

Quality Forged Components For The Turbomachinery Industry

Over the past 15 years Patriot has become a highly trusted and respected supplier to the turbomachinery industry. Our unrivalled experience & expertise allows us to offer an extensive array of rough machined forgings for the following components...

- Impellers (Hub Discs & Covers)
- Compressor Shafts
- Stability Tested Turbine Rotor Shafts
- Nozzles & Nozzle Blocks
- Diffusers
- Balance Piston Rings
- Diaphragm Rings
- Thrust Bearings
- Inlet Sleeves/Rings
- Blades & Buckets
- Intake Heads
- Discharge Heads
- Seals (Labyrinths)
- Endwall Forgings
- Bonnets
- Spring Guides
- Bell Seals
- Mufflers
- Bearing Covers
- Interceptor Valves
- Centering Beams
- Strainers
- Throttle Valves



Patriot Offers Full Machining Capabilities Including Blade-Side-Finish-Machining for Disks & Covers



See reverse for a complete list of raw materials, specialty grades & approved industry specifications.



PATRIOT
FORGE CO.

TURBOMACHINERY MATERIALS & SPECIFICATIONS

STOCKING GRADES SPECIFICATIONS

4130	13-4	303	ASTM A418
4140 TO ASTM A471 CLASS 12	13-8-MO (XM-13)	304L	(ROTOR SHAFT U.T. SPEC)
4320	15-5-PH	309	ASTM A472
4330	17-4-PH (630)	316H	(HEAT STABILITY PROCESS SPEC)
4330 NV	AM455 (CUSTOM 455)	347	ASTM A471 CLASS 12, 13 & 14
4340	A286 (A638 TYPE 660)	403	API 617, UG84, NACE MR-0175
4340 VAR	ALLOY 20 (CARPENTER 20)	410	
4340 ESR	6061F ALUMINUM	422	OEM PROPRIETARY GRADES
4340 MOD	SA182 F1, F22	422ESR	
HY80 , HY100	SA182 F6NM	LF2	
NITRALLOY 135M			
ASTM A470 CLASS 2, 4, 7, 8 & 9			

As an approved forging supplier to a variety of leading OEM Turbomachinery manufacturers, Patriot maintains an extensive inventory of all common proprietary industry grades including over 50 G.E. & Siemens Westinghouse grades. Please contact us for a complete list.

BALANCE OF OUR ACTIVE INVENTORY

STAINLESS & HIGH TEMPERATURE ALLOYS AIRCRAFT / MILITARY LOW ALLOY ASME GRADES CARBON

304	MIL 24093	A668	SA 105	1018
304H	MIL 23284	3310/12	SA 266 CL 1-4	1020
310	MIL 23009	4145	SA 182 F5,F6,	1022
316	MIL 6758	4150	F6A, F9,	1030
316L	MIL 5626	4150 RESUL	F11, F51,	1035
316L LOW CO.	MIL 8844	4320	F55, F91	1040
317L	MIL 860	4330V	SA 564 GR. 630	1045
321	MIL 890	8620	SA 638 GR. 660	1055
347H	MIL 5000	8627	SA 705 XM16	1060
405	MIL 18732	8630 MOD	SA 479 XM11, XM19	1070
416	QQ-N-281, 286	9310		1095
420	QQS 763	52100		1141
XM32 (JETHETE)	AMS 6512	EN30B		1146
NITRONIC 50	AMS 8699	17 Cr Ni Mo 6		
NITRONIC 60	AMS 6414	A508 CL 2,3,4		
MONEL 400	AMS 6415			
MONEL K500	AMS 5667			
INCONEL 600	AMS 5659			
INCONEL 625				

TOOL STEELS & SPECIALTY ALLOYS

INCONEL 625 PLUS		2025 ALUMINUM
INCONEL 718		300M
INCONEL 750	D2, A2, H13, S-7, W1, M2	C26
INCONEL 800	ELECTRICAL IRON	6AL-4V TITANIUM
INCONEL 825	2014 ALUMINUM	



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