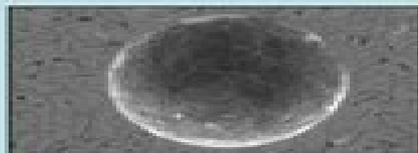


Hydrogen Blowhole



Problem causes:
 High moisture content in charge or alloy materials
 Inadequate degassing or filtration
 High content of aluminium or silicon
 High level of sulphur in moulding sand
 Multiple use of metal alloy
 Heat treated or annealed
 Iron or steel in contact with and/or produced from
 Iron or steel in contact with and/or produced from moisture

Nitrogen Fissure



Problem causes:
 Use of high steel scrap content in waste melted iron
 Inadequate degassing or filtration
 Use of materials with high nitrogen content
 Use of high nitrogen materials (e.g. 20 or 25% of steel scrap) in the charge
 Inadequate degassing

Compaction of Graphite Flakes



Problem causes:
 Normally found in medium to heavy sections, often in association with nitrogen fissures.
Problem causes:
 High oil content in charge combined with high moisture content
 Use of materials with high nitrogen content
 Use of materials with high sulphur content
 Inadequate degassing or filtration
 Inadequate heat treatment

Shrinkage



Problem causes:
 Not suitable or not properly used sand
 Inadequate compaction or shaking
 Not suitable moulding from cavity design and pattern and
 Drafting design causing large changes in casting section
 Use of steel tools

Slag Entrapment



Problem causes:
 Inadequate slag removal during melting and pouring
 Inadequate slag removal from ladle
 Lack of slag traps or filters
 Use of high sulphur and high nitrogen materials
 Poor quality of any filtering materials
 Inadequate pouring

Carbon Monoxide Blowhole



Problem causes:
 High sulphur in composition with high temperature content
 Inadequate degassing or filtration
 Use of high sulphur and high nitrogen materials
 Inadequate pouring
Note: Carbon monoxide blowholes are also caused by the manganese sulphide blowholes.

Intercellular Carbide



Problem causes:
 Excess of carbon in charge combined with high moisture content
 Use of C, Si, Mn and Fe
 Low levels of graphite promoting elements such as Bi, Sb and Pb in base iron
 Low sulphur content
 Inadequate degassing and long holding of base iron
 Too high amount of steel scrap in the charge

Steadite



Problem causes:
 Excess of high phosphorus content
 Too high sulphur in base iron
Note: High phosphorus content also increases the likelihood of brittleness and distortion of the iron.

Undercooled Graphite



Problem causes:
 Inadequate degassing or filtration
 Rapid solidification
 Inadequate pouring
 High content of sulphur
 Low content of graphite

C Type Graphite



Problem causes:
 Also called worm graphite, is mainly found in iron with higher sulphur content.
Problem causes:
 Often found in combination of very slow cooling rate and low sulphur content

Widmanstätten Graphite



Problem causes:
 High content of base elements such as Fe, Si and Mn
 Often seen in thicker sections subject to slower cooling rate and segregation.

Ferritic Rim



Problem causes:
 Too low content of graphite in generalised moulds
 Under solidification
 Slow solidification
 Low pouring temperature

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Common Metallurgical Defects In Grey Cast Irons

Raffaella Di Napoli



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