



Technical Data Sheet

ATI 201LN™

Stainless Steel: Austenitic

(UNS S20153)

INTRODUCTION

Materials for use at sub-zero temperatures should be ductile, tough and strong at their use temperature. Only a limited number of materials, among them most of the austenitic stainless steels, satisfy all of these requirements. The austenitic stainless steels not only maintain their toughness and ductility, but they also increase in yield and tensile strengths as temperatures decrease. By choosing the right austenitic stainless steel, the demands of many cryogenic temperature applications can be satisfied.

The familiar type 300 series austenitic stainless steels have been used satisfactorily for many years as materials of construction for liquid oxygen tanks and accessories as well as liquid hydrogen handling equipment. Other applications include components containing liquid carbon dioxide, acetylene, methane, argon and nitrogen. Hence, service temperatures ranging from -80°F to -320°F (-62°F to -196°F) are typical based on the boiling points of these liquids.

Type 201 austenitic stainless steel has been available for over 50 years and has gained acceptance in a number of applications. Compared to the 300 series alloys, the lower-nickel 200 series alloys offer an economical way to obtain superior mechanical properties. ATI has created a special composition of type 201 specifically for sub-zero temperature service as welded tanks and vessels. This alloy, designated ATI 201LN, also identified by the Unified Numbering System Designation S20153, has replaced familiar 300 series stainlesses such as type 301 or type 304 in many applications based upon technical equivalency and economic considerations. Consequently, ATI 201LN alloy is often a good choice for use at temperatures down to -320°F (-196°F).

ATI 201LN alloy is also suited for many ambient temperature structural applications, such as railroad freight cars, truck trailers, coal handling and other bulk transport equipment where there is a need for a good combination of corrosion resistance, strength, toughness and ease of fabrication.

TYPICAL COMPOSITION

Ferritic alloys such as carbon steels or 400 series stainless steels experience a ductile-to-brittle transition (DBT) as the temperature is reduced. This DBT is a major barrier to the use of most ferritic steels at sub-ambient temperatures. Even some of the austenitic stainless steels can become brittle at low temperatures.

This embrittlement has been attributed to a transformation from austenitic to martensitic structure at low temperature. Most austenitic stainless steels resist transformation to martensite even at very low temperatures and maintain their toughness and ductility. However, the stability of austenite varies with chemical composition. The type 301 stainless steel, which exhibits a relatively high work hardening rate even at room temperature, is an example of relatively unstable austenite. Type 304 has a much lower work hardening rate, indicating a more stable austenite. However, even the relatively unstable type 301 is often satisfactory for low temperature service.



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Composition									
Specification	ASTM Range - Weight Percent								
Composition Balanced ATI 201LN™ (UNS)	C*	Mn	P*	S*	Si*	Cr	Ni	N	Cu*
	0.03	6.40/7.50	0.045	0.015	0.75	16.00/17.5	4.00/5.0	0.10/0.2	1.00
Type 201 Alloy to ASME SA-240, ASTM A666, and ASTM A240	0.15	5.50/7.50	0.060	0.030	1.00	16.00/18.0 0	3.50/5.50	0.25*	--

* means maximum value.

ATI 201LN alloy has been designed specifically to provide sufficient austenite stability for low temperature service. As part of the composition design, carbon has been restricted to 0.03 percent maximum to minimize sensitization during welding since welding is typically required in the construction of low temperature equipment.

ATI 201LN alloy can be used for various pressure vessel, cryogenic, structural, architectural, magnetic and heat resisting applications. ATI 201LN (UNS S20153) alloy is a carefully balanced composition of type 201 which satisfies the requirements of ASME Boiler and Pressure Vessel Specification SA-240 and ASTM A 240 (Standard Specification for Heat Resisting Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels).

ATI 201LN alloy is included in the ASME Boiler and Pressure Vessel Code under the nominal composition designation "16Cr-4Ni-6Mn" steel. It is listed for Section VIII, Divisions 1 and 2 construction to 800°F (427°C) maximum use temperature and for Section XII service to 650°F (343°C) maximum use temperature. The minimum design temperatures are -320°F (196°C). The maximum allowable stress values for 100°F (40°C) and below are 23,800 psi (164 MPa) for Division I and the maximum allowable design stress intensity value S_m in tension is 30,000 psi (207 Mpa) for Division II. These limiting stresses are employed when designing to cryogenic temperatures even though the strength of austenitic stainless steels increases as temperature decreases below room temperature. The 23,800 psi (164 MPa) maximum allowable stress for ATI 201LN alloy is substantially higher than the maximum allowable stress for type 304 alloy, 18,750 psi (129 MPa), allowing the use of thinner sections for ATI 201LN alloy, or allowing an additional safety factor with a gage equivalent to that for type 304.

TYPICAL APPLICATIONS

Liquefied Gas Storage Vessels
Portable Gas Storage Tanks

PRODUCT FORMS

ATI 201LN stainless steel is available in plate, sheet, and strip product forms from ATI and is listed in ASTM A240.

MECHANICAL PROPERTIES

The austenitic stainless steels are generally utilized in the annealed condition. The mechanical properties that are of primary importance in fabrication and use, and consequently receive the most attention are the yield strength, tensile strength, elongation, and impact properties. Since toughness and resistance to impact loading are important at low temperatures these properties are given below for a number of heats to demonstrate the excellent impact resistance of ATI 201LN alloy.

Impact Loading

It is known that austenitic stainless steels (e.g., type 304), in general, retain their excellent impact properties at low temperatures. ATI 201LN alloy, as illustrated on page 4, retains excellent impact properties down to -320°F (-196°C).



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ATI 201LN™ Alloy Room Temperature Data

Data for Tests at +70 F (21 C)						
Heat	Direction	0.2% Yield Strength (ksi)	Tensile Strength (ksi)	Elongation (% in 2")	Impact Energy (ft-lbs.)	Lateral Expansion (in.)
M-6	T	46.4	99.3	56.0	208	0.085
M-7	T	46.6	97.6	59.0	184	0.088
	T				162	0.092
M-8	T	49.8	97.1	56.5	154	0.087
	T				186	0.084
	T				172	0.087

ATI 201LN™ Alloy Low Temperature Data

Data for Tests at -100 F (-73 C)						
Heat	Direction	0.2% Yield Strength (ksi)	Tensile Strength (ksi)	Elongation (% in 2")	Impact Energy (ft-lbs.)	Lateral Expansion (in.)
M-6	T	63.4	179.2	42.5	150	0.084
	T	61.8	176.0	45.0	150	0.081
M-7	T	68.7	177.3	47.0	134	0.080
	T	71.7	176.9	46.0	130	0.072
M-8	T	72.8	179.2	47.5	142	0.070
	T	70.7	177.7	50.0	138	0.078



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Data for Tests at -320 F (-196 C)						
Heat	Direction	0.2% Yield Strength (ksi)	Tensile Strength (ksi)	Elongation (% in 2")	Impact Energy (ft-lbs.)	Lateral Expansion (in.)
M-1	T	83.2	231.5	27.0	68	0.045
	T				59	0.048
	T				68	0.046
M-2	L	83.9	203.0	25.0	82	0.048
	L				86	0.050
	L				106	0.054
M-6	T	75.6	233.9	31.0	61	0.038
	T	77.8	210.0	23.0	58	0.038
	T				80	0.044
	L	82.5	190.5	22.0	95	0.056
	L	75.2	242.6	37.0	84	0.053
	L				59	0.038
M-7	T	84.8	200.5	22.5	56	0.034
	T	87.6	244.2	36.0	68	0.041
	T				47	0.028
	L	87.6	234.0	27.5	54	0.038
	L	87.4	249.7	34.0	52	0.032
	L				56	0.035

L - Designates impact sample length lies in longitudinal or rolling direction and notch running through thickness.
 T - Designates impact sample length lies in transverse or width direction and notch running through thickness.
 Impact Energy and Lateral Expansion are determined according to the American Society for Testing and Materials (ASTM) Procedure E-23 (Notched Bar Impact Testing of Metallic Materials).

Yield and Tensile Strengths

The yield and tensile strengths of austenitic stainless steels increase as temperature is decreased. The tensile strength tends to increase more rapidly than does the yield strength. The effects of sub-zero temperatures on the ATI 201LN alloy are graphically illustrated in Figure 1. ATI 201LN alloy maintains high elongations and continues to increase in tensile strength as temperature decreases. Austenite stability has been controlled in the ATI 201LN alloy.

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Allegheny Technologies Incorporated
 1000 Six PPG Place
 Pittsburgh, PA 15222-5479 U.S.A.
 www.ATImetals.com

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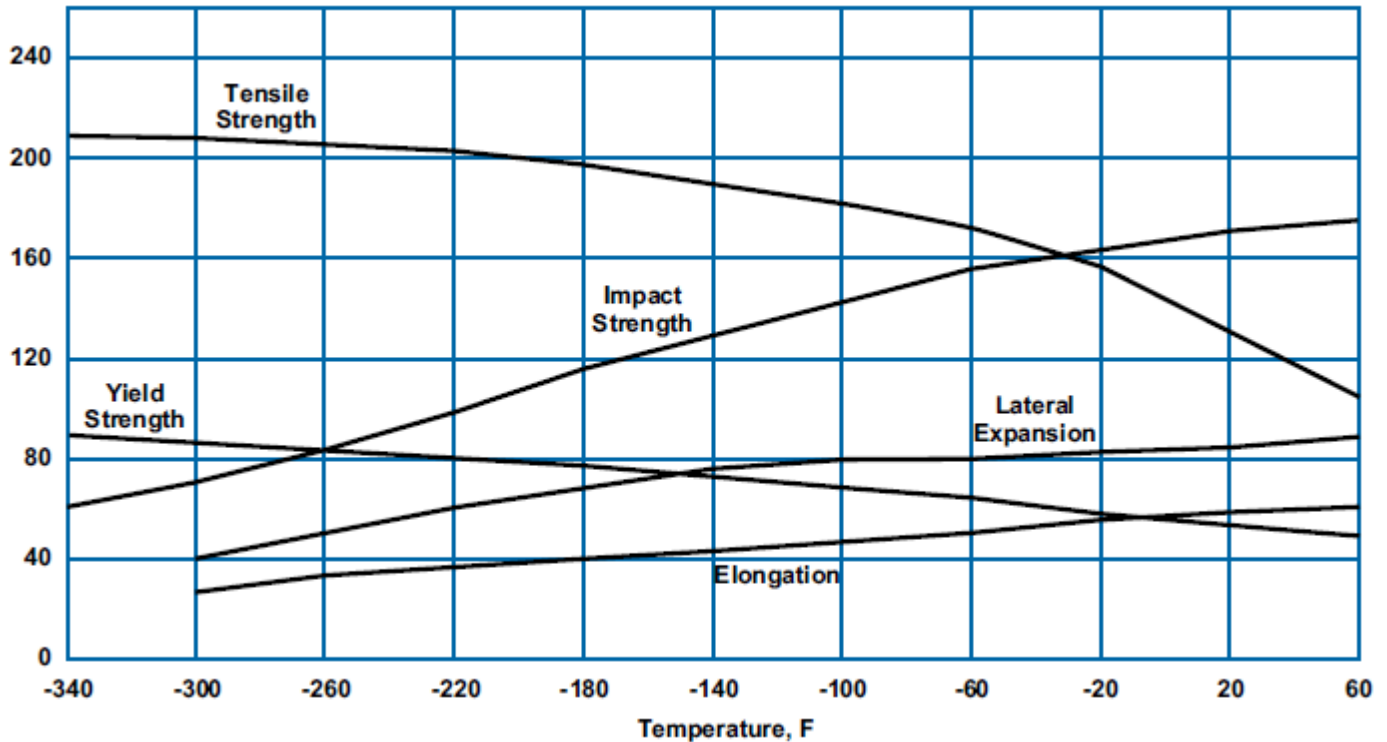


Figure 1 - ATI 201LN™ alloy mechanical properties from room temperature to -320°F

EFFECT OF SENSITIZATION

Since welding is an important method of fabrication, the potential effect of sensitization on mechanical properties must be considered. Sensitization of annealed austenitic stainless steels normally causes a small loss of toughness at low temperatures. The degree of change is related to the amount of carbide precipitation that occurs. This, in turn, is dependent on the carbon content of the material. In ATI 201LN alloy, the carbon content has been reduced to the level of 0.03 percent maximum, minimizing the amount of carbide precipitation, and maintaining good low temperature impact properties in welded sections. In addition to the loss of toughness induced by the presence of carbides, the depletion of carbon from solid solution can destabilize austenite. This can lead to martensite formation and further loss of toughness.

An additional effect of welding, that of an increased grain size in and adjacent to the welds, can have an effect on sub-zero properties. However the data shown below for ATI 201LN alloy, including data for grain size deliberately grown to ASTM # 1 (a very large grain size), show that large grain size does not detrimentally affect properties at -320°F (-196°C).



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Effect of Grain Size on ATI 201LN™ Alloy (Properties for Heat M-6)							
Heat Treatment	ASTM Grain Size	Test Temp °F (°C)	0.2% Yield Strength (ksi)	Tensile Strength ksi (MPa)	Elongation (% in 2")	Impact Energy ft-lbs. (Joules)	Lateral Expansion (in.)
Mill Anneal	6	70 (21)	46.4 (320)	99.3 (685)	51	184-202 (250-274)	0.085-0.088
Mill Anneal	6	-320 (-196)	75.6-77.8 (521-536)	210.0-234.0 (1448-1613)	23-31	58-61 (74-83)	0.038-0.039
Mill Anneal + 100 Min. @ 2050 F	2.5-3	-320 (-196)	81.7 (563)	191.4 (1320)	21	107-108 (145-146)	0.055-0.057
Mill Anneal + 300 Min. @ 2050 F	0.5-1.5	-320 (-196)	71.6 (525)	213.3 (1471)	23.5	124-134 (168-182)	0.057-0.067

Impact Energy and Lateral Expansion data are range of three samples tested.

CORROSION RESISTANCE

ATI 201LN alloy is resistant to a wide variety of mild to moderately corrosive media. Generally speaking, ATI 201LN alloy has proven entirely adequate for applications where type 301 has been satisfactory and has been successfully substituted for type 304 in a variety of mild environments.