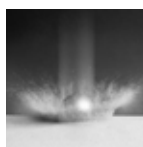


AUBERT & DUVAL



SPACE INDUSTRY METALLURGICAL SOLUTIONS



www.aubertduval.com

Equipment

Melting

Melting furnaces (EAF, AOD, VOD)
up to 60 tons
Vacuum Induction Melting (VIM)
up to 20 tons
Titanium Plasma Arc Melting
furnace (PAM-CHR)
Remelting furnaces (ESR, VAR)
up to 30 tons

Powder metallurgy

Gas atomization (Air, VIM)

Forging

Open-die forging presses
from 1,200 to 10,000 tons
Closed-die forging presses
from 4,500 to 65,000 tons

Rolling mill

7-200 mm diameter bars

Heat treatment

Solution and ageing furnaces
Horizontal and vertical quenching
equipment

Testing

Immersion UT
up to 13 tons (28,000 lbs)
Automated contact UT
up to 20 tons

The 65kt closed-die
forging press:
a world-class tool for
the manufacturing of
complex, large, thick
and seamless parts

AUBERT & DUVAL

The Space industry supplier of choice

A&D has been selected on major space programs for its unique combination of metallurgical expertise and know-how along with world-class melting and forging tools. This unique industrial set-up enables us to offer highly reliable and secure metallurgical solutions for the most complex, lighter, large-scaled, critical and cryogenic applications.

Thanks to this positioning, Aubert & Duval is supporting the development of the most ambitious projects: space stations, heavy or reusable launchers, spacecrafts as well as all satellite sizes.

A unique combination to help realize your ambitions

- Passionate teams driven by metallurgical innovation and industrial challenges.
- R&T and co-engineering culture with unrivalled simulation capabilities.
- A unique integrated solution of world-class tools from melting to closed-die forging.
- Multi-material expertise: special steels, superalloys, titanium, aluminum (forging only).
- A multi-certified player able to support customers' needs on all markets (aeronautics, defense, nuclear): ISO 9001/EN 9100, ISO.
- 14001, OHSAS 18001 ; NADCAP ; AQAP2110 ; TAA experienced (US market) , Fully Authorized Economic Operator (AEO).



Process flow

Melting

HPS

NiSA

Ti

Remelting

Powder atomization

PM

Conversion

HPS

NiSA

Ti

Al

Forging
and/or rolling

Open-die forging
and/or Closed-die forging

Heat treatment

Machining

Non-destructive testing

Bars



Rotating and static parts



Powders



Main materials

HPS

High performance steels

A range of alloyed steels with tightly controlled characteristics, offering optimum value for customers.

NiSA

Nickel-based superalloys

A range of alloyed materials with specific resistance to very high temperatures and corrosion, the majority component being nickel.

Ti

Titanium alloys

Pure or alloyed titanium, combining mechanical properties and corrosion-resistance with light weight.

Al

Aluminum alloys

Slightly alloyed aluminum, widely used in aircraft.

PM

Metal powders

Steels, superalloys and titanium powders for additive manufacturing and aero rotating parts.

Main materials

AI

Aluminum alloys

▶

Al2000 series

▶

Al7000 series

▶

5083

▶

6061

▶

Aluminum-Lithium

Ti

Titanium alloys

▶

AD grade

▶

Common name

▶

TA6V

▶

Ti6Al4V

▶

TA6V

▶

Ti6Al4V ELI

▶

Ti10 2 3

▶

Ti10 2 3

NiSA

Nickel-based superalloys

▶

AD grade

▶

Common name

▶

AD730®

▶

NiCr16Co9Mo3W3Ti3Al2

▶

NY276

▶

C276

▶

NiMo16Cr15W

▶

PER3

▶

Waspaloy

▶

NiCr20Co13Mo4Ti3Al

▶

PER625

▶

IN625

▶

NiCr22M9Nb

▶

PER718

▶

IN718

▶

NiCr19Fe19Nb5Mo3

▶

XSH

▶

KC20WN

▶

CoCr20W15Ni

HPS

High performance steels

▶

AD grade

▶

Common name

▶

819B

▶

35NCD16

▶

35NiCrMo16

▶

GKH®

▶

32CDV13

▶

32CrMoV12-9

▶

M50NiL

▶

13MoCrNiV42-16-14

▶

Marval®18

▶

M250

▶

X2NiCoMo18-8-5

▶

ML340

▶

X23NiCoCrMoAl13-6-3

▶

MLX®17

▶

X1CrNiMoAlTi12-11-2

▶

MLX®19

▶

X1CrNiMoAlTi12-10-2

▶

MO6ACW

▶

D6AC

▶

48CrMoNiV4-10

▶

SCV®

▶

15CDV6

▶

15CrMoV6

▶

X15U5W

▶

15-5PH

▶

X5CrNiCu15-5

▶

X18PA

▶

X6CrNiTi18-0

▶

XD15NW®

▶

X40CrMoVN16-2

▶

XDBD

▶

440C

▶

X105CrMo17

▶

XN26TW

▶

A286

▶

X6NiCrTiMoVB25-15-2

* Patented grade

AUBERT & DUVAL
Already
on board with

Launchers: Ariane, Vega ESA programs ; PSLV Indian program ;
Stations: ISS & Axiom programs ;
Spacecrafts: Orion & Cygnus programs ;
Satellites: very large range of programs from LEO to GEOSAT tanks ...

And you tomorrow!

AI FORGINGS

Ti FORGINGS

Propellant/
Helium Tanks

Spherical tanks
Up to 2 meters (79") diameter

HPS FORGINGS

NiSA FORGINGS

Propulsion Parts

Compressor disc

Turbine disc

Impeller

Shaft

Up to 1.4
meters diameter

Up to 4
meters (157")
long

AI FORGINGS

Ti FORGINGS

HPS FORGINGS

Structural Parts

Cone

Dome

Bulkhead

Bracket

Up to 30 tons (66,000)
up to 7 meters (276") long

Main data

Closed-die forgings:
▶ Diameter up to 2 m / 79 in
▶ from 20 kgs / 44 lbs
up to 13,000 kg / 28,600 lbs
Open-die forgings:
▶ up to 30,000 kg / 66,000 lbs

Bars

Main sizes	mm	inches
Round Bars	Ø 7.5-500	Ø 0.30-20
Flat & Square Bars	T ≤ 310	T ≤ 12
Sheets	0.6 ≤ T ≤ 150	0.2 ≤ T ≤ 6

Surface conditions
▶ Black
▶ Peeled
▶ Ground
▶ Others
Heat treatment conditions
▶ Annealed
▶ Hyperquenched
▶ Normalized
▶ Heat solution treated
▶ Heat treated
▶ Aged

Innovation

We continuously develop new processes and grades to help face the challenges of the space industry.

HPS

ML340

Duplex hardening grade specifically adapted for high temperature turbine shafts (450°C/840°F), requiring 2230 MPa/323 Ksi resistance. Benefits: weight savings, improved engine efficiency & gas consumption.

NiSA

AD730®

Fully innovative nickel-based superalloy withstanding higher temperatures (750 °C / 1,382 °F) while reserving strength, creep and fatigue resistance at a competitive cost.

AI

Aluminum-Lithium alloys

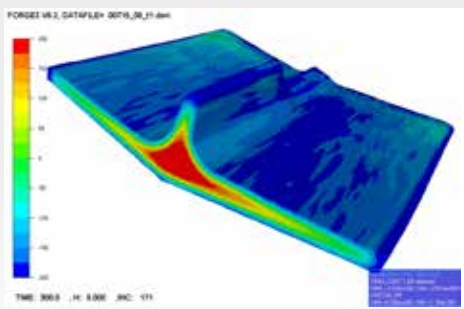
Allowing weight gain up to 4% with static properties equivalent or higher than 7010/7050 & improved fatigue and rigidity properties over 10%.

PM

ABD®900 and AD®730

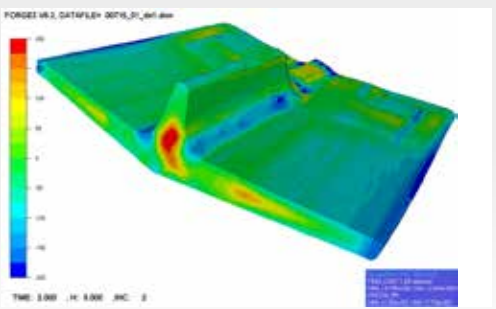
(see pages 6-7)

Co-engineering



Example of residual stress after quenching

- ▶ Simulation of complex, large, thick and seamless parts
- ▶ Leading expertise in residual stress - optimization and control of stress relief:
 - Allows parts to be machined without constraints
 - Allows you to eliminate the roughing and straightening steps
- A&D offers its support at the earliest stage in your development with:
 - Metallurgical know-how to obtain best mechanical properties (LH2, High T°...)
 - Co-design & input weight reduction



Example of residual stress elimination after cold-work

AUBERT & DUVAL

A complete metal powder offer for additive manufacturing

PM Main materials

NiSA Nickel-based superalloys

Aubert & Duval grade

HX
Ni247
Ni625
Ni718
Ni738

New alloys

ABD-900AM¹
AD730[®]
MHA3300²

Ti Titanium alloys

Ti6Al4V ELI³

¹: in partnership with Alloyed

²: in partnership with Mitsubishi Heavy Industries

³: in partnership with Pyrogenesis

Over the years, Aubert & Duval has acquired a deep and thorough knowledge in the design and optimization of metal powders in order to meet customers' most stringent requirements, particularly for air industry and space applications. We support space equipment manufacturers in achieving success in powder development for series production in their additive manufacturing.

Our research centers and development teams are dedicated to developing new alloys and optimizing powder characteristics to achieve the best material performance and processability for all additive manufacturing technologies.

The performance of our powders at the heart of your additive manufacturing success

Thanks to our long-standing experience serving the space industry, we can offer tailored metal powder, including design of the chemical and mechanical properties, in accordance with space requirements.

We help our customers in the definition of metal powder specifications in order to develop suitable solutions for space applications for propulsion and structural parts for use at higher temperature and for higher trust & weight savings.

Powder sizes

Laser Beam Melting:

• 10-53 or 15-63 µm

Electron Beam Melting:

• 45-106 µm

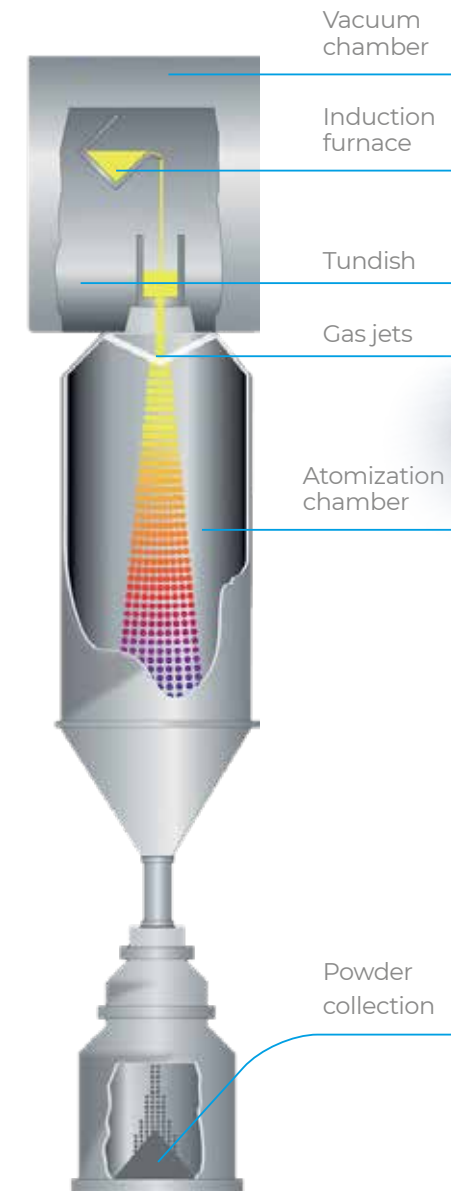
Direct Energy Deposition:

• 45-90 µm

Customized particle size distributions available upon request



Our Atomization Process



Key features of our Atomization Equipment

- Melting in VIM
- N- or Ar-atomization
- High cleanliness level
- Highly spherical powder morphology
- Fully-controlled low oxygen and carbon levels
- Minimize porosity internally and of satellites
- High stability and reproducibility

Quality Control

With 40 years of experience in high quality gas-atomized powders, Aubert & Duval has a high level of expertise and also dedicated laboratory equipment ensuring the highest quality for powders:

- Powder size distribution: by sieving and laser diffraction
- Morphology: SEM pictures
- Chemical composition: ICP, GDMS & fusion
- Absorption Spectrometer (GFAAS)
- Other physical properties : density, flowability



Quality and certifications

- EN 9100
- ISO 9001
- Customer accreditations

Powders for AM Technology

Our metal powders are designed for the full range of additive manufacturing processes:

Powder Bed

- Laser Beam Melting
- Electron Beam Melting
- Binder Jetting & Sintering

Blown Powder


- Laser Metal Deposition
- Cold Spray



Combustion chamber for rocket engine. ABD®-900AM powder inside. Courtesy of Airborne Engineering, Alloyed and Renishaw

AUBERT&DUVAL



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