


“Saya akui bahawa saya telah membaca karya ini dan pada pandangan saya karya ini adalah memadai dari segi skop dan kualiti untuk tujuan penganugerahan Ijazah Sarjana Muda Kejuruteraan Mekanikal (Struktur & Bahan)”

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A STUDY ON END-QUENCH PROCESS OF CARBON STEEL, LOW ALLOY
STEEL AND STAINLESS STEEL

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Laporan ini diserahkan kepada Fakulti Kejuruteraan Mekanikal
sebagai memenuhi sebahagian daripada syarat penganugerahan
Ijazah Sarjana Muda Kejuruteraan Mekanikal (Struktur & Bahan)

Fakulti Kejuruteraan Mekanikal
Kolej Universiti Teknikal Kebangsaan Malaysia

MEI 2006

“Saya akui laporan ini adalah hasil kerja saya sendiri kecuali ringkasan dan petikan yang tiap-tiap satunya saya jelaskan sumbernya”

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ACKNOWLEDGEMENT

Since the thesis of studying the Jominy end-quenching process based on carbon steel, low alloy steel and stainless steel was appeared in 2005, many lecturers, friends and reviews have provided a helpful feedback and suggestion in developing this thesis. I wish to thank to:

1. Mr. Wan Mohd Farid Bin Wan Mohamad, supervisor (FKM) *Kolej Universiti Teknikal Kebangsaan Malaysia (KUTKM)*.
2. Mr. Ahmad Rivai, lecturer (FKM) *Kolej Universiti Teknikal Kebangsaan Malaysia (KUTKM)*.
3. Mr. Mahader Bin Muhamad, technician (FKM) *Kolej Universiti Teknikal Kebangsaan Malaysia (KUTKM)*.
4. Mr. Azhar, technician (FKP) *Kolej Universiti Teknikal Kebangsaan Malaysia (KUTKM)*.

Finally, I need to thank again for the people above due to their assistance and cooperation and also my beloved family to success my thesis.

ABSTRACT

The purpose of this study was identifying the effect of quenching process bases on their hardenability, microstructure and distortion profile of three different steels. Three experiments have carried out involving hardness test, distortion examination and microstructure analyze. Where the samples hardness profile across the bars uniformly show hardness decrease towards the center, which was due to the decrease in the cooling rate towards the center. Sample with fast cooling rate, the transformation from austenite to pearlite cannot occur and the new phase obtained by quenching was called martensite. Martensite was a supersaturated metastable phase and has body centered tetragonal lattice (bct) instead of bcc. After sample was quenched, it was usually very hard and strong but brittle. Martensite looks needle-like under microscope due to its fine lamellar structure. Therefore the quenched end with high cooling rate will have high hardness profile. The microstructural changes from martensite at the quenched end to ferrite-pearlite where far from quenched end were depend to the cooling rate. Each quench medium has different cooling rate, therefore different quench medium will showed a different results to the samples.

ABSTRAK

Tujuan bagi kajian ini adalah untuk mengenalpastikan kesan proses penyejukan kejut terhadap kekerasan, mikrostruktur dan keherotan bagi tiga jenis besi yang berlainan. Tiga ujian telah dijalankan iaitu ujian kekerasan, pemeriksaan keherotan dan menganalisis perubahan mikrostruktur. Di mana kekerasan sampel menunjukkan kadar pengurangan yang serata apabila merentasi ke bahagian tengah bar yang disebabkan oleh pengurangan kadar penyejukan ke bahagian tengah. Sampel yang mempunyai kadar penyejukan yang cepat, perubahan austenite kepada pearlite tidak dapat dilakukan dan ia akan menjanakan satu fasa yang baru yang dikenali sebagai martensite. Martensiti adalah fasa yang lampau tepu. Selepas sampel disejukan, biasanya ia sangat keras dan kuat tetapi rapuh. Dibawah pemerhatian mikroskop, mikrostruktur martensiti kelihatan berbentuk jarum yang disebabkan keunikan lapisan strukturnya. Oleh demikian, bahagian hujung yang mempunyai kadar penyejukan yang tinggi akan menunjukkan kekerasan yang maksimum. Mikrostruktur akan berubah dari Martensiti pada bahagian hujung sample ke bentuk ferriti-pearliti dimana jauh dari bahagian hujung sample. Setiap jenis medium penyejukan kejut mempunyai kadar penyejukan yang berlainan. Oleh demikian, ia akan membawa hasil keputusan yang berlainan kepada sample yang diuji.

TABLE OF CONTENT

CHAPTER	ITEM	PAGE
1	INTRODUCTION	1
	1.1 Objective	3
	1.2 Scope of Research	3
	1.3 Heat Treatment	4
	1.4 Hardenability	5
	1.5 Microstructural Development	7
	1.6 Mechanical Properties	10
	1.6.1 AISI 1045 Carbon Steel	10
	1.6.2 AISI 4130 Low Alloy Steel	11
	1.6.3 AISI 304 Stainless Steel	12
	1.7 Quench Medium	13
	1.8 Distortion Profile	14
2	LITERATURE REVIEW	17
3	METHODOLOGY	30
	3.1 Experimental Procedures	30
	3.2 Sample Preparations	30
	3.3 Heat Treatment	31

CHAPTER	ITEM	PAGE
	3.3.1 Solution Heat Treatment	31
	3.3.2 End Quenching	32
3.4	Mechanical Testing	33
	3.4.1 Hardness Test	33
	3.4.2 Distortion Examination	34
3.5	Microstructure Examination	34
4	ANALYSIS AND DISCUSSION	37
4.1	Introduction	37
4.2	Hardness Test Analysis	37
	4.2.1 Sample Steels with Water Quenched	38
	4.2.1.1 Hardness Test Analysis For AISI 1045 Carbon Steel	38
	4.2.1.2 Hardness Test Analysis For AISI 4130 Low Alloy Steel	42
	4.2.1.3 Hardness Test Analysis For AISI 304 Stainless Steel	46

CHAPTER	ITEM	PAGE
	4.2.1.4 Different Steel Samples with Water Quenched	50
4.2.2	Sample Steels with Oil Quenched	52
	4.2.2.1 Hardness Test Analysis For AISI 1045 Carbon Steel	52
	4.2.2.2 Hardness Test Analysis For AISI 4130 Low Alloy Steel	56
	4.2.2.3 Hardness Test Analysis For AISI 304 Stainless Steel	60
	4.2.2.4 Different Steel Samples with Oil Quenched	64
4.2.3	Sample Steels with Air Quenched	66
	4.2.3.1 Hardness Test Analysis For AISI 1045 Carbon Steel	66

CHAPTER	ITEM	PAGE
	4.2.3.2 Hardness Test Analysis For AISI 4130 Low Alloy Steel	70
	4.2.3.3 Hardness Test Analysis For AISI 304 Stainless Steel	74
	4.2.4 Sample Steels with Different Quench Mediums	78
4.3	Distortion Analysis	81
	4.3.1 Sample Steels with Water Quenched	81
	4.3.1.1 Distortion Analysis For AISI 1045 Carbon Steel	81
	4.3.1.2 Distortion Analysis For AISI 4130 Low Alloy Steel	84
	4.3.1.3 Distortion Analysis For AISI 304 Stainless Steel	86
	4.3.2 Sample Steels with Oil Quenched	89
	4.3.2.1 Distortion Analysis For AISI 1045 Carbon Steel	89

CHAPTER	ITEM	PAGE
	4.3.2.2 Distortion Analysis For AISI 4130 Low Alloy Steel	91
	4.3.2.3 Distortion Analysis For AISI 304 Stainless Steel	93
	4.3.3 Sample Steels with Air Quenched	96
	4.3.3.1 Distortion Analysis For AISI 1045 Carbon Steel	96
	4.3.3.2 Distortion Analysis For AISI 4130 Low Alloy Steel	98
	4.3.3.3 Distortion Analysis For AISI 304 Stainless Steel	100
4.4	Metallographic Analysis	103
	4.4.1 Water As Quench Medium	103
	4.4.2 Oil As Quench Medium	108
5	CONCLUSION	113
	5.1 The Problems Encountered	118
	5.2 The suggestion for Future Research.	119
	REFERENCES	121

CHAPTER	ITEM	PAGE
APPENDIX		
A	AISI 1045 Carbon Steel Certificate	124
B	AISI 4130 Low Alloy Steel Certificate	125
C	Jominy End Quench Test Machine	128

LIST OF TABLE

NO.	TITLE	PAGE
1.1	Composition of AISI 1045 Carbon Steel	10
1.2	Composition of AISI 4130 Low Alloy Steel	11
1.3	Composition of AISI 304 Stainless Steel	12
2.1	Comparison of Grossmann and Heat Flux Quench Severity Data.	19
4.1	Hardness Profile A1-W before undergone Water Quenched	39
4.2	Hardness Profile A1-W after undergone Water Quenched	40
4.3	Hardness Profile A2-W before undergone Water Quenched	43
4.4	Hardness Profile A2-W after undergone Water Quenched	44
4.5	Hardness Profile A3-W before undergone Water Quenched	47
4.6	Hardness Profile A3-W after undergone Water Quenched	48
4.7	Hardness Profile A1-O before undergone Oil Quenched	53
4.8	Hardness Profile A1-O after undergone Oil Quenched	54

NO.	TITLE	PAGE
4.9	Hardness Profile A2-O before undergone Oil Quenched	57
4.10	Hardness Profile A2-O after undergone Oil Quenched	58
4.11	Hardness Profile A3-O before undergone Oil Quenched	61
4.12	Hardness Profile A3-O after undergone Oil Quenched	62
4.13	Hardness Profile A1-A before undergone Air Quenched	67
4.14	Hardness Profile A1-A after undergone Air Quenched	68
4.15	Hardness Profile A2-A before undergone Air Quenched	71
4.16	Hardness Profile A2-A after undergone Air Quenched	72
4.17	Hardness Profile A3-A before undergone Air Quenched	75
4.18	Hardness Profile A3-A after undergone Air Quenched	76
4.19	Distortion Profile A1-W before undergone Water Quenched	82
4.20	Distortion Profile A1-W after undergone Water Quenched	83
4.21	Distortion Profile A2-W after undergone Water Quenched	85
4.22	Distortion Profile A3-W after undergone Water Quenched	87

NO.	TITLE	PAGE
4.23	Distortion Profile A1-O after undergone Oil Quenched	90
4.24	Distortion Profile A2-O after undergone Oil Quenched	92
4.25	Distortion Profile A3-O after undergone Oil Quenched	94
4.26	Distortion Profile A1-A after undergone Air Quenched	97
4.27	Distortion Profile A2-A after undergone Air Quenched	99
4.28	Distortion Profile A3-A after undergone Air Quenched	101

LIST OF FIGURE

NO.	TITLE	PAGE
1.1	Possible transformations involving the decomposition of austenite. Solid arrows, transformations involving diffusion: dashed arrow, diffusion less transformation.	2
1.2	Schematic temperature versus time plot showing both solution and precipitation heat treatments for precipitation hardening.	4
1.3	Jominy end-quench hardenability test (left), and Typical distribution of hardness in Jominy bars (right).	5
1.4	Several types of microstructures.	8
1.5	Hardness of martensite, as a function of carbon content.	8
1.6	Correlation of continuous-cooling-transformation diagram and end-quench hardenability test data for eutectoid carbon steel.	9
1.7	Distortion profile before and after quenching process.	14

NO.	TITLE	PAGE
2.1	Variation of heat flux with probe surface temperature during end quenching of stainless steel.	19
2.2	Hardness traverse results for air- and oil-quenched heat treatment blanks used for corrosion experiment and for valve heat treat blanks used for the heat treatment distortion studies.	20
2.3	Hourglass distortion patterns can be seen near the quenched end in flat ground in the Jominy bars due to diameter variation along the length.	22
2.4	Data for Diameter versus Distance from quenched end.	22
2.5	Data for Rockwell Hardness versus Distance from quenched end.	24
2.6	The microstructures of martensite and ferrite/pearlite.	25
2.7	Microstructures of AISI 1040 steel disk specimens quenched in conventional quench media: (a) 10% brine, (b) water, (c) mineral oil, (d) sunflower oil, (e) coconut oil, and (f) groundnut oil.	26
2.8	Effect of Austenite Grain Size on Hardenability in the Jominy End Quench Test.	27
2.9	Rockwell Hardness versus Distance from quenched end for alloy steel and carbon steel [Dr. James Marrow].	28

NO.	TITLE	PAGE
2.10	Rockwell Hardness versus Distance from quenched end for alloy steel and carbon steel [Serdar Z. Elgun].	28
3.1	Dimension of the Jominy Bar.	31
3.2	Jominy End Quenching process.	32
3.3	Sections selected to microstructure examination.	35
4.1	Jominy End Quenched Test data for AISI 1045 before and after Water Quenched.	41
4.2	Jominy End Quenched Test data for AISI 4130 before and after Water Quenched.	45
4.3	Jominy End Quenched Test data for AISI 304 before and after Water Quenched.	49
4.4	Jominy End Quenched Test data for Different Steel Samples (Water Quenched).	51
4.5	Jominy End Quenched Test data for AISI 1045 before and after Oil Quenched.	55
4.6	Jominy End Quenched Test data for AISI 4130 before and after Oil Quenched.	59
4.7	Jominy End Quenched Test data for AISI 304 before and after Oil Quenched.	62
4.8	Jominy End Quenched Test data for Different Steel Samples (Oil Quenched)	65
4.9	Jominy End Quenched Test data for AISI 1045 before and after Air Quenched.	69
4.10	Jominy End Quenched Test data for AISI 4130 before and after Air Quenched.	73
4.11	Jominy End Quenched Test data for AISI 304 before and after Air Quenched.	77

NO.	TITLE	PAGE
4.12	Jominy End Quenched Test data for Different Quench Mediums for AISI 1045 Carbon Steel.	78
4.13	Jominy End Quenched Test data for Different Quench Mediums for AISI 4130 Low Alloy Steel.	79
4.14	Distortion Profile data for AISI 1045 before and after Water Quenched.	84
4.15	Distortion Profile data for AISI 4130 before and after Water Quenched.	86
4.16	Distortion Profile data for AISI 304 before and after Water Quenched.	88
4.17	Distortion Profile data for AISI 1045 before and after Oil Quenched.	91
4.18	Distortion Profile data for AISI 4130 before and after Oil Quenched.	93
4.19	Distortion Profile data for AISI 304 before and after oil Quenched.	95
4.20	Distortion Profile data for AISI 1045 before and after Air Quenched.	98
4.21	Distortion Profile data for AISI 4130 before and after Air Quenched.	100
4.22	Distortion Profile data for AISI 304 before and after Air Quenched.	102
4.23	The A1-W sample structure at the quenched end under 100X Magnification.	104
4.24	The A1-W sample structure at 2 inch from the quenched end under 100X Magnification.	104

NO.	TITLE	PAGE
4.25	The A2-W sample structure at the quenched end under 100X Magnification.	105
4.26	The A2-W sample structure at 2 inch from the quenched end under 100X Magnification.	106
4.27	The A3-W sample structure at the quenched end under 100X Magnification.	107
4.28	The A3-W sample structure at 2 inch from the quenched end under 100X Magnification.	107
4.29	The A1-O sample structure at the quenched end under 100X Magnification.	108
4.30	The A1-O sample structure at 2 inch from the quenched end under 100X Magnification.	109
4.31	The A2-O sample structure at the quenched end under 100X Magnification.	110
4.32	The A2-O sample structure at 2 inch from the quenched end under 100X Magnification.	111
4.33	The A3-O sample structure at the quenched end under 100X Magnification.	111
4.34	The A3-O sample structure at 2 inch from the quenched end under 100X Magnification.	112

LIST OF SYMBOLS

SYMBOL	DEFINITION
A1-W	AISI 1045 Carbon Steel with Water Quenched
A2-W	AISI 4130 Low Alloy Steel with Water Quenched
A3-W	AISI 304 Stainless Steel with Water Quenched
A1-O	AISI 1045 Carbon Steel with Oil Quenched
A2-O	AISI 4130 Low Alloy Steel with Oil Quenched
A3-O	AISI 304 Stainless Steel with Oil Quenched
A1-A	AISI 1045 Carbon Steel with Air Quenched
A2-A	AISI 4130 Low Alloy Steel with Air Quenched
A3-A	AISI 304 Stainless Steel with Air Quenched

CHAPTER I

INTRODUCTION

Quenching is the most basic and widely practiced steel heat treatment processes. It allows the base properties and performance of the steel to be significantly enhanced, such that a relatively inexpensive and simple starting material can be used for a wide range of demanding applications. Apart from the widely used immersion quenching techniques, the fundamental and latest development of other quenching techniques such as spray quenching, gas quenching in vacuum furnaces and hot salt bath quenching.

Quenching refers to rapid cooling of metal parts from the solution-treating temperature, typically in the range of 845-870 °C (1550 to 1600 °F) for steel alloys. Quenching is performed to prevent ferrite or pearlite formation and allow bainite or martensite to be formed. Martensite is the most commonly desired transformation product; refer to Figure 1.1. Quenching of steel in liquid medium consists of three distinct stages of cooling: vapor phase, nucleate boiling, and convective stage. Quenching is the most critical part of the hardening process. The quenching process has to be designed so as to extract heat from the hot work piece at such a rate as to produce the microstructure, hardness and residual stresses desired. There is much type of quenching techniques such as spray quenching, gas quenching in vacuum furnaces, intensive quenching, hot salt bath quenching, and Jominy end-quenching and so on.

When steel is heated to a temperature above the upper limit of its critical range and is then rapidly cooled in a suitable medium such as water or oil, it is hardened. An increase in hardness is obtained. The increase in hardness is greater as the cooling rate is increased. The ultimate tensile strength of mild steel is greatly improved by water quenching instead of air cooled. The hardened article is usually too brittle for use, and is therefore tempered in order to reduce its hardness and increase its toughness. By tempering is meant reheating steel (however previously treated) to a temperature of tempering, the more does the treated steel approach its condition of minimum hardness.

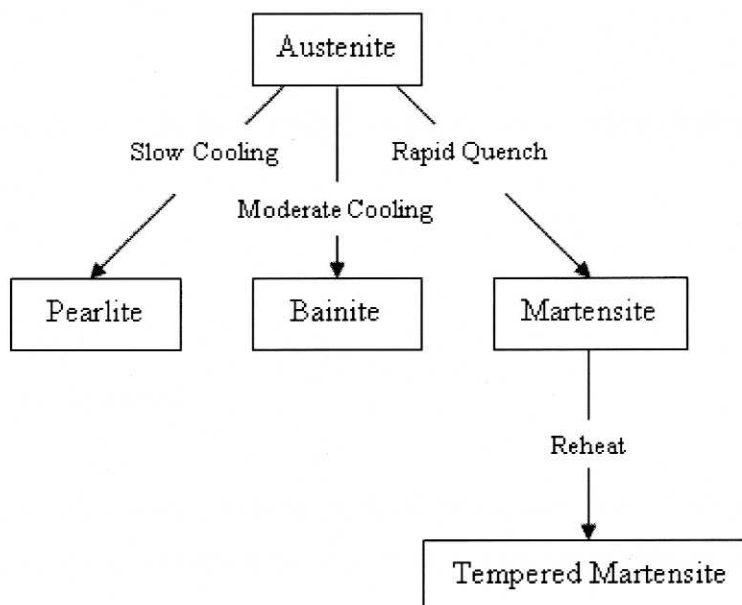


Figure 1.1 Possible transformations involving the decomposition of austenite. Solid arrows, transformations involving diffusion: dashed arrow, diffusion less transformation.

1.1 Objective

The project is concerned with effect of end quenching process based on their hardenability, microstructure and distortion profile. The objectives are as follows:

- 1) To obtain experiment data for AISI 1045 carbon steel, AISI 4130 low alloy steel and AISI 304 stainless steel in three difference quenching medium such as water, quench oil and air;
- 2) To investigate the resultant microstructure of steel when subjected to type of heat treatment; and
- 3) To observe the microstructural changes occur when different parameters involved.

1.2 Scope of Research

- a) Conduct laboratory work on AISI 1045 carbon steel, AISI 4130 low alloy steel and AISI 304 stainless steel with heated austenitizing temperature and cooled in different quenching medium.
- b) The microstructure analyses, hardness and distortion profile will be done after undergoing the end quenching process.