VDM® Alloy 2120 MoN
Nicrofer 5821 hMoN
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VDM® Alloy 2120 MoN is a nickel-chromium-molybdenum alloy with particularly low carbon content and an addition of nitrogen, developed by VDM Metals. The material distinguishes itself through an outstanding corrosion resistance under reducing as well as under oxidizing conditions. Furthermore, VDM® Alloy 2120 MoN is characterized by superior strength compared to other C alloys.

VDM® Alloy 2120 MoN is characterized by:
- extraordinary resistance against pitting and crevice corrosion as well as against chlorine induced stress corrosion cracking
- excellent resistance against a huge number of corrosive media, beginning with strong reducing conditions right up to oxidizing conditions
- excellent resistance against mineral acids like sulfuric acid, hydrochloric acid
- good ductility
- good weldability
- intended application area of -196 to 450 °C (-320 to 842 °F)
- approval for pressure vessels according to ASME Code Section VIII Div 1; Section VIII Div 2, Class 1 applications.

<table>
<thead>
<tr>
<th>Designation</th>
<th>Standard</th>
<th>Material Designation</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>EN</td>
<td>2.4700</td>
</tr>
<tr>
<td></td>
<td>UNS</td>
<td>N06058</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Standards</th>
</tr>
</thead>
<tbody>
<tr>
<td>Product form</td>
</tr>
<tr>
<td>Strip</td>
</tr>
<tr>
<td>Rod and bar</td>
</tr>
<tr>
<td>Sheet and plate</td>
</tr>
<tr>
<td>Tube and pipe welded</td>
</tr>
<tr>
<td>Forging</td>
</tr>
</tbody>
</table>

*Solution annealed variation

Table 1 – Designations and standards
Chemical composition

<table>
<thead>
<tr>
<th></th>
<th>Ni</th>
<th>Cr</th>
<th>Mo</th>
<th>Fe</th>
<th>Cu</th>
<th>Al</th>
<th>W</th>
<th>Co</th>
<th>Si</th>
<th>Mn</th>
<th>N</th>
<th>S</th>
<th>C</th>
<th>P</th>
</tr>
</thead>
<tbody>
<tr>
<td>Min.</td>
<td>20.0</td>
<td></td>
<td>18.5</td>
<td></td>
<td>1.5</td>
<td>0.5</td>
<td>0.4</td>
<td>0.3</td>
<td>0.3</td>
<td>0.1</td>
<td>0.50</td>
<td>0.02</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Max.</td>
<td>bal.</td>
<td>23.0</td>
<td>21.0</td>
<td>1.5</td>
<td>0.5</td>
<td>0.4</td>
<td>0.3</td>
<td>0.1</td>
<td>0.5</td>
<td>0.15</td>
<td>0.01</td>
<td>0.01</td>
<td>0.015</td>
<td></td>
</tr>
</tbody>
</table>

Due to technical reasons this alloy may contain additional elements.

Table 2 – Chemical composition (%)

Physical properties

<table>
<thead>
<tr>
<th>Density</th>
<th>8.6 g/cm³ (537 lb/ft³) at 20 °C (68 °F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Melting range</td>
<td>1,330-1,370 °C (2,426-2,498 °F)</td>
</tr>
<tr>
<td>Relative magnetic permeability at 20 °C (68 °F)</td>
<td>The material is non-magnetic</td>
</tr>
</tbody>
</table>

Table 3 – Typical physical properties of VDM® Alloy 2120 MoN at elevated temperatures
Microstructural properties

VDM® Alloy 2120 MoN has a face-centered cubic structure. In the temperature range from 600 to 1,140 °C (1,112 to 2,084 °F), inter-metallic phases may form in the event of longer exposure times or too slow cooling down. In addition, carbides can precipitate on the grain boundaries, which reduce resistance against inter-crystalline corrosion.

Mechanical properties

The following mechanical properties are applicable to VDM® Alloy 2120 MoN in solution annealed form:

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Yield strength $R_{y 0.2}$ MPa ksi</th>
<th>Yield strength $R_{y 1.0}$ MPa ksi</th>
<th>Tensile strength $R_{m}$ MPa ksi</th>
<th>Elongation A %</th>
</tr>
</thead>
<tbody>
<tr>
<td>°C</td>
<td>MPa</td>
<td>ksi</td>
<td>MPa</td>
<td>ksi</td>
</tr>
<tr>
<td>20</td>
<td>360</td>
<td>52.2</td>
<td>400</td>
<td>58.0</td>
</tr>
<tr>
<td>400</td>
<td>200</td>
<td>29.1</td>
<td>240</td>
<td>34.8</td>
</tr>
<tr>
<td>500</td>
<td>160</td>
<td>26.1</td>
<td>220</td>
<td>31.9</td>
</tr>
</tbody>
</table>

Table 4 – Mechanical short-term properties of the soft annealed VDM® Alloy 2120 MoN at room temperature and elevated temperatures (min. values)

ISO V-notch impact energy

Average value, room temperature: ≥ 185 J

Average value, -196 °C (-320.8 °F): ≥ 140 J

Cut axis perpendicular to the surface
1) average value from 3 samples. The minimum average value may only be fallen below by a single value, namely no more than 30 %.
2) These values only apply for normal samples according to DIN EN ISO 148-1. For undersized samples according to DIN EN ISO 148-1, the minimum values indicated for the notch impact energy linear to the sample cross-section in the gap must be reduced. For undersized samples < 5 mm according to DIN EN ISO 148-1, the values for the individual case must be agreed separately with the manufacturer.
Corrosion resistance

VDM® Alloy 2120 MoN can be used in many chemical processes with both oxidizing as well as reducing media. The high chromium and molybdenum concentrations make the alloy very resistant to chloride attacks. VDM® Alloy 2120 MoN has a PREN no. of 86 (PREN = %Cr+3.3Mo+30N). In general, the material is superior to other C-alloys in terms of crevice and pitting corrosion (see Figure 1).

![Figure 1 – Critical pitting temperature in a “green death” solution](image1)

The material possesses outstanding corrosion resistance in reducing acids, such as hydrochloric acid and sulfuric acid (see Figure 2). VDM® Alloy 2120 MoN exhibits a good resistance to inter crystalline corrosion according to ASTM G28 method A. Optimum corrosion resistance is only ensured if the material is used in a clean and metallic bright condition.

![Figure 2 – ISO corrosion diagram of VDM® Alloy 2120 MoN](image2)
Applications

VDM® Alloy 2120 MoN has a wide range of applications in the chemical, petrochemical and pharmaceutical industries as well as in energy production and environmental technologies.

Typical applications include:
- components in flue gas desulfurization and waste incineration plants as e.g. scrubbers, raw gas inlets and heat recovery systems
- handling of mineral acids like sulfuric acid, hydrochloric acid and acid mixtures even when contaminated with chlorides
- acetic acid and acetic anhydride production
- production and processing of halogen containing chemicals
- equipment for organic synthesizes and fine and specialty chemicals production
- components exposed to seawater and to highly concentrated brines
- sour gas and geothermal services
- tubes in geothermal power plants
- components for flue gas desulfurization

Fabrication and heat treatment

VDM® Alloy 2120 MoN can readily be hot and cold worked and machined.

Heating
Workpieces must be clean and free from all kinds of contaminants before and during any heat treatment. VDM® Alloy 2120 MoN may become impaired if heated in the presence of contaminants such as sulfur, phosphorus, lead and other low-melting-point metals. Sources of such contaminants include marking and temperature-indicating paints and crayons, lubricating grease and fluids and fuels. Fuels must be as low in sulfur as possible. Natural gas should contain less than 0.1 wt.-% sulfur. Fuel oils with a sulfur Content not exceeding 0.5 wt.-% are suitable. Due to their close control of temperature and freedom from contamination, thermal treatments in electric furnaces under vacuum or an inert gas atmosphere are to be preferred. Treatments in an air atmosphere and alternatively in gas-fired furnaces are acceptable though, if contaminants are at low levels so that a neutral or slightly oxidizing furnace atmosphere is attained. A furnace atmosphere fluctuating between oxidizing and reducing must be avoided as well as direct flame impingement on the metal.

Hot forming
VDM® Alloy 2120 can be hot-formed at a temperature range of between 1,200 and 1,050 °C (2,190 and 1,922 °F) with subsequent rapid cooling down in water or in air. For heating up, workpieces should be placed in a furnace that has been heated up to the maximum hot-forming temperature (solution annealing temperature). The workpieces should be retained in the furnace for around 60 minutes per 100 mm of thickness once the furnace has reached its temperature again. After
this, they should be removed from the furnace immediately and formed within the temperature range stated above, with reheating necessary once the temperature reaches 1,050 °C (1,922 °F). Solution annealing after hot forming is recommended for the achievement of optimal properties and maximum corrosion resistance.

Cold forming
For cold forming the material should be in the annealed condition. VDM® Alloy 2120 MoN has a higher work-hardening rather than austenitic stainless steels. This should be taken into account when selecting forming equipment. Interstage annealing may be necessary with high degrees of cold forming. After cold working with more than 15% deformation solution annealing is required before use.

Heat treatment
Solution annealing should take place at temperatures of between 1,150 and 1,185 °C (2,102 – 2,156 °F) to achieve optimal properties. The retention time during annealing depends on the semi-finished product thickness and can be calculated as follows:
- For thicknesses \( d \leq 10 \text{ mm (0.4 in)} \), the retention time is \( t = d \cdot 3 \text{ min/mm} \)
- For thicknesses \( 10 \text{ to } 20 \text{ mm (0.4 to 0.8 in)} \), the retention time is \( t = 30 \text{ min} + (d - 10 \text{ mm}) \cdot 2 \text{ min/mm} \)
- For thicknesses of \( d > 20 \text{ mm (0.8 in)} \), the retention time is \( t = 50 \text{ min} + (d - 20 \text{ mm}) \cdot 1 \text{ min/mm} \)

The retention time commences with material temperature equalization; longer times are generally considerably less critical than retention times that are too short. For maximum corrosion resistance, the workpieces must be quickly cooled from the annealing temperature of at least 1,100 to 500 °C (2,012 to 932 °F) with a cooling rate of >150 °C/min (302 °F). The material must be placed in a furnace that has been heated up to the maximum annealing temperature before any heat treatment. For strip and wire products, the heat treatment can be performed in a continuous furnace at a speed and temperature that is adapted to the material thickness. The cleanliness requirements listed under "Heating" must be observed.

Scaling and pickling
Oxides of VDM® Alloy 2120 MoN and discoloration adjacent to welds are more adherent than on stainless steels. Grinding with very fine abrasive belts or discs is recommended. Care should be taken to prevent tarnishing. Before pickling which may be performed in a nitric/hydrofluoric acid mixture with proper control of pickling time and temperature, the surface oxide layer must be broken up by abrasive blasting, by carefully performed grinding or by pretreatment in a fused salt bath.

Machining
Machining of VDM® Alloy 2120 should take place in an annealed condition. Because of the considerably elevated tendency toward work hardening in comparison with low-alloy austenitic stainless steels, a low cutting speed and a feed level that is not too high should be selected and the cutting tool should be engaged at all times. An adequate chip depth is important in order to cut below the previously formed strain-hardened zone. Optimum heat dissipation through the use of large quantities of suitable, preferably aqueous, lubricants has considerable influence on a stable machining process.
Welding Information

When welding nickel alloys and special stainless steels, the following information should be taken into account:

**Safety**
The safety recommendations of the manufacturer of welding consumables have to be taken into consideration especially to avoid dust and smoke exposure.

**Workplace**
A workplace, which is specifically separated from areas in which C-steel is being processed, must be provided. Maximum cleanliness is required, and drafts should be avoided during gas-shielded welding.

**Auxiliary equipment and clothing**
Clean fine leather gloves and clean working clothes must be used.

**Tools and machines**
Tools that have been used for other materials may not be used for nickel alloys and stainless steels. Only stainless steel brushes may be used. Machines such as shears, punches or rollers must be fitted (e.g. with felt, cardboard, films) so that the workpiece surfaces cannot be damaged by such equipment due to pressed-in iron particles as this can lead to corrosion.

**Edge preparation**
Welding edge preparation should preferably be carried out using mechanical methods such as lathing, milling or planing. Abrasive waterjet cutting or plasma cutting is also possible. In the latter case, however, the cut edge (seam flank) must be cleanly reworked. Careful grinding without overheating is also permissible.

**Striking the arc**
Striking may only take place in the seam area, such as on the weld edges or on an outlet piece, and not on the component surface. Striking points are places that may be more susceptible to corrosion.

**Included angle**
Compared to C-steels, nickel alloys and special stainless steels exhibit lower heat conductivity and greater heat expansion. Larger root gaps and web spacing (1 to 3 mm/ 0,039 to 0,118 in) are required to live up to these properties. Due to the viscosity of the welding material (compared to standard austenitic steels) and the tendency to shrink, opening angles of 60 to 70° – as shown in Figure 3 – have to be provided for butt welds.
Cleaning
Cleaning of the base material in the seam area (both sides) and the welding filler (e.g. welding rod) should be carried out using acetone.

Welding parameter and influences
Care should be taken that the work is performed with a deliberately chosen, low heat input as indicated in Table 6 by way of example. The stringer bead technique is recommended. The interpass temperature should not exceed 150 °C (302 °F). The welding parameters should be monitored as a matter of principle.
The heat input $Q$ can be calculated as follows:

$$Q = \frac{U \cdot I \cdot 60}{v \cdot 1.000} \left( \frac{\text{kJ}}{\text{cm}} \right)$$

$U$ = arc voltage, volts
$I$ = welding current strength, amperes
$v$ = welding speed, cm/minute

**Post- treatment (brushing, pickling and thermal treatments)**

Brushing with a stainless steel wire brush immediately after welding, i.e. while the metal is still warm generally results in removal of heat tint and produces the desired surface condition without additional pickling.

Pickling, if required or pre-scribed, however, would generally be the last operation performed on the weldment. Please also refer to the information on ‘Descaling and pickling. Neither pre- nor post weld heat treatments are normally required.

**Following filler metals are recommended**

VDM® FM 2120
ISO 18274 - S Ni 6058 (NiCr21Mo20),
AWS 5.14 Classification ERNiCrMo-19 (UNS N06058)
as TIG rods, weld wire, wire electrode
(TÜV data sheet No. 18953, 18954, 18965)
### Table 5 – Welding parameters

<table>
<thead>
<tr>
<th>Thickness (mm (in))</th>
<th>Welding process</th>
<th>Filler material</th>
<th>Root pass(^1)</th>
<th>Intermediate and final passes</th>
<th>Welding speed (cm/min.)</th>
<th>Shielding gas Type</th>
<th>Rate (l/min.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>3 ((0.118))</td>
<td>m-TIG</td>
<td>1.6-2 ((0.063-0.079))</td>
<td>90 ((10))</td>
<td>110-120 ((11))</td>
<td>15 ((I1))</td>
<td>8-10</td>
<td></td>
</tr>
<tr>
<td>6 ((0.236))</td>
<td>m-TIG</td>
<td>2.0 ((0.079))</td>
<td>100-110 ((10))</td>
<td>120-140 ((12))</td>
<td>14-16 ((I1))</td>
<td>8-10</td>
<td></td>
</tr>
<tr>
<td>8 ((0.315))</td>
<td>m-TIG</td>
<td>2.4 ((0.0945))</td>
<td>100-110 ((11))</td>
<td>130-140 ((12))</td>
<td>14-16 ((I1))</td>
<td>8-10</td>
<td></td>
</tr>
<tr>
<td>10 ((0.394))</td>
<td>m-TIG</td>
<td>2.4-3.2 ((0.063-0.079))</td>
<td>100-110 ((11))</td>
<td>130-140 ((12))</td>
<td>14-16 ((I1))</td>
<td>8-10</td>
<td></td>
</tr>
<tr>
<td>3 ((0.118))</td>
<td>v-TIG (^2)</td>
<td>1.0-1.2 ((0.039-0.0472))</td>
<td>1.2 ((1))</td>
<td>-</td>
<td>150 ((11))</td>
<td>25 ((I1))</td>
<td>12-14</td>
</tr>
<tr>
<td>5 ((0.197))</td>
<td>v-TIG (^2)</td>
<td>1.2 ((0.0472))</td>
<td>1.4 ((1))</td>
<td>-</td>
<td>180 ((12))</td>
<td>25 ((I1))</td>
<td>12-14</td>
</tr>
<tr>
<td>8 ((0.351))</td>
<td>MIG/MAG(^3)</td>
<td>1.0-1.2 ((0.039-0.0472))</td>
<td>6-7 ((1))</td>
<td>-</td>
<td>130-140 ((23-27))</td>
<td>24-30 ((I1))</td>
<td>18</td>
</tr>
<tr>
<td>10 ((0.394))</td>
<td>MIG/MAG(^3)</td>
<td>1.2 ((0.0472))</td>
<td>6-7 ((1))</td>
<td>-</td>
<td>130-150 ((23-27))</td>
<td>25 - 30 ((I1))</td>
<td>18</td>
</tr>
</tbody>
</table>

\(^1\) Root layer: For all weld processes, a sufficient protection with backing gas e.g. by Ar 4.6 is needed.

\(^2\) Automated TIG: If applicable, the root layer should be welded manually.

\(^3\) For MAG welding: The application of a 3 or 4 component gas mix is recommended (CO2 < 0.12%).

\(Z\)-Ar\(He\)HC30/2/0,05, \(Z\)-Ar\(He\)HC30/2/0,079

Section energy \(kJ/cm\): TIG, MIG/MAG manual or automated ca. 8.

The parameters given are indicative values to facilitate the setting of the welding machine.
Availability

VDM® Alloy 2120 MoN is available as plate, sheet, strip and wire.

Plate/sheet
Delivery condition: hot or cold-rolled, heat-treated, de-scaled or pickled

<table>
<thead>
<tr>
<th>Condition</th>
<th>Thickness mm (in)</th>
<th>Width mm (in)</th>
<th>Length mm (in)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cold rolled</td>
<td>1-7 (0.039-0.275)</td>
<td>≤ 2,500 (98.42)</td>
<td>≤ 8,000 (314.96)</td>
</tr>
<tr>
<td>Hot rolled*</td>
<td>3-30 (0.11-1.18)</td>
<td>≤ 2,500 (98.42)</td>
<td>≤ 8,000 (314.26)</td>
</tr>
</tbody>
</table>

* Plates/ sheets ≤ 2 mm (0.08 in) thickness are available on request.

Strip
Delivery condition: cold-rolled, heat-treated, pickled or bright annealed

<table>
<thead>
<tr>
<th>Thickness mm (in)</th>
<th>Width mm (in)</th>
<th>Coil-inside diameter mm (in)</th>
<th>Length mm (in)</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.025-0.15 (0.00984-0.00591)</td>
<td>4-230 (0.157-9.06)</td>
<td>300 (11.8)</td>
<td>400 (15.7)</td>
</tr>
<tr>
<td>0.15-0.25 (0.00591-0.00984)</td>
<td>4-720 (0.157-28.3)</td>
<td>300 (11.8)</td>
<td>400 (15.7)</td>
</tr>
<tr>
<td>0.25-0.6 (0.00984-0.0236)</td>
<td>6-750 (0.236-29.5)</td>
<td>–</td>
<td>400 (15.7)</td>
</tr>
<tr>
<td>0.6-1 (0.0236-0.0394)</td>
<td>8-750 (0.315-29.5)</td>
<td>–</td>
<td>400 (15.7)</td>
</tr>
<tr>
<td>1-2 (0.0394-0.0787)</td>
<td>15-750 (0.591-29.5)</td>
<td>–</td>
<td>400 (15.7)</td>
</tr>
<tr>
<td>2-3 (0.0787-0.118)</td>
<td>25-750 (0.984-29.5)</td>
<td>–</td>
<td>400 (15.7)</td>
</tr>
</tbody>
</table>

Rolled sheet – separated from the coil – are available in lengths from 250-4,000 mm (9.84 to 157.48 in).

Wire
Delivery condition: drawn bright, ¼ hard to hard, bright annealed in rings, containers, on spools and headstocks

<table>
<thead>
<tr>
<th>Drawn mm (in)</th>
<th>Hot rolled mm (in)</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.16-10 (0.006-0.04)</td>
<td>5.5-19 (0.22-0.75)</td>
</tr>
</tbody>
</table>

Rod and bar
Delivery condition: forged, rolled, drawn, heat-treated, oxidized, de-scaled or pickled, twisted, peeled, ground or polished

<table>
<thead>
<tr>
<th>Dimensions</th>
<th>Outside diameter mm (in)</th>
<th>Length mm (in)</th>
</tr>
</thead>
<tbody>
<tr>
<td>General</td>
<td>6-250 (0.236-9.84) 1)</td>
<td>1,500-12,000 (59.1 – 472)</td>
</tr>
</tbody>
</table>

1) Other dimension are subject to special enquiry

Other dimensions and shapes such as circular blanks, rings, seamless or longitudinal-welded tubes and pipes or forgings are subject to special enquiry.
Technical publications


Legal Notice

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