



FERROUS FOUNDRYMAN'S

H A N D B O O K



Contents

<i>Preface</i>	<i>xi</i>
<i>Acknowledgements</i>	<i>xii</i>
Chapter 1 Tables and general data	1
SI units and their relation to other units	1
SI, metric, non-SI and non-metric conversions	2
Conversion table of stress values	5
Areas and volumes of circles, spheres, cylinders etc.	6
The physical properties of metals	7
Densities of casting alloys	9
Approximate bulk densities of common materials	10
Patternmakers' contraction allowances	11
Volume shrinkage of principal casting alloys	13
Comparison of sieve sizes	14
Calculation of average grain size	15
Calculation of AFS grain fineness number	16
Recommended standard colours for patterns	17
Dust control in foundries	18
Buoyancy forces on cores	18
Opening forces on moulds	19
Dimensional tolerances and consistency achieved in castings	21
Chapter 2 Types of cast iron	23
Introduction	23
Physical properties of cast irons	27
Iron casting processes	28
Chapter 3 Grey cast iron	30
Specifications	30
Relationship between composition, strength and structure of grey cast iron	32
Applications of grey iron castings	37
The production of grey irons	37

Chapter 4 Melting cast iron	40
Introduction	40
Cupola melting	40
Electric melting	53
Shop floor control of metal composition	60
Chapter 5 Inoculation of grey cast iron	62
Introduction	62
Ladle inoculation	64
Late stream inoculation	66
Mould inoculation	69
Chapter 6 Ductile iron	70
Production of ductile iron	70
Melting ductile iron base	74
Cupola melting and duplexing	74
Induction furnace melting	75
Use of the tundish cover ladle	75
Sandwich treatment	77
NODULANT	77
Pure magnesium converter process	77
Cored wire treatment	78
In-the-mould treatment	78
Inhibiting elements	78
Inoculation and fading	79
Specifications for ductile cast iron	79
Heat treatment of ductile iron	82
Casting ductile iron	84
Compacted graphite irons	84
Chapter 7 Malleable cast iron	90
Introduction	90
Whiteheart malleable	90
Blackheart malleable iron	92
Chapter 8 Special purpose cast irons	95
Heat resisting alloys	95
Corrosion resistant cast irons	101
Wear resistant cast irons	102

Chapter 9 Types of steel castings	108
Introduction	108
Specifications for steel castings	109
Types of steel castings	111
Carbon steels	112
Low alloy and medium alloy steels	112
Austenitic manganese steel	114
High alloy steels	114
Duplex steels	117
Physical properties of steels	117
Selection of suitable steel for casting	117
Chapter 10 Melting and treatment of steel for casting	121
Arc furnace melting	121
Induction furnace melting	123
AOD refining	125
Melting and casting quality	125
Chapter 11 Molten metal handling	130
Iron foundries	130
Metal handling systems	130
Ladle lining	130
KALTEK ladle lining system for iron foundries	132
KALTEK insulating lining system for automatic pouring boxes	136
Casting defects due to poor ladle maintenance	137
Molten metal handling in steel foundries	138
Ladle practice	138
The KALTEK ladle lining system	142
Pouring temperature for steels	144
Chapter 12 Sands and green sand	146
Silica sand	146
Measurement of sand properties	149
Non-silica sands	151
Green sand	152
Parting agents	163
Special moulding materials, LUTRON	163
Green sand moulding machines	164

Chapter 13 Resin bonded sand	167
Chemical binders	167
Self-hardening process	167
Sand reclamation	173
Self-hardening resin binder systems	180
Triggered hardening systems	184
Heat triggered processes	186
Gas triggered processes	192
Review of resin coremaking processes	198
Chapter 14 Sodium silicate bonded sand	204
CO ₂ silicate process (basic process)	204
Improvements to the CO ₂ silicate process	207
Self-setting sodium silicate processes	209
Adhesives and sealants	213
Chapter 15 Lost foam casting	216
Principle of the process	216
Patternmaking	217
Assembling clusters	218
Coating the patterns	218
Investing in sand	218
The mechanism of casting into foam patterns	218
Advantages of lost foam casting	221
Disadvantages	222
Applications	222
The future	224
Chapter 16 Coatings for moulds and cores	226
The need for a coating	226
Choice of coating and form of supply	227
Components of a coating	228
Application methods for coatings	230
Coatings for iron and steel foundries	234
Coatings for high production foundries	234
Coatings for jobbing moulds and cores	237
Spirit based coatings	237
The TRIBONOL process	240
Miscellaneous coatings	241
Coatings for foundry tools	243

Chapter 17 Filtration and the running and gating of iron castings	245
Introduction	245
Conventional running systems without filters	245
Filtration of iron castings	250
SEDEX ceramic foam filters	256
Cellular ceramic filters	259
Combined filter, feeder and pouring cup, the KALPUR direct pouring system	266
 Chapter 18 Filtration and the running and gating of steel castings	 272
Introduction	272
Controlling the flow of metal	272
Conventional running systems without filters	274
The use of ceramic foam filters	277
Inclusions in steel castings	277
STELEX ZR ceramic foam filters	279
KALPUR ST direct pour unit	286
Cost savings through the use of STELEX and KALPUR	294
 Chapter 19 Feeding of castings	 296
Introduction	296
Natural feeders	296
Aided feeders – feeding systems	297
The calculation of feeder dimensions	301
Determination of feeding requirements	305
Steel, malleable iron, white irons, light alloys and copper based alloy castings	305
Grey and ductile irons	307
Foseco feeding systems	310
KALPUR filter feeder units	322
Breaker cores	323
Application of feeder sleeves	325
FERRUX anti-piping compounds for iron and steel castings	331
Aids to the calculation of feeder requirements	334
FEEDERCALC	335
 Chapter 20 Computer simulation of casting processes	 344
Introduction	344
Solidification modelling	344

x *Contents*

Mould filling simulation	346
The SOLSTAR solidification program	346
Cost benefits of solidification simulation	351
Conclusions	352
<i>Index</i>	353