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Korrosion hos metaller och legeringar – Korrosionsprovning i vatten av zirkoniumlegeringar för användning i kärnkraftsreaktorer (ISO 10270:1995 inklusive Cor 1:1997)

Corrosion of metals and alloys – Aqueous corrosion testing of zirconium alloys for use in nuclear power reactors (ISO 10270:1995 including Cor 1:1997)

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The European Standard EN ISO 10270:2008 has the status of a Swedish Standard. This document contains the official English version of EN ISO 10270:2008.

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EUROPEAN STANDARD
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English Version

Corrosion of metals and alloys - Aqueous corrosion testing of zirconium alloys for use in nuclear power reactors (ISO 10270:1995, including Cor 1:1997)

Corrosion des métaux et alliages - Essais de corrosion aqueuse des alliages de zirconium utilisés dans les réacteurs nucléaires (ISO 10270:1995, Cor 1:1997 inclus)

Korrosion von Metallen und Legierungen - Korrosionsprüfung in wässrigen Lösungen für in Kernreaktoren angewendete Zirkoniumlegierungen (ISO 10270:1995, Cor 1:1997 einschließlich)

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Foreword

The text of ISO 10270:1995, including Cor 1:1997 has been prepared by Technical Committee ISO/TC 156 "Corrosion of metals and alloys" of the International Organization for Standardization (ISO) and has been taken over as EN ISO 10270:2008 by Technical Committee CEN/TC 262 "Metallic and other inorganic coatings" the secretariat of which is held by BSI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2008, and conflicting national standards shall be withdrawn at the latest by October 2008.

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The text of ISO 10270:1995, including Cor 1:1997 has been approved by CEN as a EN ISO 10270:2008 without any modification.

Corrosion of metals and alloys — Aqueous corrosion testing of zirconium alloys for use in nuclear power reactors

WARNING — This International Standard may involve the use of hazardous materials, operations and equipment (see clause 9). It is the responsibility of whoever uses this International Standard to consult and establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

1 Scope

This International Standard specifies:

- a) the determination of mass gain;
- b) the surface inspection of products of zirconium and its alloys when corrosion tested in water at 360 °C or in steam at or above 400 °C;
- c) that the tests in steam shall be performed at 10,3 MPa (1 500 psi).

This International Standard is applicable to wrought products, castings, powder metallurgy products and weld metals.

This method has been widely used in the development of new alloys, heat treating practices and for the evaluation of welding techniques, and should be utilized in its entirety to the extent specified for a product acceptance test, rather than merely a means of assessing performance in service.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below.

Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 5813:1983, *Water quality — Determination of dissolved oxygen — Iodometric method.*

ISO 5814:1990, *Water quality — Determination of dissolved oxygen — Electrochemical probe method.*

3 Definitions

For the purposes of this International Standard, the following definitions apply.

3.1 etching: A process for removal of surface metal by action of acids in water.

3.2 control coupons: Zirconium alloy specimens of known performance used to monitor the validity of the test.

3.3 high mass gain coupons: Zirconium alloy specimens that have been specially heat-treated to produce a mass gain higher than the maximum given in materials acceptance specifications and which are used for verifying the severity of the test procedure.

4 Principle

Specimens of zirconium or its alloys are exposed to high-pressure water or steam at elevated temperatures for 72 h or 336 h. The corrosion is normally measured by the gain in mass of the specimens and

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by the appearance of an oxide film on the specimen surfaces. In some instances, such as weld evaluation, mass gain measurements are either impractical to make or are not required. When so specified, the appearance of the specimen shall be the sole criterion for acceptance. The test pressure in steam shall be 10,3 MPa (1 500 psi).

5 Significance

5.1 Specimens are normally tested after careful etching and rinsing. Specimens with as-manufactured surfaces may also be tested without further surface removal.

5.2 When tubing with a second material clad on the surface is to be tested, the cladding shall be removed prior to the test.

6 Interference

Autoclave loads that have one or more specimens showing gross oxidation may, by contamination of the environment, affect results of other specimens in the autoclave.

7 Reagents and materials

During the test, unless otherwise stated, only reagents of recognized analytical grade and only water as described in 7.4 or 7.5 shall be used.

7.1 Argon gas, welding grade.

7.2 Nitrogen gas for purging or controlling oxygen content.

7.3 Argon-hydrogen mixture for purging to remove oxygen.

7.4 Grade A water — purified water having an electrical resistivity of not less than 1 M Ω ·cm at 25 °C as measured before the start of the test.

7.5 Grade B water — deionized or demineralized water having an electrical resistivity of not less than 0,5 M Ω ·cm at 25 °C. Grade A water can be used instead of grade B water.

7.6 Detergents and solvents for specimen cleaning including ethanol and acetone.

7.7 Concentrated hydrofluoric acid (HF).

7.8 Concentrated nitric acid (HNO₃).

7.9 Concentrated sulfuric acid (H₂SO₄).

7.10 Control coupons, as defined in 3.2.

7.11 High mass gain coupons, as defined in 3.3.

8 Apparatus

8.1 General

The apparatus shall consist of equipment for

- a) etching the specimens when required;
- b) measuring the specimens', surface area and mass, the water resistivity and pH, the test temperature and pressure, the etch and rinse temperature;
- c) performing the water or steam corrosion tests at elevated temperatures and pressures.

8.2 Etching equipment, comprising an acid bath, a running water rinse and a deionized water rinse needed for proper metal removal and stain-free rinsing. Polyethylene or polypropylene tanks are commonly used with a bottom feed for running water rinses. Specimen hangers are generally made of type 300 series stainless steel. When many specimens are processed, a mechanical dipper for the etching process is useful.

8.3 Autoclaves, constructed of type 300 series stainless steel or nickel base alloys such as UNS grade N06600 or N06690 and manufactured to conform to government regulations governing unfired pressure vessels. The autoclave is fitted with devices for measurement and control of pressure and temperature, safety devices and venting valves. Control systems for pressure and temperature shall be adequate to meet the requirements of this International Standard. Sample holders and other internal accessories are also constructed of type 300 or type 400 series stainless steel, or nickel-base alloys such as UNS grade N06600 or N06690.

8.4 Specimen size measuring equipment, accurate to 50 μ m.

8.5 Analytical balance, accurate to 0,1 mg.

9 Hazards

9.1 The chemicals used in preparing specimens for this test are hazardous. Detailed information on safe handling of organic compounds, acids and products of zirconium and its alloys should be obtained from competent sources.

9.2 High-temperature, high-pressure autoclave operation must be in accordance with government regulations and manufacturer's instructions.

9.3 Hydrogen gas used for addition to the autoclave steam supply must be handled in accordance with guidelines for explosives and inflammable substances.

9.4 Cold water should not be added directly to the autoclave vessel in order to accelerate cooling upon the completion of testing.

10 Sampling, test specimens and test units

10.1 The size and the quantity of the test specimens, the method of selection, surface preparation and test acceptance criteria shall be specified in the product specification or by agreement between the purchaser and the seller as stated in the purchase contract. Total surface area for each specimen shall be a minimum 10 cm².

10.2 Each specimen and control coupon shall be individually identified.

11 Preparation of apparatus

11.1 General requirements for new or reworked autoclaves (8.3) and parts of autoclaves previously used for testing materials other than in accordance with this International Standard are as follows.

11.1.1 Before specimens are tested in a new or reworked autoclave, or in one having new valves, tubing, gaskets, etc., which are in contact with the test specimen, clean the apparatus thoroughly, wipe with ethanol or acetone (7.6), and rinse twice with grade B water (7.5). Dry the autoclave or auxiliary equipment by vacuum cleaning or drain and wipe with a clean, lint-free cloth and inspect carefully to ensure freedom from contamination. There should be no visible contamination, such as lubricant, residues, dust

or dirt, loose oxides or rust, or an oil or grease film on the water surface, internal surface, gasket or head surfaces.

11.1.2 Clean all new and reworked fixtures and jigs to be used in the autoclave and rinse in hot grade B water. Autoclave the fixtures and jigs for at least 1 day at 400 °C in steam at 10,3 MPa or, preferably, at 360 °C in water. Inspect the parts for corrosion products. If corrosion products are found or electrical resistivity of the residual water after the test measures less than 0,1 MΩ·cm, clean and autoclave the parts again.

11.2 General requirements for autoclaves and parts in continuous use for corrosion testing under this International Standard are as follows.

All autoclaves, fixtures, parts and jigs that have been in continuous use and have shown satisfactory behaviour in prior tests shall be rinsed with grade B water. The fixtures and jigs for corrosion products shall be inspected after each test and items showing loose corrosion products, shall be re-worked and re-prepared.

12 Calibration and standardization

12.1 High mass gain coupon preparation

High mass gain coupons (7.11) shall be selected from a previously tested lot. The selected material shall be specially heat treated prior to exposure in order to produce the desired mass gain in the autoclave test. Heating for 8 h at 900 °C and cooling to 300 °C at a rate not exceeding 3,3 °C/min in an inert atmosphere or vacuum is a suggested procedure, but alternative procedures can be used. This treatment shall be used in the case of Zircalloy type alloys. Other alloy types may require different heat treatment.

12.2 Autoclaves

12.2.1 Prior to use for product acceptance testing, an autoclave shall be profiled thermally as in 12.4.2 and shall demonstrate acceptability by testing at least three control coupons, one each at the top, middle and bottom of a useful volume. The test results shall be incorporated in the certification document for the autoclave acceptance test. When desired, high mass gain coupons may also be used.

The new or used autoclave is considered acceptable if each control coupon mass gain is reproducible within the previously established control coupon mean mass gain, ± 3 standard deviations.

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12.2.2 The control coupon lot (7.10) and, when desired, the high mass gain coupon lot (7.11) mass gain mean and standard deviation shall be established by a minimum of one autoclave test as follows.

Randomly select 12 specimens from either the control coupon lot or the high mass gain coupon lot or both.

Prepare all specimens in accordance with 13.4 in order to meet the pretest requirements of this International Standard.

Locate the 12 or 24 specimens in a fixture or jig (see figure 1), and place the fixture or jig inside the useful volume of the autoclave.

Complete the steam or water corrosion test in accordance with any one of the four methods in section 14.3.

Remove specimens and weigh in accordance with the requirement of this International Standard.

Calculate and establish the mass gain mean and standard deviation [$(n - 1)$ method] of each set of coupons for the test method used.

NOTE 1 For the product acceptance tests, the mean value and standard deviation for the control coupons may be the value established as described above or it may be calculated periodically using all accepted values determined over the preceding three-month period but not less than 21 values.

12.2.3 An alternative method for establishing the mass gain mean and standard deviation is as follows.

Expose the control coupons to be used in three different tests. In each test a minimum of one specimen should be exposed in each of the top, middle and bottom positions of the autoclave. Determine the mass gain.

The mean value for control coupons is the mean for the three tests and three positions.

The standard deviation for the control coupon lot is calculated by the $(n - 1)$ method using the data from all of the control coupons taken from the same material lot.

12.3 Use of control coupons

12.3.1 Each autoclave run used for acceptance of product shall contain at least three control coupons with one at the top, one at the middle and one at the bottom of the specimen load.

12.3.2 The control coupons may be as manufactured or etched before testing, but if etched, the surfaces shall exhibit no stains, pits or areas of abnormal etching attack.

12.3.3 An autoclave test shall be considered acceptable only if each post-test control coupon mass gain is not less than the established mean value $- 3$ standard deviations and the visual appearance of each control coupon is equal to or better than the product acceptance standard. If a control coupon post-test mass gain exceeds the mean value $+ 3$ standard deviations, or the specified mass gain value and one or more test specimens from the corresponding location in the autoclave fail to meet the mass gain acceptance criterion, the failed specimen(s) may be discarded and a new test made to determine conformance.

12.3.4 Control coupons may be re-used after mechanical removal of oxide film followed by etching as described in 13.4.1.

12.4 Calibration

12.4.1 The temperature measurement and recording systems used to determine conformance shall be calibrated at least every six months and shall not deviate more than ± 3 °C from the calibration reference materials traceable to national standards.

12.4.2 Vertical thermal profiles of the autoclaves at the test temperatures shall be made at least once in each six-month period, or whenever the heaters or the control thermocouples are adjusted or replaced. The axial extent of the autoclave used for performing the product acceptance testing shall be restricted to the volume shown to be within ± 3 °C of the recorded autoclave temperature, after temperature compensation for calibration of the thermocouples. This volume is considered the useful volume. The profile thermocouples may be located at the centre or near the radial extremity of the autoclave volume.

12.4.3 Pressure-measuring devices shall be calibrated annually and the recorded reading shall be within $\pm 0,35$ MPa of the calibrated device over the range used for testing.

13 Conditioning

13.1 Test water quality

The water used to conduct the corrosion test shall be grade A water (7.4) and have an oxygen content not exceeding 45 µg/g. The oxygen content specification may be met either by direct measurement using the

appropriate method specified in ISO 5813 or ISO 5814 or by the use of venting method A or B specified in 14.3.

13.2 Autoclave load restrictions

The surface area of specimens loaded in a static autoclave should not exceed 0,1 m²/l of autoclave volume.

13.3 Test conditions

13.3.1 Temperature

The recorded temperature within the volume used for testing shall be the specified value ± 3 °C for steam tests, and ± 6 °C for water tests.

13.3.2 Pressure

The recorded pressure shall be as specified $\pm 0,7$ MPa for steam tests and $\pm 1,4$ MPa for water tests.

13.3.3 Time

The recommended exposure times are 3 days or 14 days. The exposure time tolerance at the specified temperature and pressure shall be ${}^{+8}_0$ h. The time at specified conditions need not be continuous.

13.3.4 Tests

Tests where temperature or pressure limits or both are exceeded for not more than 10 % of the nominal test time, but where control coupons indicate satisfactory behaviour may, at the discretion of the test laboratory, be deemed acceptable.

13.4 Specimen preparation

13.4.1 Etched specimens

Specimens should be thoroughly cleaned prior to acid etching (3.1) and carefully rinsed to prepare the surfaces for testing in a manner that eliminates the effects of machining, grinding or other techniques used to obtain a specimen of the desired site. Any etching technique that produces a desired smooth and shiny finish free of stains may be used. Zirconium-niobium alloys etch to a matt finish. An example of a suitable procedure for etching and rinsing is given in annex A.

13.4.2 As-manufacturer specimens

These specimens should be thoroughly cleaned prior to testing to avoid contamination of the autoclave which could, in turn, adversely affect other specimens used in the test. The extent of specimen cleaning shall be specified by agreement between contracting parties. An example of a suitable cleaning procedure is given in annex A.

14 Procedure

14.1 Inspection of specimens

Examine the specimen for folds, cracks, blisters, foreign material, lustre, brown acid stain, etc. Discard or re-prepare any etched specimen exhibiting acid stain or dull surfaces.

14.2 Dimensions, weight and inspection

Measure each test specimen, either before or after testing, to ± 50 μ m and calculate the surface area rounded off to the nearest 1 mm². Weigh the specimens to the nearest 0,1 mg with the analytical balance (8.5). Check the balance with a calibrated mass in the appropriate range before use and zero it after each fourth weighing. Weigh the specimens when they are thoroughly dry and at the same temperature as the balance.

14.3 Autoclaving

14.3.1 Placing of test specimens

Place the clean and weighed test specimens on the clean fixtures in a manner which precludes specimen-to-specimen contact. Autoclaved (8.3) stainless steel type 300 or type 400 series washers or wire-mesh grids may be used as separators. Immediately before immersing in the autoclave (8.3) the fixtures containing the specimens may be rinsed in grade B water (7.5). Immediately before the operation, rinse the autoclave twice with grade B water. Place the specimens and fixtures in the useful volume of the cleaned and rinsed autoclave.

14.3.2 Venting method A

14.3.2.1 Water tests

It is necessary to determine the volume of water required to ensure that the parts being tested are covered with water during the entire test period. The means of achieving this is as follows.