

FUNCTIONS OF THE ALLOYING ELEMENTS IN STEEL

By DR. EDGAR C. BAIN

U. S. Steel Corporation

Pittsburgh, Pa.



A SERIES OF FIVE EDUCATIONAL LECTURES ON THE FUNCTIONS OF THE ALLOYING ELEMENTS IN STEEL PRESENTED TO MEMBERS OF THE A. S. M. DURING THE TWENTY-FIRST NATIONAL METAL CONGRESS AND EXPOSITION, CHICAGO, ILLINOIS, OCTOBER 23 to 27, 1939.

Copyright 1939
by
American Society for Metals
Cleveland, Ohio

Second Printing
July, 1940

Third Printing
May, 1943

Fourth Printing
July, 1945

Printed in U.S.A.

FOREWORD

A CRITICAL appraisal of the several series of educational lectures presented in the past to the members of the American Society for Metals on the occasions of the Annual Metal Congress would undoubtedly emphasize the degree to which the lecturers had succeeded in making admittedly complex technical subjects seem convincingly simple. Nor has this circumstance been the result of either verbal legerdemain or superficiality. It is rather the manifestation of orderly thought, clear writing and, in short, good teaching. With a precedent of this nature well established, the present author could certainly do no less than strive to maintain the tradition; indeed, only to the extent to which this discussion of the roles of the alloying elements in steel adheres to the established standards of simple, logical presentation, may any satisfaction be taken in its preparation.

Most simplifications of comprehensive subjects are accomplished by the device of classification, — the assignment of things and phenomena to categories. Upon the skill in setting up the categories largely depends the acceptability of the simplification. In the present instance the choice of useful categories may be regarded as more or less obvious but that they be convincing requires a great many exemplifications. In the field of steels carrying alloying elements it is not always easy to secure examples which are not confusing by reason of manifesting more than a single active factor and likewise more than one single effect.

In securing an adequate number of examples of the physical-metallurgical influences exerted by the alloying elements with a single variable exerting a single effect at a time, the author has been greatly assisted by the work of those to whom acknowledgment is made in the footnotes. These acknowledgments cannot, however, adequately express the author's

appreciation nor his gratitude. To the staff of the United States Steel Corporation Research Laboratory, and several Research Institutions of the Manufacturing Subsidiary Companies of the United States Steel Corporation, are due special thanks for skillful experimentation and for data. To Mr. Milton Male, Research Engineer, United States Steel Corporation of Delaware, the author gratefully acknowledges his indebtedness for valued assistance with the drawings illustrating the lectures.

TABLE OF CONTENTS

	PAGE
CHAPTER I	
INTRODUCTION—(VIEWPOINT AND SCOPE)	1
CHAPTER II	
FUNDAMENTAL CHARACTERISTICS OF STEELS	6
Allotropy and Binary Alloys of Iron	6
Significance of Equilibrium Diagrams	12
THE CARBON STEELS	17
The Ferrite-Carbide Aggregate	17
The Solid-Solution Austenite	18
The Transformation of Austenite is Controllable	18
Modes of Carbide Dispersion	20
The Lamellar Family of Structures	23
The Pro-Eutectoid Reaction	31
The Acicular Mode of Transformation	34
The Nature of Martensite	35
Tempering	37
Spheroidal versus Lamellar Structures	38
Transformation of Austenite at Constant Temperatures	40
Hardenability	44
Grain Size and Hardenability	48
Limitations of Carbon Steel in Hardenability	52
Austenite Grain Size and Final Properties	54
SUMMARY OF CARBON STEELS AND NEED FOR ALLOYS	56
CHAPTER III	
ALLOYING ELEMENTS IN UNHARDENED STEELS	59
Classification of the Constituents in Alloy Steel	59
DISTRIBUTION OF THE COMMON ELEMENTS IN ANNEALED STEEL	61
Principles of Distribution	61
General Trends in Distribution of the Elements	62
EFFECTS OF THE ALLOYING ELEMENTS UPON FERRITE	65
Solid-Solution Hardening Effect in Pure Iron	65
Solid-Solution Hardening in the Presence of Carbide	67
Constant Heat-Treatment versus Constant Structure	71
Individuality of the Elements in Ferrite	73
EFFECTS OF THE ELEMENTS UPON CARBIDE	74
Cementite and the Special Carbides	74
Chromium in Carbides	78
Molybdenum in Carbides	79
Tungsten in Carbides	80
Vanadium in Carbides	82
Special Carbides in Annealed Alloy Steel—Summary	83
EFFECTS OF ELEMENTS IN NONMETALLIC INCLUSIONS	83
Nonmetallic Inclusions and Machinability	84
EFFECTS OF ALLOYING ELEMENTS IN INTERMETALLIC COMPOUNDS....	86
Nitrides Possibly a Special Case	87
EFFECTS OF ELEMENTS IN DISPERSED METALLIC PARTICLES	88

	PAGE
SUMMARY OF ALLOYING ELEMENTS IN UNHARDENED STEELS	89
Partition of Elements Between Ferrite and Carbide	89
Steels Dominated by Alloy-Bearing Ferrite	89
Low-Alloy, High-Strength, Structural Steel	90
Special Low-Carbon, High-Alloy Steels	91
Typical Property Changes Induced by Alloying Elements	92
Individuality of the Elements in Unhardened Steel	95

CHAPTER IV

EFFECTS OF ALLOYING ELEMENTS IN FORMING AUSTENITE	100
ALLOYING ELEMENTS IN STEEL RENDERED AUSTENITIC FOR HARDEN- ING	100
Importance of Appropriate Heating for Hardening	101
The Formation of Austenite by Carbon Diffusion	101
Selecting the Heating Temperature	112
Ternary Space Models and Their Sections	113
Abbreviated Temperature-Constant Alloy Sections	115
Composition Range for Austenite at Constant Temperature	122
Eutectoid Composition and Temperature in Alloy Systems	126
Equilibrium versus Rate of Solution (Diffusion)	128
ALLOY DISTRIBUTION IN HEATED STEELS	129
Elements Dissolved in Austenite	130
Elements in Undissolved Carbide	130
Persistent Carbides and Grain Size	133
Elements in Nonmetallic Inclusions	133
Usefulness of Nonmetallic Inclusions	134
Inclusions and Grain Growth	135
Aluminum-Treated Steels and Grain Growth	135
SUMMARY OF ELEMENTS IN STEEL AT AUSTENITIC TEMPERATURE ...	142

CHAPTER V

EFFECTS OF THE ELEMENTS IN HARDENING STEEL	144
Need for Heat-Treatment and Alloys	144
CHARACTERISTICS OF THE AUSTENITE-MARTENSITE TRANSFORMATION.	145
The Hardness of Martensite—Retained Austenite	145
Alloys and Martensitic Hardness	146
Carbon and Martensitic Hardness	148
CONCEPTS OF HARDENABILITY	150
Intensity of Hardening versus Hardenability	150
Measurable Manifestations of Hardenability	151
Estimations and Designations of Hardenability	155
The Physics of Hardenability	161
Summary of Hardenability Designations	172
EFFECTS OF ALLOYING ELEMENTS UPON HARDENABILITY	174
Factors Influencing Hardenability	175
Elements in Solution in Austenite	177
Depression of A_r a Reflection of Hardenability	185
Designating Dissolved Alloy versus Hardenability	186
Elements in Carbides	187
Anomalous Hardening at Low Heating Temperatures	192
Elements in Nonmetallic Inclusions	194

	PAGE
Microscopic Homogeneity and Hardenability	199
Hardenability of Familiar Compositions	201
Extra-Equilibrium Constitution Diagrams	206
Factors Extraneous to the Steel	208
Significance of Heating Temperature	221
UNIQUE STRUCTURES IN ALLOY STEELS	223
Comparison of S-Curves	226
Individual Alloy Effect on Special Structure	227

CHAPTER VI

EFFECTS OF ALLOYING ELEMENTS IN TEMPERING	228
NATURE OF THE TEMPERING REACTION	229
Time and Temperature Relationships in Tempering	230
Retained Austenite During Tempering	234
Alloying Elements and Softening	244
RETARDATION OF SOFTENING AND SECONDARY HARDNESS	246
Tempering in the Presence of Carbide-Forming Elements	246
Time Interval and Secondary Hardening	265
The Secondary Hardness Mechanism	271
Strength at Elevated Temperature	275
Advantages of Special Dispersions	276
SIMILARITIES IN TEMPERED ALLOY STEELS	277
Hardness and Tensile Properties	277
LOSS OF TOUGHNESS IN INTERMEDIATE TEMPERING	281
Low Temperature Tempering	281
Heat Evolutions in Tempering	287
Loss of Toughness at Higher Tempering Temperatures	288
TEMPERING OF STRUCTURES OTHER THAN MARTENSITE	290
Rates of Softening in Three Structures	291
VALUE OF TEMPERING DATA	293
STEELS RENDERED INHOMOGENEOUS	295
Carburized Steels	296
Hardening Case-Carburized Steels	298
Nitrided Steels	299
RECAPITULATION	300