



After assembling the crevice formers, the coupons are immersed in the electrolyte for 72 h, but other exposure times also are permitted. The standard, likewise, allows for sample removal and inspection; nevertheless, care should be exercised because sample withdrawals could lead to variations in the rate of attack. After the predetermined exposure duration, the samples are removed from the solution, visually inspected, and weighed with a minimum accuracy of 0.001 g. ASTM G46, *Standard Guide for Examination and Evaluation of Pitting Corrosion*, can be used to characterize the extent of the attack.

The rubber band method is inexpensive, easy, fast to assemble, and produces useful comparative results in a short time. The ASTM G48 Method B technique, however, has a few disadvantages and limitations. For example, as shown in figure 58, in certain alloys, particularly the less alloyed materials, such as type 304 stainless steel, crevices can initiate at the contact point between the rubber bands and the specimen. Indeed, similar approaches were used in classical corrosion lectures to demonstrate that stainless steels could be “cut in half” with a rubber band.<sup>30</sup> Likewise, the test is invalid if either rubber band or O-ring breaks during testing, and the compressive pressure exerted by the rubber band onto the crevice formers is not uniform and can be difficult to replicate. Moreover, DeForce has shown that the type of rubber band used affects the results.<sup>31</sup> According to the author, “specifying the rubber band elasticity (or rubber content) can improve the repeatability of ASTM G48 Method B.” Last, although the mass loss is recorded after testing, there is currently no acceptance criterion. Producers and end-users have commercially accepted criteria, such as a maximum of 0.038 mm crevice depth and 0.2 mg/cm<sup>2</sup> mass loss. In all cases, the user and the vendor should agree on the pass or fail criteria.

## ASTM G48 METHODS D AND F: CREVICE CORROSION TEMPERATURE

ASTM G48 Methods D (nickel- and chromium-bearing alloys) and F (stainless steels) overcome some of the limitations of the rubber band technique and allow the determination of the

critical crevice temperature (CCT) of a material. In the standard, the CCT is defined as the minimum temperature, in degrees Celsius, to produce crevice attack at least 0.025-mm deep on the bold surface of a specimen beneath the crevice former, ignoring edge attack. The methods also can be used to rank alloy performance, aid in materials selection, and the design of new materials.<sup>32,33,34,35,36,37</sup>

Methods D and F involve immersing creviced samples in acidified 6 wt% FeCl<sub>3</sub> + 1 wt% hydrochloric acid (HCl; pH adjusted to pH = 1.0) for a period of time. Both methods use TFE-fluorocarbon MCA, and various geometries and construction materials are allowed. Method D recommends a torque of 0.28 N·m, whereas Method F suggests 1.58 N·m for stainless steel. Authors also have reported, however, that applied torque values between 2 and 8 N·m were required to produce the most reproducible crevice corrosion results when evaluating highly corrosion-resistant nickel alloys.<sup>34</sup> The recommended duration of the immersion is 72 h (Method D) and 24 h (Method F). The length of the tests has been evaluated by interlaboratory testing.

The initial temperature of the test solution may be estimated using the empirical expressions shown in equations (5) and (6). The minimum temperature is 0°C and the maximum 85°C because of the thermal degradation of the ferric chloride electrolyte.

$$\text{Method D: } (1.5 \times \%Cr) + (1.9 \times Mo) + (4.9 \times \%Nb) + (8.6 \times \%W) - 36.2. \quad (5)$$

$$\text{Method F: } (3.2 \times \%Cr) + (7.5 \times Mo) + (10.5 \times \%N) + (8.6 \times \%W) - 81.0. \quad (6)$$

A chief limitation of equations (5) and (6) is that the empirical expressions consider the effects of bulk composition alone, without taking into account the influence of alloy microstructure. For example, sensitized and properly annealed stainless steels will have identical CCT values according to equation (5), yet the actual CCT will be drastically lower in the sensitized samples given the local depletion of chromium and molybdenum adjacent to, for example, chromium carbides.<sup>33,38</sup> Likewise, the

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