

LOW – ALLOY STEEL MELTING TECHNOLOGY

Kenjaboev Shukurjon Sharipovich,

DSc Professor., Namangan Engineering – Construction Institute

Sarimsakova Sokhibakhon Rakhmonjanovna,

Teacher., Specialized school №8 Under the Department of

Pre – School Education and School Education

Abstract

In this article, the mode of liquefaction of steel alloy was used. The obtained liquid metal is cleaned from non – metallic inclusions and gas pores by non – furnace processing, and casting technology was developed on the basis of energy and resource efficient innovative technologies. The composition of the sand – clay mold was worked out to obtain a high – quality cast product, and a high – quality cast product was obtained by liquefaction. Also, thermal treatment regimes were developed to increase the mechanical properties of the cast alloy, and as a result, a high – quality and resource – efficient cast product was obtained.

Keywords: Chrome, manganese, alloyed, shaft, sand – clay mold, hardness.

INTRODUCTION

The origin of the production of ferrous metal alloys can be traced back to 2000 BC, when manuscripts found in ancient China and India refer to artificial ferrous metals. Competitive forces and market globalization in the metallurgical and mechanical engineering industries continue to develop and implement new technologies for steel and cast iron production in the 21st century. The attitude of the industry to its own local and global technologies leads to the step – by – step improvement of existing technologies, as well as major changes in several important areas, such as the production of steel and its alloys [1 – 4].

Ferrous metal alloys have satisfactory physical – chemical, technological and mechanical properties, they are characterized by the change of properties due to the change of chemical composition, as well as the direction of the properties in the necessary direction due to the change in structure due to thermal treatment, the cost of the alloy is cheaper [5 – 8].

Foundries are one of the important branches of the mechanical engineering industry, in which castings of different shapes and sizes are obtained by pouring various metals or their alloys into a pre – prepared mold. The mass of castings (parts or their semi – finished product) can be from a few grams to 250 tons and more. As for the cast semi – finished product, their shape and size are slightly larger than the investment value, designed for mechanical processing, depending on the shape and size of the details. Statistics show that about 70% by mass of cast irons produced today are gray and modified high – strength cast irons, about 20% are steels, and the rest are malleable cast irons and non – ferrous metal alloys [9, 10].

MATERIAL AND METHODS

Shafts made of 35XGCA steels are used for ball rolling machines in the “1st grade rolling” workshop of “UzMetkombinat” JSC, one of the leading enterprises of our republic. This steel alloy of the 35XGCL brand is cast in the “Casting Mechanics” workshop of the combine.

Alloy steels are of great importance in reducing their mass, while improving the quality of machines and structures, ensuring long – term accurate operation. Alloying elements increase the fineness, viscosity, corrosion resistance and other mechanical properties of steel, as well as the malleability property, the depth of corrosion and other technological properties, change the physical (magnetic and electrical) properties, corrosion resistance properties at high temperatures and under normal conditions. improves [11 – 14].

Today, in the “Casting – Mechanics” shop of “UzMetkombinat” JSC, shafts made of 35XGCL brand steel, which are cast for ball rolling machines, are cast into sand – clay molds. Iron ore, low – manganese steel, secondary metal, ferroalloys, ferrosilicon (FeSi 65), ferromanganese (FeMn 95), calcium carbonate (CaCO_3) and others were prepared as raw materials for slag. A basic 2.0 ton electric arc furnace was initially selected to liquefy the alloy. After checking that the inner lining of the furnace was in good condition, first small and then large solid materials were loaded into the furnace. As soon as the alloy began to liquefy, 3 percent limestone (CaCO_3) by weight of the alloy was added to the furnace as a flux. According to the established norms, the temperature of liquefaction of the chemical composition reached 1550°C . After that, ferroalloys with high melting point were put into the furnace at 1565°C [15, 16]. To reduce the carbon content of the alloy, oxygen was pumped from the side of the furnace with a pressure of 0.8 – 1 MPa through a specially installed furnace. As a result, carbon and harmful gases in the alloy were reduced. After the alloy was completely liquefied, samples were taken from three places by mixing the liquid alloy, and the chemical composition of the alloy was checked on the “SPECTROLAB – 10 L” equipment. When the temperature of the liquid alloy reached $1610 - 1620^\circ\text{C}$, it was poured into a special ladle preheated to $800 - 850^\circ\text{C}$.



a)



b)

1 – picture. a) The process of loading ferroalloys into the furnace, b) The process of heating the furnace using a gas burner

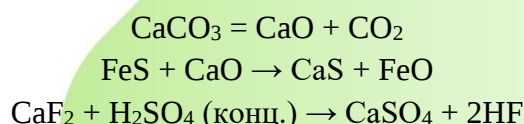
Several methods were used in order to reduce gas pores and mirror inclusions in the alloy, to obtain high – quality cast products [17, 18].

The first method: This method is considered a chemical method and cleans the alloy from non – metallic inclusions by 50 – 70%. For this purpose, synthetic slag (55% CaO, 40% Al₂O₃ and a small amount of SiO₂, MnO, FeO) liquefied in an electric furnace was introduced into the furnace at 3 – 5 % based on the weight of the liquid alloy. In this method, the liquid alloy quickly reacts with the synthetic slag, cleaning the mirrors from impurities and gases. Then it became possible to obtain high – quality cast products.

The second method: This method is to process the steel alloy in a vacuum chamber, and this method is shown. It is known that the dissolution of O₂, H₂, N₂ and other gases in it decreased as the metal pressure in the furnace decreased. As a result, the gases released from it also followed the mirror inclusions with it. Therefore, in order to clean the metal in the cavity from gases and non – metallic materials, first the air in the chamber was pushed to a pressure of 0.267 – 0.667 kPa, then the molten metal was introduced into it and kept there for 10 – 15 minutes. Non – metallic inclusions followed along with the gases separated from the metal in the form of bubbles, and as a result, the amount of gases in it decreased by 3 – 5 times, and the amount of non – metallic inclusions decreased by 2 – 3 times.

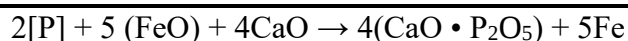
The third method: In this method, one of the inert gases (helium, neon, argon, krypton, xenon, radon, oganesson) was transferred from the liquid alloy in the cavity under a low pressure. In this, the metal was thoroughly mixed and cleaned of gas and non-metallic inclusions. Casting in a stream of inert gases through a special device to prevent metal from oxidizing when pouring into the mold gave good results, especially for alloy steel ingots.

The fourth method: It is considered to purify the alloy from sulphur, which is a harmful element, and for this purpose, the liquid alloy was removed from the furnace in another electric furnace. For this, the temperature of the liquid alloy is raised to 1630 – 1650⁰ C in the second electric furnace, slaked limestone (CaCO₃) and CaF₂ are introduced into the furnace, and after holding for 10 – 15 minutes, the slag separated from the liquid alloy is taken out of the furnace.



The fifth method: In this case, the harmful element in the alloy was removed from phosphorus, and for this purpose, the liquid alloy was removed from the furnace in another electric furnace. For this, the temperature of the liquid alloy is raised to 1440 – 1450⁰ C in the second electric furnace, slaked limestone (CaCO₃) is introduced into the furnace, and after 8 – 10 minutes, the slag separated from the liquid alloy is thrown out.





After using the out – of – furnace liquid alloy in five ways, the liquid alloy was cast into prepared sand – clay molds after removing pores and mirror inclusions.

CONSLUCION

Based on the liquefaction regimes of steel alloy at different temperatures in electric arc furnaces, the technology of obtaining cast products with surface cleanliness and high mechanical properties has been improved, and the technology of liquefaction of the alloy in an optimal way and pouring into casting molds has been developed. The alloy was treated with inert gases outside the furnace. Processing mode and casting technology were developed based on the dynamics of gas and mirror inclusions in the resulting alloy.

Based on the results of the research, the following conclusions were made, which were taken as the main reasons for the flux, furnace lining, quality of refractory materials, preheating process of the charge and other similar factors. Based on the stated reasons, the quality of the furnace lining and lining material were considered to be the most important factors that led to a decrease in the quality of the final casting.

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