

Iron Castings Engineering Handbook



Contents

Chapter 1

Economic Considerations and Procurement 1

I. INTRODUCTION	1
A. Types of Foundries	1
B. Advancing Technology (new chemically based systems, labor-saving machines, metallurgical methods, success of high-alloy irons, inspection techniques)	2
II. FUNCTIONAL CONSIDERATIONS	2
A. Rapid Transition into a Finished Product	3
B. Suiting Shape and Size to Function	3
C. Placing Metal for Maximum Efficiency	4
D. Optimizing Appearance for Maximum Sales Appeal	4
E. Producing a Complex Part as an Integral Unit	5
F. Improved Dependability	5
III. ECONOMIC CONSIDERATIONS	6
A. Production Savings (assembly, material handling & fabrication, production scheduling, inventory investment, space savings)	6
B. Machining Savings	7
C. Weight Savings	7
D. Engineering Time Savings	8
E. Savings in Dies, Jigs and Fixtures	8
F. Indirect or Overhead Savings	9
IV. THE SIX BASIC TYPES OF CAST IRON	9
A. Gray Iron	9
B. Malleable Iron (ferritic, pearlitic)	10
C. Ductile Iron (ferritic, pearlitic, heat-treated)	10
D. White Iron	11
E. Alloyed Iron	11
F. Compacted Graphite Iron	12
V. DESIGN ADVANTAGES OF CASTINGS	12
A. Low Unit Cost	12
B. High Fluidity, Low Shrinkage, Design Freedom	12
C. Wide Choice of Properties	13
VI. PURCHASING FACTORS AND COST CONSIDERATIONS	14
A. Factors Directly Affecting Casting Cost (casting design, type of metal, quality requirements, pattern equipment, postcasting operations, technical services, order quantity, type of price quotation)	14
B. Factors Indirectly Affecting Casting Cost (added costs of substandard quality, poor service & off-schedule delivery)	16
C. Dimensional Allowances and Tolerances (shrinkage, draft, machining, distortion, tolerances)	17
D. Cast Surface Finish	20
E. Engineering and Purchasing Requirements	20
F. Standard Specifications	20

Chapter 2

The Iron Casting Process 21

I. INTRODUCTION	21
II. MOLDING/CASTING PROCESSES	22
A. Sand Molding/Casting Processes (green, chemically bonded)	22
B. Permanent Mold Processes (permanent mold, centrifugal, diecasting, continuous)	23
C. Special Molding/Casting Processes (shell, vacuum, ceramic, expendable)	25
III. COREMAKING PROCESSES	28
A. Oil Sand Core Process	28
B. Shell Core Process	28
C. Hotbox Core Process	28
D. Coldbox Core Process	29
E. Self-Curing Core Process	29
IV. THE MELTING PROCESS	29
V. POURING AND SHAKEOUT	29
VI. THE CLEANING PROCESS	30
VII. SELECTING PATTERN EQUIPMENT	30
A. Types of Patterns (loose, matchplate, cope-and-drag, insert, other)	31
B. Coremaking Equipment	33
C. Pattern Rigging, Maintenance and Storage	33

Chapter 3

Specifications, Inspection and Testing 35

I. SPECIFICATIONS	35
A. Sources of Specifications	35
B. Material Vs. Casting	36
C. Types of Specifications	36
D. Additional Requirements	37
E. Standard Specifications	37
II. INSPECTION	38
A. Sampling Plans	38
B. Quality Aspects (finish, dimensional accuracy, soundness, metal properties)	38
III. TESTING	40
A. Mechanical Property Tests (hardness, tensile properties, chemical analysis, microstructure, modulus of elasticity, electrical resistance, service load)	40
B. Casting Soundness Tests (density, internal soundness/wall thickness, surface defects/discontinuities, surface imperfections, pressure)	43

Chapter 4

Metallurgy of Cast Irons 47

I. INTRODUCTION	47
II. TYPES OF CAST IRON	48
A. White Iron	48
B. Malleable Iron	49
C. Gray Iron	50
D. Ductile Iron	51
E. Compacted Graphite Iron	51
F. High Alloy Irons	52
III. CHEMICAL COMPOSITION OF CAST IRONS	52
A. Carbon Equivalent	52
B. Combined Carbon	53
C. Sulfur	53
D. Manganese	53
E. Phosphorus	54
F. Minor Elements	54
G. Alloying Elements	54
IV. SOLIDIFICATION OF CAST IRONS	55
A. Thermal Analysis	55
B. Chill Test	56
C. Inoculation	56
V. GRAPHITE MORPHOLOGIES	56
A. Gray Iron Graphite	57
B. Malleable Iron Graphite	59
C. Ductile Iron Graphite	59
D. Compacted Graphite Iron	60
VI. MATRIX STRUCTURE DEVELOPMENT	60

Chapter 5

Casting Design 63

I. INTRODUCTION	63
A. Component Design (cosmetic/nonload bearing, functional shape, physical attribute, static structural and dynamic structural components)	63
B. Capabilities of Iron Castings	63
II. SYSTEMS APPROACH TO ENGINEERING DESIGN ...	64
A. Parameters of Cost-Effective Casting Design (fluid life, solidification shrinkage, slag/dross formation, pouring temperature, modulus of elasticity, section modulus)	65
B. Developing a Model	68
C. Matching the Alloy to the Design (controlling solidification shrinkage, designing junctions, soft vs. highly configured shapes, from CAD screen to casting geometry)	68
III. DESIGN FOR FUNCTION	72
A. Metal Selection (gray, ductile, austempered, compacted graphite, white, high alloyed, malleable)	72
B. Special Design Considerations (inserts, loose inserts, chill casting, bimetal casting, cast-in lettering, casting identifications)	74
IV. GEOMETRY CONSIDERATIONS FOR STRUCTURE ...	76
A. Stress Distribution	77
B. Stress Analysis (brittle lacquer technique, foil strain gauges)	77
C. Compression Loads	79
D. Area Moment of Inertia and Deflection	79
E. Noise and Vibration	81
F. Finite Element Analysis (FEA)	81

G. Example of Structural Geometry	82
H. Process Geometry	82

V. DESIGN FOR MANUFACTURABILITY	84
A. Molding Process Selection	84
B. Casting Process Modeling	84
C. Rapid Prototyping	85
D. Mold Design (parting lines, bosses & projections, patternmaker's contractions, pattern draft)	85
E. Designing Cores (core use, support, limitations, holes, venting & sand removal)	88
F. Designing for Secondary Operations	89
G. Tooling Design	90
VI. GEOMETRIC DIMENSIONING AND TOLERANCING ...	91
VII. CAD/SOLID MODELING	93
VIII. SUMMARY	93

Chapter 6A

Mechanical Properties of Gray Iron 95

I. CLASSES/GRADES OF GRAY IRON	95
II. FACTORS AFFECTING MECHANICAL PROPERTIES ..	95
A. Microstructure	95
B. Composition	96
C. Section Effect	96
III. HARDNESS PROPERTIES	97
IV. TENSILE PROPERTIES	98
A. Factors Affecting Strength (base chemical composition, alloy additions, influential trace elements, inoculation, section size, new formula for tensile strength, processing factors)	98
B. Tensile Strength Determination	103
C. Hardness Vs. Tensile Strength	104
D. Yield Strength	106
E. Elasticity and Deformation (stress-strain relationship, modulus of elasticity, Poisson's ratio, damping capacity)	106
V. COMPRESSIVE PROPERTIES	110
A. Combined Tension and Compression Stresses ...	111
B. Transverse Properties	113
VI. SHEAR AND TORSIONAL PROPERTIES	113
VII. FATIGUE PROPERTIES	115
A. Endurance Values	115
B. Fatigue Crack Growth Rate	116
C. Combined Stresses	116
D. Temperature Effect	117
E. Prestressing	117
F. Alloying and Heat Treatment	118
G. Ambient Effect	118
VIII. FRACTURE TOUGHNESS PROPERTIES	119
A. Impact Tests	119
B. Fracture of Sharply Notched Specimens	120
IX. ELEVATED-TEMPERATURE PROPERTIES	121
A. Material Selection	122
B. Short-Time, High-Temperature Service	122
C. Creep, Stress-Rupture	123
D. Growth, Oxidation, Scaling	126
E. Thermal Fatigue	129
X. LOW-TEMPERATURE PROPERTIES	131

Chapter 6B

Mechanical Properties of Malleable Iron 135

I. CLASSES/GRADES OF MALLEABLE IRON	135
II. FACTORS AFFECTING MECHANICAL PROPERTIES	135
A. Microstructure	135
B. Composition	136
C. Section Effect	136
III. HARDNESS PROPERTIES	136
IV. TENSILE PROPERTIES	137
A. Modulus of Elasticity	138
B. Damping Capacity	139
V. COMPRESSIVE PROPERTIES	139
VI. SHEAR AND TORSIONAL PROPERTIES	139
VII. FATIGUE PROPERTIES	140
VIII. FRACTURE TOUGHNESS PROPERTIES	141
A. Impact Tests	141
B. Fracture of Sharply Notched Specimens	142
C. Galvanizing Embrittlement	142
IX. ELEVATED-TEMPERATURE PROPERTIES	143
X. LOW-TEMPERATURE PROPERTIES	144

Chapter 6C

Mechanical Properties of Ductile Iron 147

I. CLASSES/GRADES OF DUCTILE IRON	147
II. FACTORS AFFECTING MECHANICAL PROPERTIES	147
A. Microstructure	148
B. Composition	148
C. Section Effect	148
III. HARDNESS PROPERTIES	149
IV. TENSILE PROPERTIES	150
A. Modulus of Elasticity	152
B. Damping Capacity	153
V. COMPRESSIVE PROPERTIES	153
A. Combined Stresses	153
VI. SHEAR AND TORSIONAL PROPERTIES	154
VII. FATIGUE PROPERTIES	154
VIII. FRACTURE TOUGHNESS PROPERTIES	157
A. Impact Tests	158
B. Fracture of Sharply Notched Specimens	160
IX. ELEVATED-TEMPERATURE PROPERTIES	161
A. Material Selection	161
B. Effect of Temperature	161
C. Growth, Oxidation, Scaling	162
D. Short-Time Elevated-Temperature Properties	163
E. Creep, Stress-Rupture	164
F. Thermal Fatigue	166
X. LOW-TEMPERATURE PROPERTIES	167

Chapter 6D

Mechanical Properties of Compacted Graphite Iron 171

I. CLASSES/GRADES OF CG IRON	171
II. FACTORS AFFECTING MECHANICAL PROPERTIES	172
A. Microstructure	172
B. Composition	173
C. Section Effect	175
III. HARDNESS PROPERTIES	176
IV. TENSILE PROPERTIES	176
A. Ultimate Tensile and Yield Strengths	177
B. Elongation	177
C. Modulus of Elasticity	177
D. Damping Capacity	179
E. Alloying and Tensile Properties	180
F. Effect of Inoculation	180
V. COMPRESSIVE PROPERTIES	180
VI. SHEAR AND TORTIONAL PROPERTIES	182
VII. FATIGUE PROPERTIES	184
VIII. WEAR PROPERTIES	186
IX. ELEVATED-TEMPERATURE PROPERTIES	188
A. Tensile Properties	188
B. Creep	188
C. Growth, Oxidation, Scaling	189
D. Thermal Expansion	189
E. Thermal Fatigue	189
F. Thermal Shock Resistance	191

Chapter 7

High-Alloy Cast Irons 195

I. INTRODUCTION	195
II. CORROSION-RESISTANT SERVICE	195
A. Nickel-Alloyed Austenitic Irons (austenitic flake graphite/Ni-Resist, austenitic ductile iron/Ni-Resist, applications)	195
B. High-Silicon Irons	201
C. High-Chromium Irons	201
III. ELEVATED-TEMPERATURE SERVICE	201
A. Nickel-Alloyed Austenitic Irons (gray & ductile Ni-Resist)	201
B. High-Silicon Irons (gray & ductile)	203
C. Aluminum-Alloyed Irons	205
D. High-Chromium White Irons (scaling resistance, heat resistance, mechanical properties, applications)	207
IV. ABRASION-RESISTANT SERVICE	209
A. High-Chromium White Irons (development, performance evaluation & improvement, control of retained austenite & matrix structure, heat treatment, chromium content, applications) ..	209
B. Nickel-Chromium White Irons (Ni-Hard) (types, heat treatment, applications, fracture & failure) ...	217
V. SUMMARY	220

Chapter 8

Physical Properties of Cast Iron 223

I. DENSITY	223
II. LIQUID IRON PROPERTIES	225
A. Surface Energy	225
B. Contact Angles	226
C. Viscosity of Molten Iron	229
III. THERMAL PROPERTIES	230
A. Specific Heat and Enthalpy	230
B. Latent Heat of Fusion and Solid-State Transformation	233
C. Thermal Expansion	233
IV. CONDUCTIVE PROPERTIES	235
A. Thermal Conductivity	236
B. Electrical Resistivity	238
V. MAGNETIC PROPERTIES	240
VI. ACOUSTIC PROPERTIES	242

Chapter 9

Corrosion and Wear of Iron Castings 245

I. CORROSION OF IRON CASTINGS	245
A. Definition of Corrosion	245
B. Rate of Corrosion	245
C. Corrosion Mechanism (gray, ductile, malleable, white)	246
D. Influence of Chemical Composition (Si, Cr, Ni, Cu, Mo)	248
E. Types of Corrosion (galvanic, pitting, intergranular, stress, erosion, fretting)	248
F. Corrosion-Resistant Classifications	250
G. Corrosion in Various Environments (atmospheric, flue gas, water, soil, acid, alkali, salt, organic solvent & sulfur compound, molten metal)	251
H. Coatings for Corrosion Protection (metallic, organic, conversion, enamel)	261
II. WEAR OF IRON CASTINGS	262
A. Types of Wear (abrasive, adhesive or frictional, fretting or fatigue, cavitation, combination)	262
B. Wear Testing and Evaluation	262
C. Wear Behavior	262
D. Adhesive or Frictional Wear (dry sliding wear, lubricated sliding wear)	264
E. Treatments to Enhance Wear Resistance	268
III. SYNERGISM OF CORROSION AND WEAR	268

Chapter 10A

Heat Treatment of Iron Castings 271

I. GENERAL CONSIDERATIONS	271
A. Heat Treatment of Iron Vs. Steel	271
B. Treatment Determination	272
C. Critical Temperature Ranges	273

II. STRESS RELIEVING	273
A. Causes of Residual Stresses (variation in cooling rate, mechanical restraint in the mold, surface peening during cleaning, subsequent processing)	273
B. Stress-Free, As-Cast	274
C. Testing for Residual Stress	275
D. Principles of Stress Relief	275
E. Stress-Relieving Temperatures	276
F. Other Stress Relief Methods (weathering, vibration)	277
III. ANNEALING	277
A. High-Temperature Annealing	278
B. Medium-Temperature Annealing	278
C. Low-Temperature (Subcritical) Annealing (Ferritizing)	278
D. Two-Stage Annealing	279
E. Annealing of Alloyed Irons	280
IV. NORMALIZING	281
A. Normalizing Applications	281
B. Normalizing Procedures	281
C. Effect of Normalizing Properties	281
D. Normalizing of Alloyed Irons	282
V. THROUGH HARDENING	283
A. Hardenability (ideal diameter & Jominy values, calculations from composition, severity of quench, IT diagrams)	283
B. Through-Hardening Procedures (heating, quenching, tempering)	287
C. Properties Obtainable	290
VI. SPECIAL HEAT TREATMENT FOR PEARLITIC MALLEABLE IRONS	291
A. Processes for Pearlitic Malleable Irons (various quenching & tempering combinations)	291
B. Properties of Pearlitic Malleable Irons	292
VII. SURFACE HARDENING	293
A. Metallurgical Aspects	293
B. Quench Hardening Methods (spot, spin & progressive hardening)	293
C. Quench Hardening-Heating Methods (flame, induction, laser, immersion)	294
D. Diffusion Hardening	294
VIII. TEMPERATURE CONTROL IN HEAT TREATMENT ..	296
IX. ATMOSPHERIC CONTROL IN HEAT TREATMENT ...	297

Chapter 10B

Austempering of Iron Castings .. 299

I. INTRODUCTION	299
II. HISTORY OF AUSTEMPERING	299
III. HEAT TREATMENT AND METALLURGY	302
IV. EFFECT OF CASTING FACTORS	302
V. EFFECT OF HEAT-TREATING FACTORS	302
VI. PROPERTIES AND APPLICATION	303
A. Austempered Malleable Iron (AMI)	303
B. Austempered Gray Iron (AGI)	304
C. Austempered Compacted Graphite Iron (ACGI)	304
D. Austempered Ductile Iron (ADI)	304

Chapter 11

Welding of Iron Castings 309

I. INTRODUCTION	309
II. FACTORS AFFECTING WELD QUALITY	309
A. Fusion Zone	309
B. Partial Fusion and Heat Affected Zones	311
C. Stresses	311
D. Porosity	312
E. Base Metal Weldability	312
F. Weld Preparation	312
G. Preheating	313
H. Heat Input	313
I. Deposition Technique	314
J. Protective Slags, Fluxes and Gases	314
K. Postwelding Heat Treatment	315
III. ARC WELDING PROCESSES	315
A. Process Descriptions (SMAW, GMAW, GTAW, FCAW and SAW)	315
B. Electrode Selection	316
C. Special Arc Techniques	316
D. Buttering of Welds	317
E. Preheat Requirements	317
F. Mechanical Properties	318
IV. GAS WELDING PROCESSES	320
A. Cast Iron Filler Rod Welding (joint preparation, preheating, mechanical properties)	321
B. Powder Welding	322
C. Braze Welding	322
V. AUSTENITIC IRON WELDING	325
VI. ADDITIONAL FUSION PROCESSES	325
A. Thermit Welding	325
B. Foundry Metal (Flow) Weld	325
C. Fusion Bonding of Iron to Steel	326
D. Bimetallic Casting	326
E. Electrical Resistance Welding	326
F. Specialized Fusion Processes	327
VII. SOLID PHASE BONDING PROCESSES	327
A. Friction Welding	327
B. Pressure Welding	327
VIII. SURFACING AND BUILDUP	328
IX. BRAZING AND SOLDERING	329
A. Brazing (joint preparation, alloys & fluxes, heating)	329
B. Soldering	330
X. CUTTING PROCESSES	330
A. Oxygen Cutting Processes (oscillatory motion, wire feed, waster plate, iron powder, burning lances)	331
B. Arc Cutting Processes (carbon, shielded metal, air-carbon, oxygen, plasma)	331
XI. WELD QUALIFICATION TESTING	332
A. Qualification Documentation (procedure specification, qualification)	332
B. Inspection Techniques (visual examination, liquid penetrant, magnetic particle, radiography)	332

Chapter 12

Machining and Grinding of Iron Castings 335

I. INTRODUCTION	335
II. MACHINING CAST IRON	335
A. Machinability Rating	335
B. Effect of Microstructure on Machinability of Cast Iron	335
C. Microstructural Constituents (ferrite, pearlite, martensite, bainite, austenite, carbides, steadite, manganese sulfide, mixed matrix structures)	336
III. TOOL LIFE	337
A. Surface Condition	337
B. Hard Spots	337
IV. SURFACE FINISH AND ACCURACY	338
A. Surface Evaluation (quality factors in turning & face milling)	338
B. Breakout in Cutting Gray Iron	341
C. Distortion and Accuracy	341
V. TOOL FORCES AND POWER REQUIREMENTS	343
VI. CUTTING FLUIDS/COOLANTS	344
VII. TOOL MATERIALS AND STARTING RECOMMENDATIONS	345
A. High-Speed Steels (HSS)	345
B. Cast Alloys	345
C. Carbides and Coated Carbides	345
D. Ceramics/Cermets (alumina, Al_2O_3/TiC , silicon nitride)	345
E. Cubic Boron Nitride (CBN)	346
F. Starting Recommendations for Machining	346
VIII. MACHINING PROCESSES	364
A. Coining and Punching	364
B. Roller Burnishing	364
C. Scraping	364
IX. GRINDING CAST IRON	365
A. Surface Grinding, Horizontal Spindle	365
B. Surface Grinding, Vertical Spindle	365
C. Cylindrical Grinding	365
D. Centerless Grinding	365
E. Internal Grinding	366
F. Abrasive Belt Grinding	366
G. Starting Recommendations for Grinding	366
X. GRINDING PROCESSES	373
A. Honing	373
B. Lapping	373
XI. ECONOMICS IN MACHINING AND GRINDING	373

(Chapter 13 on next page)

Chapter 13

Coatings and Surface Engineering for Iron Castings 375

I.	INTRODUCTION	375
II.	SURFACE CLEANING	375
A.	Mechanical Cleaning	375
B.	Nonmechanical Cleaning (molten salt baths, pickling)	375
C.	Chemical Cleaning (alkalines, solvents, emulsions)	377
III.	TEMPORARY CORROSION PROTECTION	377
IV.	ELECTROPLATING	378
A.	Cadmium Plating	378
B.	Chromium Plating	379
C.	Copper Plating	380
D.	Lead Plating	380
E.	Electrolytic Nickel Plating	380
F.	Nonelectrolytic Nickel Plating	381
G.	Zinc Plating	381
H.	Tin Plating	381
I.	Tin-Nickel Plating	382
J.	Brass and Bronze Plating	382
V.	HOT-DIPPED METAL COATING	382
A.	Zinc Galvanizing	382
B.	Tinning	383
C.	Lead and Lead Alloy Coatings	384
D.	Aluminizing	384
VI.	THERMALLY SPRAYED MATERIALS AND COATINGS	384
A.	Plasma Spray	384
B.	Wire Arc Spray	385

C.	Flame Spray	385
D.	Detonation Gun Spray	386
E.	HVOF Spray	386
F.	Thermal Spray Coating Characteristics	386
G.	Thermal Spray Applications and Coating Selection	387
VII.	DIFFUSION COATINGS	388
A.	Calorized Coatings	388
B.	Chromized Coatings	388
C.	Cyanided Carbonitrided	388
D.	Nickel-Phosphorus Coatings	388
E.	Nitrided Coatings	388
F.	Sheradized Coatings	388
VIII.	CONVERSION COATINGS	389
A.	Phosphate Coatings	389
B.	Oxide Coatings	389
C.	Chromate Coatings	389
IX.	PORCELAIN ENAMEL COATINGS	390
X.	LIQUID ORGANIC COATINGS (PAINTS)	392
A.	Enamels	392
B.	Lacquers	392
C.	Aqueous Coatings	393
D.	Rubber-Base Products	393
E.	Bituminous Substances	393
F.	Suspensions	393
G.	Novelty Finishes	394
H.	Methods of Application (spraying, dipping, electrocoating)	394
XI.	DRY POWDER ORGANIC COATINGS	395
	Glossary	397
	Index	415