

What Is Tungsten Alloy Block

中钨智造科技有限公司

CTIA GROUP LTD

CTIA GROUP LTD

Global Leader in Intelligent Manufacturing for Tungsten, Molybdenum, and Rare Earth Industries

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INTRODUCTION TO CTIA GROUP

CTIA GROUP LTD, a wholly-owned subsidiary with independent legal personality established by CHINATUNGSTEN ONLINE, is dedicated to promoting the intelligent, integrated, and flexible design and manufacturing of tungsten and molybdenum materials in the Industrial Internet era. CHINATUNGSTEN ONLINE, founded in 1997 with www.chinatungsten.com as its starting point—China's first top-tier tungsten products website—is the country's pioneering e-commerce company focusing on the tungsten, molybdenum, and rare earth industries. Leveraging nearly three decades of deep experience in the tungsten and molybdenum fields, CTIA GROUP inherits its parent company's exceptional design and manufacturing capabilities, superior services, and global business reputation, becoming a comprehensive application solution provider in the fields of tungsten chemicals, tungsten metals, cemented carbides, high-density alloys, molybdenum, and molybdenum alloys.

Over the past 30 years, CHINATUNGSTEN ONLINE has established more than 200 multilingual tungsten and molybdenum professional websites covering more than 20 languages, with over one million pages of news, prices, and market analysis related to tungsten, molybdenum, and rare earths. Since 2013, its WeChat official account "CHINATUNGSTEN ONLINE" has published over 40,000 pieces of information, serving nearly 100,000 followers and providing free information daily to hundreds of thousands of industry professionals worldwide. With cumulative visits to its website cluster and official account reaching billions of times, it has become a recognized global and authoritative information hub for the tungsten, molybdenum, and rare earth industries, providing 24/7 multilingual news, product performance, market prices, and market trend services.

Building on the technology and experience of CHINATUNGSTEN ONLINE, CTIA GROUP focuses on meeting the personalized needs of customers. Utilizing AI technology, it collaboratively designs and produces tungsten and molybdenum products with specific chemical compositions and physical properties (such as particle size, density, hardness, strength, dimensions, and tolerances) with customers. It offers full-process integrated services ranging from mold opening, trial production, to finishing, packaging, and logistics. Over the past 30 years, CHINATUNGSTEN ONLINE has provided R&D, design, and production services for over 500,000 types of tungsten and molybdenum products to more than 130,000 customers worldwide, laying the foundation for customized, flexible, and intelligent manufacturing. Relying on this foundation, CTIA GROUP further deepens the intelligent manufacturing and integrated innovation of tungsten and molybdenum materials in the Industrial Internet era.

Dr. Hanns and his team at CTIA GROUP, based on their more than 30 years of industry experience, have also written and publicly released knowledge, technology, tungsten price and market trend analysis related to tungsten, molybdenum, and rare earths, freely sharing it with the tungsten industry. Dr. Han, with over 30 years of experience since the 1990s in the e-commerce and international trade of tungsten and molybdenum products, as well as the design and manufacturing of cemented carbides and high-density alloys, is a renowned expert in tungsten and molybdenum products both domestically and internationally. Adhering to the principle of providing professional and high-quality information to the industry, CTIA GROUP's team continuously writes technical research papers, articles, and industry reports based on production practice and market customer needs, winning widespread praise in the industry. These achievements provide solid support for CTIA GROUP's technological innovation, product promotion, and industry exchanges, propelling it to become a leader in global tungsten and molybdenum product manufacturing and information services.



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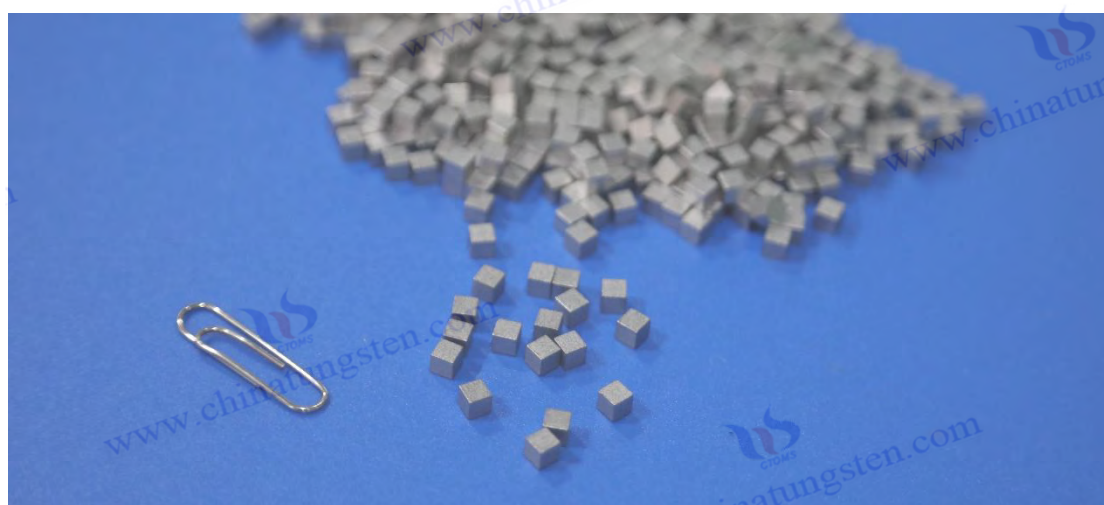
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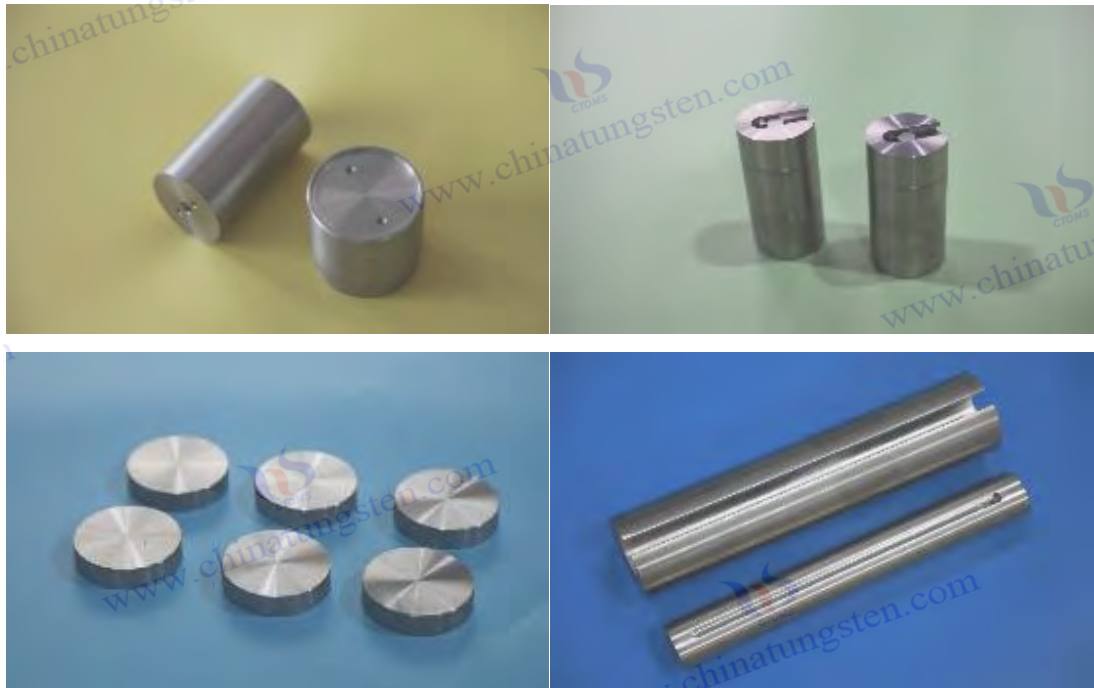
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Chapter 1 Basic Knowledge and Development History of Tungsten Alloy Blocks

1.1 Definition of Tungsten Alloy Block

Tungsten alloy block is an important starting point for understanding its application basis in modern industry and scientific research, involving a comprehensive consideration of material properties and uses. Tungsten alloy block generally refers to a block material made of tungsten as the main component and combined with other metal elements through a specific process. Its notable features are high density and high atomic number, which make it occupy an important position in radiation protection, counterweights and precision manufacturing. The preparation process relies on advanced materials technology to form a strong and uniform structure by mixing, pressing and sintering tungsten with other metal powders. The definition of tungsten alloy block is not only limited to its physical form, but also covers its functional design. It can be customized according to the needs of different industries, such as being used as a shielding material in medical equipment or as a high-density component in the industrial field. In the course of development, tungsten alloy block has gradually evolved from an auxiliary material for traditional metal processing to a key functional material, widely used in multiple fields.

Tungsten alloy blocks is also closely related to their manufacturing process. Powder metallurgy, as the core technology, optimizes the material's microstructure by controlling powder particle size and mixing ratio. The emergence of this block material is due to advances in materials science, especially the introduction of high-temperature and high-pressure processing, such as hot isostatic pressing, which further improves its density and stability. In practical applications, tungsten alloy blocks need to meet diverse performance requirements, such as corrosion resistance, high-temperature resistance, and mechanical strength. These properties enable them to perform well in complex environments. Manufacturers adjust the size and shape of the blocks according to specific uses. Researchers continue to explore their potential applications through experiments and analysis to guide technological improvements.

1.1.1 Definition of Tungsten Alloy Block

Tungsten alloy block is the basis for understanding its technical characteristics and application scenarios, and involves the intersection of materials science and engineering design. Tungsten alloy block is a block-shaped solid material made of tungsten as the main component and other metal elements through a powder metallurgy process. Its core characteristics are high density and excellent radiation absorption capacity. This conceptual definition not only emphasizes the high melting point and hardness of tungsten, but also includes performance optimization achieved by adding other metal elements, such as improving ductility or processability. The conceptual definition of tungsten alloy block is also closely related to its practical function. It is designed as a component that can meet specific industrial and scientific research needs, such as being used as a shielding material in radiation protection, or as a balance block in mechanical equipment. In the course of development, the concept of tungsten alloy block has gradually expanded from a single material to a multifunctional composite material, adapting to the transformation from traditional manufacturing to modern high-tech applications.

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The concept definition process focused on combining material properties with process parameters. Powder metallurgy achieves a uniform distribution of tungsten and other metals through mixing and sintering, while hot isostatic pressing further optimizes the internal structure, reducing defects and porosity. The concept definition of the tungsten alloy block also addressed its adaptability in diverse environments, such as maintaining stability in high-temperature or corrosive environments, which excels in medical devices, industrial testing, and scientific research instruments. Manufacturers adjust the block's geometry and size to meet specific application requirements, while researchers continuously refine the concept definition and explore new applications through microscopic analysis and performance testing.

1.1.2 Composition of tungsten alloy block

Tungsten alloy blocks is a key factor in determining their performance and scope of application, involving the ratio and interaction of elements in materials science. Tungsten , as the main component, becomes the core of the alloy due to its high density and high atomic number, providing excellent radiation shielding and mechanical strength. The addition of other metal elements, such as nickel, copper or iron, is intended to enhance the ductility, processability and corrosion resistance of tungsten. These components are formulated in specific proportions to form a unique composite material. The composition design of tungsten alloy blocks not only takes into account the physical properties of the material, but also focuses on its controllability during the manufacturing process, such as achieving uniform mixing through powder metallurgy. The diversity of composition enables tungsten alloy blocks to adapt to a variety of uses, from radiation protection in the medical field to heavy components in the industrial field, demonstrating its wide range of application potential.

The process of determining the composition relies on precise material preparation technology. The powder metallurgy process ensures the uniform distribution of the various components by mixing tungsten powder with other metal powders. The hot isostatic pressing process further optimizes the bonding strength between the components through high temperature and high pressure treatment. The composition of tungsten alloy blocks is also constrained by the application environment. For example, in scenarios requiring high thermal conductivity, the addition of copper is particularly important, while in scenarios requiring high strength, the addition of nickel is even more critical. Manufacturers adjust the composition ratio according to specific needs. Researchers verify the impact of composition on material properties through chemical analysis and performance testing to guide process improvements.

1.1.3 Effect of Tungsten Alloy Block Composition

Tungsten alloy composition is central to understanding its superior performance and diverse applications, encompassing the specific contributions of each element to the material's properties. Tungsten , the primary component, provides the alloy's radiation shielding properties with its high density and atomic number, while also imparting its exceptional mechanical strength and high-temperature resistance. However, tungsten 's inherent brittleness limits its workability, necessitating the addition of other metallic elements, such as nickel, copper, or iron. Nickel enhances ductility and toughness, making tungsten

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alloys less susceptible to cracking during molding and use. Copper enhances thermal conductivity and corrosion resistance, making it suitable for environments requiring high thermal stability. Iron provides additional strength and cost-effectiveness in certain formulations. These components, carefully blended, create a synergistic effect, optimizing the overall performance of the tungsten alloy. The role of composition is not only reflected in the physical properties but also influences the manufacturing process and the functionality of the final product.

The role of the components is fully utilized during the preparation process through the powder metallurgy process, which ensures the uniform distribution of each element by mixing different metal powders. The hot isostatic pressing process further strengthens the bonding between the components through omnidirectional pressure and reduces internal defects. The high density of tungsten makes it dominant in radiation protection, while the ductility of the added metal improves the adaptability of tungsten alloy blocks in complex processing, such as cutting or grinding into special-shaped structures. In medical equipment, the role of components ensures the efficiency of shielding materials; in the industrial field, the optimization of components supports the durability of heavy-duty components. Manufacturers adjust the proportion of components according to specific application scenarios. Researchers explore the synergistic mechanism of each component through microscopic analysis and performance testing to guide technological improvements.

1.2 Development History of Tungsten Alloy Blocks

Tungsten alloy blocks is a microcosm of the progress of materials science and industrial technology, reflecting the evolution from primitive exploration to modern application. The origins of tungsten alloy blocks can be traced back to the early stages of metal processing technology, when people began to recognize the high density and high-temperature resistance of tungsten and tried to combine it with other metals to overcome its processing difficulties. In the early stages of development, tungsten alloys were mainly used for simple industrial components. With the advent of powder metallurgy technology, the preparation process was significantly improved, enabling tungsten alloy blocks to be produced in a more uniform and dense form. The introduction of hot isostatic pressing marked a major technological breakthrough, optimizing the material's microstructure and promoting the widespread application of tungsten alloy blocks in radiation protection and precision manufacturing. Over the course of its development history, tungsten alloy blocks have gradually transformed from auxiliary materials to key functional materials, adapting to the needs of various fields such as medicine, industry, and scientific research.

Tungsten alloys has been accompanied by the continuous expansion of application needs. In the early days, tungsten alloy blocks were mostly used in basic industrial fields such as mechanical balancing and wear-resistant components. Later, with the increasing demand for radiation protection, their role in medical equipment and the nuclear industry became increasingly prominent. Advances in manufacturing processes, such as the optimization of powder metallurgy and hot isostatic pressing, have contributed to the improvement of the performance of tungsten alloy blocks, enabling them to meet higher standards in application scenarios.

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1.2.1 Early Exploration and Application of Tungsten Alloys

Early tungsten alloys marked the starting point of the development of tungsten alloy blocks, marking the initial understanding and utilization of tungsten's properties in materials science. Tungsten began to attract attention in the late 19th century due to its high melting point and density, and researchers attempted to combine it with other metals to improve its processing properties and practicality. Early exploration focused on simple alloy formulas, producing rough tungsten alloy blocks through manual mixing and preliminary smelting processes. These blocks were initially used in industrial fields such as tool manufacturing and high-temperature resistant components, demonstrating certain advantages due to tungsten's hardness. However, due to the process limitations of the time, the uniformity and density of early tungsten alloys were poor, limiting their wider application.

Tungsten alloys entered a new phase with the advent of powder metallurgy. This process significantly improved the material's uniformity by mixing tungsten powder with other metal powders and pressing them into shape. Early attempts at hot isostatic pressing further optimized the structure, reduced internal defects, and enabled tungsten alloy blocks to exhibit more stable properties. Early applications were primarily focused on the machinery industry, such as heavy equipment components and wear-resistant linings, with initial attempts also beginning in some radiation-related fields.

1.2.2 Technological evolution of tungsten alloy blocks

Tungsten alloy blocks are a concentrated reflection of the technological progress in their development history, reflecting the continuous innovation of materials science and manufacturing processes. In the early stages, the preparation of tungsten alloy blocks mainly relied on simple smelting and casting techniques. Researchers explored the combination of tungsten and other metals through experiments and initially realized the forming of block materials. The process at this stage was relatively rough, the uniformity and density of the material were limited, and the scope of application was mostly limited to basic industrial fields. Subsequent developments brought about the introduction of powder metallurgy technology. This process significantly improves the microstructure and properties of the material by mixing, pressing and sintering tungsten powder with other metal powders, marking that tungsten alloy block technology has entered a new stage. The emergence of hot isostatic pressing technology has further promoted technological evolution. Through high temperature and high pressure omnidirectional processing, the internal structure of the material is optimized, defects are reduced, and density and stability are improved.

The intermediate stages of technological evolution saw the expansion of tungsten alloy block applications and the refinement of processes. Optimization of powder metallurgy processes resulted in a more uniform distribution of components, while the widespread use of hot isostatic pressing (HIP) enabled its adaptation to more complex processing requirements, such as special-shaped structures or thin-walled parts. During this phase, tungsten alloy blocks began to emerge in radiation protection, medical equipment, and precision manufacturing. Manufacturers adjusted process parameters based on industry needs, and researchers verified the effectiveness of the technology through experiments and

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simulation analysis. Later in the evolution, the technology entered a phase of intelligentization and efficiency, with the introduction of multi-axis machining equipment and surface treatment technologies, further enhancing the precision and durability of tungsten alloy blocks.

1.2.3 Development achievements of modern tungsten alloy blocks

Modern tungsten alloy ingots represents the fusion of materials science and industrial technology, demonstrating significant advancements in performance and application. Currently, tungsten alloy ingots, due to their high density and high atomic number, have become the material of choice in radiation protection. Optimized manufacturing processes, such as powder metallurgy and hot isostatic pressing (HIP), achieve high density and uniformity through precise control of powder particle size and pressure. This advancement enables tungsten alloy ingots to excel in medical devices, industrial testing, and scientific research instruments, providing effective shielding in radiotherapy equipment and nuclear medicine containers. Modern technology has also introduced multi-axis machining and surface treatment processes, enabling the fabrication of complex, custom-shaped structures to meet diverse design requirements, enhancing their potential for application in precision manufacturing. These advancements are also evident in the durability and environmental friendliness of tungsten alloy ingots. The optimized HIP process delivers excellent mechanical strength and corrosion resistance, extending their service life, while the use of non-toxic components reduces environmental impact. Manufacturers customize production for modern applications, and researchers validate these findings through performance testing and environmental simulations, guiding technological advancements. Modern tungsten alloy blocks also benefit from the support of intelligent manufacturing technologies, such as optimizing the production process through real-time monitoring, thereby improving quality consistency.

1.3 Comparison of the Differences between Tungsten Alloy Blocks and Other Block Materials

Tungsten alloy blocks is to compare them with other bulk materials, which involves multiple considerations of performance, application, and manufacturing process. Compared with traditional bulk materials such as lead or steel, tungsten alloy blocks provide better radiation shielding capabilities with their high density and high atomic number, giving them an advantage in the medical and nuclear industries. Lead blocks are lower in cost but more toxic, while steel blocks are inferior in density and shielding efficiency. In terms of preparation process, tungsten alloy blocks rely on powder metallurgy and hot isostatic pressing technology to achieve high density and uniformity, while lead blocks are mostly formed by simple casting, and steel blocks require a complex forging process. The processing difficulty and precision are not as good as tungsten alloy blocks. The difference of tungsten alloy blocks is also reflected in their mechanical properties. The high hardness and toughness make them superior to lead blocks in wear resistance and impact resistance. The processed special-shaped structures are also more flexible than steel blocks.

The comparison also encompasses application scenarios and environmental adaptability. Tungsten alloy blocks, due to their low toxicity and recyclability, are gradually replacing lead blocks in medical devices and scientific research instruments. Their compact design is suitable for space-constrained industrial

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applications, while steel blocks are primarily used for structural support rather than shielding. Tungsten alloy blocks optimized for hot isostatic pressing (HIP) exhibit stability in high-temperature and corrosive environments, surpassing the durability of traditional materials. Manufacturers adjust production strategies based on these comparison results, and researchers verify these differences through performance testing and application analysis, guiding technical optimization.

1.3.1 Differences in performance and application compared to pure tungsten bulk

The difference in performance and application compared to pure tungsten blocks is the key to understanding the unique value of tungsten alloy blocks, which involves a comprehensive comparison of material properties and processing technology. Pure tungsten blocks are known for their extremely high melting point and density, and exhibit excellent high temperature resistance and radiation absorption capabilities, but their significant brittleness limits their processability and scope of application. Tungsten alloy blocks significantly improve the ductility and toughness of pure tungsten by adding metals such as nickel, copper or iron, enabling them to maintain stability during complex cutting, grinding and forming processes. In terms of preparation technology, tungsten alloy blocks use powder metallurgy and hot isostatic pressing technology to optimize the microstructure through uniform mixing and omnidirectional pressure treatment, while the preparation of pure tungsten blocks mostly relies on high-temperature sintering, which makes it difficult to eliminate internal defects. This makes tungsten alloy blocks superior to pure tungsten blocks in mechanical properties and processing accuracy, expanding their application scenarios.

In terms of application, pure tungsten blocks, due to their brittleness, are primarily used for simple components in high-temperature environments, such as electrodes or heat-resistant linings. Tungsten alloy blocks, with their improved toughness and density, are widely used in fields requiring high precision and complex shapes, such as shielding components for medical radiation protection and balancing blocks for industrial equipment. Tungsten alloy blocks optimized through the hot isostatic pressing process also offer increased corrosion resistance and consistency, making them suitable for use in changing environments. Pure tungsten blocks are susceptible to environmental factors over long-term use.

1.3.2 Comparison with lead blocks

Comparison with lead blocks is an important dimension for evaluating the advantages of tungsten alloy blocks, covering many differences in performance, environmental protection, and application scenarios. Lead blocks are known for their low cost and high density, and have long been the mainstream choice for radiation shielding materials, but their softness and toxicity have become significant disadvantages. Tungsten alloy blocks provide radiation absorption capabilities comparable to lead through high density and high atomic number. At the same time, due to the reinforcement of added metals such as nickel or copper, they have higher hardness and mechanical strength, making them less likely to deform during processing and use. In terms of preparation process, tungsten alloy blocks rely on powder metallurgy and hot isostatic pressing technology to achieve high density and uniformity, while lead blocks are mostly formed by simple casting, with poor surface quality and internal structural stability. This makes tungsten

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alloy blocks superior to lead blocks in precision manufacturing and long-term durability.

In a comparison of applications, lead blocks are gradually being replaced by tungsten alloy blocks due to toxicity restrictions, particularly in the medical equipment and nuclear industries. Tungsten alloy blocks' non-toxicity and recyclability make them more compliant with modern environmental requirements. Tungsten alloy blocks optimized through hot isostatic pressing (HIP) excel in compact designs, making them suitable for space-constrained applications such as portable radiation detection equipment. Lead blocks, due to their bulk, are often used in fixed shielding structures.

1.3.3 Comparison with steel blocks

Comparison with steel blocks is an important perspective for measuring the unique performance of tungsten alloy blocks, involving a comprehensive consideration of density, shielding efficiency, and processing difficulty. Steel blocks are known for their high strength and low cost, and are widely used in structural supports and mechanical components, but their density and atomic number are low, and their radiation shielding capabilities are far inferior to those of tungsten alloy blocks. Tungsten alloy blocks provide excellent radiation absorption performance through their high density and high atomic number characteristics, making them particularly suitable for protection needs in medical and industrial settings. In terms of preparation technology, tungsten alloy blocks use powder metallurgy and hot isostatic pressing technology to optimize the microstructure and density. Although the forging or casting process of steel blocks is suitable for large-scale production, it is difficult to achieve high-precision special-shaped structures or high density. This makes tungsten alloy blocks superior to steel blocks in radiation protection and precision processing.

In various applications, steel blocks are often used for mechanical components requiring high strength and wear resistance, such as industrial equipment frames. Tungsten alloy blocks, due to their compactness and efficient shielding capabilities, are widely used in radiation-sensitive environments, such as CT scanners and particle accelerators. Tungsten alloy blocks optimized through the hot isostatic pressing process also exhibit improved corrosion resistance and stability, making them suitable for complex environments. Steel blocks are susceptible to damage from long-term exposure to radiation or chemical conditions. Manufacturers adjust material ratios based on application requirements, and researchers verify these differences through mechanical testing and radiation attenuation analysis, guiding technological improvements.



CTIA GROUP LTD Tungsten Alloy Block

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Chapter 2 Classification of Tungsten Alloys

2.1 Tungsten Alloy Blocks by Composition

Tungsten alloy blocks by composition is the basis for understanding their diverse properties and applications, and reflects the concept of achieving functional optimization through element ratios in materials science. Tungsten alloy blocks can be divided into multiple categories based on the main added metals, and each category meets different industrial and scientific research needs through a specific combination of components. Preparation processes such as powder metallurgy lay the foundation for classification by mixing, pressing and sintering tungsten with other metal powders, while the hot isostatic pressing process further optimizes the microstructure and density of the material, making each type of tungsten alloy block unique in performance. Tungsten alloy blocks classified by composition are widely used in radiation protection, mechanical components and high-temperature environments, reflecting the flexibility of material design. In the course of development, this classification method has promoted the expansion of tungsten alloy blocks from single use to multi-field applications, and in the future, its classification system may be further enriched through new component ratios.

The classification process focuses on the impact of composition on performance and processability. The uniformity of materials optimized through hot isostatic pressing enhances performance differentiation between categories. Manufacturers select the appropriate composition combination based on application requirements. Researchers verify the classification results through experiments and analysis, guiding technological improvements.

2.1.1 Tungsten-nickel-iron alloy block

Tungsten -nickel-iron alloy blocks are an important type of tungsten alloy blocks classified by composition, and they excel in multiple fields with their unique combination of properties. Tungsten, as the main component, provides high density and high atomic number, giving the alloy excellent radiation absorption capacity and mechanical strength, while the addition of nickel and iron significantly improves the material's ductility and toughness, making it less susceptible to cracking during processing. Preparation processes such as powder metallurgy form a stable microstructure by uniformly mixing, pressing and sintering tungsten, nickel and iron powders. The hot isostatic pressing process further optimizes the density through omnidirectional pressure, ensuring the uniformity and stability of the alloy block. Due to its excellent comprehensive properties, tungsten -nickel -iron alloy blocks have become an ideal choice for radiation protection and counterweights, and are widely used in medical equipment, industrial testing and scientific research instruments.

Tungsten -nickel-iron alloy blocks is reflected in their versatility. Nickel enhances the alloy's corrosion resistance and machinability, while iron provides additional economical and strong support, enabling it to perform well in complex environments. Optimized hot isostatic pressing reduces internal defects and improves machining accuracy. Post-processing processes such as cutting and grinding further refine the block's geometry, and surface treatments such as anti-oxidation coatings extend its service life.

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Manufacturers adjust the nickel-iron ratio based on specific applications, and researchers explore its characteristics through performance testing and microanalysis to guide technological improvements.

2.1.2 Tungsten-nickel-copper alloy block

Tungsten -nickel-copper alloy blocks are another important category of tungsten alloy blocks classified by composition , renowned for their excellent thermal conductivity and corrosion resistance. Tungsten , as the core component, provides high density and high radiation absorption capacity, while the addition of nickel enhances ductility and toughness. Copper significantly improves the alloy's thermal conductivity and corrosion resistance, making it suitable for environments requiring thermal management or chemical stability. Preparation processes such as powder metallurgy lay the foundation for the material by mixing tungsten, nickel, and copper powders , pressing, and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces porosity, and improves material uniformity. Tungsten -nickel-copper alloy blocks excel in high-temperature environments and radiation protection, and are widely used in medical imaging equipment, industrial heating components, and scientific research instruments.

Tungsten -nickel-copper alloy blocks gives them unique advantages in specialized applications. Copper's thermal conductivity ensures stability under high heat loads , while nickel enhances flexibility during processing. The optimized hot isostatic pressing process results in a highly dense material. Post-processing techniques such as grinding and surface polishing enhance the block's precision, while surface treatments such as corrosion-resistant coatings enhance durability in humid environments. Manufacturers adjust the copper content based on thermal management requirements, and researchers verify its performance through thermal conductivity testing and corrosion experiments, guiding technological improvements.

2.1.3 Tungsten copper alloy block

Tungsten copper alloy block is a unique type of tungsten alloy block classified by composition , and occupies an important position in specific fields due to its excellent electrical conductivity and thermal conductivity. Tungsten provides high density and high radiation shielding capabilities, while the addition of copper significantly enhances the electrical conductivity and thermal conductivity of the alloy, making it perform well in scenarios requiring efficient heat dissipation or electrical contact. Preparation processes such as powder metallurgy form a two-phase structure by mixing, pressing and sintering tungsten and copper powders , and the hot isostatic pressing process optimizes the density of the material through omnidirectional pressure to ensure performance stability. Although the melting points of tungsten and copper are quite different, the preparation process needs to be precisely controlled to achieve uniform distribution. Tungsten copper alloy blocks are widely used in electronic equipment, discharge machining electrodes and radiation protection components.

Tungsten-copper alloy blocks contributes to their dual properties: tungsten provides mechanical strength and radiation protection, while copper ensures efficient thermal management and electrical performance.

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Optimized materials through hot isostatic pressing (HIP) reduce the risk of phase separation. Post-processing, such as cutting and surface treatment, refines the block geometry. Surface treatments, such as anti-oxidation coatings, extend service life. Manufacturers adjust the tungsten-copper ratio based on electrical conductivity or heat dissipation requirements. Researchers verify these properties through electrical conductivity testing and thermal conductivity analysis, guiding technological improvements.

2.1.4 Tungsten silver alloy block

Tungsten-silver alloy block is a special type of tungsten alloy block classified by composition, and it shows significant advantages in specific applications with its unique electrical conductivity and thermal management capabilities. Tungsten, as the main component, provides excellent radiation absorption and mechanical strength due to its high density and high atomic number, while the addition of silver significantly improves the electrical conductivity, thermal conductivity and corrosion resistance of the alloy, making it outstanding in environments requiring efficient electrical contact or heat dissipation. Preparation processes such as powder metallurgy form a uniform two-phase structure by mixing, pressing and sintering tungsten powder and silver powder. Although the melting points of tungsten and silver are quite different, the process needs to be precisely controlled to ensure the uniformity of the composition distribution. The hot isostatic pressing process further optimizes the microstructure through omnidirectional pressure, reduces porosity, and improves the density and stability of the material. Tungsten-silver alloy blocks are widely used in electronic components, discharge machining electrodes and some radiation protection scenarios due to their excellent comprehensive properties.

Tungsten-silver alloy blocks contribute to their dual properties: tungsten provides high hardness and radiation shielding capabilities, while silver offers excellent electrical and thermal conductivity, making them suitable for devices requiring high current or heat loads. Hot isostatic pressing (HIP) optimizes the material to reduce the risk of phase separation and microcracks. Post-processing techniques such as cutting and grinding refine the block geometry, while surface treatments such as anti-oxidation or anti-corrosion coatings extend service life, making it particularly stable in humid or high-temperature environments.

2.1.5 Tungsten-molybdenum alloy block

Tungsten alloy blocks classified by composition. They perform well in extreme environments with their excellent high-temperature resistance and mechanical strength. Tungsten, as the core component, provides high density and high radiation absorption capacity, while the addition of molybdenum enhances the alloy's resistance to high-temperature oxidation and ductility, enabling it to maintain stability under high-temperature or high-stress conditions. Preparation processes such as powder metallurgy form a uniform microstructure by mixing, pressing and sintering tungsten powder and molybdenum powder. The hot isostatic pressing process further optimizes the material's density through omnidirectional pressure, reduces internal defects, and ensures consistent performance. Although both tungsten and molybdenum have high melting points, the preparation process requires precise control of temperature and pressure to achieve the best combination. Tungsten-molybdenum alloy blocks are

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widely used in high-temperature furnaces, aviation components, and radiation protection equipment.

The composition of tungsten-molybdenum alloy blocks lies in their synergistic combination of high-temperature resistance and mechanical properties. Tungsten provides high density and radiation shielding capabilities, while molybdenum enhances oxidation resistance and toughness, making them suitable for long-term exposure to high-temperature environments. The material, optimized through the hot isostatic pressing process, exhibits high density and low porosity. Post-processing techniques such as cutting and surface polishing enhance the precision of the blocks, while surface treatments such as high-temperature resistant coatings enhance their durability under extreme conditions. Manufacturers adjust the tungsten-molybdenum ratio based on the requirements of high-temperature applications. Researchers verify their properties through high-temperature testing, mechanical property analysis, and microstructural observations, guiding technological improvements.

2.1.6 Tungsten-niobium alloy block

Tungsten alloy ingot classified by composition, emerging in specialized fields for their excellent corrosion resistance and high strength. Tungsten, as the primary component, provides high density and radiation absorption, while the addition of niobium enhances the alloy's corrosion resistance and ductility, enabling it to perform well in acidic or humid environments. Preparation processes such as powder metallurgy create a stable microstructure by mixing, pressing, and sintering tungsten and niobium powders. Hot isostatic pressing optimizes the material's uniformity and density through omnidirectional pressure, reducing defects during processing. The difference in melting points between tungsten and niobium requires precise process control to ensure uniform distribution of components and stable performance. Tungsten-niobium alloy ingots are widely used in chemical equipment, medical radiation protection, and scientific research experimental equipment.

The composition of the tungsten-niobium alloy blocks contributes to their combined corrosion resistance and mechanical properties. Tungsten provides high hardness and radiation shielding capabilities, while niobium enhances chemical resistance and toughness, making them suitable for applications requiring long-term durability. The material, optimized through hot isostatic pressing (HIP), exhibits high density and low internal stress. Post-processing such as grinding and surface treatment refines the block's geometry, while surface treatments such as corrosion-resistant coatings further enhance its stability in harsh environments.

2.2 Tungsten Alloy Blocks by Density

Tungsten alloy blocks by density is a systematic division based on their physical properties, reflecting the performance differences of the material in different application scenarios. The density of tungsten alloy blocks is significantly higher than that of traditional metal materials due to the high-density characteristics of its main component, tungsten. By adjusting the proportion of added metals and the preparation process, the density range can be diversified. Preparation processes such as powder metallurgy lay the foundation for density by mixing tungsten with other metal powders, pressing and

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sintering. The hot isostatic pressing process further optimizes the density of the material through omnidirectional pressure, making the density classification more accurate. Tungsten alloy blocks classified by density cover high-density and medium-density categories, which are suitable for fields requiring efficient shielding or lightweight design respectively. This classification method has promoted the widespread application of tungsten alloy blocks in medical, industrial and scientific research fields, and the density range may be further refined through new processes in the future.

The density classification process focuses on matching material properties with application requirements. The uniformity of materials optimized through the hot isostatic pressing process enhances performance stability across all density levels. Manufacturers select the appropriate density level based on specific applications. Researchers verify the classification results through density testing and performance analysis, guiding technological improvements.

2.2.1 High-density tungsten alloy block

High-density tungsten alloy blocks are the core type of tungsten alloy blocks classified by density. They perform outstandingly in specific fields with their excellent radiation absorption capacity and mechanical strength. The high-density property mainly comes from the high atomic number and dense structure of tungsten. By increasing the tungsten content and combining it with the hot isostatic pressing process, the extremely high density of the material is achieved. This feature makes high-density tungsten alloy blocks an ideal choice for radiation protection. They are widely used in medical equipment such as radiotherapy machines and nuclear medicine containers, as well as industrial detection equipment in scenarios requiring efficient shielding. Preparation processes such as powder metallurgy lay the foundation for density by mixing, pressing and sintering a high proportion of tungsten powder with other metal powders. The hot isostatic pressing process further eliminates internal porosity through omnidirectional pressure, ensuring the uniformity and stability of the material.

High-density tungsten alloy blocks is also reflected in their mechanical properties and processing adaptability. The addition of metals such as nickel or copper not only improves ductility, but also supports the processing of complex shapes, such as cutting or grinding into special-shaped structures. The material optimized by the hot isostatic pressing process has low porosity and high-quality surface. Post-processing processes such as surface polishing and coating treatment enhance its corrosion resistance and durability, making it suitable for long-term use environments. Manufacturers adjust the tungsten content according to radiation protection requirements. Researchers verify its characteristics through radiation attenuation tests and mechanical property analysis to guide technical improvements. High-density tungsten alloy blocks are particularly good in compact designs. In the future, lightweight technology or new alloy ratios may be used to further expand their application potential in medical and scientific research fields.

2.2.2 Medium density tungsten alloy block

Medium-density tungsten alloy blocks are another important category of tungsten alloy blocks classified by density. They have advantages in a variety of applications with their balanced performance and

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lightweight design. The realization of medium density is achieved by reducing the tungsten content and increasing the ductile metals such as copper or nickel, which optimizes the relationship between the weight and protective ability of the material. Preparation processes such as powder metallurgy lay the foundation for medium density by mixing appropriate amounts of tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces defects, and ensures the stability of the material. Medium-density tungsten alloy blocks are widely used in scenarios where the weight of equipment needs to be reduced, such as portable radiation detection equipment, geological exploration instruments and some industrial balancing parts.

medium-density tungsten alloy blocks lies in their compromise between protective performance and processing flexibility. The ductility of the added metal supports complex processing processes such as grinding or 3D forming, while the density of tungsten still ensures basic radiation shielding capabilities. The material optimized by the hot isostatic pressing process has uniformity, and post-processing processes such as surface treatment improve wear resistance and appearance quality, making it suitable for use in a variety of environments. Manufacturers adjust the proportion of ingredients according to lightweight requirements, and researchers verify its performance through density testing and application simulation to guide technical improvements. Medium-density tungsten alloy blocks are particularly practical in the field and in mobile equipment. In the future, their performance and application range may be further improved by optimizing the ratio or introducing composite material technology.

2.3 Classification of Tungsten Alloy Blocks by Application Scenario

Tungsten alloy blocks by application scenario is a grouping method based on their functional requirements, reflecting the targeted application of materials in different industries. Due to its high density, high atomic number and excellent mechanical properties, tungsten alloy blocks can adapt to a variety of complex environments and meet diverse usage needs by adjusting the composition and preparation process. Preparation processes such as powder metallurgy lay the foundation for the material by mixing tungsten with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, improving the density and stability of the material. Tungsten alloy blocks classified by application scenarios include three categories: radiation protection, counterweights, and structural support, serving the medical, industrial, and mechanical fields respectively. This classification method has promoted the popularization of tungsten alloy blocks in practical applications, and its application scenarios may be further expanded through technological innovation in the future.

The classification process focuses on matching material properties with the intended use environment. The uniformity of the material optimized by the hot isostatic pressing process enhances performance across various application categories. Manufacturers adjust production processes based on specific scenarios, and researchers verify the classification results through application testing and performance analysis, guiding technological improvements. Future developments may optimize tungsten alloy blocks classified by application scenario through intelligent design and novel material ratios, adapting them to

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more emerging fields.

2.3.1 Tungsten alloy blocks for radiation protection

Tungsten alloy blocks for radiation protection are the core type of tungsten alloy blocks classified by application scenarios, and play a key role in sensitive environments with their excellent radiation absorption capabilities. The high density and high atomic number of tungsten enable it to effectively shield X-rays, gamma rays and some neutron radiation. By adding metals such as nickel or copper, the ductility and processability of the material are enhanced. Preparation processes such as powder metallurgy form a dense microstructure by mixing a high proportion of tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process further optimizes the material through omnidirectional pressure, reduces internal porosity, and ensures protection efficiency. Tungsten alloy blocks for radiation protection are widely used in the medical field, such as radiotherapy equipment, CT machines and nuclear medicine containers, as well as scenarios where radiation isolation is required in industrial testing and scientific research experiments.

This type of tungsten alloy block focuses on compactness and high precision. The material optimized by the hot isostatic pressing process has low porosity and uniformity. Post-processing processes such as cutting, grinding and surface polishing refine the geometry of the block. Surface treatments such as anti-corrosion coatings improve its durability in long-term use. Manufacturers adjust the tungsten content according to the type and intensity of radiation. Researchers verify its performance through radiation attenuation tests and clinical simulations to guide technological improvements. Tungsten alloy blocks for radiation protection are particularly effective in environments with limited space and high safety requirements. In the future, lightweight design or intelligent monitoring technology may be used to further enhance their application potential in the medical and industrial fields.

2.3.2 Tungsten alloy block for counterweight

Tungsten alloy blocks for counterweights are a practical type of tungsten alloy blocks classified by application scenarios. With their high density and compactness, they excel in meeting balance and stability requirements. The high density of tungsten allows it to provide a large mass in a small volume. The addition of metals such as nickel or iron enhances the toughness and processability of the material, making it suitable for manufacturing precision counterweight components. Preparation processes such as powder metallurgy lay the foundation for density by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces defects, and ensures the stability of the material. Tungsten alloy blocks for counterweights are widely used in industrial equipment, aviation equipment, and sports equipment, such as crane counterweights, aircraft counterweights, and golf heads, meeting scenarios that require precise balance and space optimization.

this type of tungsten alloy block focuses on weight distribution and processing flexibility. The material optimized by the hot isostatic pressing process has high density and uniformity. Post-processing

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processes such as 3D machining and surface treatment refine the shape of the block, and surface coatings such as wear-resistant layers extend its service life. Manufacturers adjust the size and shape of the block according to the equipment design. Researchers verify its performance through balance testing and durability analysis to guide technical improvements. Tungsten alloy blocks for counterweights are particularly practical in mobile devices and precision instruments.

2.3.3 Tungsten alloy blocks for structural support

Tungsten alloy blocks for structural support are a robust type of tungsten alloy block categorized by application scenario. Their excellent mechanical strength and durability play a vital role in supporting structures. Tungsten's high hardness and density provide exceptional resistance to compression and deformation. Adding metals such as molybdenum or niobium enhances the material's toughness and corrosion resistance, making it suitable for scenarios subject to long-term loads. Preparation processes such as powder metallurgy create a stable microstructure by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes the material's density through omnidirectional pressure, reduces internal stress, and ensures structural stability. Tungsten alloy blocks for structural support are widely used in mechanical equipment, building components, and scientific research instruments, such as heavy machinery supports and experimental platform foundations.

This type of tungsten alloy block focuses on strength and long-term durability. The material optimized by the hot isostatic pressing process has high density and low defect rate. Post-processing processes such as cutting and surface polishing improve the precision of the block. Surface treatments such as high-temperature resistant or corrosion-resistant coatings enhance its performance in extreme environments. Manufacturers adjust the thickness and shape of the block according to support requirements. Researchers verify its characteristics through mechanical testing and environmental simulation to guide technical improvements. Tungsten alloy blocks for structural support perform well in industrial and scientific research environments that require high stability. In the future, their application potential in complex structures may be further enhanced through composite material technology or intelligent design.



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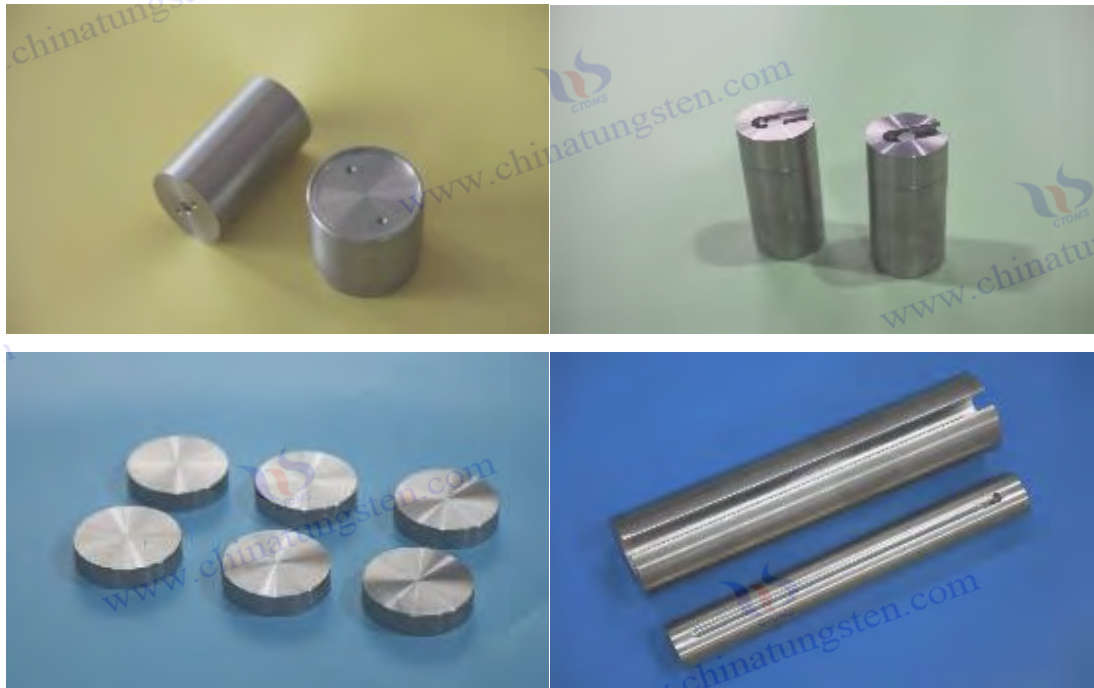
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Chapter 3 Physical and Chemical Properties of Tungsten Alloy Blocks

3.1 Physical properties of tungsten alloy blocks

Tungsten alloy blocks are the core foundation for their outstanding performance in a variety of applications, covering a wide range of properties such as density, hardness, and thermal conductivity. Tungsten, as the main component, gives the alloy blocks excellent radiation absorption and mechanical strength due to its high density and high atomic number. The addition of metals such as nickel, copper or iron forms a uniform microstructure with tungsten through powder metallurgy and hot isostatic pressing processes, further optimizing these properties. The diversity of physical properties enables tungsten alloy blocks to adapt to different scenarios, from medical radiation protection to industrial counterweights, and the meticulous control during the preparation process ensures the consistency and reliability of the material. In the course of development, the improvement of physical properties has promoted the expansion of tungsten alloy blocks from traditional uses to high-tech fields, reflecting the progress of materials science and engineering technology.

Physical property evaluation focuses on the material's performance in real-world environments. Optimized tungsten alloy blocks, resulting from hot isostatic pressing, exhibit significantly enhanced performance stability due to their low porosity and uniformity. Post-processing processes such as cutting and surface treatment refine the block's geometry, while surface coatings such as corrosion-resistant layers further enhance durability.

3.1.1 Density characteristics of tungsten alloy blocks

Tungsten alloy blocks is a core element of their physical properties, directly determining their potential applications in radiation protection, counterweights, and structural support. Tungsten's high density makes it a key contributor to alloys, and the addition of metals such as nickel, copper, or iron allows for adjustable density to meet diverse requirements. Preparation processes such as powder metallurgy lay the foundation for density by mixing high proportions of tungsten powder with other metal powders, followed by pressing and sintering. Hot isostatic pressing optimizes the microstructure through omnidirectional pressure, eliminating internal porosity and ensuring uniform and stable density. Density not only influences the weight of tungsten alloy blocks but is also closely related to their radiation absorption efficiency and mechanical strength, contributing to their excellent performance in medical devices, industrial machinery, and scientific research instruments.

Optimizing density properties relies on precise material ratios and process control. The material optimized through hot isostatic pressing (HIP) possesses high density. Post-processing techniques such as grinding and surface polishing enhance the precision of the block, making it suitable for complex applications. Manufacturers adjust the tungsten content based on specific applications. Researchers explore its properties through density testing and performance analysis to guide technological improvements. In practical applications, density properties manifest themselves in compact designs and efficient protection. In the future, lightweighting technologies or new alloying elements may be used to

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further enhance the density properties and application scope of tungsten alloy blocks.

3.1.1.1 Density range

Density range is a key aspect of the density characteristics of tungsten alloy blocks, reflecting its diverse performance achieved through composition adjustment. The high density of tungsten makes the density of its alloy blocks significantly higher than that of traditional metal materials. A higher density range can be achieved by increasing the tungsten content, while the addition of metals such as nickel, copper or iron allows the density to be flexibly adjusted within a certain range. Preparation processes such as powder metallurgy lay the foundation for the density range by controlling the mixing ratio of tungsten and other metals. The hot isostatic pressing process optimizes the density of the material through omnidirectional pressure and ensures the uniformity of the density distribution. The diversity of the density range enables tungsten alloy blocks to meet a variety of needs from high-density radiation protection to medium-density lightweight design, and are widely used in medical, industrial and scientific research fields.

The process of determining the density range focuses on the synergistic effect of the composition ratio and process parameters. The material optimized by the hot isostatic pressing process reduces internal defects, and post-processing processes such as cutting and surface treatment refine the block to meet different density requirements. Manufacturers adjust the density range according to the application scenario, and researchers verify its performance through experiments and simulation analysis to guide technical improvements. In radiation protection, the high density range ensures efficient shielding, while in counterweights or portable devices, the medium density range provides a balanced solution. Future developments may further expand the density range of tungsten alloy blocks by introducing new alloying elements or optimizing the preparation process, so that it can play a role in more demanding scenarios.

3.1.1.2 Density measurement method

Density measurement is an important means of evaluating the density characteristics of tungsten alloy blocks, ensuring that material properties meet application standards. Traditional density measurement methods, such as the Archimedeian method, calculate the volume and mass difference by immersing in a liquid and are suitable for preliminary evaluation of the density of tungsten alloy blocks. Modern technologies such as X-ray tomography and optical microscopy analysis provide more accurate internal structural information. Preparation processes such as hot isostatic pressing optimize the uniformity of the material, providing a stable foundation for density measurement. Powder metallurgy processes ensure the reliability of measurement results by controlling powder particle size and mixing ratio. The choice of density measurement method directly affects production quality control and application effects, enabling tungsten alloy blocks to achieve the expected performance in medical devices, industrial components, and scientific research instruments.

The application of measurement methods requires consideration of specific process and environmental conditions. The low porosity of materials optimized by hot isostatic pressing reduces measurement errors,

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and post-processing processes such as surface polishing enhance measurement accuracy. Manufacturers regularly employ a variety of measurement methods during production, and researchers conduct experiments to verify the accuracy of these methods and guide technical improvements. The Archimedean method is suitable for rapid testing, while X-ray technology is suitable for analyzing complex structures. Combining these two methods ensures a comprehensive assessment. Future developments may further enhance the efficiency and accuracy of density measurement methods through intelligent measurement equipment or artificial intelligence analysis, bringing the quality control of tungsten alloy blocks to new heights.

3.1.1.3 Relationship between density and material properties

The relationship between density and material properties is key to understanding the functional foundation of tungsten alloy blocks, demonstrating the profound impact of density on radiation absorption, mechanical strength, and processing characteristics. Tungsten's high density, a core advantage of alloy blocks, directly determines its efficiency in radiation protection. Higher density means stronger absorption of X-rays and gamma rays, enabling it to excel in medical equipment and industrial testing. Preparation processes such as powder metallurgy lay the foundation for density by mixing a high proportion of tungsten powder with other metal powders. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reducing porosity and thus enhancing the density of the material. This density not only enhances the radiation shielding effect, but also improves mechanical properties such as hardness and compressive strength, making it suitable for structural support and counterweight applications. The relationship between density and performance is also reflected in the processing process. Higher density improves the material's resistance to deformation, but also increases the difficulty of processing.

Tungsten alloy blocks optimized by hot isostatic pressing (HIP) achieve uniformity, reducing performance fluctuations caused by density variations. Post-processing processes such as cutting and grinding refine the block geometry, and surface treatments such as corrosion-resistant coatings further enhance durability. Manufacturers adjust density to optimize performance based on application requirements. Researchers explore these correlations through density testing and mechanical analysis to guide technological improvements. In radiation protection, density is positively correlated with shielding efficiency; in mechanical applications, density is closely related to impact resistance.

3.1.1.4 Density differences of tungsten alloy blocks with different compositions

Tungsten alloy blocks with different compositions are an important manifestation of their diverse classification and application, reflecting the significant influence of the composition ratio on physical properties. Tungsten, as the main component, has a high-density characteristic that determines the basic density level of the alloy block, while the type and proportion of added metals such as nickel, copper, iron, molybdenum or niobium directly determine the specific range of density. Preparation processes such as powder metallurgy lay the foundation for density differences by controlling the mixing ratio of tungsten and other metal powders. The hot isostatic pressing process optimizes the microstructure

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through omnidirectional pressure, ensuring the density and uniformity of tungsten alloy blocks of various components. The density difference enables tungsten alloy blocks to meet a variety of needs from high-density radiation protection to medium-density lightweight design, and are widely used in medical, industrial and scientific research fields.

The formation of density differences is closely related to the role of composition. Tungsten-nickel-iron alloy blocks have a higher density due to their high tungsten content and the compactness of nickel-iron, making them suitable for efficient shielding. Tungsten-copper alloy blocks have a relatively low density due to the lower density of copper, making them suitable for thermal conductivity and lightweight applications. Tungsten-molybdenum alloy blocks provide a balance of medium and high density due to the density characteristics of molybdenum. The material optimized by the hot isostatic pressing process has reduced internal defects, and post-processing processes such as grinding and surface treatment have refined the blocks to meet different density requirements. Manufacturers adjust the composition ratio according to the application scenario, and researchers verify the differences through density testing and microanalysis to guide technical improvements. Density differences affect equipment design and performance in actual applications. In the future, it may be possible to further refine the density differences of tungsten alloy blocks with different compositions through new alloying elements or process optimization.

3.1.2 Melting point and heat resistance of tungsten alloy blocks

Tungsten alloy blocks are key attributes of their physical properties, which determine their stability and application range in high-temperature environments. The high melting point of tungsten, as the basis of the alloy block, gives it excellent high-temperature resistance. The addition of metals such as copper, nickel or molybdenum forms a composite structure with tungsten through powder metallurgy and hot isostatic pressing processes, further optimizing the heat resistance. Preparation processes such as powder metallurgy lay the foundation for melting point and heat resistance by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process enhances the microscopic stability of the material through omnidirectional pressure and reduces the risk of deformation at high temperatures. The melting point and heat resistance of tungsten alloy blocks enable them to perform well in high-temperature furnaces, aviation components and radiation protection equipment, demonstrating their reliability under extreme conditions.

Melting point and heat resistance performance depend on the synergistic effect of composition and processing. Materials optimized through hot isostatic pressing exhibit high density and low internal stress. Post-processing techniques such as surface polishing and high-temperature resistant coatings enhance the heat resistance of the blocks. Manufacturers adjust alloy ratios based on high-temperature application requirements. Researchers verify their properties through high-temperature testing and thermal expansion analysis, guiding technological improvements. In practical applications, the melting point and heat resistance ensure the material's stability in high-temperature environments. In the future, the heat resistance of tungsten alloy blocks may be further enhanced through the introduction of new heat-resistant alloying elements or surface modification techniques.

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3.1.2.1 Melting point range

The melting point range is the core factor in the melting point and heat resistance of tungsten alloy blocks, reflecting the significant influence of the composition ratio on high-temperature performance. The high melting point characteristics of tungsten provide a foundation for extremely high thermal stability for its alloy blocks, while the lower melting points of added metals such as copper, nickel or molybdenum form the melting point range of the composite material. Preparation processes such as powder metallurgy lay the foundation for the melting point range by controlling the mixing ratio of tungsten and other metal powders. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure to ensure the uniformity of the melting point distribution. The diversity of the melting point range enables tungsten alloy blocks to adapt to a variety of scenarios from high-temperature industry to medium-temperature applications, and are widely used in high-temperature furnaces, medical equipment and aviation components.

Determining the melting point range relies on precise compositional blending and process control. Optimized hot isostatic pressing reduces the risk of phase separation. Post-processing techniques such as cutting and surface treatment refine the block to accommodate varying melting point requirements. Manufacturers adjust the melting point range for high-temperature environments. Researchers verify performance through melting point testing and thermal stability analysis, guiding technological improvements. In high-temperature applications, the melting point range ensures material stability; in moderate-temperature environments, it provides flexible processing options.

3.1.2.2 High temperature stability performance

High-temperature stability is a key attribute of tungsten alloy blocks in terms of melting point and heat resistance, reflecting their reliability and durability in extreme thermal environments. The high melting point of tungsten provides an excellent foundation for thermal stability for the alloy blocks, while the addition of metals such as nickel, copper, or molybdenum forms a composite structure with tungsten through powder metallurgy and hot isostatic pressing processes, further enhancing the structural integrity at high temperatures. Preparation processes such as powder metallurgy lay the foundation for high-temperature stability by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reducing the risk of microcracks or deformation caused by high temperatures. The high-temperature stability of tungsten alloy blocks enables them to perform well in high-temperature furnaces, aviation components, and radiation protection equipment, especially in applications that require long-term exposure to high-temperature environments.

The superiority of high-temperature stability is also reflected in the material's performance in thermal cycles. The material optimized by the hot isostatic pressing process reduces the risk of thermal fatigue due to its high density and low internal stress. Post-processing processes such as surface polishing and high-temperature resistant coatings further enhance the thermal stability of the block, making it suitable for use in high-temperature oxidizing or corrosive environments. Manufacturers adjust the alloy ratio

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according to the needs of high-temperature applications. Researchers verify its performance through high-temperature testing, thermal expansion analysis, and microstructural observation to guide technological improvements. In practical applications, high-temperature stability ensures the structural integrity of the material at high temperatures. In the future, it may be possible to further enhance the high-temperature stability of tungsten alloy blocks by introducing new heat-resistant alloy elements or surface modification technologies, so that they can maintain excellent performance under more extreme conditions.

3.1.2.3 Effect of temperature on physical state

The effect of temperature on the physical state is an important aspect of the study of the melting point and heat resistance of tungsten alloy blocks, revealing the dynamic changes in their structure and properties due to thermal effects. Tungsten's high melting point allows it to remain solid at room temperature. As the temperature rises, the addition of metals with lower melting points, such as copper or nickel, may cause local softening or phase change, affecting the physical state of the alloy block. Preparation processes such as powder metallurgy lay the foundation for the material's basic structure by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes microscopic uniformity through omnidirectional pressure and reduces defects caused by temperature changes. The effect of temperature on the physical state involves not only melting behavior, but also thermal expansion and phase separation risks, which make the performance of tungsten alloy blocks vary at different temperatures.

The specific impact of temperature changes on physical properties depends on composition and process control. Materials optimized through hot isostatic pressing (HIP) have low porosity, reducing deformation at high temperatures. Post-processing processes such as cutting and surface treatment refine the block to accommodate temperature fluctuations. Manufacturers adjust alloy ratios based on the operating temperature range. Researchers verify these effects through thermal simulation experiments, microscopic analysis, and thermal expansion testing to guide technological improvements. At high temperatures, tungsten alloy blocks may undergo microstructural adjustments, but they maintain solid-state stability within their melting point range.

3.1.2.4 Application of heat resistance

The application of heat resistance is the result of applying the melting point and heat resistance of tungsten alloy blocks to practical scenarios, demonstrating their unique value in high-temperature environments. The high melting point of tungsten and the synergistic effect of the added metals enable tungsten alloy blocks to operate stably and long-term in high-temperature furnaces, aviation components, and radiation protection equipment. Preparation processes such as powder metallurgy, which combines tungsten powder with other metal powders, followed by pressing and sintering, lay the foundation for heat resistance. Hot isostatic pressing (HIP) optimizes the microstructure through omnidirectional pressure, enhancing the material's resistance to deformation at high temperatures. Heat resistance is also demonstrated in high-temperature sterilization processes in medical devices and in heat-loaded

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environments in industrial equipment. Due to its superior performance, tungsten alloy blocks are gradually replacing traditional materials and becoming the preferred choice in high-temperature applications. The practical application of heat resistance depends on the matching of process and environmental conditions. Optimized HIP materials achieve high density and low thermal stress. Post-processing processes such as surface polishing and high-temperature coatings enhance the heat resistance of the blocks. Manufacturers adjust production parameters based on high-temperature scenarios. Researchers verify their heat resistance through high-temperature testing and application simulations, guiding technological improvements. In high-temperature furnaces, heat resistance ensures that the material does not deform; in aviation components, it provides long-term stable support.

3.1.3 Mechanical properties of tungsten alloy blocks

Tungsten alloy blocks are an important component of their physical properties, determining their reliability and durability in mechanical applications. Tungsten's high hardness and density provide excellent resistance to compression and deformation, while the addition of metals such as nickel, copper, or iron enhances the material's toughness and ductility through powder metallurgy and hot isostatic pressing processes. Preparation processes such as powder metallurgy lay the foundation for mechanical properties by mixing tungsten powder with other metal powders, pressing, and sintering. Hot isostatic pressing optimizes the microstructure through omnidirectional pressure, reduces internal defects, and ensures the material's mechanical stability. The mechanical properties of tungsten alloy blocks enable them to excel in structural support, counterweights, and precision manufacturing, and are widely used in industrial equipment, aviation equipment, and scientific research instruments.

The optimization of mechanical properties relies on the synergistic effect of composition and process. The material optimized by hot isostatic pressing (HIP) has enhanced impact and fatigue resistance due to its high density. Post-processing processes such as cutting and surface treatment refine the geometry of the block, and surface coatings such as wear-resistant layers extend its service life. Manufacturers adjust the alloy ratio according to mechanical requirements, and researchers verify its performance through mechanical testing, fracture analysis, and fatigue experiments to guide technological improvements. Mechanical properties ensure the stability of the material under high loads in practical applications. In the future, the mechanical properties of tungsten alloy blocks may be further improved through the introduction of composite materials or intelligent design, giving them greater advantages in complex mechanical environments.

3.1.3.1 Hardness index

The hardness index is the core attribute of the mechanical properties of tungsten alloy blocks, reflecting its performance in mechanical processing and wear-resistant environments. The high hardness characteristics of tungsten, as the basis of alloy blocks, are derived from its high density and the stability of its crystal structure. The addition of metals such as nickel, copper or iron through powder metallurgy and hot isostatic pressing processes forms a composite structure with tungsten, further optimizing the hardness performance. Preparation processes such as powder metallurgy lay the foundation for hardness

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index by mixing a high proportion of tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces internal defects, and ensures the uniformity and consistency of hardness. The level of hardness index directly affects the application effect of tungsten alloy blocks in cutting tools, wear-resistant parts and radiation protection equipment, making them perform well in industrial manufacturing and medical fields.

The superiority of the hardness index is also reflected in its support for processing and durability. The material optimized by the hot isostatic pressing process has low porosity, which reduces the risk of uneven hardness. Post-processing processes such as grinding and surface polishing improve the surface quality of the block, making it suitable for precision processing needs. Surface treatments such as corrosion-resistant or wear-resistant coatings further enhance the practical application effect of the hardness index and extend its service life. Manufacturers adjust the tungsten content and processing technology according to the application scenario. Researchers verify its performance through hardness testing, microscopic analysis and wear resistance experiments to guide technological improvements. In cutting tools, the hardness index ensures the wear resistance of the material; in radiation protection, it supports the processing of complex structures.

3.1.3.2 Strength performance

Strength performance is a key factor in the mechanical properties of tungsten alloy blocks, determining their load-bearing capacity under high loads and complex environments. Tungsten's high density and crystal structure provide excellent compressive and tensile strength, while the addition of metals such as nickel, copper, or molybdenum through powder metallurgy and hot isostatic pressing processes enhances the overall strength and stability of the material. Preparation processes such as powder metallurgy lay the foundation for strength performance by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces internal stress, and ensures the mechanical reliability of the material. The high and low strength performance makes tungsten alloy blocks perform well in structural supports, counterweights, and aviation components, and are widely used in industrial equipment, scientific research instruments, and machinery manufacturing.

The optimization of strength performance depends on the synergy of composition and process. The material optimized by hot isostatic pressing has enhanced impact resistance and fatigue resistance due to its high density. Post-processing processes such as cutting and surface treatment refine the geometry of the block, and surface coatings such as high-temperature resistant layers extend the strength performance in extreme environments. Manufacturers adjust the alloy ratio according to mechanical requirements, and researchers verify its performance through tensile testing, compression testing and fatigue analysis to guide technological improvements. In structural support, strength performance ensures the stability of the material under high loads; in aviation components, it supports long-term use requirements. Future developments may further enhance the strength performance of tungsten alloy blocks by introducing composite material design or intelligent processing technology, giving it greater advantages in complex mechanical environments.

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3.1.3.3 Toughness characteristics

Toughness is an important attribute in the mechanical properties of tungsten alloy blocks, reflecting its ability to resist cracking when subjected to impact and deformation. The high hardness of tungsten makes it naturally brittle, while the addition of metals such as nickel, copper or niobium through powder metallurgy and hot isostatic pressing processes significantly improves the ductility and toughness of the alloy, making it less likely to crack in complex processing and use environments. Preparation processes such as powder metallurgy lay the foundation for toughness characteristics by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces internal defects, and ensures the toughness stability of the material. The high and low toughness characteristics enable tungsten alloy blocks to perform well in impact loads, vibration environments and special-shaped structure manufacturing, and are widely used in medical equipment, industrial components and scientific research instruments.

The optimization process of toughness characteristics focuses on the balance between composition and process. The material optimized by hot isostatic pressing process has low internal stress, which reduces the risk of micro cracks caused by impact. Post-processing processes such as grinding and surface treatment refine the shape of the block, and surface coatings such as anti-corrosion layers enhance the toughness performance in harsh environments. Manufacturers adjust the proportion of tough metals according to application requirements. Researchers verify its characteristics through impact testing, fracture analysis and fatigue experiments to guide technical improvements. In medical radiation protection, toughness characteristics support the processing of complex structures; in industrial counterweights, it ensures vibration resistance. Future developments may further enhance the toughness characteristics of tungsten alloy blocks by introducing new ductile alloy elements or surface modification technologies, so that they can maintain excellent performance in highly dynamic environments.

3.1.3.4 Elastic modulus

The elastic modulus is a key parameter in the mechanical properties of tungsten alloy blocks, measuring their ability to recover from deformation and rigidity when subjected to stress. Tungsten's high density and crystal structure give the alloy blocks a high elastic modulus, while the addition of metals such as iron, molybdenum, or niobium through powder metallurgy and hot isostatic pressing adjusts the material's rigidity and elasticity balance, enabling it to excel in meeting high-precision and stability requirements. Preparation processes such as powder metallurgy lay the foundation for the elastic modulus by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces internal defects, and ensures the elastic consistency of the material. The high and low elastic modulus enable tungsten alloy blocks to perform well in precision manufacturing, structural support, and aviation components, and are widely used in industrial equipment and scientific research.

The optimization of the elastic modulus depends on the precise control of the composition and process. The material optimized by the hot isostatic pressing process has enhanced deformation resistance due to

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its high density. Post-processing processes such as cutting and surface treatment refine the geometric accuracy of the block. Surface coatings such as wear-resistant layers prolong the elastic modulus during long-term use. Manufacturers adjust the alloy ratio according to the rigidity requirements. Researchers verify its performance through tensile testing, bending experiments and microanalysis to guide technological improvements. In precision manufacturing, the elastic modulus ensures the dimensional stability of the material; in aviation components, it supports high rigidity requirements. Future developments may further improve the elastic modulus of tungsten alloy blocks by introducing composite material design or intelligent processing technology, enabling greater breakthroughs in high-precision and dynamic environments.

3.1.3.5 Plasticity

Plasticity is an important characteristic among the mechanical properties of tungsten alloy blocks, reflecting its ability to deform without breaking during processing and use. The high hardness and density of tungsten make it naturally brittle, but by adding metals such as nickel, copper or niobium, the plasticity of tungsten alloy blocks has been significantly improved. Preparation processes such as powder metallurgy lay the foundation for plasticity by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces internal defects and stress concentration points, and enhances the ductility of the material. The level of plasticity directly affects the plasticity of tungsten alloy blocks in complex processing processes such as cold forming, forging or stretching, as well as their ability to resist deformation in practical applications, making them perform well in medical equipment, industrial components and aviation fields.

The optimization of plastic performance relies on the synergistic effect of composition and process. The ductility of added metals such as nickel significantly improves the plasticity of tungsten alloy blocks. The material optimized by the hot isostatic pressing process has low porosity and uniformity, which reduces the risk of cracking during processing. Post-processing processes such as cold working and surface polishing further refine the shape of the block. Surface coatings such as anti-corrosion layers enhance the stability of plasticity in harsh environments. Manufacturers adjust the proportion of plastic metal according to processing requirements. Researchers verify its performance through tensile testing, plastic deformation analysis and microscopic observation to guide technological improvements. In the manufacture of special-shaped structures, plastic performance supports the realization of complex geometries; in impact load scenarios, it provides fracture resistance.

3.1.4 Thermal properties of tungsten alloy blocks

Tungsten alloy ingots are a key component of their physical properties, determining their potential for applications in high-temperature environments and thermal management. Tungsten's high melting point and thermal conductivity provide the alloy with excellent thermal stability. Additions of metals such as copper, nickel, or molybdenum optimize thermal conductivity and thermal expansion characteristics through powder metallurgy and hot isostatic pressing (HIP). Preparation processes such as Powder

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Metallurgy, which involves mixing tungsten powder with other metal powders, followed by pressing and sintering, lay the foundation for these thermal properties. HIP, through omnidirectional pressure, optimizes the microstructure, reduces heat transfer resistance points, and ensures thermal stability. The thermal properties of tungsten alloy ingots excel in high-temperature furnaces, electronic components, and radiation protection equipment, resulting in widespread applications in industrial manufacturing, medical devices, and aviation. Thermal performance evaluation focuses on the material's performance under thermal cycling and temperature gradients. The HIP-optimized material, with its high density and uniformity, enhances thermal conductivity. Post-processing processes such as surface treatment and coatings improve the durability of these thermal properties. Manufacturers adjust alloy ratios based on thermal management requirements, and researchers verify their properties through thermal conductivity testing, thermal expansion analysis, and high-temperature simulations, guiding technological improvements. In practical applications, thermal performance ensures the material's stability and heat dissipation capabilities at high temperatures. Future improvements in the thermal performance of tungsten alloy blocks may be possible through the introduction of new thermally conductive materials or surface modification technologies, giving them greater advantages in extreme thermal environments and efficient heat dissipation scenarios.

3.1.4.1 Thermal conductivity

Thermal conductivity is the core property of tungsten alloy blocks in thermal performance, reflecting its efficiency in heat transfer and heat dissipation. Tungsten itself has a certain thermal conductivity, and the addition of metals such as copper or silver significantly improves the thermal conductivity of the alloy, making it outstanding in environments that require efficient heat dissipation. Preparation processes such as powder metallurgy lay the foundation for thermal conductivity by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces the interfacial impedance in heat conduction, and ensures the uniformity of the thermal conductivity of the material. The level of thermal conductivity directly affects the application effect of tungsten alloy blocks in electronic components, discharge machining electrodes and high-temperature equipment, making it widely used in industrial manufacturing and medical fields.

Optimizing thermal conductivity relies on precise control of composition and processing. Copper's high thermal conductivity is particularly pronounced in tungsten-copper alloys. The material optimized through hot isostatic pressing (HIP) has low porosity, reducing thermal resistance. Post-processing techniques such as surface polishing and thermally conductive coatings enhance the actual thermal conductivity. Manufacturers adjust the copper content based on heat dissipation requirements. Researchers verify performance through thermal conductivity testing, heat flow analysis, and microstructural observations, guiding technological improvements. In electronic components, thermal conductivity ensures efficient heat dissipation; in high-temperature equipment, it supports stable thermal management. Future developments may further enhance the thermal conductivity of tungsten alloy blocks by introducing nano-thermal conductive materials or optimizing phase interface technologies, enabling greater breakthroughs in high-power electronics and thermal management.

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3.1.4.2 Thermal expansion coefficient

The coefficient of thermal expansion is an important parameter in the thermal properties of tungsten alloy blocks, measuring the degree of volume change under temperature changes. Tungsten's low thermal expansion characteristics provide a good foundation for the thermal stability of the alloy blocks, while the thermal expansion coefficients of added metals such as nickel or copper are higher, forming a balanced characteristic of the composite material. Preparation processes such as powder metallurgy lay the foundation for the thermal expansion coefficient by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces stress concentration caused by temperature changes, and ensures the thermal stability of the material. The level of thermal expansion coefficient directly affects the application effect of tungsten alloy blocks in precision manufacturing, aviation components and radiation protection equipment, enabling them to perform well in complex thermal cycle environments.

Optimizing the coefficient of thermal expansion (CTE) focuses on the synergistic effect of composition and processing. The uniformity of the material optimized by hot isostatic pressing (HIP) reduces the risk of uneven thermal expansion. Post-processing techniques such as surface treatment and thermal stress-resistant coatings enhance the thermal stability of the block. Manufacturers adjust alloy ratios based on temperature ranges, and researchers verify their performance through thermal expansion testing, thermal simulation analysis, and microscopic observations, guiding technological improvements. In precision manufacturing, the CTE ensures dimensional stability; in aviation components, it supports structural integrity at high temperatures.

3.1.4.3 Application of thermal properties

The application of thermal properties is a direct reflection of the role played by tungsten alloy blocks in actual scenarios, demonstrating its unique value in thermal management, high-temperature stability, and heat dissipation needs. The high melting point and thermal conductivity of tungsten provide a solid thermal foundation for the alloy block, while the addition of metals such as copper, nickel, or silver optimizes the thermal conductivity and thermal expansion characteristics through powder metallurgy and hot isostatic pressing processes, enabling it to perform well in a variety of high-temperature environments. Preparation processes such as powder metallurgy lay the foundation for thermal properties by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces the blockage points in heat conduction, and ensures the thermal stability of the material. The application of thermal properties is widely seen in high-temperature furnaces, electronic components, and medical equipment, especially in scenarios that require efficient heat dissipation or high-temperature resistance.

In specific applications, the manifestation of thermal performance depends on the matching of materials and environments. The high density and uniformity of materials optimized by the hot isostatic pressing process enhance thermal conductivity and resistance to thermal stress. Post-processing processes such as surface polishing and thermal conductive coatings improve the durability of thermal performance. In

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high-temperature furnaces, the heat resistance and thermal stability of tungsten alloy blocks ensure the structural integrity of the equipment during long-term high-temperature operation. In electronic components, the high thermal conductivity supports efficient heat dissipation and prevents overheating damage. In medical equipment such as radiotherapy machines, the low thermal expansion coefficient ensures the dimensional stability of precision components during thermal cycles.

3.1.5 Electrical properties of tungsten alloy blocks

Tungsten alloy blocks are an important component of their physical properties and determine their potential for application in electrical contact, electrical conduction, and electrical discharge machining. Tungsten's high melting point and certain electrical conductivity provide the basis for the alloy blocks' electrical properties, while the addition of metals such as copper, silver, or nickel significantly improves the conductivity and resistivity properties through powder metallurgy and hot isostatic pressing processes. Preparation processes such as powder metallurgy lay the foundation for electrical properties by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces the interfacial impedance in electrical conduction, and ensures the electrical stability of the material. The electrical properties of tungsten alloy blocks enable them to perform well in electronic components, electrical discharge machining electrodes, and electrical contact parts, and are widely used in industrial manufacturing, high-tech equipment, and scientific research.

The evaluation of electrical properties focuses on the material's performance in current transfer and thermoelectric environments. The material optimized by the hot isostatic pressing process has enhanced electrical conductivity due to its high density and uniformity. Post-processing processes such as surface treatment and electroplating improve the durability of electrical properties. Manufacturers adjust the alloy ratio based on electrical contact or conductivity requirements. Researchers verify its characteristics through resistivity testing, conductivity analysis, and electrical corrosion experiments to guide technological improvements. In practical applications, electrical performance ensures the reliability of the material under high current or discharge conditions. In the future, it may be possible to further optimize the electrical properties of tungsten alloy blocks by introducing new conductive alloy elements or surface modification technologies, giving them greater advantages in electronic technology and precision manufacturing.

3.1.5.1 Resistivity

Resistivity is a key parameter in the electrical properties of tungsten alloy blocks, which measures its resistance characteristics when current passes through. Tungsten itself has a high resistivity, and the addition of metals such as copper or silver significantly reduces the resistivity of the alloy, making it outstanding in scenarios that require efficient electrical conductivity. Preparation processes such as powder metallurgy lay the foundation for resistivity by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces the grain boundary impedance in electrical conduction, and ensures

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the resistivity stability of the material. The level of resistivity directly affects the application effect of tungsten alloy blocks in electronic components, discharge machining electrodes and electrical contact parts, making it widely used in industrial manufacturing and high-tech equipment.

The optimization of resistivity relies on precise control of composition and process. The high conductivity of copper is particularly significant in tungsten-copper alloys. The material optimized by the hot isostatic pressing process has low porosity, which reduces resistivity fluctuations. Post-processing processes such as surface polishing and electroplating improve the actual performance of resistivity. Manufacturers adjust the copper content according to conductivity requirements. Researchers verify its performance through resistivity testing, current density analysis and microstructure observation to guide technological improvements. In discharge machining electrodes, low resistivity ensures efficient energy transfer; in electronic components, it supports stable current flow. Future developments may further reduce the resistivity of tungsten alloy blocks by introducing nano-conductive materials or optimizing phase interface technology, enabling greater breakthroughs in high-power electronics and precision manufacturing.

3.1.5.2 Conductivity

Electrical conductivity is an important attribute in the electrical performance of tungsten alloy blocks, reflecting its efficiency and ability in current transmission. Tungsten itself has a low electrical conductivity, but the addition of metals such as silver or copper significantly improves the electrical conductivity of the alloy, making it outstanding in environments that require efficient electrical contact or heat dissipation. Preparation processes such as powder metallurgy lay the foundation for electrical conductivity by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces the interfacial impedance in electrical conduction, and ensures the uniformity of the material's electrical conductivity. The level of electrical conductivity directly affects the application effect of tungsten alloy blocks in electronic components, discharge machining electrodes, and electrical contact parts, making it widely used in industrial manufacturing and medical equipment.

Optimizing electrical conductivity focuses on the synergistic effect of composition and process. Silver's high conductivity is particularly pronounced in tungsten-silver alloys. The high density of the material after optimization by hot isostatic pressing enhances electrical conductivity. Post-processing processes such as surface treatment and electroplating improve the durability of electrical conductivity. Manufacturers adjust the silver content based on electrical contact or heat dissipation requirements. Researchers verify performance through conductivity testing, current distribution analysis, and electrocorrosion experiments to guide technological improvements.

3.1.5.3 Test methods for electrical properties

The test method of electrical properties is an important means to evaluate the electrical characteristics of tungsten alloy blocks, ensuring their reliability and consistency in practical applications. The electrical

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properties of tungsten alloy blocks, such as resistivity and conductivity, need to be quantified through scientific methods. Commonly used test methods include the four-probe method and the Van der Pauw method. The former measures resistivity by placing four probes on the surface of the material, which is suitable for accurately evaluating conductive properties; the latter uses contact resistance analysis and is suitable for electrical testing of complex structures. Preparation processes such as powder metallurgy lay the foundation for electrical properties by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces defects in electrical conduction, and provides a stable material basis for testing. The accuracy of the test method directly affects production quality control and application effects, enabling tungsten alloy blocks to achieve the expected performance in electronic components, discharge machining electrodes, and electrical contact parts.

The implementation of the test method needs to be combined with material properties and environmental conditions. The material optimized by the hot isostatic pressing process has high density and uniformity, which reduces the test error. Post-processing processes such as surface polishing and electroplating improve the contact quality of the test points. Manufacturers regularly use a variety of test methods in the production process, such as using the four-probe method to detect resistivity changes and combining the Van der Pauw method to evaluate electrical contact performance. Researchers verify the accuracy of the method through experiments to guide technical improvements. Other auxiliary methods such as AC impedance spectroscopy and thermocouple measurements are also commonly used for dynamic electrical performance evaluation to ensure stability under high temperature or high current conditions. In electronics manufacturing, the test method ensures efficient conduction; in discharge machining, it supports the verification of arc stability.

3.1.5.4 Factors affecting electrical performance

The factors affecting electrical properties are the key to understanding the conductive properties and application range of tungsten alloy blocks, which involve the combined effects of composition, process and use environment. The high resistivity of tungsten provides the basic electrical properties for the alloy blocks, while the addition of metals such as copper or silver significantly reduces the resistivity and improves the conductivity. The adjustment of the composition ratio is the core factor affecting the electrical properties. Preparation processes such as powder metallurgy lay the foundation for electrical properties by controlling the mixing uniformity of tungsten and other metal powders. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces the grain boundary impedance in electrical conduction, and ensures performance stability. The use environment such as temperature, humidity or mechanical stress also affects the electrical properties, making tungsten alloy blocks exhibit diverse characteristics in electronic components, discharge machining electrodes and electrical contact parts.

The specific role of influencing factors depends on the coordinated optimization of materials and processes. The material optimized by the hot isostatic pressing process has low porosity, which reduces the fluctuation of electrical properties. Post-processing processes such as surface treatment and

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electroplating improve the quality of electrical contact. Surface oxidation or contamination may increase resistivity. Manufacturers adjust the composition and process parameters according to application requirements. Researchers verify the influencing factors through resistivity testing, conductivity analysis and environmental simulation experiments to guide technological improvements. Increased temperature may reduce conductivity, increased humidity may cause changes in surface resistance, and mechanical stress affects the stability of the internal structure. In high-power electronics, the composition ratio ensures efficient conduction; in harsh environments, process optimization reduces performance degradation. Future development may further optimize the factors affecting electrical properties by introducing new conductive materials or intelligent process control, so that tungsten alloy blocks can perform better under complex conditions.

3.1.6 Magnetic properties of tungsten alloy blocks

Tungsten alloy blocks are unique attributes of their physical properties, determining their potential for application in electromagnetic environments. Tungsten itself possesses weak or non-magnetic properties, but the magnetic properties of added metals such as iron, nickel, or molybdenum influence the alloy's overall magnetic performance through powder metallurgy and hot isostatic pressing (HIP). Preparation processes such as powder metallurgy lay the foundation for magnetic properties by mixing tungsten powder with other metal powders, pressing, and sintering. HIP optimizes the microstructure through omnidirectional pressure, reducing non-uniformities in magnetic permeability and ensuring the material's magnetic stability. The magnetic properties of tungsten alloy blocks excel in electromagnetic shielding, sensor components, and industrial equipment, and are widely used in electronics manufacturing, scientific instrumentation, and machinery.

The evaluation of magnetic properties focuses on the material's response in a magnetic field. Materials optimized through hot isostatic pressing (HIP) exhibit enhanced magnetic consistency due to their high density and uniformity. Post-processing processes such as surface treatment and coating improve the durability of magnetic properties. Manufacturers adjust the proportion of magnetic metals based on electromagnetic requirements. Researchers verify their properties through magnetic permeability testing, hysteresis loop analysis, and microstructural observations, guiding technological improvements. In practical applications, magnetic properties ensure the material's compatibility in electromagnetic environments. In the future, the introduction of new magnetic alloying elements or surface modification techniques may further optimize the magnetic properties of tungsten alloy blocks, giving them greater advantages in high-tech electromagnetic equipment.

3.1.6.1 Magnetic characteristics

Magnetic characteristics are the core elements of the magnetic properties of tungsten alloy blocks, reflecting their response characteristics and application potential in magnetic fields. Tungsten itself has weak magnetic or nearly non-magnetic properties, and the addition of metals such as iron or nickel significantly enhances the magnetism of the alloy, forming a variety of characteristics ranging from weak magnetism to medium magnetism. Preparation processes such as powder metallurgy lay the foundation

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for magnetic characteristics by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces the grain boundary resistance in the magnetic permeability, and ensures the consistency of magnetism. The level of magnetic characteristics directly affects the application effect of tungsten alloy blocks in electromagnetic shielding, sensor components and industrial equipment, making it widely used in the fields of electronic manufacturing and scientific research. Optimizing magnetic properties relies on precise control of composition and processing. Iron's high magnetic permeability is particularly pronounced in tungsten-iron alloys. The low porosity of materials optimized through hot isostatic pressing reduces magnetic fluctuations. Post-processing techniques such as surface polishing and magnetic coating enhance the actual performance of magnetic properties. Manufacturers adjust iron content based on electromagnetic requirements. Researchers verify performance through magnetic permeability testing, magnetization curve analysis, and microstructural observations, guiding technological improvements. In electromagnetic shielding, magnetic properties support efficient magnetic field isolation; in sensor components, they ensure sensitivity stability.

3.1.6.2 Magnetic permeability

Magnetic permeability is a key parameter in the magnetic properties of tungsten alloy blocks, which measures its ability to transfer magnetic flux in a magnetic field. Tungsten itself has weak magnetic or non-magnetic properties, and the addition of metals such as iron, nickel or molybdenum significantly improves the magnetic permeability of the alloy, making it perform outstandingly in scenarios requiring magnetic field regulation. Preparation processes such as powder metallurgy lay the foundation for magnetic permeability by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces the grain boundary impedance in the magnetic permeability, and ensures the magnetic consistency of the material. The level of magnetic permeability directly affects the application effect of tungsten alloy blocks in electromagnetic shielding, sensor components and industrial equipment, making it widely used in electronic manufacturing, scientific research instruments and machinery. Optimizing magnetic permeability relies on precise control of composition and processing. Iron's high magnetic permeability is particularly pronounced in tungsten-iron alloys. Materials optimized through hot isostatic pressing (HIP) exhibit low porosity, reducing permeability nonuniformity. Post-processing techniques such as surface polishing and magnetic coating enhance the actual permeability performance. Manufacturers adjust the proportion of magnetic metals based on electromagnetic requirements. Researchers verify performance through permeability testing, magnetization curve analysis, and microstructural observations, guiding technological improvements. In electromagnetic shielding, high permeability supports efficient magnetic field isolation; in sensor components, it ensures sensitivity stability. Magnetic permeability is also affected by temperature and stress, requiring dynamic adjustment in practical applications.

3.1.6.3 Measurement of magnetic properties

Measuring magnetic properties is an important means of evaluating the magnetic characteristics of

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tungsten alloy blocks, ensuring their reliability and consistency in electromagnetic environments. Common measurement methods include the oscillating sample magnetometer method and the BH analyzer method. The former accurately assesses magnetization intensity by detecting changes in the sample's magnetic moment in an alternating magnetic field; the latter analyzes magnetic permeability and hysteresis properties by measuring the relationship between magnetic induction intensity and magnetic field strength. Preparation processes such as powder metallurgy lay the foundation for magnetic properties by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reducing defects in magnetic properties and providing a stable material foundation for measurement. The accuracy of the measurement method directly affects production quality control and application results, enabling tungsten alloy blocks to achieve the expected performance in electromagnetic shielding and sensor components.

The implementation of the measurement method needs to be combined with the material properties and test conditions. The material optimized by the hot isostatic pressing process has high density and uniformity, which reduces the measurement error. Post-processing processes such as surface polishing and magnetic coating improve the magnetic response quality of the test point. Manufacturers regularly use a variety of measurement methods during the production process, such as using the oscillating sample magnetometer method to detect the magnetization intensity, combined with the BH analyzer method to evaluate the change in magnetic permeability. Researchers verify the accuracy of the method through experiments to guide technical improvements. Other auxiliary methods such as magnetoresistance measurement and ferromagnetic resonance analysis are also commonly used for dynamic magnetic performance evaluation to ensure stability under high temperature or high stress conditions. In electromagnetic shielding, the measurement method ensures efficient magnetic field isolation; in sensor development, it supports sensitivity verification.

3.1.6.4 Effect of chemical composition on magnetic properties

The influence of chemical composition on magnetic properties is the core of understanding the magnetic properties of tungsten alloy blocks, involving the specific contribution of each element in the magnetic field response. Tungsten itself has weak magnetic or non-magnetic properties, and its magnetic properties are mainly determined by the addition of metals such as iron, nickel, or molybdenum. The high magnetic permeability of iron and the moderate magnetism of nickel significantly enhance the magnetization ability of the alloy, while the addition of molybdenum may reduce magnetism but improve high-temperature stability. Preparation processes such as powder metallurgy lay the foundation for magnetic properties by controlling the mixing ratio of tungsten and other metal powders. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure to ensure the uniformity of chemical composition distribution. The influence of chemical composition enables tungsten alloy blocks to exhibit diverse magnetic properties in electromagnetic shielding, sensor components, and industrial equipment.

The specific effect of chemical composition depends on the ratio of ingredients and process optimization.

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Materials optimized through hot isostatic pressing (HIP) have low porosity, which reduces fluctuations in magnetic properties. Post-processing processes such as surface treatment and magnetic coating enhance the actual performance of the chemical composition effect. Increasing the iron content significantly increases magnetic permeability, while nickel balances magnetism and toughness. The addition of molybdenum maintains magnetic stability in high-temperature environments. Manufacturers adjust chemical composition based on electromagnetic requirements, and researchers verify its impact through permeability testing, magnetization analysis, and microstructural observations to guide technological improvements. In electromagnetic shielding, chemical composition ensures efficient magnetic field isolation; in sensors, it supports sensitivity adjustment.

3.1.6.5 Application Scenarios of Magnetic Properties

The application scenarios of magnetic properties are a direct reflection of the role played by tungsten alloy blocks in actual environments, demonstrating their unique value in electromagnetic control and protection. The magnetic properties of tungsten alloy blocks are mainly determined by the addition of metals such as iron or nickel. Combined with the high density of tungsten, it performs well in scenarios requiring magnetic field isolation or magnetic sensitive response. Preparation processes such as powder metallurgy lay the foundation for magnetic properties by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure and enhances the stability of the material in the magnetic field. The application scenarios of magnetic properties are widely seen in electromagnetic shielding, sensor components and industrial equipment, especially in the fields of electronic manufacturing, scientific research instruments and machinery.

In specific applications, the manifestation of magnetic performance depends on the matching of materials and scenarios. The materials optimized by the hot isostatic pressing process have enhanced magnetic permeability and magnetization consistency due to their high density and uniformity. Post-processing processes such as surface polishing and magnetic coating improve the durability of magnetic properties. In electromagnetic shielding, the high magnetic permeability of tungsten alloy blocks supports electronic equipment from external magnetic field interference; in sensor components, magnetic characteristics ensure sensitivity and response speed; and in industrial equipment such as motor components, it provides stable magnetic field regulation. Manufacturers adjust the proportion of magnetic metals according to application requirements. Researchers verify their performance through magnetic field simulation experiments, magnetic permeability testing, and application analysis to guide technical improvements.

3.2 Chemical properties of tungsten alloy blocks

Tungsten alloy blocks are the key foundation for their stability in various environmental conditions and determine their durability and reliability in long-term use. Tungsten's high chemical stability provides a solid foundation for its alloy blocks, while the addition of metals such as nickel, copper, or iron through powder metallurgy and hot isostatic pressing (HIP) forms a composite structure with tungsten, further optimizing its corrosion resistance and chemical reaction properties. Preparation processes such as

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powder metallurgy lay the foundation for chemical properties by mixing tungsten powder with other metal powders, pressing, and sintering. The HIP process optimizes the microstructure through omnidirectional pressure, reduces weak points in chemical reactions, and ensures material uniformity. The chemical properties of tungsten alloy blocks enable them to perform well in acidic, alkaline, or humid environments, and are widely used in medical devices, industrial components, and scientific research instruments.

Chemical performance evaluation focuses on the material's performance in different chemical environments. Materials optimized through hot isostatic pressing (HIP) exhibit enhanced corrosion resistance due to their high density and low porosity. Post-processing processes such as surface treatment and corrosion-resistant coatings further enhance chemical stability. Manufacturers adjust alloy ratios based on the application environment, and researchers verify their properties through chemical corrosion testing, surface analysis, and environmental simulations, guiding technological improvements. Chemical performance ensures the material's durability under complex conditions in practical applications. In the future, the chemical properties of tungsten alloy blocks may be further optimized through the introduction of new corrosion-resistant alloying elements or surface modification technologies, giving them greater advantages in more demanding environments.

3.2.1 Chemical stability of tungsten alloy blocks

Tungsten alloy blocks is a core attribute of their chemical properties, reflecting their ability to resist corrosion and degradation in various chemical environments. The high chemical inertness of tungsten provides an excellent corrosion-resistant foundation for its alloy blocks , while the addition of metals such as copper, nickel, or niobium through powder metallurgy and hot isostatic pressing processes optimizes the overall stability of the alloy, enabling it to perform well in acidic, alkaline, or humid conditions. Preparation processes such as powder metallurgy lay the foundation for chemical stability by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces penetration points in chemical reactions, and ensures the durability of the material. The chemical stability of tungsten alloy blocks has led to their widespread use in medical devices, industrial testing, and scientific research instruments, especially in situations where long-term exposure to chemical environments is required. Optimizing chemical stability relies on the synergistic effect of composition and processing. The high density of materials optimized through hot isostatic pressing reduces the penetration of corrosive media. Post-processing techniques such as surface polishing and anti-corrosion coatings enhance the chemical stability of the blocks . Manufacturers adjust alloy ratios based on the operating environment, and researchers verify performance through corrosion testing, chemical reaction analysis, and microstructural observations, guiding technological improvements. Chemical stability ensures material stability in acidic or alkaline environments and supports long-term durability in humid conditions.

3.2.1.1 Reactivity with common acids

Reactivity with common acids is an important aspect of the chemical stability of tungsten alloy blocks,

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reflecting their corrosion resistance in acidic environments. Tungsten itself is highly chemically inert to most acids, especially at room temperature, where it is difficult to be corroded by dilute acids. However, the addition of metals such as copper or nickel may cause local reactions under specific acidic conditions, affecting the overall stability of the alloy. Preparation processes such as powder metallurgy lay the foundation for reactivity by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reducing weak points for acidic media penetration and ensuring the material's acid resistance. The reactivity of tungsten alloy blocks with common acids enables them to perform well in industrial equipment, medical devices, and scientific research instruments, especially in acidic processing or storage environments.

The specific manifestation of reactivity depends on the type and concentration of the acid. The material optimized by the hot isostatic pressing process has low porosity, which reduces the penetration of acid corrosion. Post-processing processes such as surface polishing and acid-resistant coating improve the acid resistance of the block. Manufacturers adjust the alloy ratio according to the acidic environment. Researchers verify its performance through acid immersion tests, surface analysis and corrosion rate measurements to guide technical improvements. Dilute sulfuric acid and hydrochloric acid have low reactivity to tungsten alloy blocks, while concentrated nitric acid may have a certain impact on the added metal and needs to be protected by surface treatment. In industrial processing, acid resistance ensures the stability of equipment components; in the medical field, it supports compatibility with acidic disinfection environments.

3.2.1.2 Reactivity with common bases

Reactivity with common alkalis is another key aspect of the chemical stability of tungsten alloy blocks, reflecting their corrosion resistance in alkaline environments. Tungsten exhibits high chemical stability to most alkalis, especially under neutral or weak alkaline conditions. Adding metals such as aluminum or niobium may produce slight reactions in strong alkaline environments, affecting the overall durability of the alloy. Preparation processes such as powder metallurgy lay the foundation for reactivity by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces weak points for alkaline medium penetration, and ensures the material's alkali resistance. The reactivity of tungsten alloy blocks with common alkalis enables them to perform well in industrial cleaning, medical disinfection, and scientific research experiments, especially in scenarios that require contact with alkaline solutions.

The specific manifestation of reactivity depends on the concentration and temperature of the alkali. The material optimized by the hot isostatic pressing process reduces the spread of alkaline corrosion due to its high density. Post-processing processes such as surface polishing and alkali-resistant coating improve the alkali resistance of the block. Manufacturers adjust the alloy ratio according to the alkaline environment. Researchers verify its performance through alkali immersion tests, surface analysis and corrosion rate measurements to guide technical improvements. Weak bases such as sodium hydroxide have low reactivity to tungsten alloy blocks at room temperature, while high-temperature strong bases

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may cause slight corrosion to the added metal, which needs to be alleviated by surface protection. In industrial cleaning, alkali resistance ensures the long-term use of equipment components; in medical disinfection, it supports the compatibility of alkaline cleaning processes.

3.2.1.3 Interactions with other chemicals

The interaction with other chemical substances is an important research area in the chemical stability of tungsten alloy blocks, reflecting its adaptability in diverse chemical environments. The high chemical inertness of tungsten provides the basis for its alloy blocks to resist corrosion from a variety of chemical substances, while added metals such as copper, nickel or niobium may react with oxidants, salts or organic solvents under certain conditions, affecting the overall stability. Preparation processes such as powder metallurgy lay the foundation for the interaction by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces weak points for chemical penetration, and ensures the durability of the material. The interaction of tungsten alloy blocks with other chemical substances enables them to perform well in industrial processing, medical equipment and scientific research experiments, especially in scenarios involving complex chemical environments.

The specific manifestation of the interaction depends on the properties of the chemical substances and the environmental conditions. The material optimized by the hot isostatic pressing process has low porosity, which reduces the penetration of chemical corrosion. Post-processing processes such as surface polishing and chemical-resistant coatings improve the resistance of the block. Manufacturers adjust the alloy ratio according to the use environment. Researchers verify its performance through chemical immersion tests, surface analysis and reaction rate measurements to guide technical improvements. Oxidants such as hydrogen peroxide may have a slight oxidizing effect on the added metal. Salts such as sodium chloride may cause local corrosion under humid conditions. Organic solvents such as ethanol generally have little effect on tungsten alloy blocks. Surface protection measures such as antioxidant coatings or passivation treatments can further reduce the risk of interaction. In industrial processing, chemical resistance ensures the stability of equipment components; in the medical field, it supports compatibility with disinfectant environments.

3.2.2 Corrosion resistance of tungsten alloy blocks

Tungsten alloy blocks is a core attribute of their chemical properties, determining their long-term serviceability and reliability in harsh environments. The high chemical stability of tungsten provides an excellent corrosion-resistant foundation for its alloy blocks, while the addition of metals such as nickel, copper, or niobium optimizes the overall corrosion resistance of the alloy through powder metallurgy and hot isostatic pressing processes, enabling it to perform well in acidic, alkaline, or saline environments. Preparation processes such as powder metallurgy lay the foundation for corrosion resistance by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reducing weak points for penetration of corrosive media and ensuring the durability of the material. The corrosion resistance

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of tungsten alloy blocks makes them widely used in industrial equipment, medical devices, and scientific research instruments, especially when they need to be exposed to corrosive environments for a long time.

Optimizing corrosion resistance relies on a synergistic effect of composition and processing. The high density of materials optimized through hot isostatic pressing reduces the diffusion of corrosive media. Post-processing techniques such as surface polishing and anti-corrosion coatings enhance the corrosion resistance of the blocks. Manufacturers adjust alloy ratios based on the corrosive environment, and researchers verify performance through corrosion testing, surface analysis, and environmental simulations, guiding technological improvements. Corrosion resistance ensures material stability in acidic, alkaline, or humid environments, supporting the reliability of equipment components over long-term use.

3.2.2.1 Tolerance in acidic environment

The ability to withstand acidic environments is a key aspect of the corrosion resistance of tungsten alloy blocks, reflecting their corrosion resistance under acidic conditions. Tungsten itself is highly chemically inert to most acids, especially at room temperature, where it is difficult to be corroded by dilute acids. Adding metals such as copper or nickel may cause local reactions under strong acidic or high-temperature acidic conditions, affecting the alloy's resistance. Preparation processes such as powder metallurgy lay the foundation for resistance by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces weak points for acidic medium penetration, and ensures the stability of the material. The ability of tungsten alloy blocks to withstand acidic environments enables them to perform well in industrial processing, medical equipment, and scientific research experiments, especially in acidic cleaning or storage environments.

The specific performance of tolerance depends on the type, concentration and temperature of the acid. The material optimized by the hot isostatic pressing process has low porosity, which reduces the penetration of acid corrosion. Post-processing processes such as surface polishing and acid-resistant coating improve the tolerance of the block. Manufacturers adjust the alloy ratio according to the acidic environment. Researchers verify its performance through acid immersion tests, surface analysis and corrosion rate measurements to guide technical improvements. Dilute sulfuric acid and hydrochloric acid have low corrosiveness to tungsten alloy blocks, while concentrated nitric acid or high-temperature acid may have a certain impact on the added metal, which needs to be alleviated by surface protection. In industrial processing, tolerance ensures the long-term use of equipment components; in the medical field, it supports compatibility with acid disinfection processes.

3.2.2.2 Tolerance in alkaline environment

The ability to withstand alkaline environments is another important aspect of the corrosion resistance of tungsten alloy blocks, reflecting their corrosion resistance performance under alkaline conditions. Tungsten exhibits high chemical stability to most alkalis, especially under neutral or weak alkaline

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conditions. Adding metals such as aluminum or niobium may produce slight reactions in strong alkaline or high-temperature alkaline environments, affecting the alloy's tolerance. Preparation processes such as powder metallurgy lay the foundation for tolerance by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces weak points for alkaline medium penetration, and ensures the stability of the material. The ability of tungsten alloy blocks to withstand alkaline environments enables them to perform well in industrial cleaning, medical disinfection, and scientific research experiments, especially in scenarios that require contact with alkaline solutions.

The specific performance of tolerance depends on the concentration, temperature and exposure time of the alkali. The material optimized by the hot isostatic pressing process reduces the spread of alkaline corrosion due to its high density. Post-processing processes such as surface polishing and alkali-resistant coating improve the tolerance of the block. Manufacturers adjust the alloy ratio according to the alkaline environment. Researchers verify its performance through alkaline immersion tests, surface analysis and corrosion rate measurements to guide technical improvements. Weak bases such as sodium hydroxide have low reactivity to tungsten alloy blocks at room temperature, while high temperature, strong alkali or long-term exposure may cause slight corrosion to the added metal, which needs to be alleviated by surface protection. In industrial cleaning, tolerance ensures the long-term use of equipment components; in medical disinfection, it supports the compatibility of alkaline cleaning processes.

3.2.2.3 Corrosion in humid environments

Corrosion in humid environments is a key research area in the corrosion resistance of tungsten alloy blocks, reflecting their long-term performance in high humidity or water-containing environments. The high chemical stability of tungsten provides an excellent corrosion resistance foundation for its alloy blocks, but added metals such as copper or nickel may react electrochemically with oxygen or salt in water under humid conditions, causing local corrosion or oxidation. Preparation processes such as powder metallurgy lay the foundation for corrosion resistance by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces weak points for penetration of humid media, and ensures the durability of the material. The corrosion performance of tungsten alloy blocks in humid environments makes them perform well in marine equipment, medical devices and field instruments, especially in environments that require long-term exposure to moisture or salt spray.

The specific manifestation of corrosion depends on humidity, salt concentration and temperature. The material optimized by hot isostatic pressing process has low porosity, which reduces the penetration of water vapor or salt. Post-processing processes such as surface polishing and anti-corrosion coating improve the moisture resistance of the block. Manufacturers adjust the alloy ratio according to the humid environment. Researchers verify its performance through moisture exposure tests, salt spray experiments and surface analysis to guide technical improvements. In high humidity environments, tungsten alloy blocks may experience slight surface oxidation, especially in environments containing chloride salts. The risk of local corrosion of copper or nickel increases and needs to be controlled through surface protection

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measures. In marine equipment, moisture resistance ensures the long-term use of components; in the medical field, it supports compatibility with humid sterilization environments.

3.2.2.4 Protection measures in different corrosive environments

Protective measures in different corrosive environments are an important means to improve the corrosion resistance of tungsten alloy blocks, aiming to ensure their long-term reliability under acidic, alkaline or humid conditions. The high chemical stability of tungsten provides the basis for corrosion resistance of its alloy blocks, but the addition of metals such as nickel, copper or niobium may react in specific environments and need to be protected through processes and surface treatments. Preparation processes such as powder metallurgy lay the foundation for protective measures by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, reduces weak points for penetration of corrosive media, and ensures the stability of the material. The implementation of protective measures enables it to perform well in industrial equipment, medical devices and scientific research instruments, especially when long-term exposure to corrosive environments is required.

The specific choice of protective measures depends on the type and intensity of the corrosive environment. The materials optimized by the hot isostatic pressing process have high density, which reduces the risk of corrosion. Post-processing processes such as surface polishing and coating treatment improve the protective effect. Manufacturers select protection strategies based on environmental conditions. Researchers verify their performance through corrosion testing, surface analysis and durability experiments to guide technical improvements. In acidic environments, acid-resistant coatings such as phosphate treatment or passivation layers can effectively reduce corrosion; in alkaline environments, alkali-resistant coatings or ceramic coatings can enhance protection; in humid environments, antioxidant coatings or waterproof seals can prevent water vapor penetration. Surface treatments such as electroplating or spraying polymer films are also commonly used for multiple protections to extend service life. In industrial processing, protective measures ensure the stability of equipment components; in the medical field, they support tolerance to sterilized environments.

3.2.3 Environmental friendliness of tungsten alloy blocks

Tungsten alloy blocks is an important attribute of their chemical properties, reflecting their environmental friendliness during production, use, and recycling. Tungsten itself is a non-toxic metal, and its alloy blocks are made by adding metals such as nickel, copper, or iron, which have a lower toxicity risk than traditional lead-based materials. Preparation processes such as powder metallurgy lay the foundation for environmental friendliness by mixing tungsten powder with other metal powders, pressing, and sintering. The hot isostatic pressing process optimizes material utilization through omnidirectional pressure and reduces waste generation in the production process. The environmental friendliness of tungsten alloy blocks makes them perform well in medical devices, industrial components, and consumer products, especially in scenarios where toxic materials need to be replaced, meeting the requirements of modern green manufacturing.

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Optimizing environmental performance relies on material selection and process improvements. The high density of materials optimized through hot isostatic pressing reduces emissions during production. Post-processing processes such as surface treatment and recycling technologies enhance environmental performance. Manufacturers adjust alloy ratios based on environmental standards, and researchers verify their performance through toxicity testing, life cycle assessments, and environmental simulations, guiding technological improvements. Tungsten alloy blocks use recyclable metals in production, reducing resource waste; their non-toxic properties reduce health risks during use; and they can be smelted and reused during recycling, reducing the environmental burden. Compared to lead-based materials, the environmental friendliness of tungsten alloy blocks has led to their gradual replacement for traditional materials in medical radiation protection and industrial counterweights. In the medical field, environmental friendliness supports the health and safety of patients and operators; in the industrial field, it meets the requirements of sustainable development.

3.2.3.1 Safety of chemical composition

Chemical safety is a core element in the environmental performance of tungsten alloy ingots, determining the level of health risks associated with their production, use, and exposure. Tungsten, as the primary component, is a non-toxic metal whose chemical inertness makes it less likely to release hazardous substances in various environments. However, the selection and proportion of additive metals, such as nickel, copper, or iron, directly impact the alloy's safety. Manufacturing processes such as powder metallurgy, through mixing tungsten powder with other metal powders, pressing, and sintering, lay the foundation for the chemical composition. Hot isostatic pressing (HIP) optimizes the microstructure through omnidirectional pressure, minimizing component segregation or surface active sites, ensuring material stability. The chemical safety of tungsten alloy ingots excels in medical devices, industrial components, and consumer products, particularly in applications involving human contact or sensitive environments, where they significantly outperform traditional toxic materials. Optimizing chemical safety relies on both component selection and process control. The high density and low porosity of HIP-optimized materials reduce the risk of chemical reactions or releases. Post-processing processes such as surface polishing and biocompatible coatings further enhance safety. Manufacturers adjust alloy ratios based on safety standards, prioritizing low-toxic metals like copper and reducing nickel content. Researchers verify performance through toxicity testing, leaching experiments, and biocompatibility analysis, guiding technological improvements. Tungsten alloy blocks release no harmful gases or leachates at room temperature, and added metals, when kept within controlled limits, do not cause allergies or chronic toxicity, making them far superior to materials containing lead or mercury. In the medical field, the safety of the chemical composition supports radiation shielding components that come into direct contact with the human body; in the industrial field, it ensures the health protection of operators.

3.2.3.2 Impact on the biological environment

The impact on the biological environment is a key assessment dimension of the environmental friendliness of tungsten alloy blocks, reflecting their sustainability in natural ecosystems and biological

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systems. As a non-toxic metal, tungsten alloy blocks do not release heavy metals harmful to plants and animals when decomposed or worn. Added metals such as nickel or copper also exhibit low ecotoxicity at reasonable proportions. Preparation processes such as powder metallurgy lay the foundation for environmental friendliness by mixing tungsten powder with other metal powders, pressing and sintering. The hot isostatic pressing process optimizes material utilization through omnidirectional pressure, reducing waste and pollutant emissions during the production process. The impact of tungsten alloy blocks on the biological environment enables them to perform well in medical equipment, field instruments and green industries, especially in scenarios where the ecological footprint needs to be reduced, gradually replacing traditional toxic materials.

Optimizing the impact on the biological environment relies on material properties and process improvements. The high density of materials after optimization of the hot isostatic pressing process reduces their penetration into soil or water bodies during use or disposal. Post-processing processes such as surface treatment and recycling technologies further reduce ecological risks. Manufacturers adjust production processes in accordance with environmental regulations, and researchers verify their performance through ecotoxicity tests, soil leaching experiments, and water quality analysis to guide technological improvements. Tungsten alloy blocks degrade slowly in the natural environment, and the released trace metals do not significantly interfere with plant growth or aquatic ecology; compared to lead materials, their bioaccumulation risk is extremely low. In the medical field, the impact on the biological environment supports the design of sustainable medical devices; in field applications, it reduces environmental pollution.

Between tungsten alloy and lead are a key comparison factor in the environmental performance of tungsten alloy ingots, highlighting their advantages as a non-toxic alternative. Tungsten's high chemical stability provides excellent corrosion resistance in acidic, alkaline, or humid environments, while lead is highly reactive and readily reacts with acids to form toxic compounds, such as lead salts. Manufacturing processes such as powder metallurgy, which combines tungsten powder with other metal powders, followed by pressing and sintering, lay the foundation for the chemical properties of tungsten alloy ingots. Hot isostatic pressing (HIP) optimizes the microstructure through omnidirectional pressure, reducing vulnerable points for corrosive media penetration. However, simple casting of lead materials struggles to achieve high densities. This difference in chemical properties has led to its increasing use as a replacement for lead in medical devices, industrial components, and consumer products, particularly in applications requiring high safety. Optimizing this chemical difference relies on a combination of composition and processing. Optimized HIP-processed tungsten alloy ingots exhibit low porosity, reducing the risk of chemical reactions. Post-processing processes such as surface polishing and corrosion-resistant coatings further enhance durability. Lead, however, exhibits poor corrosion resistance due to its rough surface and susceptibility to oxidation. Manufacturers select tungsten alloys based on environmental requirements. Researchers verify these differences through corrosion testing, toxicity analysis, and chemical stability experiments, guiding technological improvements. Tungsten alloy blocks do not produce toxic leachates in acidic environments, whereas lead readily forms lead salts. In alkaline conditions, tungsten alloy blocks remain stable, while lead may slowly corrode. In humid environments, oxidation of tungsten alloy blocks is far less susceptible to electrochemical corrosion than lead. These

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chemical differences support the use of non-toxic shielding materials in medical radiation protection and reduce the risk of environmental contamination in industrial counterweights.

3.3 CTIA GROUP LTD Tungsten Alloy Block MSDS

The chemical and corporate identification information of CTIA GROUP LTD Tungsten Alloy Ingot is clear. The product name is CTIA GROUP LTD Tungsten Alloy Ingot, produced by CTIA GROUP LTD Technology Co., Ltd. The CAS numbers of the tungsten, nickel, iron, cobalt, and copper components it contains are 7440-33-7, 7440-02-0, 7439-89-6, 7440-48-4, and 7440-50-8 respectively .

From the perspective of composition, CTIA GROUP LTD's tungsten alloy blocks belong to refractory metal alloys. Common alloy systems are diverse, such as W+Ni+Fe , W+Cu , etc., where the tungsten content is usually between 70% and 99.5%. The content of other elements such as nickel, iron, and copper varies, and a small amount of cobalt may also be contained. These components together determine the properties of the alloy .

Tungsten alloy blocks have remarkable physical and chemical properties, including a density of 17.0-19.3 g/cm³, a melting point of 2500-3000°C, a Vickers hardness of 300-500, a tensile strength of 700-1200 MPa, a thermal conductivity of 80-150 W/(m · K), and a resistivity of approximately 5.5-7.0 μΩ

· cm. These properties determine their application scenarios . Ecological data show that there is currently no data showing that high-density tungsten alloy is harmful to the environment, and it has no obvious harm to the environment and health, indicating that it is relatively safe in terms of environmental impact .

Waste disposal must comply with local laws and environmental protection requirements. It can be recycled or handed over to professional institutions for treatment, reflecting the principle of environmental protection . During transportation, avoid collisions to prevent damage to the packaging, and transport it separately from other materials to ensure stability during transportation .



CTIA GROUP LTD Tungsten Alloy Block

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Chapter 4 Production Process of Tungsten Alloy Block

4.1 Selection and pretreatment of tungsten alloy block raw materials

Tungsten alloy blocks are key links in the production process, which directly determine the quality and performance of the final product. Tungsten, as the main component, provides core advantages for alloy blocks with its high density and high melting point characteristics, while the selection of added metals such as nickel, copper or iron needs to be optimized according to application requirements. The preparation process is mainly based on powder metallurgy. The selection of raw materials focuses on purity, particle size and uniformity. The pretreatment process includes powder screening, mixing and drying to ensure the stability of the microstructure. As a subsequent optimization method, the hot isostatic pressing process further improves the density of the material and reduces defects through omnidirectional pressure. The selection of raw materials and the pretreatment process affect the performance of tungsten alloy blocks in radiation protection, counterweights and structural support, and promote their widespread application in medical, industrial and scientific research fields.

Process design at this stage focuses on matching raw material properties with processing requirements. The optimized hot isostatic pressing process enhances uniformity and performance consistency. Post-processing techniques such as surface treatment and finishing further enhance product quality. Manufacturers select raw materials based on the application scenario, and researchers verify pretreatment results through performance testing and microanalysis, guiding technical improvements.

4.1.1 Tungsten powder purity requirements

The purity requirement of tungsten powder is the core standard in the selection and pretreatment of raw materials for tungsten alloy blocks, which directly affects the mechanical properties and chemical stability of the material. The high purity of tungsten powder ensures the reliability of the alloy block in high temperature or corrosive environments. The purity is usually required to reach more than 99.9% to reduce the negative impact of impurities such as oxygen, carbon or silicon on the microstructure and performance. Preparation processes such as powder metallurgy rely on mixing high-purity tungsten powder with other metal powders. Excessive impurity content may lead to pore formation or grain boundary weakening, affecting density and strength. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, and combined with high-purity tungsten powder, it significantly improves the uniformity and corrosion resistance of the material. The high purity requirements of tungsten powder enable it to perform well in radiation protection, counterweights and precision manufacturing, especially in scenarios requiring long-term stability.

The process of determining purity requirements focuses on matching material properties with application requirements. Materials optimized through the hot isostatic pressing process exhibit low impurity levels, reducing performance fluctuations. Post-processing processes such as surface polishing and chemical cleaning further enhance the purity effect. Manufacturers select high-purity tungsten powder based on product specifications. Researchers verify its purity through spectral analysis, oxygen content testing,

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and microstructural observations to guide technological improvements. High-purity tungsten powder reduces oxidation reactions, enhancing the durability of alloy blocks; in medical devices, it ensures reliable radiation shielding. Insufficient purity can lead to increased processing difficulty or reduced performance, requiring refining to control.

4.1.2 Tungsten powder screening standards

Tungsten powder screening standards are an important step in the selection and pretreatment of raw materials for tungsten alloy blocks, and determine the impact of powder particle size, morphology, and distribution on the production process and final performance. Screening standards generally require that the tungsten powder particle size be in the range of 1-10 microns and that the particle size distribution be uniform to ensure that the powder is tightly packed during the pressing and sintering process, reducing porosity and defects. Preparation processes such as powder metallurgy rely on mixing screened tungsten powder with other metal powders. Too large a particle size may lead to uneven pressing, while too small a particle size may increase the risk of oxidation. The hot isostatic pressing process optimizes the microstructure through omnidirectional pressure, and combined with the screening standards, it significantly improves the density and mechanical strength of the material. The high or low screening standards of tungsten powder enable it to perform well in radiation protection, counterweights, and structural support, especially in scenarios requiring high precision and uniformity.

The screening criteria formulation process focuses on matching powder properties with process requirements. The materials optimized by the hot isostatic pressing process have a uniform particle size distribution, which reduces defects in the sintering process. Post-processing processes such as screening and surface treatment further enhance the screening effect.

4.1.3 Basis for alloy element selection

The basis for selecting alloying elements is a key decision point in the selection and pretreatment of raw materials for tungsten alloy blocks, which directly determines the performance and application range of the material. Tungsten, as the main component, provides core properties with its high density and high melting point. The selection of alloying elements needs to be optimized based on target properties such as radiation absorption, mechanical strength or conductivity. Common choices include nickel, copper, iron, molybdenum or niobium, based on the chemical stability, ductility and compatibility of the elements with tungsten. Preparation processes such as powder metallurgy rely on the mixing of these elements, and the hot isostatic pressing process optimizes the microstructure through omnidirectional pressure to ensure uniform distribution and bonding strength between elements. The basis for selecting alloying elements enables it to perform well in radiation protection, counterweights and high-temperature applications, especially in scenarios requiring specific functionality.

The formulation of the selection basis focuses on the matching of application requirements and material properties. The material optimized by the hot isostatic pressing process has enhanced the synergistic effect of elements due to its uniformity. Post-processing processes such as surface treatment further

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improve performance. Manufacturers select elements based on the use of the product. Researchers verify the selection basis through phase diagram analysis, mechanical testing and corrosion experiments to guide technical improvements. Nickel is often used to improve toughness due to its strong ductility, copper is suitable for heat dissipation due to its good thermal conductivity, and iron provides economic and strength support. The selection of elements also needs to consider cost and processing difficulty. In the future, the introduction of new elements or the design of composite materials may be used to further optimize the selection basis to make tungsten alloy blocks suitable for a wider range of applications.

4.1.4 Alloying element ratio principles

The principle of alloy element ratio is the core guide in the selection and pretreatment of raw materials for tungsten alloy blocks, aiming to balance performance, processability and economy. The ratio principle emphasizes that the tungsten content is usually 85%-97%, which serves as the main skeleton to provide high density and radiation absorption capacity, while the proportion of added elements such as nickel, copper or iron is controlled at 3%-15% to optimize toughness, conductivity or cost. Preparation processes such as powder metallurgy rely on precise ratios to ensure uniform mixing of powders, and the hot isostatic pressing process strengthens the microstructure through omnidirectional pressure to reduce defects caused by improper ratios. The ratio principle enables it to perform well in radiation protection, counterweights and structural support, especially in scenarios requiring high precision and stability.

The formulation of the matching principles emphasizes the balance between performance and process. The density of the optimized material after hot isostatic pressing enhances the stability of the matching effect. Post-processing processes such as sintering and surface treatment further optimize the material properties. Manufacturers adjust the matching ratio based on application requirements. Researchers verify the principles through experimental design, microanalysis, and performance testing to guide technological improvements. The principles dictate avoiding excessive concentrations of any single element to prevent performance imbalances. For example, excessive nickel can reduce hardness, while excessive copper can weaken strength.

4.1.5 Alloying element ratio method

The alloying element ratio method is a technical implementation link in the selection and pretreatment of raw materials for tungsten alloy blocks, ensuring composition uniformity and performance consistency. Common methods include the weight percentage method and the molar ratio method. The former mixes tungsten, nickel, copper and other powders according to the mass ratio, and the latter optimizes the reaction based on the stoichiometric ratio. Preparation processes such as powder metallurgy achieve precise ratios through high-energy ball milling or mechanical alloying, and the hot isostatic pressing process uses omnidirectional pressure to enhance the mixing effect and reduce the risk of stratification or segregation. The ratio method enables it to perform well in radiation protection, counterweighting and precision manufacturing, especially in scenarios requiring high uniformity.

The implementation of the proportioning method emphasizes process control and quality testing. The

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low porosity of materials optimized by hot isostatic pressing enhances proportioning uniformity. Post-processing steps such as screening and mixing verification further enhance precision. Manufacturers develop production processes based on the proportioning method, and researchers verify the effectiveness of the method through X-ray diffraction, particle size analysis, and density testing, guiding technological improvements.

4.1.6 Raw material cleaning process

The raw material cleaning process is a key step in raw material selection and pretreatment during the tungsten alloy block production process. It aims to remove impurities, oxides, and organic residues from the powder surface to ensure smooth subsequent processing. Tungsten powder and additive metal powders such as nickel, copper, or iron may absorb moisture, grease, or dust particles during preparation or transportation. Cleaning typically involves ultrasonic cleaning or acid-base washing. The former uses high-frequency vibrations to remove surface contaminants, while the latter uses diluted acid (such as dilute sulfuric acid) or alkaline solutions to remove oxide layers. Manufacturing processes such as powder metallurgy rely on clean, clean powder after cleaning to ensure uniform mixing. Hot isostatic pressing (HIP) optimizes the microstructure through omnidirectional pressure, further minimizing the impact of residual impurities on material properties. This cleaning process excels in applications such as radiation protection, counterweights, and precision manufacturing, particularly where high purity and stability are required.

Optimizing the cleaning process focuses on balancing efficiency and quality. Materials optimized for hot isostatic pressing (HIP) exhibit enhanced cleaning effectiveness due to their low impurity content. Post-processing techniques such as centrifugal dehydration and drying further enhance powder cleanliness. Manufacturers develop cleaning parameters based on powder conditions. Researchers verify process effectiveness through surface analysis, impurity detection, and microscopic observation, guiding technical improvements. Ultrasonic cleaning is suitable for fine powders, while acid and alkaline cleaning is targeted at heavily oxidized materials. Post-cleaning neutralization and rinsing steps require strict control to prevent residues. The cleaning process also needs to consider environmental requirements and minimize wastewater discharge.

4.1.7 Drying of raw materials

Raw material drying is a crucial step in the raw material selection and pretreatment process for tungsten alloy ingot production. It aims to remove moisture and volatile impurities from the powder to prevent defects during sintering. Tungsten powder and additive metal powders may absorb moisture during cleaning or storage. Drying typically involves vacuum drying or hot air ovens. The former evaporates moisture in a low-pressure environment, while the latter removes surface and internal moisture through controlled heating (typically 60-120°C). Manufacturing processes such as powder metallurgy rely on dried powders to ensure flowability and mixing uniformity. Hot isostatic pressing (HIP) uses omnidirectional pressure to optimize microstructure and reduce moisture-induced porosity or cracks. Drying enhances performance in radiation protection, counterweights, and structural support applications,

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particularly where high density and stability are required. Optimizing the drying process focuses on temperature and time management. The low moisture content of HIP-optimized materials enhances drying effectiveness. Post-processing steps such as cooling and sealed storage further improve powder stability. Manufacturers set drying parameters based on powder characteristics. Researchers verify the effectiveness of the process through moisture measurement, thermogravimetric analysis, and microscopic observation, guiding technological improvements. Vacuum drying is suitable for high purity requirements, while hot air drying is suitable for large-scale production. Secondary moisture absorption should be avoided after drying.

4.1.8 Other preprocessing steps

Additional pretreatment steps are crucial complements to raw material selection and pretreatment in the tungsten alloy ingot production process. These encompass powder size adjustment, surface modification, and optimized mixing uniformity, ensuring smooth subsequent processing. In addition to cleaning and drying, pretreatment also includes mechanical grinding, ball milling, and surface passivation. Mechanical grinding adjusts the particle size distribution of the tungsten powder and the additive metal powders. Ball milling utilizes high-energy ball mills to achieve compositional uniformity. Surface passivation involves chemical treatment (such as nitric acid soaking) to form a protective layer and reduce oxidation. Manufacturing processes such as powder metallurgy rely on these steps to optimize powder properties. Hot isostatic pressing (HIP) strengthens the microstructure through omnidirectional pressure, minimizing the impact of pretreatment defects on final performance. These additional pretreatment steps contribute to its excellent performance in radiation protection, counterweighting, and precision manufacturing, particularly in applications requiring high consistency and complex structures. Optimizing these pretreatment steps emphasizes process synergy and quality control. The uniformity of the material after HIPing enhances the pretreatment effect. Post-processing steps such as screening and testing further enhance powder quality.

4.2 Knowledge about preparing tungsten alloy blocks by powder metallurgy

The preparation of tungsten alloy blocks by powder metallurgy is a core technology in the production process and is widely used in the manufacture of high-performance tungsten alloy products. This method fully utilizes the high density and mechanical strength characteristics of tungsten by mixing tungsten powder with other alloying element powders, pressing and sintering, while optimizing the material's toughness, conductivity or thermal stability by adding elements such as nickel, copper or iron. The entire process begins with the selection and pretreatment of raw materials, then enters the powder mixing, molding and sintering stages, and finally improves the material quality through hot isostatic pressing or subsequent processing. Powder metallurgy has become the mainstream choice for the production of tungsten alloy blocks due to its advantages in achieving complex shapes and high uniformity, especially in fields requiring high precision and reliability such as radiation protection, counterweights and structural support. Its process focuses on the microstructural control of the material to ensure performance consistency and production efficiency, and is widely used in the manufacture of medical equipment, industrial components and scientific research instruments.

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The implementation of powder metallurgy relies on multi-step process optimization. Hot isostatic pressing (HIP), a subsequent reinforcement process, applies omnidirectional pressure to further eliminate internal defects and improve the material's density and stability. Post-processing processes such as surface polishing and heat treatment further refine the product to meet diverse application requirements.

4.2.1 Powder mixing equipment

Powder mixing equipment is a key tool in the process of preparing tungsten alloy blocks by powder metallurgy, which directly affects the uniformity of the powder and the subsequent molding quality. When choosing suitable mixing equipment, it is necessary to consider the particle size, density and fluidity of the tungsten powder and the powder of the added elements. Common equipment includes V-type mixers, double-cone mixers and ball mills. The V-type mixer achieves free flow and uniform distribution of powder through its unique design, which is suitable for processing medium-sized powders; the double-cone mixer enhances the mixing effect through rotational motion, which is particularly suitable for mixing high-density materials; the ball mill not only achieves mixing through the collision and grinding of the spheres and the powder, but also adjusts the powder particle size, which is suitable for complex alloy formulas that require fine mixing. The design of these equipment focuses on reducing the segregation and agglomeration of the powder, ensuring that the components are fully integrated at the microscopic level, laying the foundation for subsequent pressing and sintering.

The operation of powder mixing equipment needs to be adjusted according to the process requirements. The material of the equipment is usually wear-resistant and corrosion-resistant alloys to adapt to the high hardness characteristics of tungsten alloy. During the mixing process, the speed, running time and loading capacity of the equipment need to be optimized according to the powder characteristics to avoid over-grinding or insufficient mixing. Hot isostatic pressing process as a subsequent step can further consolidate the mixing effect and reduce minor unevenness caused by equipment limitations. Post-processing processes such as screening and testing are used to verify the mixing quality. Manufacturers select equipment based on production scale and product requirements. Researchers evaluate equipment performance through microscopic observation, particle size analysis and uniformity testing to guide technical improvements.

4.2.2 Powder mixing process parameters

Powder mixing process parameters are the core control factors in the process of preparing tungsten alloy blocks by powder metallurgy, which determine the mixing effect and the consistency of material properties. The process parameters mainly include mixing time, rotation speed, filling ratio and environmental conditions such as temperature and humidity. The setting of these parameters needs to be adjusted according to the physical and chemical properties of tungsten powder and additive element powder to achieve uniform distribution of components and avoid powder agglomeration or stratification. The mixing time needs to be long enough to ensure full fusion, but too long may cause over-grinding of powder, affecting particle size and fluidity; the rotation speed needs to be selected according to the equipment type and powder characteristics. Too high may cause powder to fly, and too low will make it

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difficult to achieve a uniform effect; the filling ratio affects the fluidity and contact opportunities of the powder in the equipment and needs to be kept within a reasonable range of the equipment capacity; environmental conditions such as low humidity can help reduce moisture adsorption and keep the powder dry.

The optimization process of process parameters focuses on matching with production goals. The hot isostatic pressing process, as a subsequent strengthening method, can compensate for minor defects in the mixing process through omnidirectional pressure and further improve the uniformity of the material. Post-processing processes such as sintering and surface treatment rely on the stability of the mixing parameters to ensure product quality. Manufacturers adjust parameters according to specific alloy formulas and equipment performance. Researchers verify the parameter effects through experimental design, microstructure analysis and performance testing to guide technical improvements. Reasonable setting of mixing process parameters can reduce porosity and cracks in subsequent sintering and improve the density and mechanical properties of tungsten alloy blocks.

4.2.3 Mixing uniformity test

Testing for mixing uniformity is a key quality control step in the powder metallurgy process for producing tungsten alloy blocks . It ensures the consistent distribution of the various components after powder mixing, which impacts the microstructure and properties of the sintered material . Testing methods include sampling analysis, microscopic observation, and chemical composition testing. Sampling analysis involves extracting samples from different locations to assess the distribution of components. Microscopic observation uses scanning electron microscopy or optical microscopy to examine the mixing state of powder particles and identify possible segregation or agglomeration. Chemical composition testing, such as X-ray fluorescence spectroscopy or inductively coupled plasma emission spectroscopy, quantitatively determines whether the content of each element meets the required ratio. The combined application of these methods can comprehensively reflect the mixing effect and provide a reliable basis for subsequent processing.

The implementation of mixing uniformity testing requires a combination of process flow and testing accuracy. The high density of materials optimized by the hot isostatic pressing process can further reveal microscopic defects caused by uneven mixing. Post-processing processes such as uniformity correction and performance verification rely on test results for adjustment. Manufacturers develop testing plans based on product standards, and researchers verify test results through statistical analysis, image processing, and composition comparison to guide technological improvements. The results of uniformity testing directly affect sintering quality. For example, uneven mixing may lead to local performance differences or decreased mechanical strength. In radiation protection, uniformity ensures the consistency of shielding effects; in precision manufacturing, it guarantees the stability of complex structures.

4.2.4 Type of pressing equipment

The type of pressing equipment is a key component in the powder metallurgy process of preparing

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tungsten alloy blocks , directly affecting the powder molding quality and material density. Commonly used equipment includes unidirectional hydraulic presses, bidirectional hydraulic presses, and isostatic presses. Unidirectional hydraulic presses apply pressure in a single direction and are suitable for forming small or simple tungsten alloy blocks. Bidirectional hydraulic presses improve molding uniformity through up and down pressure and are particularly suitable for parts of medium complexity. Isostatic presses use liquid or gas to apply omnidirectional pressure, which can effectively reduce internal stress and is suitable for high-precision and complex geometric tungsten alloy blocks. The selection of these equipment needs to be optimized based on the characteristics of the tungsten powder and the added element powder, the target density, and the subsequent processing requirements to ensure that the powder is tightly combined during the pressing process, laying a solid foundation for sintering.

The selection of pressing equipment also requires consideration of its structural design and durability. The equipment's molds are typically constructed of high-strength steel or cemented carbide to withstand the high hardness of tungsten alloys. During operation, the equipment's pressure distribution and mold fit must be compatible with powder flowability. Hot isostatic pressing, as a subsequent strengthening method, can further eliminate minor defects that may occur during the pressing process.

4.2.5 Compression pressure control

Pressing pressure control is the core link in the process of preparing tungsten alloy blocks by powder metallurgy , which determines the degree of compression of the powder and the density of the final material. The pressing pressure needs to be adjusted according to the characteristics of the tungsten powder and the added element powder to achieve uniform particle bonding and reduce porosity. The control process is usually achieved through a hydraulic system or mechanical device. The pressure gradually increases from the initial pre-pressure to the target value. It is necessary to ensure that the force on each part is balanced to avoid local overpressure causing cracks or deformation. Reasonable pressure control can enhance the contact area between powders, promote atomic diffusion, and provide an ideal microstructure for subsequent sintering. As a subsequent optimization method, the hot isostatic pressing process further improves the density of the material through omnidirectional pressure to compensate for the uneven pressure distribution that may exist during the pressing process. The optimization of pressing pressure control focuses on matching process parameters with material properties. The material after optimization of the hot isostatic pressing process has enhanced stability of the pressing due to its high density. Post-processing processes such as surface polishing and density testing rely on the quality of pressure control. Manufacturers set the pressure range according to powder particle size and molding requirements. Researchers verify the control effect through pressure distribution analysis, microscopic observation and density testing to guide technical improvements. Too low pressure may lead to loose molding and affect the sintering effect; too high pressure may cause powder particle breakage or mold wear, and balance must be achieved through precise adjustment.

4.2.6 Pressing time setting

The pressing time setting is an important parameter in the process of preparing tungsten alloy blocks by

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powder metallurgy , which directly affects the compression quality and molding stability of the powder. The pressing time needs to be adjusted according to the characteristics of the tungsten powder and the added element powder, the type of pressing equipment and the target density. If the time is too short, the powder may not be fully compacted, leaving pores; if the time is too long, it may cause excessive deformation of the powder particles and affect the microstructure. The setting process is usually divided into pre-pressing and main pressing stages . The pre-pressing time is used for initial forming, and the main pressing time ensures that the pressure is evenly distributed and reaches the expected density. As a subsequent strengthening method, the hot isostatic pressing process can further optimize the pressing effect through omnidirectional pressure and reduce internal defects caused by insufficient time.

The optimization of pressing time setting focuses on the balance between process efficiency and quality. The material after optimization of the hot isostatic pressing process has enhanced the effect of time setting due to its high density. Post-processing processes such as pre-sintering inspection and density verification rely on the stability of time control. Manufacturers set time parameters based on powder mixing uniformity and equipment performance. Researchers verify the setting effect through time gradient experiments, microstructure analysis and performance testing to guide technical improvements. The pressing time must also be coordinated with the pressure and temperature conditions. Too short may lead to incomplete molding, and too long will increase production costs. The best balance needs to be achieved through process optimization. In the counterweight and structural support, the time setting ensures the density and mechanical properties of the material.

4.2.7 Selection of sintering equipment

The selection of sintering equipment is a key decision in the powder metallurgy process for preparing tungsten alloy ingots , determining the material's microstructure and ultimate properties. Commonly used equipment includes box-type resistance furnaces, vacuum sintering furnaces, and hydrogen-shielded sintering furnaces. Box-type resistance furnaces utilize electric heating elements to provide a high-temperature environment, making them suitable for basic sintering. Vacuum sintering furnaces utilize a vacuum environment to reduce oxidation and are particularly suitable for high-purity tungsten alloy ingots. Hydrogen-shielded sintering furnaces utilize a reducing atmosphere to remove oxides and enhance material density. The selection of these equipment must be optimized based on the tungsten alloy's composition, target performance, and production scale to ensure adequate diffusion and bonding of powder particles during sintering, forming a stable crystal structure.

The implementation of the selection of sintering equipment needs to consider its temperature control accuracy and atmosphere management capabilities. The lining of the equipment is usually made of high-temperature resistant materials such as silicon carbide or aluminum oxide to adapt to the high melting point characteristics of tungsten alloy. The hot isostatic pressing process, as a subsequent optimization method, can further eliminate micropores in the sintering process. Post-processing processes such as heat treatment and surface finishing depend on the sintering quality of the equipment. Manufacturers select the type of equipment based on product requirements. Researchers verify the equipment effect through sintering temperature analysis, microstructure observation and performance testing to guide technical

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improvements. Sintering equipment must also be equipped with a good exhaust and cooling system to control gas emissions and thermal stress during the sintering process. In radiation protection and precision manufacturing, equipment selection ensures the uniformity and stability of the material.

4.2.8 Sintering temperature control

Tungsten alloy blocks by powder metallurgy, which directly affects the microstructure, density and mechanical properties of the material. The sintering temperature needs to be adjusted according to the characteristics of tungsten powder and added elements such as nickel, copper or iron. It is usually set below the solidus of tungsten to promote atomic diffusion and bonding between powder particles, while avoiding structural damage caused by melting. The temperature control process relies on the precise heating system of the sintering equipment. It needs to be gradually heated from room temperature to the target value, and uniform heating must be ensured through the insulation stage. Excessively high temperatures may cause excessive particle growth or composition segregation, while too low temperatures may lead to insufficient sintering, leaving porosity. As a subsequent optimization method, the hot isostatic pressing process further improves the density of the material through omnidirectional pressure to make up for the defects caused by insufficient temperature control.

Optimizing sintering temperature control focuses on coordinating process parameters with material properties. The high density of materials after optimized hot isostatic pressing enhances the effectiveness of temperature control. Post-processing processes such as heat treatment and surface inspection rely on ensuring temperature stability. Manufacturers set temperature ranges based on alloy ratios and equipment performance. Researchers verify control effectiveness through thermal expansion analysis, microscopic observation, and hardness testing to guide technological improvements. Temperature control also requires consideration of heating rate and holding time to avoid thermal stress or cracking. Temperature control ensures material uniformity and strength in radiation protection and structural support.

4.2.9 Sintering atmosphere adjustment

Sintering atmosphere adjustment is an important process step in the preparation of tungsten alloy blocks by powder metallurgy. It aims to optimize the sintering environment to reduce oxidation, control chemical reactions and improve material properties. Sintering atmosphere usually includes vacuum, hydrogen or inert gases such as argon. The vacuum environment reduces oxidation reactions by removing oxygen, hydrogen acts as a reducing atmosphere to remove surface oxides, and inert gases provide a stable non-reactive environment. Atmosphere adjustment needs to be selected according to the composition and target performance of the tungsten alloy. Tungsten powder and added elements easily react with oxygen to form oxides at high temperatures. A suitable sintering atmosphere can effectively inhibit this process. As a subsequent strengthening method, the hot isostatic pressing process further consolidates the effect of atmosphere adjustment through omnidirectional pressure and reduces micro defects caused by oxidation.

The optimization of sintering atmosphere regulation focuses on the matching of environmental control

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and material reaction. The materials after optimization of the hot isostatic pressing process have enhanced the stability of atmosphere regulation due to their low oxidation level. Post-processing processes such as surface cleaning and coating rely on the quality of the atmosphere. Manufacturers select suitable atmospheres based on the characteristics of the alloy. Researchers verify the regulation effect through gas analysis, surface morphology observation and corrosion testing to guide technical improvements. Vacuum sintering is suitable for high purity requirements, hydrogen sintering improves reduction efficiency, and inert gas sintering is suitable for alloys with complex compositions. Atmosphere regulation also needs to pay attention to airflow distribution and pressure stability to avoid local oxidation or contamination. In counterweight and precision manufacturing, atmosphere regulation ensures the chemical stability and durability of the material.

4.2.10 Sintering time control

Controlling the sintering time is a key parameter in the process of preparing tungsten alloy blocks by powder metallurgy, which determines the degree of diffusion between powder particles and the final density of the material. The sintering time needs to be adjusted according to the characteristics of the tungsten powder and the added elements, the sintering temperature and the atmosphere conditions. It is usually divided into three stages: heating, holding and cooling. The holding time is particularly critical to ensure that atomic diffusion and crystal growth are sufficient. Too short a time may lead to incomplete sintering, leaving pores or weak bonding areas; too long a time may cause excessive particle growth and affect the mechanical properties. As a subsequent optimization method, the hot isostatic pressing process further enhances the density of the material through omnidirectional pressure to make up for the micro defects caused by insufficient time.

The optimization of sintering time control focuses on the balance between efficiency and quality. The materials optimized by the hot isostatic pressing process have enhanced the effect of time control due to their high density. Post-processing processes such as density testing and performance verification rely on the guarantee of time stability. Manufacturers set time parameters based on alloy ratios and equipment efficiency. Researchers verify the control effect through time gradient experiments, microstructure analysis and strength testing to guide technical improvements. The sintering time also needs to be coordinated with the temperature and atmosphere. Too short may lead to insufficient sintering, while too long will increase energy consumption and production costs. The best balance needs to be achieved through process optimization. In radiation protection and precision manufacturing, time control ensures the uniformity and stability of materials.

4.3 Application of other forming processes in the production of tungsten alloy blocks

Offer diverse processing options in the production of tungsten alloy ingots, expanding the material's applicability and performance optimization potential. In addition to traditional powder metallurgy, processes such as forging, extrusion, and hot isostatic pressing (HIP) are widely used under specific conditions. Forging mechanically reshapes the tungsten alloy's crystal structure, enhancing its mechanical strength and toughness. Extrusion is suitable for producing long strips or complex cross-

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sectional shapes. HIP, as an omnidirectional forming technique, significantly improves the material's density and uniformity. The choice of these processes depends on the tungsten alloy's composition, target application, and production scale. These processes are widely used in radiation protection, counterweights, and structural support. Optimizing the forming process for tungsten alloy ingots not only improves product consistency but also meets the high precision and reliability requirements of medical devices, industrial components, and scientific research instruments. The implementation of these processes requires careful consideration of material properties and the production environment. HIP, as a supplementary method, can further eliminate minor defects introduced during the forming process. Post-processing techniques such as machining and surface treatment are tailored to the requirements of the forming process.

4.3.1 Tungsten alloy types suitable for forging processes

The key to selecting the right tungsten alloy for forging is the material's ductility and processability, which determine the suitability of the forging process for producing tungsten alloy blocks. Forging requires a certain degree of plasticity to withstand mechanical deformation, making it suitable for tungsten alloys containing a high proportion of ductile elements, such as tungsten-nickel-iron or tungsten-nickel-copper. These alloys enhance the toughness and forgeability of tungsten by adding nickel or copper, enabling them to withstand the impact forces of hammer or die forging at high temperatures. Tungsten-nickel-iron, due to its excellent strength and ductility, is often used in the manufacture of high-density counterweights and radiation shielding components. Tungsten-nickel-copper, due to its excellent thermal conductivity, is suitable for industrial applications requiring heat dissipation. Pure tungsten or alloys with high tungsten content are generally unsuitable for forging due to their high brittleness. The selection of a suitable tungsten alloy for forging requires careful consideration of the composition ratio and heat treatment conditions. Hot isostatic pressing, as a pretreatment, can optimize the material's microstructure and enhance its forging properties. Post-processing processes such as heat treatment and surface finishing further enhance the quality of forged components.

4.3.2 Operational procedures of forging process

The operational flow of the forging process is an important step in achieving material forming in the production of tungsten alloy blocks, ensuring the structural integrity and performance consistency of the product. The process usually includes three main stages: preheating, forging, and cooling. In the preheating stage, the tungsten alloy blank is heated to a high temperature to improve its plasticity, usually carried out under a protective atmosphere to avoid oxidation; in the forging stage, mechanical force is applied through hammer forging or die forging to reshape the crystal structure and eliminate internal defects; in the cooling stage, the material properties are stabilized by controlling the cooling rate to avoid cracks caused by thermal stress. The entire process requires the use of high-temperature resistant molds and precision equipment to adapt to the high hardness and high melting point characteristics of tungsten alloy and ensure the smooth progress of the forming process. The implementation of the operational flow needs to be combined with material properties and equipment capabilities. The hot isostatic pressing process, as an auxiliary means, can optimize the structure of the preheated blank. Post-processing

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processes such as machining and surface polishing are adjusted according to the forging effect.

4.3.3 Advantages of forging technology

The advantage of the forging process lies in its ability to significantly improve the mechanical properties and structural reliability of tungsten alloy blocks, enabling them to excel in a variety of applications. Forging mechanically reshapes the crystal structure, eliminating the porosity and defects that may remain in powder metallurgy, enhancing the material's density and fatigue resistance. Furthermore, the forging process improves the tungsten alloy's grain orientation, increasing its tensile strength and toughness, making it particularly suitable for manufacturing components subject to high loads. Compared to powder metallurgy, forging also produces products with improved surface quality and dimensional accuracy, reducing the complexity of subsequent processing. Tungsten-nickel-iron or tungsten-nickel-copper alloys exhibit excellent comprehensive properties after forging and are widely used in radiation protection and structural support. The advantages of the forging process are also reflected in its optimization of material properties. Hot isostatic pressing (HIP) can further enhance the forging effect, while post-processing processes such as heat treatment and surface treatment enhance the product's durability. Manufacturers are leveraging these advantages to meet demanding applications, and researchers have verified their benefits through mechanical testing and microscopic analysis.

4.3.4 Limitations of forging process

Although the forging process has significant advantages in the production of tungsten alloy blocks, it also has some limitations. These limiting factors may affect its application scope and production efficiency under certain conditions. First, the forging process has high requirements for the plasticity of the material. The inherent brittleness of tungsten itself makes it difficult to directly forge pure tungsten or high-tungsten content alloys. Even if the toughness is improved by adding ductile elements such as nickel, copper or iron, the plasticity of the alloy is still limited by the composition ratio and heat treatment conditions. When the tungsten content is too high, the material is prone to cracks or fractures during the forging process, which greatly limits the applicability of the forging process in the production of high-purity tungsten alloy blocks. In addition, forging requires heating the billet to a high temperature to enhance plasticity. This process not only increases energy consumption costs, but may also cause surface oxidation or composition segregation. Especially when the protective atmosphere is poorly controlled, the formation of an oxide layer will reduce the performance of the material and the quality of subsequent processing.

Another significant limitation is that the forging process has poor adaptability to complex geometric shapes. If tungsten alloy blocks need to be made into special-shaped structures or precision components, the difficulty of designing and manufacturing the forging die will increase significantly, and the durability of the die itself will also become a problem, because the high hardness of tungsten alloy places extremely high demands on the die material. Frequent replacement of the die not only increases production costs, but may also lead to a decrease in processing accuracy. Compared with powder metallurgy, the forging process is difficult to achieve precise control of fine structures, especially in applications that require

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high uniformity and micro-density, such as radiation shielding or micro-component manufacturing, the limitations of forging are particularly prominent. In addition, the mechanical stress of the forging process may introduce internal residual stress. If it is not effectively released through subsequent heat treatment, these stresses may cause fatigue failure or micro-crack propagation during long-term use, affecting the durability of the product.

The time and equipment requirements in the operating process also constitute the limitations of the forging process. Forging requires a long preheating and cooling time, a long production cycle, and is not suitable for large-scale rapid production, especially in industrial scenarios that require high output. In addition, forging equipment such as hammer forging machines or die forging machines has high maintenance costs, and the complexity and large-scale design of the equipment increase the difficulty of operation and maintenance. Manufacturers need to weigh these limitations when choosing a forging process. Researchers have conducted in-depth research on these limitations through mechanical property testing, microstructural analysis, and fatigue experiments, and optimized process parameters to reduce defects. However, these limitations make the forging process more suitable for the production of special parts with small batches and high performance requirements, while its application is subject to certain restrictions in standardized or large-scale production.

4.3.5 Applicable Scenarios of Casting Process

Has unique application scenarios in the production of tungsten alloy blocks, especially when rapid prototyping or the manufacture of large and complex components is required. The casting process pours the molten tungsten alloy into a mold and cools and solidifies it, making it suitable for the production of tungsten alloy blocks with complex shapes or large volumes, such as large counterweights or radiation shielding modules. Tungsten itself has an extremely high melting point, making it difficult to process with traditional casting processes. However, by adding low-melting-point elements such as copper or nickel to prepare tungsten-copper or tungsten-nickel-iron alloys, the casting process becomes a viable option. These alloys have a certain fluidity at high temperatures and can form a relatively dense structure after casting. They are particularly suitable for industrial applications that require large sizes or special shapes, such as balance blocks in aerospace or shielding components in the nuclear industry.

Casting is also suitable for applications requiring high production efficiency. Compared to the multi-step process of powder metallurgy, casting achieves initial molding with a single pour, significantly shortening production cycles and making it suitable for urgent needs or mass production. Furthermore, casting can leverage existing mold technology and flexibly adapt to varying design requirements, demonstrating its advantages in prototyping or small-batch trials. In the medical field, tungsten alloy blocks are used to manufacture large radiation protection equipment. Casting can quickly produce preforms that meet specifications, which can then be machined to meet precision requirements. In the industrial sector, casting is also suitable for manufacturing components requiring internal cavities or complex internal structures, such as heat exchangers or specialized tools, demonstrating its flexibility in specialized applications. However, the suitability of a casting process is closely related to its material properties and process control. Hot isostatic pressing (HIP), as a subsequent optimization method, can

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improve shrinkage and porosity defects in castings. Post-processing processes such as heat treatment and surface polishing further enhance product quality. Manufacturers select casting processes based on product size and usage environment. Researchers validate their suitability through solidification simulations, microstructure analysis, and performance testing. The successful application of these scenarios depends on the precise control of mold design and pouring parameters. The casting process makes up for the shortcomings of other forming methods in the production of tungsten alloy blocks in the manufacture of large or complex parts, especially in industrial production that needs to balance efficiency and cost.

4.4 Subsequent processing of tungsten alloy blocks

Subsequent processing of tungsten alloy blocks is an essential stage in the production process, aimed at improving the product's precision, performance, and service life through finishing and surface treatment. Subsequent processing typically includes machining, heat treatment, and surface modification. Machining removes excess material through turning, milling, or grinding, precisely controlling the block's geometry and surface roughness. Heat treatment optimizes the crystal structure, eliminates internal stresses, and enhances mechanical properties through controlled heating and cooling processes. Surface modification improves corrosion and wear resistance through coating or chemical treatment. These processing steps work together to ensure that tungsten alloy blocks meet the high standards required for applications such as radiation protection, counterweights, and structural support, and are widely used in medical devices, industrial components, and scientific research instruments.

Machining is the core link of subsequent processing. The high hardness and high density of tungsten alloys place high demands on cutting tools, and carbide or diamond tools are usually used for processing. The heat treatment process needs to adjust the temperature and time according to the alloy composition, aiming to improve the toughness and fatigue resistance of the material, while surface modification such as electroplating or spraying of anti-corrosion coatings are particularly suitable for humid or chemical environments. As a continuation of the preliminary optimization, the hot isostatic pressing process can provide high-quality blanks for subsequent processing, and the implementation of post-processing technology further refines the product characteristics. Manufacturers formulate processing plans based on application requirements, and researchers verify the processing effects through dimensional accuracy testing, hardness analysis and corrosion experiments. These subsequent processing treatments not only improve the appearance and functionality of tungsten alloy blocks, but also extend their service life in complex environments. Optimizing subsequent processing requires considering material properties and usage scenarios. Heat treatment and surface modification can significantly improve product durability, while machining ensures high precision. Manufacturers prioritize process integration during production, while researchers delve into processing technologies through microstructural observation, performance comparison, and life testing.

4.4.1 Commonly used cutting equipment

Commonly used cutting equipment is a core tool in the subsequent processing of tungsten alloy blocks,

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directly determining processing efficiency and finished product precision. Tungsten alloy's high hardness, high density, and wear resistance place high demands on equipment performance. Commonly used equipment includes CNC lathes, CNC milling machines, and wire-cutting machines. CNC lathes rotate the workpiece and cut with a tool, making them suitable for machining cylindrical or rotary tungsten alloy blocks. They are particularly well-suited for the initial shaping of counterweights and radiation shielding components. CNC milling machines achieve complex surface processing through multi-axis motion and are suitable for tungsten alloy blocks requiring high precision and special-shaped structures, such as aviation parts or medical device components. Wire-cutting machines utilize the principle of electric sparks to cut high-hardness materials, making them particularly suitable for precision machining or complex contours that are difficult to process with traditional cutting tools. These machines are typically equipped with a high-rigidity bed and advanced control systems to ensure stability and reduce vibration during the cutting process.

The selection of equipment also needs to consider its auxiliary functions and durability. Tool systems typically utilize carbide or diamond materials to address the difficulty of cutting tungsten alloys. Cooling systems and chip removal are crucial components of the equipment, effectively reducing cutting heat, removing chips, and preventing surface damage. Hot isostatic pressing, as an initial optimization method, provides a highly dense blank for cutting. Post-processing processes such as surface inspection and finishing rely on the stability of the equipment's performance.

4.4.2 Cutting process parameters

Cutting process parameters are key control factors in the subsequent processing of tungsten alloy blocks, directly affecting processing quality, efficiency, and tool life. Key process parameters include cutting speed, feed rate, and depth of cut. Cutting speed must be adjusted based on the hardness of the tungsten alloy and the tool material. A too high cutting speed can lead to tool overheating and wear, while a too low cutting speed can reduce production efficiency. The feed rate controls the speed of movement between the tool and the workpiece, balancing surface finish and processing time. The depth of cut determines the thickness of material removed in a single pass. Too deep a depth can cause vibration or cracks, while too shallow a depth increases the number of machining passes. The setting of process parameters requires comprehensive consideration of the tungsten alloy's composition, equipment performance, and target accuracy to ensure a stable and efficient cutting process.

The optimization of process parameters needs to be adapted to the material properties and processing environment. The material optimized by the hot isostatic pressing process provides a good foundation for cutting due to its high density. Post-processing processes such as surface polishing and dimensional correction rely on the accuracy of the parameters. Manufacturers adjust parameters according to the processing tasks, and researchers verify the effect of parameters through cutting experiments, temperature monitoring and surface morphology analysis. Cutting speed usually needs to be used in conjunction with coolant to reduce the heat-affected zone; the feed rate needs to be dynamically adjusted according to the tool wear; and the cutting depth needs to be set in combination with the workpiece size and rigidity. Improper parameters may lead to increased surface roughness or tool damage.

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4.4.3 Cutting precision control

Cutting precision control is the core technology in the subsequent processing of tungsten alloy blocks, ensuring that the products meet the design size and surface quality requirements. The high hardness of tungsten alloys poses a challenge to precision control, which is mainly achieved through equipment calibration, process optimization and testing methods. Equipment calibration includes geometric precision adjustment of machine tools and spindle runout correction to eliminate mechanical errors; process optimization involves fine adjustment of cutting parameters and multi-pass processing strategies to reduce cumulative errors; testing methods use three-dimensional coordinate measuring machines or laser scanners to conduct comprehensive inspections of machined parts to detect deviations in a timely manner. Precision control also needs to consider the influence of thermal deformation and cutting forces. The material optimized by the hot isostatic pressing process provides a basis for high-precision processing due to its uniformity.

The implementation of precision control requires a combination of processing conditions and quality standards. The high density achieved through optimized hot isostatic pressing reduces internal defects, while post-processing processes such as fine grinding and surface finishing rely on the stability of precision control. Manufacturers develop control plans based on product tolerance requirements, and researchers verify control effectiveness through error analysis, surface roughness testing, and dimensional deviation measurement. The key to precision control lies in minimizing the effects of thermal expansion and vibration. The use of constant temperature workshops and vibration damping devices can significantly improve processing accuracy. In medical devices, precision control ensures the assembly compatibility of radiation shielding components; in precision manufacturing, it ensures the tolerance requirements of complex structures. Appropriate precision control technology is the foundation for high-value-added applications of tungsten alloy blocks .

4.4.4 Grinding tool selection

The selection of grinding tools is a crucial step in the subsequent processing of tungsten alloy blocks, directly affecting surface quality and subsequent application performance. The high hardness of tungsten alloys requires grinding tools with excellent wear resistance and cutting ability. Commonly used tools include diamond grinding wheels, boron carbide grinding heads , and polishing pastes. Diamond grinding wheels, due to their ultra-high hardness, are suitable for the coarse and semi-fine grinding stages, and can quickly remove the rough surface left by cutting; boron carbide grinding heads are used for fine grinding, providing a smoother transition; and polishing pastes are used in the final polishing stage, in conjunction with soft polishing discs to achieve a mirror effect. The selection of these tools needs to be optimized based on the surface condition of the tungsten alloy, the processing stage, and the target roughness, to ensure a gradual transition from a rough surface to a high finish.

The selection of grinding tools also needs to consider their use conditions and economy. The particle size of the tools gradually increases from coarse to fine, and coolant is used in conjunction with it to reduce grinding heat and surface burns. The material optimized by the hot isostatic pressing process provides a

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stable foundation for grinding due to its density. Post-processing processes such as surface inspection and coating depend on the quality of the tools. Manufacturers select the type of tool according to processing requirements, and researchers verify the effectiveness of the tools through surface roughness measurement, microscopic observation and wear resistance testing. Diamond grinding wheels are suitable for removing large amounts of material, boron carbide grinding heads improve intermediate finish, and polishing paste ensures final accuracy. In the medical field, the selection of grinding tools ensures the biocompatible surface of tungsten alloy blocks; in the industrial field, it meets the requirements of wear-resistant parts. Reasonable tool selection is the key to improving the surface quality of tungsten alloy blocks.

4.4.5 Polishing process standards

Grinding process standards are crucial for the subsequent processing of tungsten alloy blocks, directly determining surface quality, dimensional accuracy, and subsequent application performance. Tungsten alloy's high hardness, high density, and wear resistance place stringent demands on the grinding process. Process standards typically cover surface roughness, removal rate, tool usage specifications, and safe operating procedures. Surface roughness is the primary quality indicator for grinding, typically requiring micron or submicron levels to ensure the performance of tungsten alloy blocks in applications such as radiation protection, counterweights, or precision components. Removal rates are set according to the processing stage, with the rough grinding stage focusing on rapid removal of cutting marks and the fine grinding stage focusing on smooth transitions. Tool usage specifications include grinding wheel grit selection, coolant application, and tool change frequency to avoid overheating or surface damage. Safety operating procedures require operators to wear protective equipment to prevent dust inhalation or mechanical injury. The high density of the material optimized by the hot isostatic pressing process provides a stable foundation for grinding. Post-processing processes such as polishing and inspection rely on the adherence to process standards.

The development of grinding process standards must consider material properties and application requirements. The optimized uniformity of the hot isostatic pressing process reduces local variations in grinding. Subsequent inspection processes, such as surface roughness measurement and microscopic examination, are verified against these standards for quality assurance. Manufacturers develop standards based on product specifications and industry requirements, and researchers refine these standards through grinding trials, surface topography analysis, and wear testing. A larger-grit grinding wheel is typically used during the rough grinding phase, gradually transitioning to finer-grit tools to improve the finish. Coolant not only reduces temperatures but also flushes away chips, preventing surface scratches. Tool replacement should be performed regularly based on wear to maintain consistent machining results. Standards also need to consider environmental factors, such as the impact of workshop humidity on dust control. In the medical field, grinding process standards ensure a biocompatible surface for tungsten alloy blocks; in the industrial field, they meet the requirements for highly wear-resistant components. Strict adherence to process standards is key to improving the surface quality and service life of tungsten alloy blocks, which are widely used in the manufacture of high-performance components under complex working conditions.

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4.4.6 Selection of polishing materials

The selection of polishing materials is a critical step in the subsequent processing of tungsten alloy blocks, directly impacting the final surface finish and durability. The high hardness of tungsten alloys requires polishing materials with excellent cutting ability and wear resistance. Commonly used materials include diamond polishing paste, aluminum oxide polishing powder, and silicon carbide polishing cloth. Diamond polishing paste, due to its ultra-high hardness, is suitable for removing micro-scratches and achieving a mirror finish, making it particularly well-suited for tungsten alloy blocks requiring high precision. Aluminum oxide polishing powder provides a milder abrasive action, suitable for intermediate polishing stages, gradually smoothing the surface. Silicon polishing cloth, combining a flexible substrate and abrasive particles, is suitable for polishing large areas or complex curved surfaces. The selection of these materials must be optimized based on the surface condition of the tungsten alloy, the polishing stage, and the target roughness, ensuring a gradual transition from rough surface to high gloss. The density of the material optimized by the hot isostatic pressing process provides a stable foundation for polishing. Subsequent processes such as surface coating and testing rely on the quality of the material.

The selection of polishing materials requires consideration of their particle size, hardness, and operating conditions. The optimized uniformity achieved through hot isostatic pressing reduces local defects during polishing. Post-processing procedures, such as surface roughness measurement and corrosion resistance testing, are validated based on material properties. Manufacturers select material types based on processing requirements, and researchers optimize material selection through polishing tests, surface topography analysis, and hardness testing. Diamond polishing pastes typically progress from coarse to ultrafine grains to achieve high gloss. Alumina polishing powders require appropriate pressure and rotational speed to avoid over-grinding. Silicon carbide polishing cloths require appropriate flexibility based on curvature. Material selection also requires consideration of coolant use to reduce heat buildup and surface burns. In the medical field, polishing materials must be non-toxic to meet biocompatibility requirements. In the industrial field, wear resistance and cost-effectiveness are important considerations. Proper selection of polishing materials is key to improving the surface quality and application performance of tungsten alloy blocks and is widely used in applications requiring high precision and aesthetics.

4.4.7 Polishing process requirements

Polishing process requirements are technical specifications for the subsequent processing of tungsten alloy blocks, directly determining the surface finish, flatness, and service life. The high hardness of tungsten alloys places high standards on the polishing process, and process requirements generally include surface roughness targets, polishing pressure, rotation speed, and cooling conditions. Surface roughness targets are typically set at the nanometer level or near-mirror finish to meet the stringent requirements of radiation shielding, precision counterweights, or medical components. Polishing pressure must be adjusted based on the material hardness and the properties of the polishing material. Too high a pressure may cause surface damage, while too low a pressure can make it difficult to remove tiny scratches. The rotation speed controls the movement of the polishing disc or workpiece and must

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match the pressure and material particle size to avoid overheating or unevenness. Cooling conditions are achieved using circulating water or special coolants to prevent thermal deformation and surface burns. The high density of the material optimized by the hot isostatic pressing process provides a stable foundation for polishing. Subsequent testing processes such as surface gloss measurement and microscopic inspection are used to verify quality according to requirements.

The optimization of polishing process requirements needs to be combined with material properties and processing objectives. The uniformity of the optimized hot isostatic pressing process reduces local differences in polishing. Subsequent processes such as coating and performance testing rely on the implementation of requirements. Manufacturers formulate requirements based on product applications and industry standards, and researchers optimize the requirements through polishing experiments, surface roughness analysis, and wear resistance testing. The rough polishing stage requires rapid removal of grinding marks, while the fine polishing stage focuses on microscopic flatness. The coordinated control of pressure and speed is key. Too high may cause cracks, while too low will affect efficiency. The use of coolant requires a continuous supply to prevent local overheating. In the medical field, the polishing process requires ensuring that the surface is free of microcracks to meet hygiene standards; in the industrial field, it meets high wear resistance and corrosion resistance requirements. The strict implementation of process requirements is the basis for improving the surface quality and functionality of tungsten alloy blocks, and is widely used in complex application scenarios that require high finish and reliability.

4.4.8 Coating treatment method

Coating treatment is a crucial technique in the subsequent processing of tungsten alloy ingots, aiming to enhance corrosion resistance, wear resistance, and aesthetics by depositing a protective layer on the surface. Tungsten alloy's high hardness and density make it an excellent performer in a variety of environments. However, its surface is susceptible to oxidation and chemical attack, making coating treatment a key method for enhancing its service life. Common methods include electroplating, electroless plating, and physical vapor deposition (PVD). Electroplating deposits a metal layer, such as nickel or chromium, on the surface of tungsten alloy through electrolysis and is widely used to improve corrosion resistance. Electroless plating utilizes a chemical reduction reaction to deposit a metal coating, such as nickel-phosphorus alloy, suitable for uniform coverage of complex shaped components. PVD deposits metals (such as titanium or gold) through vacuum evaporation or sputtering, creating a thin film with high hardness and wear resistance. The choice of these methods must be optimized based on the tungsten alloy's composition, application environment, and performance requirements to ensure a good bond between the coating and the substrate. The high density of the material after hot isostatic pressing (HIP) provides a stable substrate for the coating. Subsequent testing processes, such as adhesion testing and corrosion testing, depend on the quality of the treatment.

The implementation of the coating treatment method requires precise process control. The uniformity of the hot isostatic pressing process after optimization reduces coating defects, and subsequent processes such as surface polishing and coating inspection are adjusted according to the results of the method.

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Manufacturers select the type of coating based on the purpose of the product, and researchers verify the performance of the method through coating thickness measurement, microscopic observation and electrochemical testing. Electroplating requires precise control of current density and electrolyte composition, chemical plating requires a stable reducing agent concentration, and PVD requires optimization of vacuum degree and target material selection. Coating treatment is used in the medical field to improve the biocompatibility of tungsten alloy blocks, such as gold plating on radiation shielding equipment to reduce toxicity; in the industrial field, chromium plating or nickel plating enhances wear resistance and chemical corrosion resistance. These methods have significantly improved the durability of tungsten alloy blocks in complex environments and are widely used in scenarios requiring high protective performance.

4.4.9 Oxidation treatment process

The oxidation treatment process is a surface modification technology used in the subsequent processing of tungsten alloy blocks. It improves high-temperature resistance and corrosion resistance by forming an oxide layer on the surface. Tungsten alloys are prone to oxidation in high-temperature or humid environments. Oxidation treatment forms a dense oxide film, such as tungsten dioxide (WO_2) or tungsten trioxide (WO_3), by controlling the oxidation conditions to protect the substrate. The process generally includes three stages: pretreatment, oxidation treatment, and post-treatment. Pretreatment removes surface impurities through cleaning and degreasing; oxidation treatment is carried out in a high-temperature furnace or through chemical oxidation, controlling the temperature and oxygen concentration to form a uniform oxide layer; post-treatment includes cooling and surface inspection to ensure the stability of the oxide layer. The material optimized by the hot isostatic pressing process provides a high-quality substrate for oxidation treatment due to its density. Subsequent inspection processes such as thickness measurement and heat resistance testing rely on the quality of the process.

The optimization of the oxidation treatment process needs to be combined with material properties and application requirements. The uniformity of the optimized hot isostatic pressing process reduces uneven oxidation, and subsequent processes such as coating repair and performance verification are adjusted according to the process results. Manufacturers set oxidation parameters according to the use environment, and researchers verify the process performance through thermogravimetric analysis, X-ray diffraction and microscopic observation. Pretreatment requires thorough removal of oil and dirt to avoid affecting the adhesion of the oxide layer; the temperature during oxidation treatment needs to be higher than the oxidation starting point of the tungsten alloy but lower than the melting point, and the oxygen concentration needs to be precisely controlled to avoid excessive oxidation; the cooling rate in post-treatment affects the integrity of the oxide layer. Oxidation treatment is used to improve the heat resistance of tungsten alloy blocks in high-temperature industrial applications, such as forming a protective layer on furnace components; in the aviation field, it enhances structural stability in high-temperature environments. This process significantly improves the performance of tungsten alloy blocks under extreme conditions and is widely used in scenarios requiring high temperature resistance and oxidation resistance.

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4.4.10 Other surface treatment methods

Other surface treatment methods are diversified technologies in the subsequent processing of tungsten alloy blocks, aiming to meet specific functional requirements through different methods and expand the application range of tungsten alloys. In addition to coating and oxidation treatment, commonly used methods include spraying, nitriding and laser surface treatment. Spraying deposits ceramic or metal coatings, such as aluminum oxide or tungsten carbide, on the surface of tungsten alloy through plasma spraying or flame spraying to enhance wear resistance and corrosion resistance; nitriding forms a nitride layer by diffusing nitrogen atoms in a high-temperature nitrogen environment to increase surface hardness; laser surface treatment uses a high-energy laser beam to modify the surface structure to improve fatigue resistance and corrosion resistance. The selection of these methods needs to be optimized according to the composition, use environment and performance goals of the tungsten alloy to ensure that the treatment effect matches the characteristics of the substrate. The material optimized by the hot isostatic pressing process provides a stable foundation for these treatments due to its high density. Subsequent testing processes such as hardness testing and durability testing rely on the quality of the treatment.

The implementation of other surface treatment methods requires precise process design. The uniformity of the hot isostatic pressing process after optimization reduces processing defects, and subsequent processes such as surface inspection and functional testing are adjusted according to the effect of the method. Manufacturers select treatment methods based on application requirements, and researchers verify the performance of the methods through surface morphology analysis, hardness measurement and corrosion testing. Spraying requires control of coating thickness and adhesion, nitriding requires optimization of nitriding time and temperature, and laser treatment requires adjustment of laser power and scanning speed. These methods are used in the medical field to improve the biocompatibility of tungsten alloy blocks, such as spraying bioceramic coatings; in the industrial field, nitriding or laser treatment enhances the wear resistance and life of mechanical parts. For example, laser surface treatment can repair microcracks, and spraying can provide a multifunctional protective layer. These surface treatment methods have significantly expanded the application potential of tungsten alloy blocks and are widely used in complex scenarios that require high durability and special functionality.



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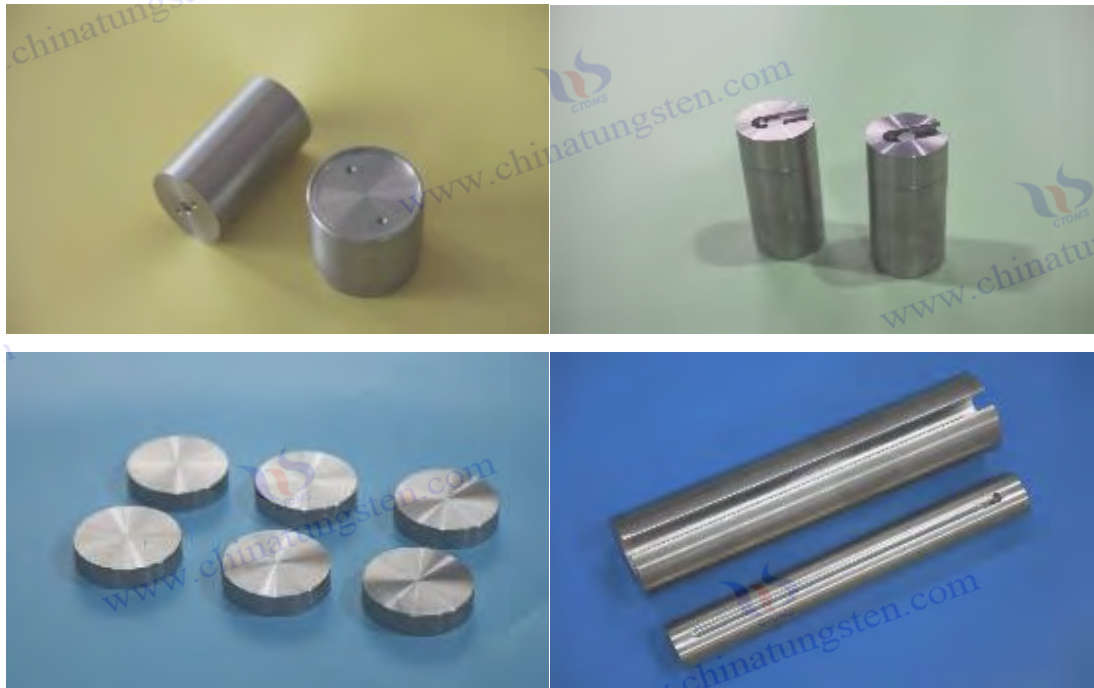
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Chapter 5 Performance Advantages and Testing Standards of Tungsten Alloy Blocks

5.1 Radiation Shielding Performance and Test Methods of Tungsten Alloy Blocks

Tungsten alloy blocks is the core advantage of their application in the medical, nuclear industry and scientific research fields, which stems from their high density and atomic number characteristics. The density of tungsten is much higher than that of traditional shielding materials such as lead. Its alloys further optimize the mechanical properties and processability by adding elements such as nickel, copper or iron, making it an ideal radiation protection material. Radiation shielding performance is not only reflected in the effective absorption of X-rays and gamma rays, but also in stability and durability in complex environments. Preparation processes such as powder metallurgy and hot isostatic pressing ensure the uniformity of the material by precisely controlling the microstructure, thereby improving the shielding effect. Testing methods are the key to evaluating performance, covering a variety of experimental methods to verify the performance of tungsten alloy blocks under different radiation conditions. They are widely used in hospital radiotherapy equipment, nuclear reactor shielding and aerospace fields.

Optimizing radiation shielding performance requires a combination of material properties and application scenarios. The high density achieved through optimized hot isostatic pressing reduces internal porosity, and subsequent processing, such as surface treatment and dimensional correction, further enhances shielding consistency. Manufacturers adjust alloy ratios based on application requirements, and researchers verify their effectiveness through radiation absorption experiments, microscopic analysis, and performance comparisons. This combination of performance and testing methods ensures the reliability and safety of tungsten alloy blocks in high-radiation environments, providing strong support for modern high-tech industries.

5.1.1 Radiation Shielding Principles

Radiation shielding principles are fundamental to understanding the shielding performance of tungsten alloy blocks, stemming from their physical properties and the mechanisms by which they interact with radiation. Tungsten alloy's high density (typically exceeding 17 g/cm^3) enables it to effectively attenuate X-rays and gamma rays, the primary energy form of these radiations being photons. This shielding principle is based on the interaction of photons with matter, encompassing three processes: the photoelectric effect, Compton scattering, and electron pair production. The photoelectric effect dominates low-energy radiation, where tungsten's high atomic number ($Z=74$) increases the probability of photons binding to inner-shell electrons, resulting in energy absorption. Compton scattering occurs in the mid-energy range, where tungsten alloys reduce radiation penetration through multiple scattering. Electron pair production plays a role in high-energy radiation, where tungsten's high density provides sufficient electron density to convert photon energy. The combined effects of these interactions enable tungsten alloys to significantly attenuate radiation intensity.

The realization of the radiation shielding principle also depends on the uniformity and thickness of the

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tungsten alloy. The material optimized by the hot isostatic pressing process ensures consistency in the radiation path due to its density. Subsequent processing processes such as finishing and surface coating further optimize the shielding effect. Manufacturers select alloy thickness based on the type of radiation and energy range. Researchers have conducted in-depth research on the principles through theoretical simulations, radiation attenuation experiments, and X-ray diffraction analysis. In the medical field, tungsten alloy blocks protect patients and medical staff from X-ray damage through shielding principles; in the nuclear industry, their high density effectively blocks gamma rays. The application of these principles makes tungsten alloy blocks a preferred alternative to lead materials. Their efficient shielding capabilities have been fully verified in a variety of high-radiation environments.

5.1.2 Shielding effectiveness evaluation

Shielding effectiveness evaluation is an important step in verifying the radiation shielding performance of tungsten alloy blocks, ensuring that they achieve the expected level of protection in actual applications. Evaluation methods include radiation dose measurement, penetration test and simulation analysis. Radiation dose measurement quantifies the degree of attenuation of radiation intensity after placing a dosimeter or Geiger- Mueller counter; penetration test calculates shielding efficiency by comparing the intensity before and after the radiation source; simulation analysis uses Monte Carlo method or finite element analysis to predict the shielding effect under different thicknesses and compositions. The combined application of these methods can fully reflect the performance of tungsten alloy blocks in X-ray, gamma ray or neutron radiation environments. The material optimized by the hot isostatic pressing process has high density, which reduces the weak points in the shielding. Subsequent inspection processes such as surface defect inspection rely on the evaluation results.

Shielding effectiveness evaluation must be conducted in conjunction with actual usage conditions and testing standards. The optimized uniformity of the hot isostatic pressing process ensures the reliability of the evaluation data, and subsequent processes such as performance verification and quality control are adjusted based on the evaluation results. Manufacturers set evaluation metrics based on industry specifications such as ASTM or ISO standards, and researchers verify the evaluation results through radiation source experiments, dose distribution analysis, and microstructural inspection. In the medical field, shielding effectiveness evaluation ensures the safety of radiotherapy equipment, and shielding efficiency must meet specific attenuation rates to protect the surrounding environment. In the nuclear industry, evaluation results guide the optimization of shielding designs. These evaluation methods provide a scientific basis for the performance optimization of tungsten alloy blocks, and their high shielding effectiveness has been widely recognized in high-radiation scenarios.

5.1.3 Related test standards

Relevant testing standards are crucial for evaluating the radiation shielding performance of tungsten alloy blocks, ensuring they meet safety and performance requirements in various application scenarios. These standards, developed by international and industry organizations, cover radiation attenuation rates, material consistency, and test method specifications. ISO 4037, provided by the International

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Organization for Standardization (ISO), defines X-ray and gamma-ray shielding test methods, specifying requirements for radiation sources, dose rates, and measurement distances. ASTM E746 and E668, both issued by the American Society for Testing and Materials (ASTM), address performance testing of neutron shielding and X-ray shielding materials, respectively, specifying sample preparation and data analysis procedures. Furthermore, IEC 61331, issued by the International Electrotechnical Commission (IEC), focuses on medical radiation protection equipment and details the test conditions and acceptance criteria for tungsten alloy shielding materials. These standards, through standardized testing procedures, ensure that the shielding effectiveness of tungsten alloy blocks meets safety thresholds in both industrial and medical settings.

The implementation of testing standards requires consideration of the actual application and production process of tungsten alloys. The high density achieved through optimized hot isostatic pressing (HIP) provides the foundation for compliance with the standards. Subsequent testing processes, such as surface inspection and performance verification, strictly adhere to the standard requirements. Manufacturers select applicable standards based on the specific application of their products, and researchers verify the applicability of these standards through standard testing experiments, radiation attenuation measurements, and data comparison. In the medical field, relevant testing standards ensure that the shielding efficiency of tungsten alloy blocks in X-ray equipment meets patient and operator safety standards. For example, the attenuation rate must reach a specific percentage to reduce radiation exposure. In the nuclear industry, standards guide the design of the thickness and uniformity of tungsten alloy shielding materials to meet the challenges of high-energy gamma rays. Implementation of the standards also involves controlling environmental conditions, such as the impact of temperature and humidity on test results, requiring laboratory calibration of equipment to ensure accuracy. These testing standards provide scientific support for the performance optimization and quality control of tungsten alloy blocks and are widely used to ensure safety in high-radiation environments.

5.1.4 Type of testing equipment

The type of testing equipment is a key tool for evaluating the radiation shielding performance of tungsten alloy blocks, directly impacting test accuracy and result reliability. Commonly used equipment includes radiation dosimeters, Geiger-Muller counters, scintillation detectors, and X-ray fluorescence spectrometers. Radiation dosimeters quantify the radiation attenuation effect of tungsten alloy blocks by measuring the radiation dose rate and are suitable for both laboratory and field testing. Geiger-Muller counters utilize the principle of gas ionization to detect radiation intensity and are particularly suitable for rapid assessment in low-dose environments. Scintillation detectors convert radiation energy into optical signals using scintillation materials and are suitable for precise measurement of high-energy gamma rays or neutron radiation. X-ray fluorescence spectrometers analyze the fluorescence emission spectrum to verify the compositional uniformity of tungsten alloys and their radiation absorption capacity. The selection of these devices must be optimized based on the radiation type, energy range, and test environment to ensure comprehensive and accurate test data. The high density of the material optimized by the hot isostatic pressing process provides a stable sample for testing. Subsequent processes, such as performance calibration, rely on the quality of the equipment.

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The application of testing equipment types needs to be combined with test standards and actual needs. The uniformity after optimization of the hot isostatic pressing process reduces the deviation in the test, and subsequent processes such as data analysis and report generation are adjusted according to the performance of the equipment. Manufacturers select the type of equipment based on the test objectives, and researchers verify the effectiveness of the equipment through equipment calibration, radiation source experiments and sensitivity tests. In the medical field, testing equipment such as dosimeters and scintillation detectors are used to verify the shielding performance of tungsten alloy blocks in radiotherapy equipment to ensure that the radiation dose is below the safety limit; in the nuclear industry, Geiger-Muller counters and X-ray fluorescence spectrometers are used to evaluate the performance of shielding materials in high-radiation environments. These devices must also be equipped with protective devices and data recording systems to ensure operational safety and traceability of results. The reasonable selection of the type of testing equipment provides technical support for the performance evaluation of tungsten alloy blocks and is widely used in high-precision radiation protection testing.

5.2 Application of Tungsten Alloy Block's Impact Resistance

Tungsten alloy blocks is a significant advantage in dynamic load environments, stemming from their high density and hardness. This impact resistance enables tungsten alloy blocks to withstand mechanical shock, vibration, or sudden loading without breaking or deforming. Toughness and strength are further optimized by adding elements such as nickel, copper, or iron. Preparation processes such as powder metallurgy and hot isostatic pressing enhance the material's impact resistance by controlling the microstructure, enabling it to perform well in high-stress scenarios. Applications are extensive, including counterweight components in aerospace, armor-piercing cores in the military, and seismic structures in industrial equipment. These superior properties not only enhance the reliability and durability of tungsten alloy blocks, but also meet the functional requirements of a variety of harsh working conditions.

The application optimization of impact resistance needs to be combined with material properties and usage environment. The high density after optimization of the hot isostatic pressing process reduces microcracks under impact. Subsequent processing such as surface strengthening and performance testing depends on the stability of performance.

5.2.1 Performance in stress environments

Tungsten alloy blocks in stress environments is the core embodiment of their impact resistance applications, especially in scenarios with high impact forces or repeated loading. The high density of tungsten alloy provides additional inertial mass, enhancing its stability in collisions or vibrations, while added elements such as nickel or iron reduce brittle fractures caused by impact by improving toughness. Stress environments include high-speed rotating parts in aerospace, ballistic impact scenarios in military equipment, and heavy-loaded structures in industrial machinery, all of which place extremely high demands on the impact resistance of materials. Preparation processes such as powder metallurgy ensure the internal consistency of the material by uniformly mixing the powder, and the hot isostatic pressing process further eliminates microscopic defects through omnidirectional pressure, significantly improving

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the impact resistance and enabling the tungsten alloy block to maintain structural integrity under high stress.

Performance in stress-bearing environments also depends on the tungsten alloy's microstructure and processing quality. The high density achieved through optimization of the hot isostatic pressing process reduces stress concentration under impact, while subsequent processing such as heat treatment and surface hardening further enhances performance stability. Manufacturers adjust material thickness and strengthening measures based on specific applications, and researchers verify performance through impact testing, stress distribution analysis, and fracture morphology observation. In the aerospace field, tungsten alloy blocks are used as propeller counterweights or gyroscope components, capable of withstanding the centrifugal force generated by high-speed rotation without deformation. In the military field, their high density and impact resistance make them an ideal material for armor-piercing projectile cores, capable of penetrating armored targets. In the industrial field, tungsten alloy blocks are used as seismic bases or buffers to effectively absorb mechanical vibration and impact energy. These performance characteristics enable them to perform well in high-stress environments and are widely used in scenarios requiring impact resistance and reliability, ensuring the safety and long-term service life of the equipment.

5.2.2 Impact resistance test method

Impact testing methods are an important means of evaluating the impact resistance of tungsten alloy blocks, ensuring their reliability and durability in high-stress environments. Tungsten alloy's high density and optimized additions give it excellent impact resistance. Testing methods must simulate the impact loads experienced in actual use and encompass a variety of experimental techniques. Commonly used methods include the Charpy impact test, the drop-weight impact test, and the high-velocity impact test. The Charpy impact test measures the energy absorbed by a material under a single impact using a cantilever beam or simply supported beam specimen and is suitable for evaluating brittle fracture propensity. The drop-weight impact test simulates dynamic loading by dropping a weight to evaluate the material's deformation and fracture behavior under heavy impact. The high-velocity impact test utilizes a gas gun or projectile device to simulate high-velocity impact and is particularly suitable for military or aviation applications. The combined application of these methods can comprehensively reflect the performance of tungsten alloy blocks under different impact conditions. The high density of the material optimized by the hot isostatic pressing process provides a stable sample for testing. Subsequent processes such as fracture analysis and performance verification rely on the test results.

The implementation of the impact test method needs to be combined with the actual application scenario and test equipment. The uniformity after the hot isostatic pressing process is optimized to reduce the abnormal points in the test, and the subsequent processes such as surface inspection and fatigue analysis are adjusted according to the test data. Manufacturers select test methods based on the use of the product, and researchers verify the effectiveness of the method through experimental design, energy absorption measurement and microstructure observation. In the aerospace field, the drop hammer impact test is used to verify the performance of tungsten alloy blocks in high-speed rotating parts; in the military field, high-

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speed impact tests are used to evaluate the impact resistance of armor-piercing projectile cores; in the industrial field, the Charpy impact test ensures the reliability of seismic structures. The testing process also needs to control environmental conditions, such as the influence of temperature and humidity on impact behavior, and standard samples and calibration equipment need to be used to ensure the repeatability of the results. These test methods provide a scientific basis for the performance optimization of tungsten alloy blocks and are widely used in safety assessments in high-impact load scenarios.

5.2.3 Impact resistance index

Impact resistance is a key parameter for measuring the impact resistance of tungsten alloy blocks , providing a quantitative basis for design and application. Tungsten alloy's high density and the synergistic effect of added elements impart excellent impact resistance. Performance indicators typically include impact absorption energy, fracture toughness, impact strength, and residual deformation. Impact absorption energy reflects a material's ability to absorb and dissipate energy under impact, typically measured via the Charpy test; higher values indicate better impact resistance. Fracture toughness describes a material's resistance to crack propagation, reflecting its potential to resist brittle fracture. Impact strength represents the energy required to fracture per unit area and is suitable for assessing a material's load-bearing capacity under dynamic loading. Residual deformation measures the degree of deformation after impact ; lower values indicate greater elastic recovery and structural stability. A comprehensive assessment of these indicators provides a comprehensive assessment of the performance of tungsten alloy blocks in high-stress environments. The high density of the material after optimization through the hot isostatic pressing process significantly improves these indicators, and subsequent processes such as heat treatment and surface hardening further optimize performance.

Determining impact resistance performance indicators requires a combination of material properties and application requirements. The uniformity achieved through optimized hot isostatic pressing reduces fluctuations in these indicators, and subsequent processes such as fatigue testing and performance calibration are adjusted based on these indicators. Manufacturers set indicator thresholds based on industry standards, and researchers validate these indicators through impact testing, fracture mechanics analysis, and deformation measurements. In aerospace, impact energy absorption and fracture toughness ensure the safety of tungsten alloy blocks in high-speed components. In the military, impact strength and residual deformation are key to evaluating the performance of armor-piercing projectile cores. In industry, these indicators guide the design of seismic-resistant structures. Measurements must also consider the influence of test conditions, such as impact velocity and temperature variations, and standardized testing equipment must be used to ensure data consistency. These performance indicators provide a crucial reference for optimizing the impact resistance of tungsten alloy blocks and are widely used in dynamic loading scenarios requiring high reliability.

5.3 High temperature resistance of tungsten alloy blocks

Tungsten alloy blocks is a significant advantage in extreme thermal environments. This is due to tungsten's high melting point and thermal stability. The addition of elements such as nickel, copper, or

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iron further optimizes the mechanical properties and oxidation resistance at high temperatures. Tungsten's melting point exceeds 3400°C, allowing the alloy to maintain structural integrity at high temperatures, making it suitable for aerospace, the energy industry, and high-temperature processing equipment. Fabrication processes such as powder metallurgy and hot isostatic pressing enhance the material's thermal resistance and creep resistance by controlling the microstructure, leading to its widespread application in gas turbine blades, high-temperature molds, and heat shield components. These superior properties not only enhance the durability of tungsten alloy blocks but also meet the functional requirements of various high-temperature operating conditions, making it an ideal alternative to traditional high-temperature materials.

Optimizing high-temperature resistance requires a combination of material properties and the intended use environment. The high density achieved through optimized hot isostatic pressing reduces microcracking at high temperatures, while subsequent processing, such as surface coating and performance testing, relies on the stability of these properties. Manufacturers adjust alloy ratios based on high-temperature applications, and researchers verify these properties through high-temperature testing, thermal expansion analysis, and microstructural observation. These high-temperature resistance properties ensure the superior performance of tungsten alloy blocks under extreme thermal conditions.

5.3.1 Performance stability test in high temperature environment

Tungsten alloy blocks in high-temperature environments is an important means of evaluating their high-temperature resistance and ensuring their reliability and long-term usability under these conditions. Tungsten alloy's high melting point and the synergistic effect of added elements impart excellent thermal stability. Testing methods must simulate actual high-temperature environments and encompass a variety of experimental techniques. Commonly used methods include high-temperature tensile testing, high-temperature creep testing, and thermal fatigue testing. High-temperature tensile testing applies tensile force at high temperatures to measure the material's strength and plasticity, assessing its deformation resistance. High-temperature creep testing observes the material's slow deformation and fracture tendency at high temperatures under prolonged loading, making it suitable for assessing long-term stability. Thermal fatigue testing involves repeated heating and cooling to measure the material's crack propagation and durability during thermal cycling. The combined application of these methods comprehensively reflects the performance of tungsten alloy blocks in high-temperature environments. The high density of the material after optimization through the hot isostatic pressing process provides a stable sample for testing. Subsequent processes such as heat treatment and surface inspection rely on these test results.

The implementation of performance stability testing needs to be combined with actual application scenarios and test equipment. The uniformity of the optimized hot isostatic pressing process reduces anomalies in the test, and subsequent processes such as high-temperature performance calibration and quality control are adjusted based on the test data. Manufacturers select test methods based on the intended use of the product, and researchers verify the test results through experimental design, stress-strain analysis, and microstructure observation. In the aerospace field, high-temperature tensile tests are

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used to verify the strength of tungsten alloy blocks in gas turbine components; in the energy industry, high-temperature creep tests evaluate the long-term stability of thermal shielding materials; in high-temperature processing equipment, thermal fatigue tests ensure the durability of the mold. The testing process also needs to control environmental conditions, such as the effects of oxygen concentration and heating rate on material behavior, and standard furnaces and calibration equipment need to be used to ensure repeatable results. These test methods provide a scientific basis for optimizing the high-temperature resistance of tungsten alloy blocks and are widely used to ensure safety and performance in extreme thermal environments.

5.3.2 Corresponding industry testing standards

Corresponding industry testing standards are crucial for evaluating the high-temperature resistance of tungsten alloy ingots, ensuring their performance in high-temperature environments meets the safety and reliability requirements of industrial and scientific research. These standards, developed by international and industry organizations, cover test specifications for high-temperature strength, creep properties, and thermal fatigue behavior. The International Organization for Standardization (ISO)'s ISO 6892 standard defines methods for high-temperature tensile testing, specifying requirements for specimen preparation, loading rate, and temperature control, making it suitable for evaluating the mechanical properties of tungsten alloys at high temperatures. The American Society for Testing and Materials (ASTM)'s ASTM E139 standard focuses on high-temperature creep and endurance testing, detailing experimental conditions for long-term loading and temperature gradients. ASTM E606 addresses thermal fatigue performance, specifying test procedures for thermal cycle numbers and stress ranges. Furthermore, the aerospace industry often references SAE AMS 7897, which specifically addresses the performance evaluation of high-temperature alloys, including their use in extreme thermal environments. The harmonization of these standards ensures comparable and consistent test results for tungsten alloy ingots under high-temperature conditions.

The implementation of testing standards must be integrated with the actual applications and production processes of tungsten alloys. The high density achieved through optimized hot isostatic pressing (HIP) provides the foundation for meeting the standards. Subsequent testing processes, such as high-temperature performance verification and microstructural analysis, must strictly adhere to the standards. Manufacturers select applicable standards based on the specific application of their products, and researchers verify the applicability of these standards through standard testing, data comparison, and performance analysis. In the aerospace sector, ISO 6892 and SAE AMS 7897 ensure that the high-temperature strength of tungsten alloy blocks in gas turbine blades meets design requirements. In the energy industry, ASTM E139 guides the creep performance evaluation of heat shield materials for long-term high-temperature exposure. In the field of high-temperature processing equipment, ASTM E606 verifies the thermal fatigue resistance of tungsten alloy molds. Implementation of these standards also involves controlling environmental conditions, such as the impact of furnace atmosphere and temperature uniformity on test results, necessitating the use of calibration equipment and standard samples to ensure accuracy. These industry testing standards provide a scientific framework for optimizing the high-temperature resistance of tungsten alloy blocks and are widely used to ensure performance and quality.

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control in extreme thermal environments.

5.4 Environmental Testing of Tungsten Alloy Blocks

Environmental testing of tungsten alloy ingots is a crucial step in assessing the environmental impact of their production, use, and disposal, reflecting their advantages as a green material. Tungsten itself is a non-toxic metal, and its alloys, through the addition of elements such as nickel, copper, or iron, have lower ecotoxicity and biohazards compared to traditional lead-based materials. Environmental testing focuses primarily on non-toxicity, biodegradability, and recycling potential. Preparation processes such as powder metallurgy and hot isostatic pressing optimize material utilization and reduce waste and pollutant emissions during production. Testing methods cover toxicity testing, leaching experiments, and life cycle assessments, and are widely used in medical devices, industrial components, and consumer products. The implementation of these tests ensures that tungsten alloy ingots comply with modern environmental regulations and sustainable development requirements, making them an ideal alternative to toxic materials.

The optimization of environmental testing needs to be combined with material properties and usage scenarios. The high density after optimization of the hot isostatic pressing process reduces potential sources of pollution, and subsequent processing technologies such as surface treatment and recycling technology further improve environmental performance.

5.4.1 Non-toxicity test method

Non-toxicity testing methods are a core technology for environmentally friendly evaluation of tungsten alloy ingots, used to assess their potential hazards to humans and ecosystems. While tungsten itself is non-toxic, added elements such as nickel may cause allergies or chronic toxicity. Therefore, testing methods must comprehensively analyze the material's safety under various conditions. Commonly used methods include in vitro cytotoxicity testing, animal inhalation testing, and leachate toxicity testing. In vitro cytotoxicity testing assesses direct toxicity by contacting cultured cells with tungsten alloy samples and observing cell survival and metabolic changes. Animal inhalation testing simulates exposure risks during processing or use by exposing experimental animals to dust, monitoring respiratory responses and tissue damage. Leachate toxicity testing assesses environmental impacts under discarded or corrosive conditions by immersing the tungsten alloy in simulated body fluids or water and analyzing the toxicity of the leachate. The combined use of these methods can fully demonstrate the non-toxic nature of tungsten alloy ingots. The low porosity of materials optimized for hot isostatic pressing reduces the release of leachates, and subsequent testing processes such as chemical analysis and biological testing rely on the results of these methods.

The implementation of non-toxic testing methods needs to be combined with actual usage scenarios and regulatory requirements. The uniformity of the optimized hot isostatic pressing process reduces anomalies in the test, and subsequent processes such as surface coating and quality control are adjusted based on the test data. Manufacturers select testing methods based on the intended use of the product,

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and researchers verify the effectiveness of the methods through experimental design, toxicity index measurement, and histopathological analysis. In the medical field, in vitro cytotoxicity tests ensure the biocompatibility of tungsten alloy blocks in radiation shielding equipment in accordance with ISO 10993 standards; in the industrial field, animal inhalation tests evaluate the safety of processing dust; in the environmental protection field, leachate toxicity tests verify the ecological impact of waste materials. The testing process also needs to control experimental conditions, such as immersion time and medium composition, and use calibration equipment and standard samples to ensure the repeatability of the results. These non-toxic testing methods provide technical support for the green certification of tungsten alloy blocks and are widely used in scenarios with high safety requirements.

5.4.2 Non-toxicity testing standards

Non-toxicity testing standards are crucial for environmentally friendly testing of tungsten alloy ingots, ensuring they meet international and industry safety requirements during production and use. These standards, developed by authoritative organizations, cover toxicity thresholds, testing conditions, and certification procedures. The International Organization for Standardization (ISO)'s ISO 10993 series of standards specifies toxicity assessment methods for biocompatibility testing of medical device materials, including cytotoxicity, acute toxicity, and chronic toxicity testing. The U.S. Environmental Protection Agency (EPA)'s TCLP (Toxicity Characteristic Leaching Procedure) standard assesses the leaching toxicity of solid waste and is applicable to determining whether tungsten alloy waste meets environmental safety requirements. The EU's REACH regulations set toxicity limits and registration requirements for chemical substances, including the content control of added elements such as nickel in tungsten alloys. The uniformity of these standards ensures international comparability and legal validity of non-toxicity assessments of tungsten alloy ingots.

The implementation of non-toxicity testing standards requires careful consideration of the actual application and production process of tungsten alloys. The high density achieved through optimized hot isostatic pressing provides the foundation for meeting the standards. Subsequent testing processes, such as toxicity analysis and performance verification, strictly adhere to the standard requirements. Manufacturers select applicable standards based on the intended use of their products, and researchers verify the applicability of these standards through standardized testing, data comparison, and toxicity index analysis. In the medical field, ISO 10993 ensures the non-toxicity of tungsten alloy blocks in radiation shielding equipment, with limits below specific cytotoxicity thresholds. In the industrial sector, the EPA TCLP standard guides the environmentally friendly disposal of processing waste, with leaching concentrations below regulatory limits. In the consumer goods sector, REACH regulations control the content of added elements to prevent long-term exposure risks. Implementation of these standards also involves controlling experimental conditions, such as the impact of test media and exposure time on results, requiring the use of calibration equipment and standard samples to ensure accuracy.

5.4.3 Recyclability evaluation indicators

Recyclability assessment metrics are a crucial component of environmentally friendly testing for

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tungsten alloy ingots. They quantify their potential for post-waste recycling and highlight their advantages as a sustainable material. Tungsten alloy's high density and durability make it highly recyclable, but the recycling process must consider economic viability, environmental impact, and material purity. Commonly used assessment metrics include recovery rate, purity retention rate, energy consumption ratio, and economic efficiency coefficient. The recovery rate measures the proportion of reusable tungsten extracted from waste tungsten alloy ingots, typically determined through metallurgical processes such as chemical leaching or smelting. The purity retention rate assesses the impurity content of the recovered material, reflecting its suitability for reprocessing. The energy consumption ratio compares the energy efficiency of the recycling process with that of primary production, with lower values indicating greater environmental friendliness. The economic efficiency coefficient combines recycling costs and market value to assess the feasibility of recycling. The combined application of these metrics comprehensively reflects the recyclability characteristics of tungsten alloy ingots. The high density of the material after optimized hot isostatic pressing reduces the sources of impurities in recycling. Subsequent processes such as material sorting and reuse rely on these metrics.

The development of recyclability assessment indicators needs to be combined with actual recycling technology and market demand. The uniformity achieved after optimization of the hot isostatic pressing process reduces the complexity of the recycling process, and subsequent processes such as performance testing and quality control are adjusted based on the indicators. Manufacturers optimize production designs based on the recycling process, and researchers verify the effectiveness of the indicators through recycling experiments, component analysis, and life cycle assessment. In the industrial field, the recovery rate and purity retention rate ensure the reuse of tungsten alloy blocks in counterweight components, achieving a recovery rate of 60%-80%. In the medical field, energy consumption ratio and economic benefit coefficient guide the recycling of radiation shielding materials and reduce the environmental footprint of primary production. The assessment process also needs to consider the limitations of recycling technology, such as the discharge of waste liquid from chemical treatment. Environmentally friendly processes and standard equipment must be used to ensure the feasibility of the results. These recyclability assessment indicators provide a scientific basis for the circular economy of tungsten alloy blocks and are widely used in resource-saving and environmentally friendly industries.

5.5 China Tungsten Alloy Block Standard

China's tungsten alloy block standards are important specifications guiding domestic production and application, reflecting the country's unique needs for resource conservation and industrial development. As the world's leading producer of tungsten resources, China has established numerous standards to regulate the production, performance, and application of tungsten alloys. National standard GB/T 26091-2010, "Tungsten-Based High-Density Alloys," specifies the chemical composition, density range (17-18.5 g/cm³), and mechanical properties, such as tensile strength and hardness, of tungsten alloys suitable for counterweights and shielding components. YB/T 5327-2016, "Tungsten Alloy Plates, Rods, and Wires," details processing dimensions and surface quality requirements, making it suitable for precision manufacturing. Furthermore, industry standards such as YS/T 811-2012, "Technical Conditions for Recycling of Tungsten Alloy Scrap," regulate the recycling process to ensure resource recycling. These

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standards were developed in response to the actual conditions of China's tungsten ore resources, emphasizing the requirements for high density and purity. The material optimized through the hot isostatic pressing process, due to its density, meets the high-performance requirements of the standards.

Chinese tungsten alloy block standards requires careful consideration of production processes and application scenarios. The optimized uniformity achieved through hot isostatic pressing ensures standard consistency, while subsequent testing processes, such as composition analysis and performance testing, strictly adhere to standard requirements. Manufacturers implement the standards based on national policies and market demand, while researchers optimize the standards through standard testing, microstructure analysis, and performance verification. In the field of radiation protection, the GB/T 26091-2010 standard ensures the shielding effectiveness of tungsten alloy blocks; in the aerospace sector, the YB/T 5327-2016 standard guides the production of high-precision components. Implementation of the standards also involves resource management, such as government quota restrictions on tungsten ore mining, which require the use of calibration equipment and standard samples to ensure compliance. These Chinese tungsten alloy block standards provide technical support for domestic industries and are widely used in high-tech and defense sectors.

5.6 International Tungsten Alloy Block Standards

International tungsten alloy ingot standards serve as a crucial reference for global coordination of production and application, ensuring consistency in international trade and multinational projects. These standards, developed by organizations such as the International Organization for Standardization (ISO) and the American Society for Testing and Materials (ASTM), cover performance testing and quality control. The ISO 9001 quality management system standard provides a common quality assurance framework for tungsten alloy production, emphasizing process control and product consistency. The ASTM B777-15 standard specifies density grades (grades 1-4, 17.0-18.5 g/cm³), tensile strength, and elongation for tungsten-based high-density alloys suitable for radiation shielding and counterweight applications. The ASTM E8/E8M standard defines tensile test methods for evaluating the mechanical properties of tungsten alloys. The international recognition of these standards ensures competitiveness and interoperability of tungsten alloy ingots in the global market. The high density of the material optimized by the hot isostatic pressing process meets the high-performance requirements of the standards.

International tungsten alloy block standards needs to be combined with global technology and market demands. The uniformity achieved after optimization of the hot isostatic pressing process reduces standard deviation, and subsequent testing processes such as performance verification and quality certification are adjusted according to the standards. Manufacturers implement standards according to international trade requirements, and researchers verify the applicability of standards through standard tests, data comparison, and performance analysis. In the medical field, the ASTM B777-15 standard ensures the shielding performance of tungsten alloy blocks in radiotherapy equipment; in the industrial field, the ISO 9001 standard guides the standardization of production processes. The implementation of standards also involves cross-border regulatory coordination, such as the EU REACH regulation's restrictions on added elements, which require the use of calibration equipment and standard samples to

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ensure compliance . These international tungsten alloy block standards provide a technical framework for the global industry and are widely used in high-demand and high-value scenarios.

5.7 Tungsten Alloy Block Standards in Europe, America, Japan, South Korea and Other Countries

Block standards in Europe, the United States, Japan, and South Korea reflect their leading position in advanced technologies and industrial applications, covering performance testing, quality control, and environmental protection requirements. The US ASTM B777-15 standard, mentioned earlier, covers the mechanical properties of high-strength alloys, suitable for the use of tungsten alloys in structural components. Japan's JIS H 4651 standard specifies the dimensional tolerances and surface quality of tungsten alloy bars and plates, emphasizing precision machining. South Korea's KS D 3620 standard focuses on the density and hardness of tungsten alloys, suitable for the electronics and aviation fields. The differences in these standards reflect the industrial characteristics and market demands of each country. Materials optimized through the hot isostatic pressing process, due to their high density, meet the high performance requirements of these standards.

These national tungsten alloy block standards requires integration with local technologies and application scenarios. The optimized uniformity achieved through the hot isostatic pressing process ensures standard consistency, while subsequent testing processes, such as performance testing and environmental assessments, are adjusted to the standard requirements. Manufacturers implement the standards based on national regulations and market demands, and researchers verify their applicability through standard testing, microanalysis, and performance comparisons. In the United States, ASTM B777-15 guides the use of tungsten alloys in military and medical applications; in Europe, EN 10025 ensures the durability of structural components; in Japan, JIS H 4651 supports the production of precision electronic components; and in South Korea, KS D 3620 promotes the development of aviation counterweight components. Implementation of the standards also addresses environmental regulations, such as the EU RoHS Directive's restrictions on toxic elements, requiring the use of calibration equipment and standard samples to ensure compliance . These tungsten alloy block standards provide technical support for advanced industries in Europe, the United States, Japan, and South Korea, and are widely used in high-tech and international cooperation projects.



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Chapter 6 Application Fields of Tungsten Alloy Blocks

6.1 Application of Tungsten Alloy Blocks in Medical Field

Tungsten alloy ingots are widely used in the medical field due to their excellent radiation shielding properties, high density, and biocompatibility. They are widely used in radiation protection and precision medical device manufacturing. Tungsten's high atomic number and density enable it to effectively absorb X-rays and gamma rays, making it an ideal alternative to traditional lead. Tungsten alloys further enhance mechanical strength and processability through the addition of elements such as nickel, copper, or iron. Fabrication processes such as powder metallurgy and hot isostatic pressing ensure material uniformity and density, meeting the high precision and reliability requirements of medical devices. Applications include radiotherapy equipment, diagnostic imaging systems, and nuclear medicine devices, where tungsten alloy ingots are used as shielding, counterweights, and collimators, significantly enhancing device safety and therapeutic effectiveness. In radiotherapy equipment, tungsten alloy shielding precisely controls radiation beams and protects healthy tissue from damage; in diagnostic imaging, its high density enhances image quality; and in nuclear medicine, it supports the handling and storage of radioisotopes. This wide range of applications demonstrates the critical role of tungsten alloy ingots in the medical field, providing enhanced safety for patients and medical staff. Optimizing the application of tungsten alloy blocks in the medical field requires integrating equipment design with clinical needs. The high density achieved through optimized hot isostatic pressing reduces the risk of radiation leakage, while subsequent processing techniques such as surface polishing and non-toxic treatment further enhance biocompatibility. Manufacturers adjust alloy ratios based on medical standards, and researchers validate application effectiveness through radiation absorption experiments, biocompatibility testing, and clinical simulations. These applications provide solid support for the development of modern medical technology, playing a particularly important role in improving tumor treatment and diagnostic accuracy.

6.1.1 Application of shielding blocks in radiotherapy equipment

The use of tungsten alloy shielding blocks in radiotherapy equipment is a significant advancement in the medical field. Their primary function is to precisely control the direction of the radiation beam and protect the patient's healthy tissue from unnecessary radiation damage. Tungsten alloy's high density (typically exceeding 17 g/cm³) and high atomic number effectively attenuate X-rays and gamma rays, making it an ideal shielding material for radiotherapy equipment. Shielding blocks are typically designed with adjustable or custom shapes and installed in linear accelerators or cobalt-60 therapy machines. Adjustments are made to the shape based on tumor location and size, ensuring that the radiation dose is concentrated in the target area. Manufacturing processes such as powder metallurgy, which uniformly blends tungsten powder with other metal powders, and hot isostatic pressing, which uses omnidirectional pressure to optimize the microstructure and reduce internal defects, ultimately enhancing the performance and durability of the shielding blocks. The use of these shielding blocks significantly improves the precision and safety of radiotherapy and is widely used in cancer treatment, such as irradiating tumors in the head, chest, and pelvis.

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Shielding block applications requires integrating radiotherapy equipment design with clinical needs. The high density of the material optimized through hot isostatic pressing reduces radiation penetration, while subsequent processing, such as surface finishing and non-toxic coatings, ensures compliance with medical hygiene standards. Manufacturers customize shielding blocks based on equipment specifications, and researchers validate their effectiveness through radiation dose measurements, microstructural analysis, and clinical feedback. During radiotherapy, the placement and adjustability of shielding blocks are critical, requiring integration with the treatment planning system (TPS) to ensure accurate radiation field delivery. These applications provide a highly effective protective mechanism in tumor treatment, significantly reducing the risk of side effects.

6.1.1.1 Shielding Block Installation Location in the Linear Accelerator

The installation position of the shield block in the linear accelerator is a key deployment point of the tungsten alloy block in the application of radiotherapy equipment, which directly affects the control accuracy of the radiation beam and the treatment effect. The linear accelerator is a device that uses high-energy electrons to generate X-rays or electron beams. It is widely used in cancer radiotherapy. Its shield block is usually installed in the collimator (multileaf) inside the treatment head (gantry head). The MLC is a system consisting of multiple movable tungsten alloy blades with shielding blocks mounted between the blades or at their edges to finely adjust the shape of the radiation field and precisely focus on the tumor area. The installation position must ensure that the shielding block is aligned with the path of the electron beam or X-ray beam, located between the beam exit and the patient. The specific position is determined by the treatment planning system and dynamically adjusted based on the geometry of the tumor and the sensitivity of adjacent tissues. Tungsten alloy blocks optimized by the hot isostatic pressing process are suitable for withstanding high radiation and mechanical movement in the MLC due to their high density and uniformity.

The optimization of the shielding block installation position needs to be combined with the structure of the linear accelerator and the treatment requirements. The material optimized by the hot isostatic pressing process reduces radiation leakage, and subsequent processing processes such as precision machining and surface polishing ensure the installation accuracy. Manufacturers customize the installation plan according to the equipment design, and researchers optimize the position selection through radiation dose distribution testing, mechanical durability analysis and clinical verification. In the treatment head, the shielding block is usually installed close to the beam exit and at a certain distance from the patient to avoid the influence of scattered radiation; the blades in the MLC maintain the stability of the shielding block during dynamic adjustment. The reasonable arrangement of these positions ensures the efficiency and safety of the linear accelerator in radiotherapy. It is widely used in the treatment of head tumors, lung cancer, prostate cancer, etc., significantly improving the accuracy of treatment and patient survival rate.

6.1.1.2 The effect of shielding blocks on gamma knife radiation

The radiation confinement effect of the gamma knife shield is a prime example of the use of tungsten alloy in medical radiotherapy equipment. Its core function is to precisely focus the radiation beam for

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tumor treatment while maximally sparing surrounding healthy tissue. The gamma knife is a stereotactic radiotherapy device that utilizes a cobalt-60 source to generate high-energy gamma rays. The tungsten alloy shield, a key component, is installed within the collimator or collimator system within the treatment head. The shield's high density (typically exceeding 17 g/cm^3) and high atomic number (tungsten has a Z of 74) enable it to effectively absorb and confine gamma rays, preventing them from spreading to non-target areas. This confinement is primarily achieved through a multi-porous or multi-leaf design. The shield adjusts its shape and position according to instructions from the treatment planning system (TPS), focusing multiple gamma beams at the center of the tumor and maximizing dose concentration. Manufacturing processes such as powder metallurgy, which uniformly mixes tungsten powder with elements such as nickel and copper, and hot isostatic pressing, optimize the microstructure to ensure the shield's high density and durability, meeting the high precision and long-term performance requirements of the gamma knife.

Optimizing the radiation confinement effect of the shielding block requires combining the radiation characteristics of the gamma knife with clinical needs. The material optimized by the hot isostatic pressing process reduces gamma ray penetration due to its low porosity, and subsequent processing such as surface finishing and non-toxic treatment improves biosafety. Manufacturers customize shielding blocks based on equipment design, and researchers verify the confinement effect through radiation dose distribution testing, microstructure analysis, and clinical simulation. In gamma knife treatment, the shielding block is usually installed near the beam exit, and multiple shielding blocks work together to form a three-dimensional radiation field. The confinement effect ensures that the radiation dose in the target area is increased to several times that of normal tissue, while the dose in non-target areas is significantly reduced. This precise confinement is particularly important in the treatment of brain tumors, cerebral vascular malformations, and functional diseases. It effectively reduces surgical risks and side effects, and improves the treatment effect and quality of life of patients.

6.1.1.3 Protection range of shielding blocks in proton therapy equipment

The protective coverage of tungsten alloy shielding in proton therapy equipment embodies the application of advanced radiotherapy techniques. Its function is to protect the patient and the surrounding environment by limiting proton beam scatter and secondary radiation. Proton therapy utilizes high-energy proton beams to precisely deposit energy at the tumor site in the form of the Bragg peak. Tungsten alloy shielding serves as an auxiliary protective component, installed near the collimator or scatterer of the treatment head. The shielding's high density and excellent radiation absorption capacity enable it to effectively shield the proton beam from scattered particles and secondary X-rays/gamma rays, extending beyond the treatment head, adjacent tissues, and exposed areas of the operator. Manufacturing processes such as powder metallurgy, which uniformly mixes tungsten powder with additives, and hot isostatic pressing optimize the microstructure, ensuring the shielding's stability under high-energy proton beam conditions and minimizing the impact of internal defects on its effectiveness. These properties make tungsten alloy shielding an indispensable protective element in proton therapy equipment.

The optimization of the shielding block's protection range requires a combination of the proton therapy's

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beam characteristics and equipment design. The high density achieved through optimization of the hot isostatic pressing process reduces radiation leakage, while subsequent processing techniques such as precision machining and surface coating improve protection consistency. Manufacturers customize shielding blocks based on proton energy and treatment plans, and researchers verify the protection range through proton beam distribution testing, dose measurement, and radiation protection assessment. In proton therapy, the shielding block's protection range typically includes the outer shell of the treatment head, non-target areas of the patient's body, and barriers in the control room. Especially when treating head or spinal tumors, the shielding block needs to precisely limit scattered radiation to protect the brain or spinal cord. The rational design of the protection range significantly reduces the potential damage to patients from secondary radiation, and demonstrates unique advantages in the treatment of pediatric tumors, reducing the risk of long-term radiation exposure. These applications provide strong support for the safety and effectiveness of proton therapy.

6.1.2 Usage scenarios of other medical radiation protection components

Other use cases for medical radiation protection components demonstrate the diverse applications of tungsten alloy blocks in radiation protection, encompassing areas such as diagnostic imaging, nuclear medicine, and radioactive material handling. Due to its high density and excellent shielding properties, tungsten alloy is manufactured into a variety of components, including X-ray shields, CT scanner collimators, nuclear medicine isotope storage containers, and protective walls. These components play unique roles in different scenarios. X-ray shields, installed around X-ray machines or dental equipment, absorb scattered radiation to protect medical personnel. CT scanner collimators adjust the X-ray beam width to optimize imaging quality and reduce patient exposure. Nuclear medicine isotope storage containers utilize the high shielding capabilities of tungsten alloy to safely store and transport radioactive isotopes. Protective walls serve as permanent shielding structures in radiology or nuclear medicine laboratories, preventing radiation transmission. Manufacturing processes such as powder metallurgy ensure material consistency through uniform mixing, while hot isostatic pressing optimizes the microstructure, enhancing component durability and protective performance.

The optimization of the use scenarios of these medical radiation protection components requires a combination of equipment characteristics and clinical needs. The materials optimized by the hot isostatic pressing process reduce radiation leakage due to their high density, and subsequent processing such as surface polishing and non-toxic treatment meet medical and health standards. Manufacturers customize components based on equipment design and radiation type, and researchers verify the use scenarios through radiation dose measurement, biocompatibility testing, and clinical feedback. In diagnostic imaging, X-ray shields and collimators improve the operational safety of imaging equipment, especially protecting medical staff during chest and abdominal scans; in nuclear medicine, isotope storage containers ensure the safe transportation of radioactive iodine-131 or technical technetium-99m to prevent environmental contamination; in laboratories, protective walls provide researchers with a stable working environment. These use scenarios demonstrate the diversity and reliability of tungsten alloy blocks in medical radiation protection and are widely used in scenarios that improve medical safety and efficiency.

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6.2 Application of Tungsten Alloy Blocks in Industry

Tungsten alloy ingots are widely used in manufacturing, energy, and heavy machinery due to their high density, high hardness, and excellent radiation shielding and impact resistance. Tungsten's high atomic number and density enable it to effectively absorb X-rays, gamma rays, and neutron radiation, making it an ideal material for industrial flaw detection equipment, counterweight systems, and wear-resistant components. The alloy's mechanical strength and processability are optimized by adding elements such as nickel, copper, or iron. Preparation processes such as powder metallurgy and hot isostatic pressing ensure the material's uniformity and density, meeting the high-performance and reliability demands of industrial equipment. Applications include radiation protection for flaw detection equipment, counterweights for mechanical equipment, mold manufacturing, and high-temperature components. The shielding properties of tungsten alloy ingots significantly improve equipment safety and detection accuracy; counterweights enhance mechanical stability; and wear-resistant components extend equipment life. The diversity of these applications demonstrates the critical role of tungsten alloy ingots in the industrial sector.

Tungsten alloy blocks in the industrial sector requires integrating equipment design and production requirements. The high density achieved through optimized hot isostatic pressing reduces the risk of radiation leakage and wear, while subsequent processing techniques such as surface hardening and precision machining further enhance performance. Manufacturers adjust alloy ratios according to industry standards, and researchers verify the effectiveness of applications through radiation absorption experiments, mechanical property testing, and durability analysis. These applications provide solid technical support for industrial production, playing a particularly important role in non-destructive testing and heavy machinery.

6.2.1 Application of NDT Equipment Shielding

Tungsten alloy shielding is a key industrial application for flaw detection equipment. Its primary function is to protect operators and the surrounding environment from X-ray, gamma-ray, or neutron radiation. Tungsten alloy's high density (typically exceeding 17 g/cm^3) and high shielding capacity make it an ideal shielding material for flaw detection in metal castings, welds, and pipelines. Shielding components, including protective walls, collimators, and mobile shielding devices, are installed in X-ray, gamma-ray, and industrial CT equipment, designed based on the radiation type and detection requirements. Manufacturing processes such as powder metallurgy, which uniformly blends tungsten powder with other metal powders, and hot isostatic pressing (HIP), optimize the microstructure and ensure the density and consistency of the shielding material. These shielding applications significantly improve the operational safety of flaw detection equipment and are widely used in the aerospace, petrochemical, and power industries, ensuring efficient and reliable inspection processes.

Optimizing the application of NDT equipment shielding requires a combination of radiation characteristics and equipment layout. The low porosity of materials optimized through the hot isostatic pressing process reduces radiation penetration, while subsequent processing, such as surface coating and

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dimensional correction, enhances shielding effectiveness. Manufacturers customize shielding components based on NDT equipment specifications, and researchers validate their effectiveness through radiation dose measurements, shielding efficiency testing, and environmental simulations. These applications provide robust radiation protection in industrial inspections, ensuring operator safety and efficient equipment operation.

6.2.1.1 Shielding Design of Tungsten Alloy in X-ray Flaw Detectors

The shielding design of tungsten alloy in X-ray flaw detectors is at the core of the application of tungsten alloy blocks in industrial flaw detection equipment. It aims to effectively limit X-ray scatter and protect operators and the environment. X-ray flaw detectors use high-energy X-rays to detect internal defects in metals. Tungsten alloy, due to its high density and atomic number ($Z=74$), significantly attenuates X-ray energy, making it a mainstream choice for shielding materials. Shielding designs typically include a collimator, a protective cover, and a movable shielding plate. The collimator is installed at the exit of the X-ray source to limit beam spread; the protective cover surrounds the X-ray tube to absorb scattered radiation; and the movable shielding plate provides temporary protection in the operating area. Preparation processes such as powder metallurgy ensure material consistency through uniform mixing, while hot isostatic pressing optimizes the microstructure, reduces internal defects, and improves shielding efficiency. The combined application of these designs ensures the safe operation of X-ray flaw detectors.

Optimizing shielding design requires a combination of X-ray energy and equipment structure. The high density achieved through optimized hot isostatic pressing reduces radiation leakage, while subsequent processing techniques such as precision machining and surface hardening enhance design accuracy. Manufacturers customize designs based on the inspection object and radiation intensity, and researchers optimize designs through X-ray dose distribution testing, shielding thickness analysis, and durability verification. In the aviation industry, tungsten alloy shielding is designed to inspect aircraft wing welds, with collimators ensuring beam focus. In the petrochemical industry, protective covers protect pipeline inspectors from radiation hazards. These designs provide efficient radiation protection in industrial inspections and are widely used in scenarios requiring high precision and safety.

6.2.1.2 Tungsten alloy protective structures for gamma-ray flaw detection equipment

Tungsten alloy protective structures for gamma-ray inspection equipment are another key application in industrial flaw detection, designed to meet the need for protection against highly penetrating gamma rays. Gamma-ray inspection equipment utilizes radioactive isotopes such as cobalt-60 or iridium-192 to detect thick-walled castings or deep flaws. Tungsten alloy's high density and excellent gamma-ray absorption make it an ideal protective material. Protective structures typically include fixed shielding walls, portable shielding containers, and operator shields. Fixed shielding walls are installed around the inspection room to absorb environmental radiation; portable shielding containers are used to transport and store radioactive sources; and operator shields provide temporary protection during on-site operations. Preparation processes such as powder metallurgy optimize material properties through uniform mixing,

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and hot isostatic pressing enhances microscopic density, ensuring the reliability of protective structures. The use of these structures significantly reduces the radiation risk of gamma-ray inspection.

Optimizing protective structures requires considering gamma ray energy and usage scenarios. Materials optimized through hot isostatic pressing (HIP) reduce radiation penetration due to their high density, while subsequent processing, such as surface coating and dimensional correction, enhances protective effectiveness. Manufacturers customize structures based on the characteristics of the inspection equipment and radiation source. Researchers verify the effectiveness of these structures through gamma ray dose measurements, shielding thickness analysis, and environmental simulations. In the power industry, fixed shielding walls are used for pipeline inspections in nuclear power plants to protect workers. In the construction industry, portable shielding containers ensure the safe transportation of radioactive sources. These protective structures provide highly effective radiation protection in industrial NDT and are widely used in scenarios requiring high safety and portability.

6.2.1.3 Layout of shielding components in industrial CT equipment

The layout of shielding components in industrial CT equipment is a key application of tungsten alloy blocks in advanced nondestructive testing, designed to optimize X-ray or gamma-ray imaging quality and protect the operating environment. Industrial CT equipment generates three-dimensional images through X-ray or gamma-ray scanning and is used to detect internal defects in complex components. Tungsten alloy shielding is a key component due to its high density and shielding capabilities. The layout typically includes a beam collimator, a detector shield, and equipment housing shielding. The beam collimator is installed in front of the X-ray source to limit scattering and improve imaging resolution; the detector shield surrounds the detector, absorbing scattered radiation to reduce noise; and the equipment housing shield covers the entire CT system to prevent radiation leakage into the operating area. Preparation processes such as powder metallurgy ensure material consistency through uniform mixing, and hot isostatic pressing optimizes the microstructure, improving the density and durability of the shielding components. The optimization of shielding layout needs to be combined with the imaging requirements and radiation characteristics of the CT equipment. The high density achieved through optimization of the hot isostatic pressing process reduces radiation scattering, and subsequent processing such as precision machining and surface treatment improves layout accuracy. Manufacturers customize layout solutions based on the specifications of the CT equipment and the inspection object, and researchers verify the layout effects through X-ray distribution testing, imaging quality analysis, and radiation protection assessments. In the automotive industry, beam collimators are used to detect microcracks in engine components; in the electronics industry, detector shields improve the clarity of chip inspection; and equipment housing shielding protects operators in factory environments. These layout methods provide efficient radiation management and imaging support in industrial CT and are widely used in inspection scenarios requiring high precision and safety.

6.2.2 Design and installation of heavy machinery counterweights

The design and installation of tungsten alloy counterweights for heavy machinery are crucial components

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of their industrial applications, aiming to optimize the stability and operational performance of machinery through precise mass distribution. Tungsten alloy's high density (typically exceeding 17 g/cm^3) enables sufficient counterweight mass within confined spaces, enhancing the balance and vibration resistance of equipment. The design and installation process involves customizing the shape and size, selecting the material, and determining the installation location. These counterweights are widely used in construction machinery, automobiles, and machine tools. Manufacturing processes such as powder metallurgy, which uniformly mixes tungsten powder with elements such as nickel, copper, or iron, and hot isostatic pressing (HIP), which optimizes the microstructure, ensure the density and durability of the counterweights. The use of these counterweights significantly improves the operating efficiency and safety of heavy machinery, particularly in high-load and dynamic environments. Optimizing counterweight design and installation requires careful consideration of the machine's structure and intended use. The high density achieved through HIP reduces mass distribution errors, while subsequent processing techniques such as surface polishing and precision machining enhance installation accuracy.

6.2.2.1 Design of the shape and size of counterweights for construction machinery

The shape and size design of counterweights for construction machinery is crucial for ensuring stable operation of equipment such as excavators, bulldozers, and cranes. Tungsten alloy's high density makes it an ideal counterweight material. Shapes typically include rectangular, cylindrical, or complex geometries. Rectangular shapes are suitable for mounting on the underside of a machine body, providing low center of gravity stability; cylindrical shapes are used for rotating components, such as crane booms, to reduce wind resistance; and complex geometries are customized to the equipment structure to optimize space utilization. Dimensional design is determined by the mechanical load and balance requirements. The length, width, and thickness ratios typically range from 1:1:0.5 to 2:1:1, ensuring uniform mass distribution. Weights range from tens to hundreds of kilograms. Manufacturing processes such as powder metallurgy optimize material distribution through uniform mixing, while hot isostatic pressing (HIP) enhances microdensity, reduces internal defects, and improves design accuracy. Optimizing shape and size requires considering the mechanical motion and load characteristics. The high density of the material optimized by HIP reduces quality variation. Subsequent processing, such as precision machining and surface treatment, enhances design consistency.

6.2.2.2 Application Advantages of Tungsten Alloy Blocks in Automobile Counterweights

The application advantages of tungsten alloy blocks in automotive counterweights lie in their high density and excellent performance, which significantly improve the vehicle's handling and safety. The high density of tungsten alloy enables it to provide high quality in a small volume, making it suitable for tire counterweights, transmission system balance, and body stabilizers, with weights typically ranging from a few grams to several hundred grams. Application advantages include precise weight control. Tungsten alloy blocks achieve minute mass adjustments through precision machining, optimizing tire dynamic balance; excellent corrosion resistance, not easy to rust in humid or salty environments, extending service life; high impact resistance, maintaining structural integrity during high-speed driving or collisions, and enhancing safety. Preparation processes such as powder metallurgy ensure material

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consistency through uniform mixing, and hot isostatic pressing processes optimize microstructures, improving durability and performance stability. Optimization of application advantages needs to be combined with automotive design and usage environment. The material optimized by hot isostatic pressing reduces quality fluctuations due to its high density, and subsequent processing processes such as surface coating and finishing improve corrosion resistance.

6.2.2.3 Installation location and fixing method of machine tool balance weight

The installation location and fixing method of machine tool balance weights are key to ensuring machining accuracy and equipment stability. The high density of tungsten alloy makes it an ideal balancing material. The installation location is usually selected near the machine tool spindle, slide, or worktable, and is determined based on the center of mass offset of the moving parts. Positions close to the spindle reduce rotational inertia imbalance; positions near the slide balance lateral loads; and worktables optimize overall stability. Fixing methods include bolting, welding, and embedded installation. Bolt connections are suitable for removable adjustment, welding provides permanent fixation, and embedded installation achieves seamless integration through reserved slots. Preparation processes such as powder metallurgy optimize material distribution through uniform mixing, and hot isostatic pressing processes improve micro-density to ensure the vibration resistance and durability of the counterweights. The optimization of the installation location and fixing method needs to be combined with the machine tool structure and processing requirements. The material optimized by hot isostatic pressing reduces the impact of vibration due to its high density. Subsequent processing processes such as surface hardening and installation correction improve the fixing effect.

6.3 Application of Tungsten Alloy in Nuclear Industry

Tungsten alloys are widely used in nuclear reactors, radioactive waste management, and nuclear fuel processing due to their excellent radiation shielding properties, high density, and high-temperature resistance. Tungsten's high atomic number ($Z=74$) and density (typically exceeding 17 g/cm^3) enable it to effectively absorb gamma rays and neutron radiation, making it an ideal replacement for lead and concrete. The addition of elements such as nickel, copper, or iron optimizes mechanical strength and processability. Fabrication processes such as powder metallurgy and hot isostatic pressing ensure uniformity and density, meeting the nuclear industry's requirements for high reliability and long life. Applications include reactor perimeter shielding, radioisotope storage vessels, and nuclear waste disposal equipment. Tungsten alloy shielding significantly reduces the risk of radiation leakage, protecting workers and the environment; storage vessels ensure the stable transportation of radioactive materials; and waste disposal equipment supports nuclear recycling. These diverse applications demonstrate the critical role of tungsten alloys in the nuclear industry, promoting improvements in nuclear energy safety and sustainability.

Tungsten alloys in the nuclear industry requires integrating nuclear reactor design with radiation protection requirements. The high density achieved through optimized hot isostatic pressing reduces radiation penetration, while subsequent processing techniques such as surface coating and precision

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machining further enhance performance. Manufacturers adjust alloy ratios according to nuclear industry standards, and researchers verify the effectiveness of these applications through radiation dose measurements, thermal stability testing, and microstructural analysis. These applications provide technical support for safe operation and environmental protection in the nuclear industry, particularly in high-radiation and high-temperature environments.

6.3.1 Arrangement of reactor perimeter shielding

The layout of reactor perimeter shielding is a core component of tungsten alloy applications in the nuclear industry, designed to effectively block gamma-ray and neutron radiation, protecting the reactor interior and external environment. Nuclear reactors generate high-energy radiation during operation, and tungsten alloy, due to its high density and excellent shielding capabilities, has become a mainstream choice for shielding materials. Typical layouts include multi-layer shielding structures, modular shielding units, and dynamically adjustable shielding systems. The multi-layer shielding structure, composed of tungsten alloy plates and composite materials, is installed between the reactor pressure vessel's outer layer and the biological shielding layer to absorb primary radiation. The modular shielding unit utilizes prefabricated tungsten alloy blocks for easy installation and replacement, making it suitable for reactor maintenance. The dynamically adjustable shielding system uses movable tungsten alloy shielding blocks to optimize protection in real time based on radiation distribution. Manufacturing processes such as powder metallurgy ensure uniform material consistency through uniform mixing, and hot isostatic pressing optimizes the microstructure, enhancing the density and durability of the shielding components. These layouts significantly improve nuclear reactor safety and are widely used in nuclear power plants and research reactors.

The optimization of shielding layout needs to be combined with the reactor's operating conditions and radiation characteristics. The material optimized by the hot isostatic pressing process has low porosity, which reduces radiation leakage. Subsequent processing such as surface hardening and dimensional correction improves the layout effect. Manufacturers customize shielding solutions based on the reactor design, and researchers optimize the layout through radiation dose distribution testing, shielding efficiency analysis, and thermal cycle verification. In nuclear power plants, multi-layer shielding structures protect operators from radiation hazards; in research reactors, modular units support experimental flexibility; and dynamic adjustment systems provide additional protection in high-radiation areas. These layouts provide efficient radiation protection in the nuclear industry and ensure the safety of long-term operation.

6.3.1.1 Arrangement of tungsten alloy shielding components on the outer layer of the reactor pressure vessel

The arrangement of tungsten alloy shielding on the outer layer of the reactor pressure vessel is a key part of the shielding layout around the nuclear reactor, designed to provide primary protection against gamma rays and neutron radiation. The pressure vessel is the core component of the nuclear reactor. The high temperature and high pressure environment inside it generates a large amount of radiation. Tungsten

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alloy shielding is installed between the outer wall of the pressure vessel and the biological shielding layer due to its high density and radiation resistance. The arrangement usually adopts multi-layer superposition or annular distribution. The multi-layer superposition absorbs radiation layer by layer through tungsten alloy plates of different thicknesses, gradually attenuating the energy; the annular distribution is arranged around the circumference of the pressure vessel to ensure all-round shielding. Preparation processes such as powder metallurgy optimize material properties through uniform mixing, and the hot isostatic pressing process improves micro-density, reduces internal defects, and improves shielding efficiency. These arrangements ensure the radiation protection effect of the outer layer of the pressure vessel, and are particularly suitable for high temperature and high pressure environments.

Optimizing shielding arrangement requires considering the pressure vessel structure and radiation distribution. The high density achieved through optimized hot isostatic pressing reduces radiation penetration, while subsequent processing techniques such as surface coating and precision assembly enhance arrangement stability. Manufacturers customize the arrangement based on reactor type and radiation intensity, and researchers verify the effectiveness of the arrangement through gamma-ray dose measurements, thermal expansion analysis, and microstructural inspection. In pressurized water reactors, a multi-layer stacked arrangement effectively shields the reactor core from radiation; in fast breeder reactors, a ring-shaped arrangement optimizes neutron shielding. These arrangements provide highly effective primary protection in the nuclear industry, significantly reducing the risk of radiation leakage and ensuring the safe operation of nuclear power plants.

6.3.1.2 Shielding block installation for nuclear reactor auxiliary equipment

The installation of shielding blocks for auxiliary equipment of nuclear reactors is a supplementary link in the application of tungsten alloys in the nuclear industry, aimed at protecting auxiliary systems related to reactor operation from radiation. Auxiliary equipment includes cooling systems, control rod drive mechanisms, and monitoring instruments. These components work near the reactor and face the threat of secondary radiation and scattered radiation. Due to their high density and excellent shielding performance, tungsten alloy shielding blocks are installed around auxiliary equipment or at pipeline connections. The installation methods include local shielding covers, pipeline shielding sections, and equipment casing reinforcement. Local shielding covers cover sensitive components such as sensors and electronic components to absorb direct radiation; pipeline shielding sections surround cooling water pipes to prevent radiation diffusion caused by leakage of radioactive materials; equipment casing reinforcement enhances overall protection through tungsten alloy plates. Preparation processes such as powder metallurgy ensure material consistency through uniform mixing, and hot isostatic pressing optimizes the microstructure to improve the reliability and durability of shielding blocks.

The optimization of shielding block settings requires a combination of auxiliary equipment functions and radiation characteristics. The material optimized by the hot isostatic pressing process reduces radiation penetration due to its high density, and subsequent processing such as surface hardening and installation correction improves the setting effect. Manufacturers customize shielding blocks based on equipment layout and radiation distribution, and researchers verify the setting effect through radiation dose

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measurements, thermal stability tests, and environmental simulations. In nuclear power plants, local shielding covers protect the electronic components of the control rod drive mechanism from the effects of gamma rays; in research reactors, pipe shielding sections ensure the safe operation of the cooling system; and equipment casing reinforcement provides comprehensive protection in high-radiation areas. These settings provide efficient auxiliary equipment protection in the nuclear industry and significantly reduce the threat of radiation to system stability.

6.4 Application of Tungsten Alloy Blocks in Aerospace

Tungsten alloy ingots are widely used in the aerospace industry due to their high density, excellent impact resistance, and high-temperature resistance. They are widely used in the manufacture of spacecraft, aircraft, and rockets. Tungsten's high density (typically exceeding 17 g/cm³) makes it an ideal counterweight material, providing sufficient mass within confined spaces. Its high hardness and toughness ensure reliability in high-stress environments, while its high-temperature resistance supports operation under extreme thermal conditions. Preparation processes such as powder metallurgy, which uniformly mixes tungsten powder with elements such as nickel, copper, or iron, and hot isostatic pressing optimize the microstructure, ensuring the material's density and consistency, meeting the high precision and long life requirements of aerospace. Applications include spacecraft counterweights, aircraft balance blocks, rocket thruster components, and thermal protection structures. The counterweight function of tungsten alloy ingots enhances flight stability, while its thermal protection properties support the challenges of re-entry. The diversity of these applications demonstrates the critical role of tungsten alloy ingots in the aerospace industry, driving the advancement of aerospace technology and ensuring safety.

Tungsten alloy ingots for aerospace applications requires consideration of both aircraft design and operating environments. The high density achieved through optimized hot isostatic pressing reduces material defects, while subsequent processing techniques such as surface polishing and precision machining further enhance performance. Manufacturers adjust alloy ratios to aerospace standards, and researchers validate the application results through mechanical property testing, thermal stability analysis, and simulations. These applications provide technical support for the aerospace industry, particularly under high-precision control and extreme conditions.

6.4.1 Spacecraft Counterweight Control

Spacecraft counterweight control is a core aspect of tungsten alloy applications in the aerospace industry, aiming to optimize a spacecraft's attitude, trajectory, and stability through precise mass distribution. Spacecraft require precise center of mass control during launch, orbital operation, and mission execution. Tungsten alloy's high density enables high mass in a compact package, making it a preferred counterweight material. Counterweights are typically installed in key locations on satellites, probes, or space stations, achieving dynamic balance through position and mass adjustment. Fabrication processes such as powder metallurgy ensure material consistency through uniform mixing, while hot isostatic pressing optimizes the microstructure, enhancing the counterweight's impact resistance and durability. These counterweight control applications significantly improve spacecraft navigation accuracy and

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mission success rates, and are widely used in communications satellites, probes, and space stations. Counterweight control optimization must be integrated with spacecraft design and mission requirements. The high density of the material optimized by hot isostatic pressing reduces mass distribution errors, while subsequent processing techniques such as precision machining and surface treatment improve installation accuracy.

6.4.1.1 Satellite Attitude Control Weight Standards

The standard for satellite attitude control weights is an important specification for ensuring the stable operation of spacecraft in orbit, reflecting the high-precision requirements of tungsten alloy blocks in satellite applications. The high density and impact resistance of tungsten alloy make it an ideal material for attitude control weights. The standard generally covers mass accuracy, dimensional tolerance, material uniformity, and installation reliability. Mass accuracy requires that the actual mass of the weight deviate from the design value within a small range (usually less than 0.1%) to ensure the accuracy of attitude adjustment; dimensional tolerances must be controlled below the millimeter level to accommodate the compact interior space of the satellite; material uniformity is optimized through hot isostatic pressing to ensure that there are no pores or cracks inside; and installation reliability requires that the weight be firmly connected to the satellite structure to withstand launch vibrations and the impact of the space environment. Preparation processes such as powder metallurgy optimize material properties through uniform mixing, and hot isostatic pressing improves micro-density to meet the strict requirements of the standard.

The development of standards requires a careful consideration of satellite design and orbital requirements. The high density achieved through optimized hot isostatic pressing reduces quality deviations, while subsequent processing, such as surface polishing and non-destructive testing, ensures compliance with standards. Manufacturers produce counterweights according to aerospace standards (such as NASA or ESA specifications), and researchers verify the effectiveness of these standards through mass measurement, vibration testing, and microstructural analysis. In communications satellites, counterweight standards ensure antenna pointing accuracy; in Earth observation satellites, they support attitude stabilization to improve imaging quality. These standards provide technical support within the aerospace industry and are widely used in satellite missions requiring high-precision attitude control.

6.4.1.2 Stability requirements for counterweights during spacecraft launch

The stability requirements of counterweights during the launch phase of a spacecraft are a key factor in ensuring the reliability of the rocket and payload under high acceleration and vibration conditions. The high density and impact resistance of tungsten alloy make it the preferred material for counterweights during the launch phase. Stability requirements generally include vibration resistance, impact strength, and mass distribution uniformity. Vibration resistance requires the counterweight to withstand the ultra-high frequency vibrations during rocket launch without displacement or fracture; impact strength requires the material to maintain structural integrity under sudden loads during the separation phase; and mass distribution uniformity ensures the stability of the rocket's center of mass and reduces the risk of yaw by

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precisely placing the counterweights. Preparation processes such as powder metallurgy optimize material properties through uniform mixing, and hot isostatic pressing processes enhance micro-density, reduce internal defects, and improve stability. The application of these requirements ensures the success rate of the launch phase and is widely used in launch vehicles and satellite launches.

Optimizing stability requires a combination of launch conditions and structural design. The high density of materials optimized through hot isostatic pressing reduces vibration damage, while subsequent processing techniques such as surface hardening and installation correction enhance stability. Manufacturers customize counterweights based on launch missions, and researchers verify stability requirements through vibration testing, impact testing, and dynamic simulations. In launch vehicles, counterweight stability ensures precise payload separation; in satellite launches, uniformity supports orbital injection accuracy. These requirements provide critical support in the aerospace industry and are widely used in launch scenarios with high dynamic loads.

6.4.1.3 Application of tungsten alloy blocks in space station counterweights

The use of tungsten alloy blocks in space station counterweights is an important guarantee for stability in long-term space missions, reflecting its unique value in microgravity environments. Space stations such as the International Space Station (ISS) need to maintain a balanced attitude and mass distribution during orbital operation. The high density of tungsten alloy enables it to provide precise mass adjustment in a limited space, making it an ideal material for counterweight blocks. Application scenarios include counterweight adjustment at module connections, balancing solar panel drive systems, and center of mass correction for internal equipment installations. Tungsten alloy blocks are precisely machined and installed at key locations on the space station to offset center of mass shifts caused by equipment movement or fuel consumption. Preparation processes such as powder metallurgy ensure material consistency through uniform mixing, and hot isostatic pressing optimizes the microstructure, improving the radiation resistance and durability of counterweight blocks to meet the demanding requirements of the space environment.

Application optimization needs to be combined with space station design and mission requirements. The material optimized by hot isostatic pressing process has high density, which reduces mass distribution error. Subsequent processing technologies such as surface coating and non-destructive testing improve space adaptability.

6.4.2 Application environment of high temperature resistant structural parts

High-temperature structural components are a key application area for tungsten alloy ingots in the aerospace industry. Due to their exceptional high-temperature resistance and thermal stability, they are widely used in high-temperature environments such as rockets, spacecraft, and probes. Tungsten's high melting point (over 3400°C) enables the alloy to maintain structural integrity under extreme thermal conditions. Mechanical strength and oxidation resistance are optimized through the addition of elements such as nickel, copper, or iron. Manufacturing processes such as powder metallurgy ensure material

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consistency through uniform mixing, while hot isostatic pressing optimizes the microstructure, enhancing the density and durability of high-temperature components. Applications include rocket engine nozzles, spacecraft re-entry, and the high-temperature interiors of space probes. Tungsten alloy ingots are capable of withstanding high-temperature shock, thermal cycling, and oxidative corrosion, significantly improving equipment safety and mission success. The diversity of these environments underscores the critical role of tungsten alloy ingots in aerospace, supporting the entire process from launch to deep space exploration. The application optimization of high-temperature resistant structural parts needs to be combined with the high-temperature environment and task requirements. The high density after optimization of the hot isostatic pressing process reduces thermal damage, and subsequent processing technologies such as surface coating and heat treatment further enhance the high-temperature resistance.

6.4.2.1 Tungsten alloy high temperature resistant blocks near rocket engine nozzles

Tungsten alloy high-temperature resistant blocks near rocket engine nozzles are a key application for high-temperature resistant structural components in the aerospace industry, designed to withstand the high temperatures and high-speed airflow within the nozzle. Rocket engine nozzles operate between the combustion chamber and the external atmosphere, with internal temperatures reaching over 2500°C. The high-speed jet flow generates intense thermal shock and mechanical stress. Tungsten alloy's high melting point and thermal creep resistance make it an ideal material for high-temperature resistant blocks, installed near the nozzle throat or expansion section to protect against high-temperature oxidation and thermal fatigue. Preparation processes such as powder metallurgy optimize material properties through uniform mixing, and hot isostatic pressing (HIP) enhances microdensity, reduces thermal cracking, and improves the reliability and life of high-temperature resistant blocks. The application of these high-temperature resistant blocks ensures the stable operation of rocket engines and is widely used in launch vehicles and space probes.

The application optimization of high-temperature resistant blocks requires consideration of nozzle design and combustion conditions. The high density of the material optimized by the hot isostatic pressing process reduces heat penetration, while subsequent processing techniques such as surface antioxidant coatings and precision machining enhance high-temperature resistance. Manufacturers customize high-temperature resistant blocks based on engine type, and researchers verify their application effectiveness through high-temperature tensile testing, thermal fatigue testing, and microstructural analysis. In liquid rocket engines, high-temperature resistant blocks protect the nozzle throat from high-temperature erosion; in solid rocket engines, they support the stable discharge of high-temperature airflow. These applications provide critical support in the aerospace industry, significantly improving the reliability of rocket engines and the success rate of missions.

6.4.2.2 High-temperature protective blocks for spacecraft re-entry into the atmosphere

High-temperature shields for spacecraft re-entry are a key example of tungsten alloy's high-temperature resistance in the aerospace industry. Designed to withstand the extreme thermal environment of

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atmospheric re-entry, these shields are designed to withstand the extreme heat of re-entry. As spacecraft re-enter the Earth's atmosphere, they travel at speeds several times the speed of sound, generating intense friction with air molecules and generating temperatures exceeding 2000°C. This requires high-temperature-resistant materials to protect critical components. Tungsten alloy's high melting point and thermal stability make them an ideal material for shields. Installed in a spacecraft's thermal protection system (TPS), such as the leading edge of a wing or the underside of a cabin, they absorb and dissipate heat to prevent structural melting or deformation. Manufacturing processes such as powder metallurgy ensure material consistency through uniform mixing, and hot isostatic pressing optimizes the microstructure, enhancing the shields' thermal shock resistance and durability to meet the stringent requirements of re-entry missions. The use of these shields significantly improves spacecraft re-entry safety and is widely used in manned spacecraft and recoverable satellites.

The application optimization of high-temperature resistant protective blocks requires a consideration of the reentry trajectory and heat flux distribution. The high density of the material optimized by the hot isostatic pressing process reduces heat conduction damage, while subsequent processing techniques such as ceramic coating and surface finishing enhance the protective effect. Manufacturers customize the protective blocks based on reentry conditions, and researchers verify the application effects through thermal simulation tests, heat flux measurements, and microstructural observations. In the space shuttle, the protective blocks protect the leading edge of the wing from high-temperature erosion; in returning probes, they ensure the integrity of the cabin to protect the payload. These applications provide critical support to the aerospace industry, significantly improving the success rate and safety of reentry missions.

6.4.2.3 High-temperature resistant structural components in space probes

High-temperature resistant structural components in space probes are a key example of tungsten alloys' high-temperature applications in deep space missions. They are designed to withstand the extreme thermal environments encountered during planetary landings or close approaches to stars. Space probes face the challenges of high thermal radiation and surface temperatures (reaching over 500°C) when approaching the Sun or landing on hot planets such as Mars and Venus. Tungsten alloy's high melting point and oxidation resistance make it an ideal material for high-temperature structural components. These components are installed in probe heat shields, lander bases, or sensor covers to protect against thermal radiation and mechanical stress. Fabrication processes such as powder metallurgy optimize material properties through uniform mixing, while hot isostatic pressing (HIP) enhances microdensity, reduces thermal cracking, and improves the reliability and lifespan of structural components. The use of these high-temperature resistant components ensures the mission success rate of probes and is widely used in solar and planetary exploration missions.

The application optimization of high-temperature resistant structural components requires consideration of the exploration mission and thermal environment. The high density of materials optimized through hot isostatic pressing reduces thermal damage, while subsequent processing techniques such as heat-resistant coatings and precision assembly enhance their effectiveness. Manufacturers customize structural components based on the mission's orbit, and researchers verify their effectiveness through

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high-temperature radiation testing, thermal expansion analysis, and microstructural inspection. In solar probes, high-temperature resistant components protect sensors from solar radiation; in Mars rovers, the bottom components of the lander resist landing heat flux. These applications provide critical support to the aerospace industry, significantly improving the reliability and data acquisition capabilities of deep space missions.

6.5 Application of Tungsten Alloy Blocks in Military Field

Tungsten alloy ingots are widely used in weapon systems, armor protection, and military equipment manufacturing due to their high density, excellent impact resistance, and penetrating properties. Tungsten's high density (typically exceeding 17 g/cm³) makes it an ideal material for armor-piercing projectile cores and anti-tank weapons. Its high hardness and toughness are further optimized by the addition of elements such as nickel, iron, or copper. Preparation processes such as powder metallurgy and hot isostatic pressing ensure the material's uniformity and density, meeting military requirements for high performance and reliability. Applications include armor-piercing projectile cores, tank armor, artillery counterweights, and missile stabilizers. The penetrating properties of tungsten alloy ingots significantly enhance weapon lethality; armor enhances defensive capabilities; and counterweights and stabilizers optimize firing accuracy. This diverse range of applications demonstrates the critical role of tungsten alloy ingots in the military, supporting the development of modern defense technology and improving combat effectiveness. Tungsten alloy ingots for military applications requires integrating weapon design and operational requirements. The high density achieved through optimized hot isostatic pressing reduces material defects, while subsequent processing techniques such as surface hardening and precision machining further enhance performance. Manufacturers adjust alloy ratios to military standards, and researchers validate the application through penetration testing, mechanical property analysis, and battlefield simulations. These applications provide technical support for military equipment, particularly in high-intensity conflict and protective environments.

6.5.1 Performance requirements for armor-piercing projectile cores

The performance requirements of armor-piercing projectile cores are central to the military's application of tungsten alloy blocks, ensuring their reliability during high-speed impacts and target penetration. Tungsten alloy's high density and hardness make it a preferred material for armor-piercing projectile cores. Performance requirements typically include high hardness, high density, excellent deformation resistance, and good ballistic stability. High hardness ensures the core's ability to penetrate armored steel or composite materials; high density provides additional kinetic energy, increasing penetration depth; deformation resistance maintains the core's shape under high-speed impacts, preventing fracture; and ballistic stability is achieved through precise length-to-diameter ratios and material uniformity, minimizing deflection during flight. Manufacturing processes such as powder metallurgy optimize material properties through uniform mixing, while hot isostatic pressing (HIP) enhances microdensity, reduces internal defects, and improves core reliability and penetration. The combined application of these performance requirements significantly enhances the combat effectiveness of armor-piercing projectiles, making them widely used in anti-tank weapons and armored vehicle defense.

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The optimization of performance requirements needs to be combined with the target characteristics and weapon system design. The material optimized by the hot isostatic pressing process has high density, which reduces impact damage. Subsequent processing processes such as surface polishing and heat treatment improve performance consistency.

6.5.1.1 Hardness requirements for tungsten alloy blocks in armor-piercing projectile cores

The hardness requirement of the tungsten alloy core in armor-piercing projectiles is a key performance indicator for ensuring armor penetration, directly impacting the weapon's lethality. Tungsten alloy's high hardness stems from its crystal structure and the strengthening effects of added elements. Hardness requirements typically reach Rockwell C (HRC) 40-50 or higher, depending on the target armor material and thickness. This high hardness ensures the core can penetrate or penetrate steel, ceramic armor, or composite materials without significant deformation or cracking during high-speed impacts (typically exceeding 1200 m/s). Manufacturing processes such as powder metallurgy optimize hardness by uniformly mixing tungsten powder with elements such as nickel and iron. Hot isostatic pressing (HIP) enhances microdensity, reduces grain boundary defects, and improves hardness consistency. Achieving these hardness requirements enables the core to withstand extremely high stresses, significantly enhancing armor-piercing capability. Optimizing hardness requires a combination of target resistance and core design. The high density of the HIP-optimized material reduces hardness gradients. Subsequent processing, such as heat treatment and case hardening, further enhances hardness. Manufacturers set hardness standards based on the target armor type, and researchers validate the effectiveness of these requirements through Rockwell hardness testing, microstructural analysis, and armor-piercing simulations. In anti-tank missiles, hardness requirements ensure the core can penetrate heavy armor; in armor-piercing artillery shells, they ensure rapid penetration of light vehicles. These hardness requirements provide technical support in the military and are widely used in weapon systems requiring high penetration.

6.5.1.2 Design of the length-to-diameter ratio of the armor-piercing projectile core

The length-to-diameter ratio of an armor-piercing projectile core is a crucial parameter for optimizing ballistic stability and penetration performance, directly impacting the weapon's combat effectiveness. Tungsten alloy's high density and uniformity make it suitable for precise ratio design. The length-to-diameter ratio (L/D) typically ranges from 5:1 to 10:1, depending on the weapon type and target characteristics. A higher L/D ratio (e.g., 8:1 or above) enhances core penetration depth and is suitable for heavy armor. A moderate L/D ratio (e.g., 5:1 to 6:1) balances stability and muzzle velocity, making it suitable for light or medium targets. Ratio design reduces air resistance through a streamlined shape, while hot isostatic pressing (HIP) optimizes the microstructure and ensures material stability during high-speed rotation. Manufacturing processes such as powder metallurgy optimize material distribution through uniform mixing, while HIP enhances density and reduces internal stresses, enhancing the feasibility of ratio design.

Optimizing proportional design requires a combination of ballistics and target resistance. The material

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optimized by the hot isostatic pressing process reduces proportional imbalance due to its high density. Subsequent processing processes such as precision machining and balancing correction improve design accuracy.

6.5.1.3 Tungsten Alloy Composition for Projectile Cores for Different Targets

Tungsten alloy composition for projectile cores tailored to specific targets is a key strategy for optimizing armor-piercing projectile performance, aiming to tailor material properties to specific armor materials and operational requirements. The composition of a tungsten alloy typically consists of tungsten content and additives (such as nickel, iron, and copper), with the specific choice determined by the target's hardness, shear resistance, and thickness. For use against steel armor, high-density alloys (such as W-Ni-Fe) with a 90%-95% tungsten content are preferred, combining the toughness of nickel and iron to enhance penetration. For use against ceramic or composite armor, W-Ni-Cu alloys with an 85%-90% tungsten content are more suitable, as the ductility of copper helps absorb impact energy. For use against lightweight targets or multi-layer armor, mixed alloys (such as W-Ni-Fe-Cu) with an 80%-85% tungsten content provide a balance of hardness and toughness. Manufacturing processes such as powder metallurgy optimize component distribution through precise mixing, and hot isostatic pressing (HIP) enhances microscopic uniformity to ensure the effectiveness of the selected composition. Optimizing composition selection requires a balance between target characteristics and armor-piercing requirements. The high density of materials optimized through hot isostatic pressing reduces component segregation, while subsequent processing steps such as heat treatment and surface hardening enhance performance consistency. Manufacturers customize alloy ratios based on target type, and researchers verify the effectiveness of these selections through armor-piercing tests, composition analysis, and microstructural observations. In anti-tank weapons, W-Ni-Fe alloys excel against steel armor; in anti-drone systems, W-Ni-Cu alloys are well-suited for composite targets. These composition selections provide technical support in the military and are widely used in weapon designs targeting various threats.



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Appendix:

Tungsten Alloy Block Terminology

the term	Definition/Explanation	Related fields/applications
Tungsten Alloy	Tungsten is a material mainly composed of tungsten alloyed with nickel, iron, copper and other elements, and has high density and high hardness.	Materials science, radiation shielding, military equipment
High density	Tungsten alloys typically have a density exceeding 17 g/cm ³ , much higher than traditional materials such as lead, making them suitable for use in counterweights and shielding.	Aerospace, industrial counterweights, nuclear industry
Powder Metallurgy	tungsten alloy blocks by mixing tungsten powder with other metal powders, pressing and sintering .	Material preparation, precision parts manufacturing
Hot isostatic pressing	The tungsten alloy is omnidirectionally compressed under high temperature and high pressure to optimize the microstructure, reduce porosity and improve density.	Preparation process and performance improvement
Radiation shielding	Tungsten alloy uses its high atomic number (Z=74) to absorb X-rays, gamma rays, and neutron radiation, protecting personnel and equipment.	Medical radiotherapy, nuclear industry, flaw detection equipment
Impact resistance	Tungsten alloy maintains structural integrity under high-speed impact or vibration conditions and is suitable for dynamic loading environments.	Military armor-piercing projectiles, aerospace counterweights
High temperature resistance	tungsten alloy (>3400°C) makes it stable in extreme thermal environments and suitable for high-temperature structural parts.	Rocket engines, spacecraft reentry
Penetration	tungsten alloy core to penetrate armored targets at high speeds depends on its high density and hardness.	Military armor-piercing projectiles, anti-tank weapons
collimator	tungsten alloy are used to limit the direction of radiation beams and improve the accuracy of radiotherapy or flaw detection.	Medical radiotherapy, industrial CT, nuclear medicine
counterweight	Tungsten alloy blocks are used to adjust the center of mass and balance of machinery or spacecraft, enhancing stability and control accuracy.	Engineering machinery, spacecraft, machine tools

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Thermal protection system	Tungsten alloy is used in protective structures of spacecraft when they re-enter the atmosphere to resist high temperatures and thermal shock.	Spacecraft re-entry, space exploration
fracture toughness	tungsten alloy before crack propagation reflects its resistance to brittle fracture.	Military projectile cores, aerospace structural parts
Biocompatibility	Tungsten alloy is non-toxic to the human body after processing in medical applications and meets the requirements of radiation protection equipment.	Medical radiotherapy, imaging diagnosis
Recyclability	Tungsten alloy can be reused through metallurgical processes, reducing resource waste and meeting environmental protection requirements.	Industrial production, nuclear waste management
heat fatigue	Tungsten alloy is durable in repeated heating and cooling and is suitable for high temperature cycle environments.	Rocket nozzles, spacecraft thermal protection



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