

METHOD OF SELECTIVE REGION VAPOR PHASE ALUMINIZING

ABSTRACT

The present invention is process for forming diffusion aluminide coatings on an uncoated surface (36, 38) of a substrate (42), without interdiffusing a sufficient amount of aluminum into a coating layer (44) to adversely affect the coating (44) growth potential and mechanical properties of said coating layer (44). A metal substrate (42) is provided comprising an external surface (36, 38) and an internal passage (34) therein defined by an internal surface (36), at least a portion of the external surface (38) of the substrate (42) being coated with a coating layer (44) selected from the group consisting of β -NiAl-base, MCrAlX, a line-of-sight diffusion aluminide, a non-line-of-sight diffusion aluminide, a pack diffusion aluminide, and a slurry diffusion aluminide on said substrate (42). The external surface (38) of the substrate (42) is cleaned. The metal substrate (42) is subjected to a aluminum vapor phase deposition process performed using a fluorine-containing activator selected from the group consisting of AlF_3 , CrF_3 , NH_4F , and combinations thereof, at a rate in the range of about 0.036 mols of fluorine per ft^3/hr of transport gas to about 0.18 mols of fluorine per ft^3/hr of transport gas, at a temperature in the range of about 1350°F (730°C) to about 1925°F (1050°C), using a transport gas selected from the group consisting of argon, nitrogen, hydrogen, and combinations thereof, the transport gas being provided at a flow rate in the range of about 20 ft^3/hr to about 120 ft^3/hr for a period of time in the range of about 2 hours to about 10 hours. The substrate (42) is then cooled. The present invention is also a superalloy article (20) coated with a diffusion aluminide layer (40) using the diffusion aluminide coating process of the present invention.

(Figure 2)