

Heat Treatment Processes



Neeco Industries, Inc.

Introduction

. Heat Treatment

- *Heat Treatment process is a series of operations involving the **Heating and Cooling** of metals in the solid state.*
- *Its purpose is to change a mechanical property or combination of mechanical properties so that the metal will be more useful, serviceable, and safe for definite purpose.*
- *By heat treating, a metal can be made harder, stronger, and more resistant to impact, heat treatment can also make a metal softer and more ductile.*

- *No one heat-treating operation can produce all of these characteristics. In fact, some properties are often improved at the expense of others. In being hardened, for example, a metal may become brittle.*





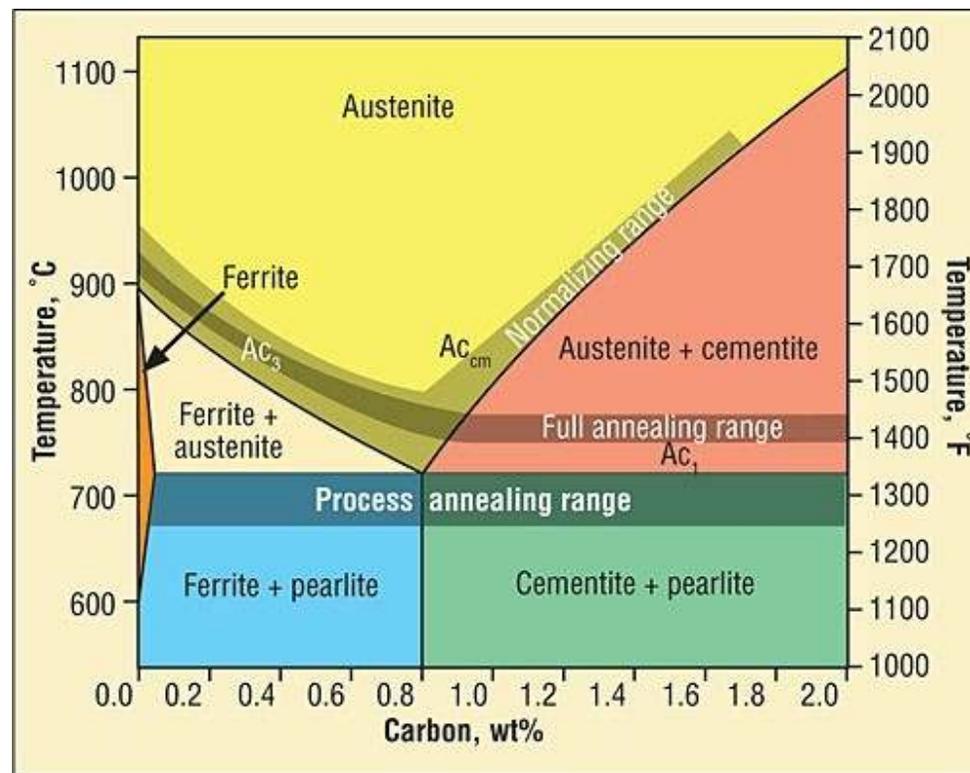
Types of Heat Treatment

- 1. Annealing*
- 2. Normalizing*
- 3. Quenching or Hardening*
- 4. Tempering*
- 5. Surface Hardening*
- 6. Case Hardening*
- 7. Austempering*
- 8. Marquenching*
- 9. Ausforming*

1. Annealing

- **Annealing** is the process for softening materials or to bring about required changes in properties, such as machinability, mechanical or electrical properties, or dimensional stability.
- The annealing process consists of heating the steel to or near the critical temperature (temperature at which crystalline phase change occurs) to make it suitable for fabrication.
- A material can be annealed by heating it to a specific temperature and then letting the material slowly cool to room temperature in an oven.

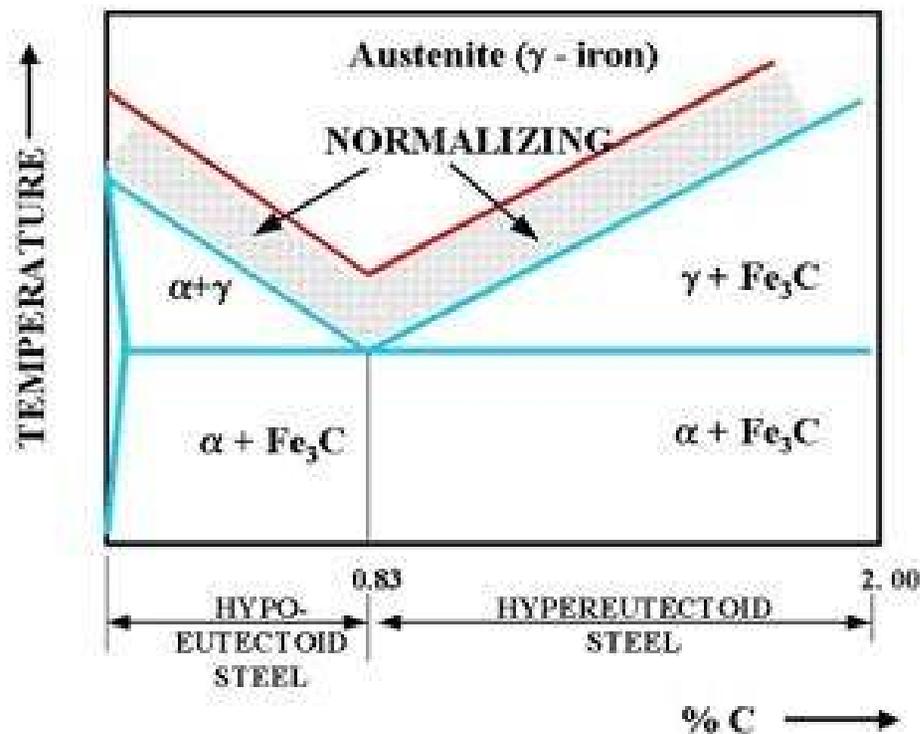
- When an annealed part is allowed to cool in *the furnace*, it is called a "*full anneal*" heat treatment.



2. Normalizing

- It is a type of heat treatment applicable to ferrous metals only.*
- It differs from annealing in that the metal is heated to a higher temperature and then removed from the furnace for air cooling.*
- The purpose of normalizing is to remove the internal stresses induced by heat treating, welding, casting, forging, forming, or machining.*

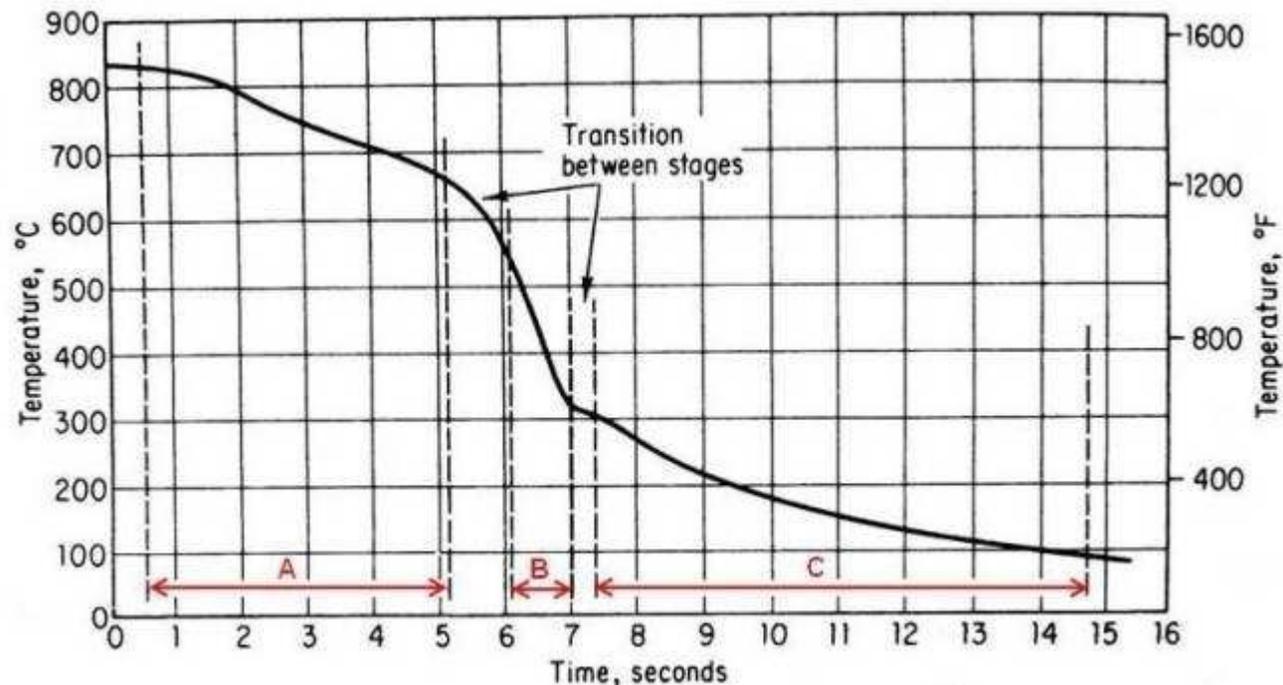
- *Normalizing is used in some plate mills, in the production of large forgings such as railroad wheels and axles, some bar products. This process is less expensive than annealing.*



3. Quenching or Hardening

- It is done to increase the strength and wear properties. One of the pre-requisites for hardening is sufficient carbon and alloy content.*
- To harden by quenching, a metal (usually steel or cast iron) must be heated into the austenitic crystal phase and then quickly cooled.*
- Depending on the alloy and other considerations (such as concern for maximum hardness vs. cracking and distortion), cooling may be done with forced air or other gas (such as nitrogen), oil , polymer dissolved in water, or brine.*

- *One drawback of using this method by itself is that the metal becomes brittle. This treatment is therefore typically followed by a **tempering process** which is a heating process at another lower specific temperature to stress relieve the material and minimize the brittleness problem.*



Typical cooling curve for a small cylinder quenched in warm water

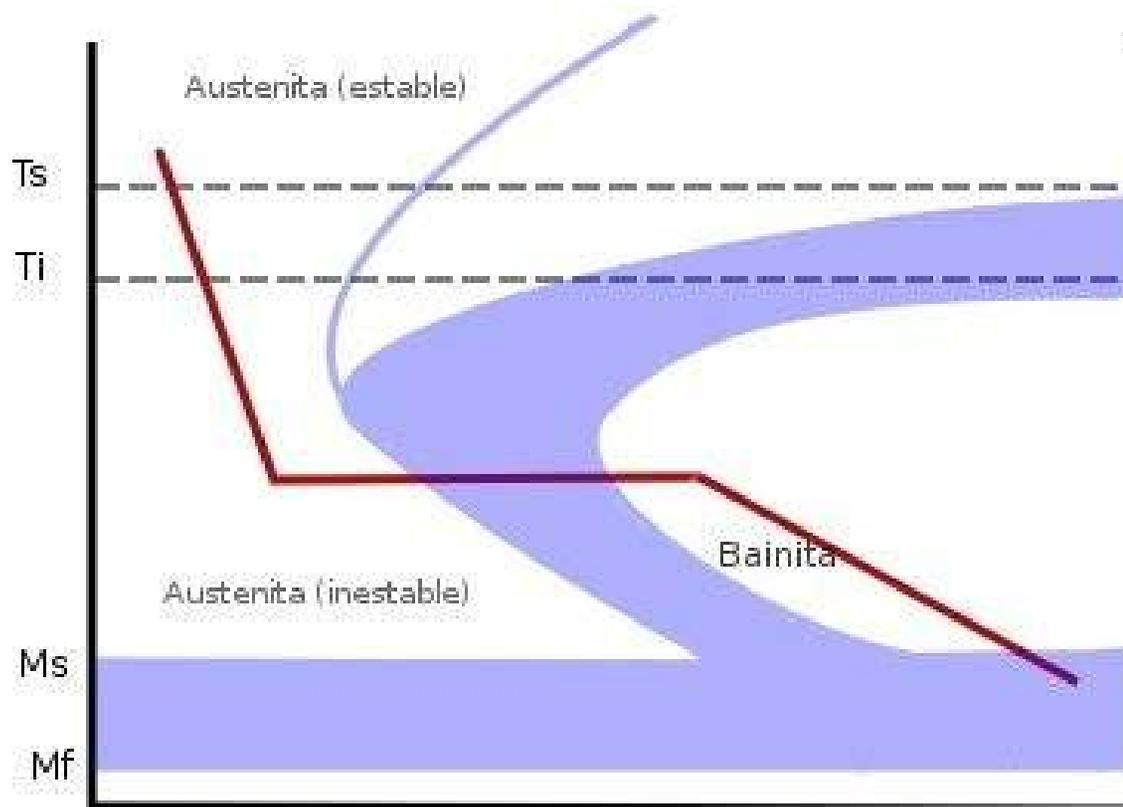
4. Case Hardening

- *Case Hardening is the process of hardening the surface of a metal, often a low carbon steel, by infusing elements into the material's surface, forming a thin layer of a harder alloy.*
- *Case hardening improves the wear resistance of machine parts without affecting the tough interior of the parts.*



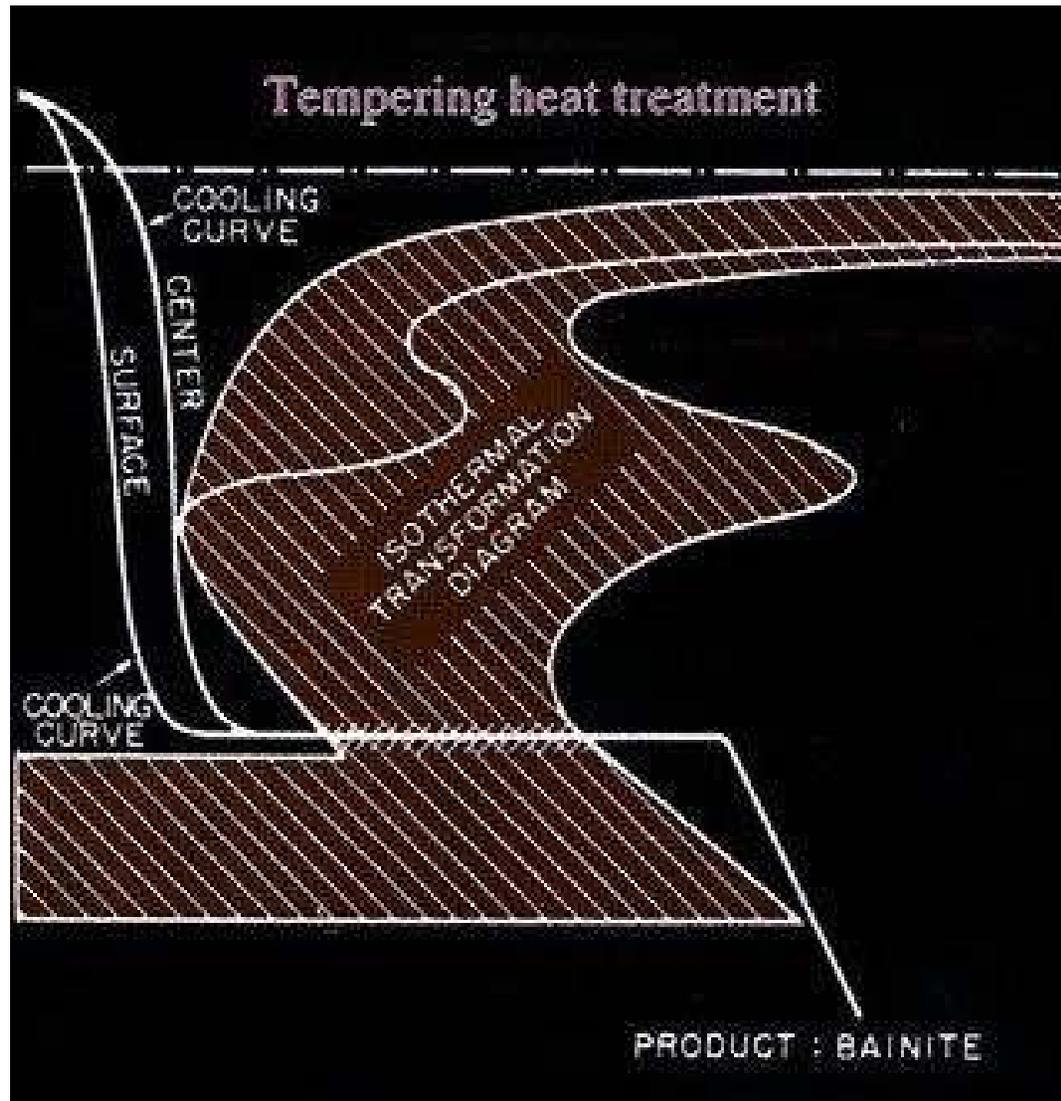
5. Austempering

- **Austempering** is heat treatment that is applied to ferrous metals, most notably steel and ductile iron.
- In steel it produces a bainite microstructure whereas in cast irons it produces a structure of acicular ferrite and high carbon, stabilized austenite known as ausferrite.
- It is primarily used to improve mechanical properties or reduce / eliminate distortion.



6. *Tempering*

- *Tempering is carried out by preheating previously quenched or normalized steel to a temperature below the critical range, holding, and then cooling to obtain the desired mechanical properties.*
- *Tempering is used to reduce the brittleness of quenched steel.*
- *The temperature chosen for the tempering process directly impacts the hardness of the work piece . The higher the temperature in the tempering process, the lower the hardness.*



7. Surface Hardening

- **Surface hardening**, treatment of steel by heat or mechanical means to increase the hardness of the outer surface while the core remains relatively soft.
- Surface-hardened steel is also valued for its low and superior flexibility in manufacturing.
- The oldest surface-hardening method is **carburizing**, in which steel is placed at a high temperature for several hours in a carbonaceous environment. The carbon diffuses into the surface of the steel, rendering it harder.

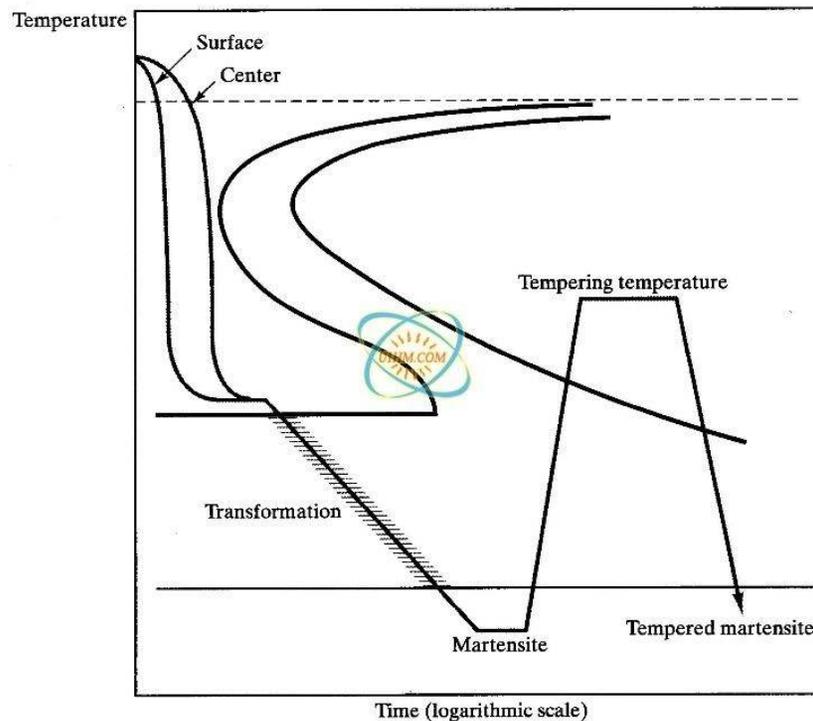
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- *Another method of surface hardening, called **nitriding**, utilizes nitrogen and heat. Cam shafts, fuel injection pumps, and valve stems are typically hardened by this process.*
 - *Flame **hardening** and induction hardening, in which high heat is applied for a short time (by gas flame or high-frequency electric current, respectively) and then the steel is immediately quenched, are used generally for larger implements.*

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- *Mechanical means of hardening the surface of steel parts include peening, which is the hammering of the heated surface, as by iron pellets shot onto the surface or by air blasting, and cold-working, which consists of rolling, hammering, or drawing at temperatures that do not affect the composition of the steel.*

8. MARTEMPERING(MARQUENCHING)

- *To overcome the restrictions of conventional quenching and tempering, Martempering process can be used.*
- *Martempering or marquenching permits the transformation of Austenite to Martensite to take place at the same time throughout the structure of the metal part.*
- *Residual stresses developed during martempering are lower than those developed during conventional quenching.*

- *Martempering also reduces or eliminates susceptibility to cracking.*
- *Another advantage of martempering in molten salt is the control of surface carburizing or decarburizing.*



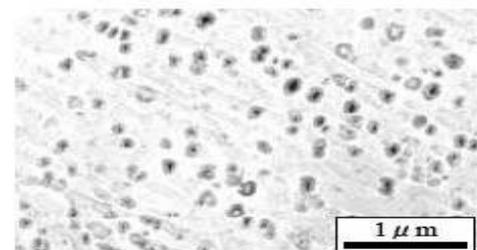
9. Ausforming

- **Ausforming** also known as *Low and High temperature thermomechanical treatments* is a method used to increase the hardness and stubbornness of an alloy by simultaneously tempering, rapid cooling, deforming and quenching to change its shape and refine the microstructure.

Atmosphere furnace
tempering
(using conventional
heat treatment
furnace)



Ausforming
&
HOP rapid heating
and tempering
(using HOP)





THANK YOU



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