-Hole</td>
<td>3</td>
<td>266,575</td>
<td>A-Hole</td>
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<tr>
<td>4</td>
<td>842,407</td>
<td>A-Hole</td>
<td>4</td>
<td>229,226</td>
<td>B-Hole</td>
<td>4</td>
<td>177,150</td>
<td>A-Hole</td>
</tr>
<tr>
<td>5</td>
<td>873,461</td>
<td>A-Hole</td>
<td>5</td>
<td>243,678</td>
<td>B-Hole</td>
<td>5</td>
<td>292,459</td>
<td>B-Hole</td>
</tr>
</tbody>
</table>

Avg. 1,199,521  
Avg. 293,569  
Avg. 312,104
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

**Property Summary of 1“ ga. 2139-T8 Plate**

**Ballistic Performance of 1.0 in. ga. 2139-T8 plate**

1 inch ga 2139-T8 & 2519-T87 plates are tested per MIL-DTL-46192C

![Graph showing ballistic performance](image)

**Note:** FSP; Fragmented Shrapnel Penetration tests  AP; Armor Piercing tests

Alex Cho (304-273-7038), Alcan Rolled Products LLC, December 8, 2006 NASA Contract no. NNL04AB64T with AS&M Inc.
Property Summary of 1“ ga. 2139-T8 Plate

1. Fracture toughness of 2139-T8 plate exceeded that of 2324-T39 and 7475-T7351 plate

2. Fatigue Resistance of 2139-T8 plate exceeded that of 2324-T39 plate

3. Ballistic performance of 2139-T8 plate exceeded that of 2519-T87 plate

4. 2139-T8 plate showed good SCC resistance and EXCO test results
IV. Development of 2139 thick gauge plate product

To evaluate the Damage Tolerance capability of thick gauge plate product, three gauges of 2139-T8 plate were produced from the two plant size ingots (13,000 lbs. ingots)

- 2.0 inch (51 mm)
- 4.25 inch (108 mm)
- 6.125 inch (156 mm)

Chemistry of two 2139 alloy ingots

<table>
<thead>
<tr>
<th></th>
<th>Cu</th>
<th>Mg</th>
<th>Mn</th>
<th>Ag</th>
<th>Zr</th>
</tr>
</thead>
<tbody>
<tr>
<td>min</td>
<td>4.5</td>
<td>0.2</td>
<td>0.2</td>
<td>0.15</td>
<td>0</td>
</tr>
<tr>
<td>max</td>
<td>5.5</td>
<td>0.8</td>
<td>0.6</td>
<td>0.6</td>
<td>0.03</td>
</tr>
</tbody>
</table>
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

Damage Tolerance of 2139-T8 Thick Plate

Effect of Plate Gauge on TYS in L-dir. of 2139-T8

![Graph showing the effect of plate gauge on TYS in the L-direction for different alloys: 2124-T8151, 7050-T7451, 2139-T8. The graph plots plate gauge (inch) on the x-axis and TYS (ksi) in the L-direction on the y-axis. The data points are distributed across different gauges for each alloy, with 2139-T8 showing the highest TYS values.]
### Mechanical Properties of 2 inch gauge 2139-T8 plate

<table>
<thead>
<tr>
<th>Age condition</th>
<th>Test dir.</th>
<th>UTS (ksi)</th>
<th>TYS (ksi)</th>
<th>Elong. (%)</th>
<th>K1c (ksi√in.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>L</td>
<td>68.9</td>
<td>65.7</td>
<td>15.0</td>
<td>57.8</td>
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<tr>
<td></td>
<td>LT</td>
<td>71.9</td>
<td>65.1</td>
<td>9.0</td>
<td>46.5</td>
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<tr>
<td></td>
<td>ST</td>
<td>69.3</td>
<td>62.0</td>
<td>9.5</td>
<td>34.4*</td>
</tr>
<tr>
<td>2</td>
<td>L</td>
<td>68.9</td>
<td>65.5</td>
<td>14.0</td>
<td>58.2*</td>
</tr>
<tr>
<td></td>
<td>LT</td>
<td>71.2</td>
<td>64.3</td>
<td>9.0</td>
<td>44.5</td>
</tr>
<tr>
<td></td>
<td>ST</td>
<td>70.4</td>
<td>63.4</td>
<td>11.0</td>
<td>40.3*</td>
</tr>
</tbody>
</table>

L-T, T-L; tested at t/4 location with B=2", W=4"
S-L; tested at t/2 with B=0.75", W=1.5"
*; invalid per Invalidity criteria #1 in ASTM E399-05
Damage Tolerance of 2139-T8 Thick Plate

2 inch (51 mm) plate

Plane Strain Fracture Toughness of 2 inch ga. Plate
2139-T8, 7475-T7351 & 2124-T8151

Development of new Al-Cu-Mg-Ag based alloy (2139) plate

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**Damage Tolerance of 2139-T8 Thick Plate**

*2 inch (51 mm) plate*

**Fatigue Crack Growth Rate in L-T**

Temperature: +75  R-Ratio: 0.1  Lab Air, 10 Hz

![Graph showing fatigue crack growth rate](image)

- 2324-T39; 1.0 in. ga
- 7475-T7351; 1.75 in. ga
- 2139-T8; 2.0 in. ga
# Development of new Al-Cu-Mg-Ag based alloy (2139) plate

## Mechanical Properties of 4.25 inch gauge 2139-T8 plate

<table>
<thead>
<tr>
<th>Age condition</th>
<th>Test dir.</th>
<th>UTS(ksi)</th>
<th>TYS(ksi)</th>
<th>Elong.(%)</th>
<th>K1c(ksi*Vin.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Age 1</td>
<td>L</td>
<td>71.5</td>
<td>66.8</td>
<td>13.0</td>
<td>44.4</td>
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<td></td>
<td>LT</td>
<td>72.8</td>
<td>65.9</td>
<td>9.5</td>
<td>36.8</td>
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<td></td>
<td>ST</td>
<td>67.9</td>
<td>59.7</td>
<td>6.4</td>
<td>34.6</td>
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<tr>
<td>Age 2</td>
<td>L</td>
<td>72.2</td>
<td>67.1</td>
<td>13.0</td>
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</tr>
<tr>
<td></td>
<td>LT</td>
<td>73.0</td>
<td>66.4</td>
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<td>LT</td>
<td>73.5</td>
<td>66.6</td>
<td>8.0</td>
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<td>ST</td>
<td>68.7</td>
<td>61.2</td>
<td>5.7</td>
<td>34.2</td>
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</table>

L-T, T-L; tested at t/4 location with B=2", W=4"
S-L; tested at t/2 with B=0.75", W=1.5"
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

**Damage Tolerance of 2139-T8 Thick Plate**

*4.25 inch (108 mm) plate*

**Fracture Toughness of 4.25" in L-T**

2139-T8, 2124-T8151 & 7050-T745

**Fracture Toughness of 4.25" in T-L**

2139-T8, 7050-T7451 & 2124-T8151

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Development of new Al-Cu-Mg-Ag based alloy (2139) plate

**Damage Tolerance of 2139-T8 Thick Plate**

*4.25 inch (108 mm) plate*

---

**Fracture Toughness of 4.25" in S-L**

2139-T8, 7050-T7451 & 2124-T8151

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**Comparison of FCGR in L-T**

Temp: +75° R-Ratio: 0.1 Lab Air Freq: 10

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Alex Cho (304-273-7038), Alcan Rolled Products LLC, December 8, 2006 NASA Contract no. NNL04AB64T with AS&M Inc.
## Development of new Al-Cu-Mg-Ag based alloy (2139) plate

### Mechanical Properties of 6.125 inch gauge 2139-T8 plate

<table>
<thead>
<tr>
<th>Age condition</th>
<th>Test dir.</th>
<th>UTS(ksi)</th>
<th>TYS(ksi)</th>
<th>Elong.(%)</th>
<th>K1c(ksi*in.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Age 1</td>
<td>L</td>
<td>73.1</td>
<td>68.1</td>
<td>12.0</td>
<td>33.0</td>
</tr>
<tr>
<td></td>
<td>LT</td>
<td>73.7</td>
<td>66.0</td>
<td>9.5</td>
<td>32.2</td>
</tr>
<tr>
<td></td>
<td>ST</td>
<td>67.2</td>
<td>59.3</td>
<td>4.7</td>
<td>36.5</td>
</tr>
<tr>
<td>Age 2</td>
<td>L</td>
<td>72.9</td>
<td>67.4</td>
<td>10.0</td>
<td>32.9</td>
</tr>
<tr>
<td></td>
<td>LT</td>
<td>73.4</td>
<td>65.5</td>
<td>9.5</td>
<td>32.2</td>
</tr>
<tr>
<td></td>
<td>ST</td>
<td>67.8</td>
<td>60.2</td>
<td>4.7</td>
<td>33.9</td>
</tr>
<tr>
<td>Age 3</td>
<td>L</td>
<td>72.7</td>
<td>67.5</td>
<td>9.5</td>
<td>32.3</td>
</tr>
<tr>
<td></td>
<td>LT</td>
<td>73.6</td>
<td>66.2</td>
<td>8.0</td>
<td>31.9</td>
</tr>
<tr>
<td></td>
<td>ST</td>
<td>68.1</td>
<td>59.8</td>
<td>6.1</td>
<td>33.5</td>
</tr>
</tbody>
</table>

L-T, T-L; tested at t/4 location with B=2", W=4"
S-L; tested at t/2 with B=0.75", W=1.5"
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

**Damage Tolerance of 2139-T8 Thick Plate**

*6.125 inch (156 mm) plate*

**Fracture Toughness of 6.125" in L-T**

2139-T8, 7050-T7451(6") & 2124-T8151(6")

**Fracture Toughness of 6.125" in T-L**

2139-T8, 7050-T7451(6") & 2124-T8151(6")

Alex Cho (304-273-7038), Alcan Rolled Products LLC, December 8, 2006  NASA Contract no. NNL04AB64T with AS&M Inc.
**Damage Tolerance of 2139-T8 Thick Plate**

**6.125 inch (156 mm) plate**

### Fracture Toughness of 6.125" in S-L

<table>
<thead>
<tr>
<th>Material</th>
<th>TYS in ST dir. (ksi)</th>
<th>K\textsubscript{1c} (ksi√m) in S-L</th>
</tr>
</thead>
<tbody>
<tr>
<td>2139-T8</td>
<td>58-62</td>
<td>30-35</td>
</tr>
<tr>
<td>7050-T7451</td>
<td>56-60</td>
<td>25-30</td>
</tr>
<tr>
<td>2124-T8151</td>
<td>52-56</td>
<td>20-25</td>
</tr>
</tbody>
</table>

### Comparison of FCGR in L-T

- **Room temp. R-Ratio: 0.1**
- **Lab Air Freq.: 10**

- **2139-T8; 6.125 in.**
- **2124-T8151; 4.0 in.**
- **7050-T7451; 5.0 in.**

**Graphs:**
- Fracture Toughness: TYS vs. K\textsubscript{1c}
- Comparison of FCGR: ΔK vs. da/dn
Texture components (volume %) of 2139-T3 plate at two through-thickness locations from four different gauge plates

### Volume% of Texture components of 2139 -T3 plate at t/2 location

<table>
<thead>
<tr>
<th>Alloy</th>
<th>Gauge(inch)</th>
<th>Temper</th>
<th>Location</th>
<th>Cube</th>
<th>Goss</th>
<th>Brass</th>
<th>S</th>
<th>Cu</th>
<th>R-Cube</th>
<th>Cube+Goss</th>
<th>Brass+S</th>
</tr>
</thead>
<tbody>
<tr>
<td>2139</td>
<td>1</td>
<td>T3</td>
<td>t/2</td>
<td>10.7</td>
<td>2.0</td>
<td>5.0</td>
<td>7.8</td>
<td>3.6</td>
<td>2.3</td>
<td>12.6</td>
<td>12.8</td>
</tr>
<tr>
<td>2139</td>
<td>2</td>
<td>T3</td>
<td>t/2</td>
<td>3.0</td>
<td>2.1</td>
<td>3.7</td>
<td>5.4</td>
<td>2.4</td>
<td>6.8</td>
<td>5.0</td>
<td>9.0</td>
</tr>
<tr>
<td>2139</td>
<td>4.25</td>
<td>T3</td>
<td>t/2</td>
<td>5.0</td>
<td>2.1</td>
<td>2.6</td>
<td>4.1</td>
<td>2.4</td>
<td>8.1</td>
<td>7.1</td>
<td>6.7</td>
</tr>
<tr>
<td>2139</td>
<td>6.125</td>
<td>T3</td>
<td>t/2</td>
<td>4.5</td>
<td>2.7</td>
<td>4.6</td>
<td>6.0</td>
<td>3.5</td>
<td>3.5</td>
<td>7.1</td>
<td>10.6</td>
</tr>
</tbody>
</table>

### Volume% of Texture components of 2139 -T3 plate at t/4 location

<table>
<thead>
<tr>
<th>Alloy</th>
<th>Gauge(inch)</th>
<th>Temper</th>
<th>Location</th>
<th>Cube</th>
<th>Goss</th>
<th>Brass</th>
<th>S</th>
<th>Cu</th>
<th>R-Cube</th>
<th>Cube+Goss</th>
<th>Brass+S</th>
</tr>
</thead>
<tbody>
<tr>
<td>2139</td>
<td>1</td>
<td>T3</td>
<td>t/4</td>
<td>6.2</td>
<td>1.6</td>
<td>5.3</td>
<td>9.2</td>
<td>4.9</td>
<td>4.1</td>
<td>7.9</td>
<td>14.4</td>
</tr>
<tr>
<td>2139</td>
<td>2</td>
<td>T3</td>
<td>t/4</td>
<td>3.4</td>
<td>3.4</td>
<td>5.6</td>
<td>8.0</td>
<td>2.3</td>
<td>6.1</td>
<td>6.7</td>
<td>13.6</td>
</tr>
<tr>
<td>2139</td>
<td>4.25</td>
<td>T3</td>
<td>t/4</td>
<td>4.4</td>
<td>1.9</td>
<td>8.4</td>
<td>11.7</td>
<td>4.1</td>
<td>2.9</td>
<td>6.3</td>
<td>20.1</td>
</tr>
<tr>
<td>2139</td>
<td>6.125</td>
<td>T3</td>
<td>t/4</td>
<td>2.8</td>
<td>2.7</td>
<td>7.6</td>
<td>10.6</td>
<td>5.0</td>
<td>3.6</td>
<td>5.4</td>
<td>18.2</td>
</tr>
</tbody>
</table>

Note:
Cube : {100}<100>  Goss ; {011}<100>  S ; {123}<634>  Brass ; {011}<211>  Cu ; {112}<111>  Rotated Cube ; {100}<011>
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

Texture components (vol%) of 2139-T3 plate at t/4

- Cube
- Goss
- Brass
- S
- Cu
- R-Cube

Volume %

1 inch ga.
2 inch ga.
4.25 inch ga.
6.125 inch ga.
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

Recrystallization (Cube & Goss) and Deformation (S & Brass) components of 2139-T3 plate at t/4

![Graph showing volume percentage of Cube, Goss, Brass, and S components against plate gauge in inches.](image-url)
Development of new Al-Cu-Mg-Ag based alloy (2139) plate

SSC tests of 2139-T8 plate in ST direction per ASTM G47 by ASTM G-38

<table>
<thead>
<tr>
<th>Test Specimen</th>
<th>Plate Ga.(in)</th>
<th>Age (hours)</th>
<th>Test Plane</th>
<th>Test Orient.</th>
<th>Applied Stress(ksi)</th>
<th>Pass /Fail</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2</td>
<td>24</td>
<td>t/2</td>
<td>ST</td>
<td>30</td>
<td>Pass</td>
</tr>
<tr>
<td>2</td>
<td>2</td>
<td>24</td>
<td>t/2</td>
<td>ST</td>
<td>30</td>
<td>Pass</td>
</tr>
<tr>
<td>3</td>
<td>2</td>
<td>24</td>
<td>t/2</td>
<td>ST</td>
<td>30</td>
<td>Pass</td>
</tr>
<tr>
<td>1</td>
<td>4.25</td>
<td>24</td>
<td>t/2</td>
<td>ST</td>
<td>30</td>
<td>Pass</td>
</tr>
<tr>
<td>2</td>
<td>4.25</td>
<td>24</td>
<td>t/2</td>
<td>ST</td>
<td>30</td>
<td>Pass</td>
</tr>
<tr>
<td>3</td>
<td>4.25</td>
<td>24</td>
<td>t/2</td>
<td>ST</td>
<td>30</td>
<td>Pass</td>
</tr>
<tr>
<td>1</td>
<td>6.125</td>
<td>20</td>
<td>t/2</td>
<td>ST</td>
<td>30</td>
<td>Pass</td>
</tr>
<tr>
<td>2</td>
<td>6.125</td>
<td>20</td>
<td>t/2</td>
<td>ST</td>
<td>30</td>
<td>Pass</td>
</tr>
<tr>
<td>3</td>
<td>6.125</td>
<td>20</td>
<td>t/2</td>
<td>ST</td>
<td>30</td>
<td>Pass</td>
</tr>
</tbody>
</table>
V. Summary & Conclusion

1. 2139-T8 thick plate was evaluated in three gauges, 2.0“(51mm), 4.25“(108mm) and 6.125“(156mm)

2. 2139-T8 plate did not show loss in strength as gauge increases as seen in other 2xxx-T8xx plate products. Instead, 2139-T8 plate maintained strength levels comparable to 7050-T7451 in all gauges tested

3. Combined properties of strength and fracture toughness in three testing directions exceeded those of other conventional damage tolerant Al alloys in all three gauges

4. 2139-T8 plate showed exceptionally good FCG Resistance in all three gauges

5. Over all, 2139-T8 thick plate demonstrated superior DT capability, compared to 2324-T39, 7475-T7351, 2124-T8151, and 7050-T7451 in comparable gauges tested so far - up to 6 inches thick (156mm)
This final report supplement in presentation format describes a comprehensive multi-tasked contract study to continue the development of the silver-bearing alloy now registered as aluminum alloy 2139 by the Aluminum Association. Two commercial scale ingots were processed into nominal plate gauges of two, four and six inches, and were extensively characterized in terms of metallurgical and crystallographic structure, and resulting mechanical properties. This report includes comparisons of the property combinations for this alloy and 2XXX and 7XXX alloys more widely used in high performance applications. Alloy 2139 shows dramatic improvement in all combinations of properties, moreover, the properties of this alloy are retained in all gauge thicknesses, contrary to typical reductions observed in thicker gauges of the other alloys in the comparison. The advancements achieved in this study are expected to result in rapid, widespread use of this alloy in a broad range of ground based, aircraft, and spacecraft applications.