Experimental Behavioural Study Of Ductile Cast Iron Microstructure And Its Mechanical Properties

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ABSTRACT

Ductile cast Iron also referred to as nodular iron or spheroidal graphite iron. The Ductile cast iron contains graphite it is in the form of discrete nodules or spheroids. This paper deals with some factors influencing microstructure and mechanical properties of ductile cast iron (DCI).

Ductile cast iron have been used for a wide variety of application in automotive, rail and heavy engineering industry because of its excellent mechanical properties such as high strength with good ductility, good wear resistance and good fatigue properties. The properties of ductile cast iron are dependent on both chemistry and heat treatment. Nodular cast iron are primarily heat treated to create matrix micro structure and associated mechanical properties not readily obtain in the as-cast condition. Final structure and properties of DCI are obtained by exactly controlled process of heat treatment. Experiments are conducted on 600/3 and 500/7 grades of ductile cast iron and following observations are made to know the properties of metal. Results of the experiment shows that it dependence of temperature and various matrixes can be obtained (i.e. mixture of graphite, ferrite and pearlite). Different quenching medias are selected to check the behaviour of the materials. Quenching medias like vegetable oil, mineral oil and water are used for this experimental analysis. After heat treatment the tensile strength, hardness, elongation and yield stress of the specimens are obtained with respect to different quenching medias.

Keywords: DCI (Ductile cast iron), heat treatment process, quenching medias.

I. INTRODUCTION

Ductile cast iron is cast iron in which the graphite is present as tiny balls in metallic matrix. Ductile cast iron is also known as nodular iron, spheroidal graphite iron, and spherulitic iron. This type of cast iron has increased strength and ductility when compared with a similar structure of gray cast iron[2]. Ductile cast iron has excellent mechanical as well as technological properties together with relatively low price. Much of the annual production of ductile iron is in the form of ductile iron pipe, used for water and sewer lines. Ductile iron is specifically useful in many automotive components. Other major industrial applications include off-highway diesel trucks, class 8 trucks, agricultural tractors, oil well pumps, fully machined piston for large marine diesel engine, bevel wheel, hydraulic clutch on diesel engine for heavy vehicle and Fittings overhead electric transmission lines[1]. If ductile iron is heated at 750^{0}C, then it is quenched (mineral oil or vegetable oil or water or any other quenching media), then its properties are vary depending upon the micro constituents present in particular metal. In general heat treatment processes involving heating, holding and continuous cooling, due to this graphite nodules are transformed into a ferrite matrix or upto 10% pearlite although it does not contain carbides.1.1As-cast ductile cast iron shows following values of the mechanical properties

- Tensile strength (N/mm^2) 600 to 647 for 600/3 grade and 500 to 560 for 500/7 grade
- Hardness (HBW) 190 to 270 for 600/3 grade and 160 to 220 for 500/7 grade
- Yield stress (N/mm^2) 530 to 540 for 600/3 grade and 450 to 460 for 500/7 grade
- Elongation (%) 3 to 4 for 600/3 grade and 7 to 18 for 500/7 grade

1.2 Heat treated ductile cast iron shows following values of the mechanical properties
- Tensile strength (N/mm^2) 635 to 647 for 600/3 grade and 543 to 552 for 500/7 grade
- Hardness (HBW) 215 to 226 for 600/3 grade and 189 to 197 for 500/7 grade
- Yield stress (N/mm^2) 526 to 560 for 600/3 grade and 460 to 470 for 500/7 grade
- Elongation (%) 10 to 15 for 600/3 grade and 20 to 25 for 500/7 grade

1.3Factor that affect heat treatment process and subsequent microstructures as well as mechanical properties are summarized as:
- Austenising temperature and time.
- Casting quality and section size of castings.

II. EXPERIMENTAL INVESTIGATION

Experimental material was melted in the electric induction furnace shown in Figure1. The basic charge was formed by cold rolled high carbon scrap and foundry returns for the control of chemical composition. Iron Silicon and magnesium alloy

(FeSiMg) modifier was used for modification and Iron Silicon (FeSi) granules inoculant was used in treatment laddle shown in figure2. Ferrite-pearlitic nodular cast iron was used as basic material for heat treatment are shown in figure3.


Figure1. Electric induction furnace


Figure2. Treatment laddle


Figure3.Material used for heat treatment

2.1 The chemical composition and microstructure study of as-cast material

Chemical composition and microstructure of the as-cast material of samples (600/3 and 500/7 samples) is presented in Table.1 and figure 4,5,6&7 and Graphite type, Nodularization, Nodule size, Nodule count for (600/3 and 500/7) microstructure are shown in below table2.

Table 1. Chemical composition of the used samples

Material	Elements	C (%)	Mn (%)	P (%)	S (%)	Si (%)	Cu (%)	Ni (%)	Cr (%)	Mo (%)	Mg (%)
600/3		3.128	0.855	0.095	0.038	1.716	0.043	0.017	0.179	<0.001	
500/7		3.377	0.478	0.087	0.041	2.932	0.04	0.018	0.066	<0.001	0.035

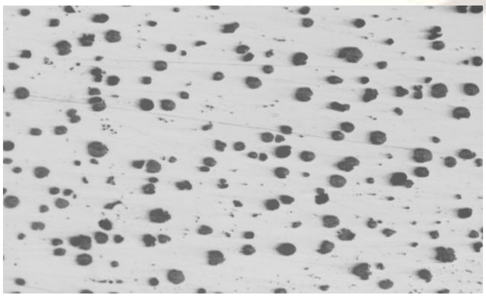


Figure 4.100X unetched

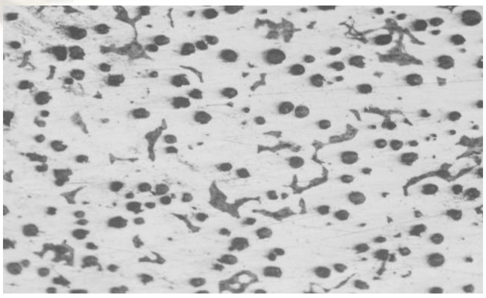
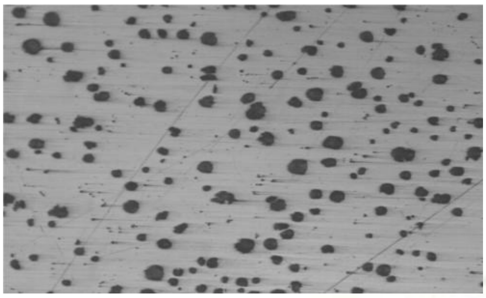


Figure5.100X nital

Figure 4 and 5 represents microstructure of the as-cast material of 600/3 grade

Microstructure consists of graphite nodules in ferrite,10% pearlite matrix with no free carbides.



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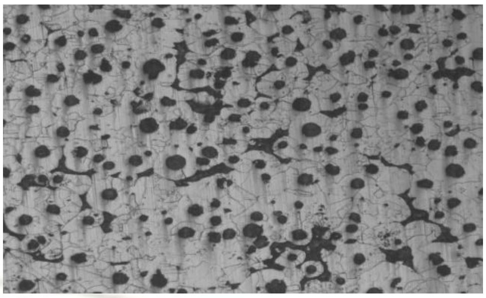

Figure 7. 100X nital

Figure 6 and 7 represents microstructure of the as-cast material of 500/7 grade
Microstructure consists of graphite nodules in ferrite,10% pearlite matrix with no free carbides.

Table 2. Microstructure study of as-cast sample

Specimen	Graphite type	Nodularization	Nodule size	Nodule count
600/3	Predominantly form VI and V	85%	6/8	$130mm^2$
500/7	Predominantly form VI and V	90%	6/8	$150mm^2$

III. HEAT TREATMENT

All the samples were initially heated at 750°C for 143 minutes in muffle furnace is shown in figure8 and they are quenched in different quenching medias like mineral oil, vegetable oil and water are shown in figure 9,10&11. After heat treatment specimens are adopted for tensile test, hardness test, yield stress, elongation and for the analysis of microstructure is shown figure 12 .

Figure 8.Muffle furnace

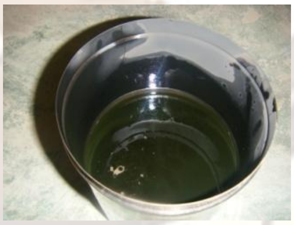

Figure 9.Mineral oil

Figure 10.Vegetable oil

Figure 11.Water

Figure 12. Specimens for tensile test and Microstructure

3.1 TESTING

Mechanical properties investigations were carried out in the testing laboratory.

a. Tensile test was made by TUE-C-1000 of the testing equipment with loading range 0 to 35 kN.

b. Brinell hardness test was made by B-3000 of the testing equipment with the tungsten ball indenter of a diameter 10 mm pressed into the surface of specimens under the load 3000kg.

c. The microstructure of the specimens was made by optical metallurgical microscope NIKON Epiphot 200.

IV. EXPERIMENTAL RESULTS - METALLOGRAPHIC ANALYSIS

Microstructure of the basic material 600/3 and 700/7 grade cast iron is quenched by different medium (after heat treatment) obtain ferrite and pearlitic nodular matrix for 600/3 (Fig.13-18), for 500/7 (Fig.19-24) and Graphite type, Nodularization, Nodule size, Nodule count for 600/3 and 500/7 are shown in below table 3

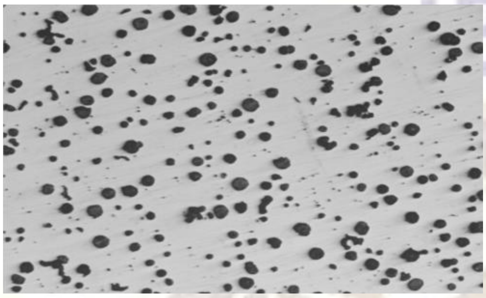
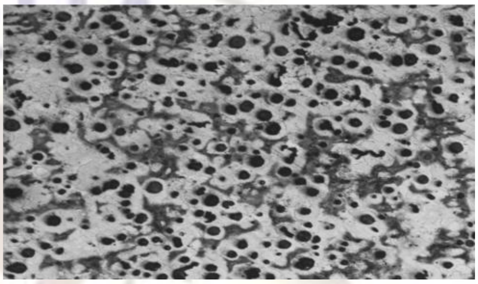

Figure13.100X unetched Figure14. 100X nital

Figure 13 and14 represents the microstructure of the material of 600/3 grade quenched by sun flower oil.

Microstructure consists of graphite nodules in ferrite,25% pearlite matrix with no free carbide.

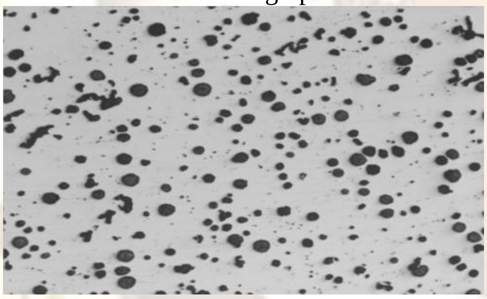
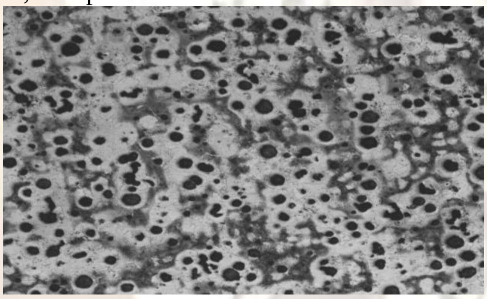

Figure 15.100X unetched Figure 16. 100X nital

Figure 15 and 16 represents the microstructure of the material of 600/3 grade quenched by mineral oil.

Microstructure consists of graphite nodules in ferrite,20% pearlite matrix with no free carbides

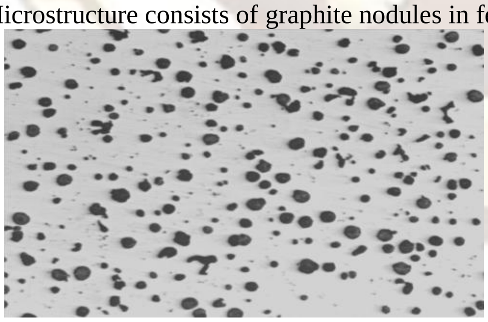


Figure17. 100X unetched Figure18. 100X nital

Figure 17 and 18 represents the microstructure of the material of 600/3 grade quenched by water. Microstructure consists of graphite nodules in ferrite,20% pearlite matrix with no free carbides

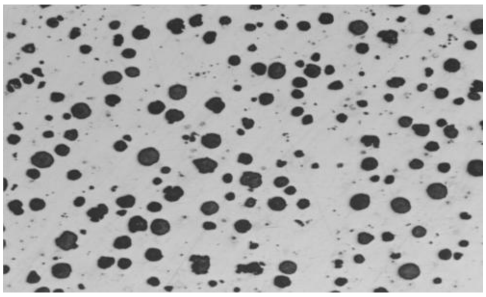

Figure.19 100X unetched

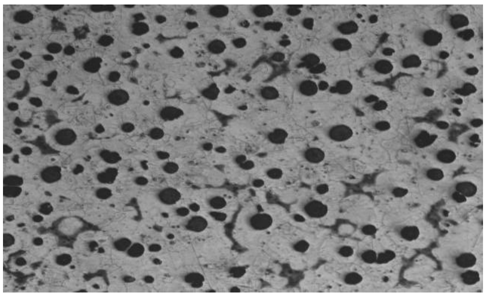

Figure 20. 100X nital

Figure 19 and 20 represents the microstructure of the material of 500/7 grade quenched by sun flower oil. Microstructure consists of graphite nodules in ferrite,10% pearlite matrix with no free carbides

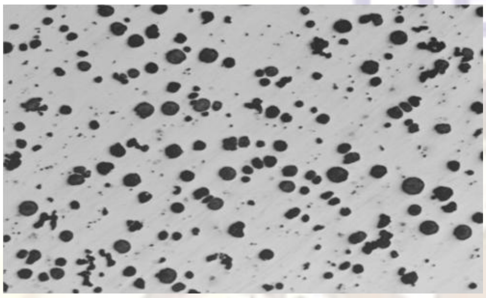

Figure 21. 100X unetched

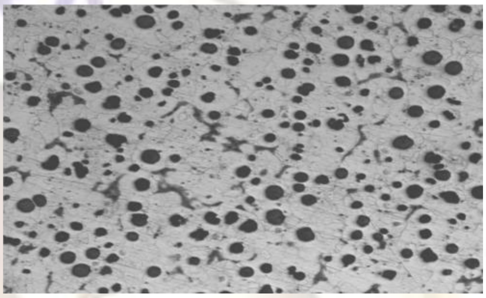

Figure 22. 100X nital

Figure 21 and 22 represents the microstructure of the material of 500/7 grade quenched by mineral oil. Microstructure consists of graphite nodules in ferrite,10% pearlite matrix with no free carbides

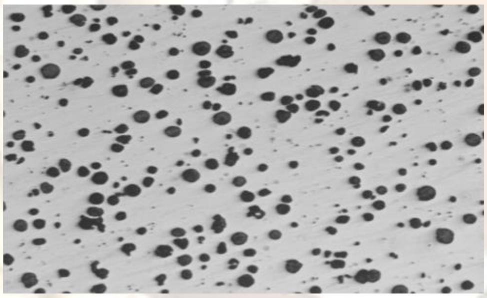

Figure 23.100X unetched

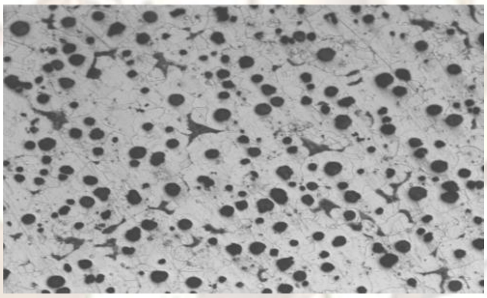

Figure 24. 100X nital

Figure 23 and 24 represents the microstructure of the material of 500/7 grade quenched by water. Microstructure consists of graphite nodules in ferrite, 10% pearlite matrix with no free carbide

Table 3 Microstructure study of heat treated sample

Specimen	Quenching medias	Graphite type	Nodularization	Nodule size	Nodule count
600/3	Vegetable oil	Predominantly form VI and V with some form III	85%	6/8	$210mm^2$
	Mineral oil.	Predominantly form VI and V with some form III	85%	6/8	$210mm^2$
	Water.	Predominantly form VI and V with some form III	85%	6/8	$210mm^2$
500/7	Vegetable oil	Predominantly form VI and V	90%	5/8	$170mm^2$
	Mineral oil.	Predominantly form VI and	85%	6/8	$180mm^2$

		V			
	Water.	Predominantly form VI and V	85 to 90%	6/8	210mm^2

V. RESULTS AND DISCUSSION

Study the mechanical properties of as-cast and heat treated (600/3 and 500/7 grade) ductile cast iron are given in the table 4.

Table 4.Study the mechanical properties of as-cast and heat treated ductile cast iron

Condition	Grade			Tensile strength (N/mm2)	Yield stress (N/mm^2)	Hardness	Elongation%
As cast	600/3			647.77	539.81	269	4.69
	500/7			560.62	459.37	197	18.69
Heat treated	600/3	Quenching medias	Vegetable oil	641.25	526.87	219	15.65
			Mineral oil.	646.88	555.56	215	14.38
			Water.	635.12	560.73	226	10.83
	500/7		Vegetable oil	548.83	460.49	197	25.15
			Mineral oil.	552.31	470.69	189	22.73
			Water.	543.57	467.28	197	22.03

VI. CONCLUSION

- After heat treatment tensile strength and hardness of ductile cast iron samples decreases significantly.
- After heat treatment also there is no change in shape and size of graphite nodules.
- After heat treatment the nodule count increases.
-So finally conclude that the heat treatment is carried at 750^{0}C is second stage of graphitization.

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