Contents

Part A	Microstructure of Steels
	By W. Pitsch, G. Sauthoff (A1-A8), and H. P. Hougardy (A9)

A1	Introduction	3
A 2	Thermodynamics of Iron and Iron-based Alloys	
A 2.1	Pure Metals	
A 2.1.1	Nonmagnetic Metals	
A 2.1.2	Iron	
A 2.2	Alloys	
A 2.2.1	Substitutional Solid Solutions Descriptions of the Gibbs energies. Equilibria in substitutional solid solutions. Chemical potential and chemical activity of a component Applications	
A 2.2.2	Interstitial Solid Solutions	20
A 2.2.3	Substitutional-Interstitial Solid Solutions	25
A 2.2.4	Stoichiometric Compounds	26
A 2.2.5	Graphite	31
A 2.2.6	Quantitative Data of Thermodynamic Functions and Equilibria	21
A 2.3	Influence of Lattice Defects	
A 3	Nucleation	36
A 3.1	Preliminary Energy Considerations	36
A 3.2	Nucleation Energy	38
A 3.3	Nucleation with Elastic Strain	41
A 3.4	Heterogeneous Nucleation.	43
A 3.5	Time-Temperature-Nucleation Diagrams	45
A 4	Diffusion	49
A 4.1	Diffusion of Interstitial Atoms	50
A 4.1.1	Diffusion Flux	50
A 4.1.2	Diffusion Coefficient	52
A 4.2	Diffusion of Substitutional Atoms in One-Component Crystals	56
A*4.3	Diffusion at Grain Boundaries and Dislocations	
A 4.4	Diffusion of Substitutional Atoms in Binary Solid Solutions.	59
A 4.5	Carbon Diffusion in Substitutional Alloys	62
A 4.6	Diffusion of Substitutional Atoms in Ternary Alloys	64
A 4.7	Evolution of Solute Distribution with Time	65
A 4.8	Diffusion in Compounds	
A 5	Typical Microstructures in Steel.	68
A 5.1	Definition of Microstructure.	68
A 5.2	Microstructure of Low Alloy Steels after Transformation of Austenite	69

A 5.3	Microstructures in Low Alloy Steels after Annealing	78
A 5.4	Effect of Substitutional Alloying Elements	83
A 6	Kinetics and Morphology of Steel Constituents	86
A 6.1	Austenite	86
A 6.1.1	Austenitization in the Single-phase v-range	90
A 6 1 2	Austenitization in the Two-phase Pange	00
A 6 1 3	Effect of Substitutional Alloving Elements	00
A 6 1 4	Degree of Homogenization	09
A 6 0		91
A 0.2		91
A 0.2.1		92
A 0.2.2		94
A 0.2.3	Unbilited Conservable	95
A 0.2.4	Substitutional Allouing Flowants	99
A 0.2.5		100
A 0.2.0	Coarsening	101
A 0.2.7		105
A 6.3	Pearlite	108
A 6.3.1	Energetics	108
A 6.3.2	Nucleation	110
A 6.3.3	Growth Kinetics of Lamellar Pearlite	111
A 6.3.4	Effects of Substitutional Alloying Elements	117
A 6.4	Martensite	120
A 6.4.1	Characteristic Attributes of Martensitic Transformations.	120
A 6.4.2	Energetics	121
A 6.4.3	The Crystallographic Model for the Formation of Plate-Martensite	122
	Conditions of the transformation. Lattice-variant (Bain)-deformation. Lattice-in-	125
	variant deformations. Habit plane. Orientation relationship. Total deformation	
A 6.4.4	Lath-Mantensite.	130
A 6.4.5	Nucleation of Martensite	131
A 6.4.6	Thermoelastic Martensite	133
465	Rainita	135
A 6 5 1	Characteristics of Bainitic Transformations and Microstenatures	135
A 6 5 2	Mechanisms and Classes of Dainitic Transformations	130
A 6 5 3	Crystallographic Investigations of Bainitic Transformations	141
110.5.5		144
A7	Structure Development by Thermal and Mechanical Treatments	147
A 7.1	Annealing of One-Phase Microstructures After Prior Cold Deformation	147
A 7.1.1	Recovery	147
A 7.1.2	Recrystallization.	148
A 7.1.3	Grain Coarsening.	151
A 7.2	One-Phase Microstructures During Hot Deformation	153
A73	Annealing of Microstructures with Presidented Particles After Cold D. Const	155
	Annealing of Wicrostructures with Precipitated Particles After Cold Deformation.	155
A /.4	Annealing of Transformable Ferrific Microstructures After Deformation	157
A 7.5	Annealing of Transformable Austenitic Microstructures After Deformation	160
A 7.6	Annealing of Transformable Microstructures with Concurrent Deformation	162
A 8	Comparative Summary of the Reactions in Steel	165
A 9	Description and Control of Transformations in Technical Applications	167
A 9.1	Equilibrium Diagrams	167
A 9.2	Time-Temperature Austenitization Diagrams	170
A 9.2.1	Time-Temperature Austenitization Diagrams for Isothermal Austenitization	1/0
	of Hypereutectoid Steels	172
A 9.2.2	Time-Temperature Austenitization Diagrams for Hypo-entectoid Steels	174
A 9.2.3	Austenitization Diagrams for Continuous Heating	175
A 9.2.4	Influence of Chemical Composition and Microstructure	.7.5
	on the Austenitization Kinetic	176

A 9.2.5	Austenite Grain Size	177
A 9.2.6	Accuracy and Precision of Time-Temperature Austenitization Diagrams	179
A 9.2.7	Time-Temperature Austenitization Diagrams and Equilibrium Diagrams	179
A 9.3 A 9.3.1	Time-Temperature Transformation Diagrams	180
	(IT-diagrams)	180
A 9.3.2	Transformation Diagrams for Continuous Cooling	182
A 9.3.3	Different Presentations of Transformation Characteristics	188
A 9.4	Influence on Transformation Characteristics	189
A 9.4.1	Influence of Austenitization	189
A 9.4.2	Influence of Alloying Elements	190
A 9.4.3	Influence of Segregations.	194
A 9.4.4	Measurement and Precision of Transformation Diagrams	197
A 9.5	Mathematical Description of Transformations	198
A 9.5.1	Calculation of Transformation Temperatures.	198
A 9.5.2	Calculation of Critical Cooling Rates	199
A 9.5.3	Complete Description of Transformation Behavior	199

Part B	The Properties of Steel in Dependence of Microstructure and Chem-	
	ical Composition	201
B 1	Mechanical Properties	203
B 1.1	Behavior under Unidirectional Loads and at Temperatures near	
	or below Room Temperature	203
B 1.1.1	Yielding	203
B 1.1.1.1	The Stress-Strain Curve	212
B 1.1.1.2	Other Test Procedures	229
B 1.1.1.3	Possibilities to Increase the Strength of Steel by Influencing	
	the Microstructure	232
B 1.1.1.4	Anisotropy of the yielding Behavior	247
B1.1.2	Toughness and Fracture Behavior	248
B 1.1.2.1	Characterization of the Different Types of Fracture	249
B 1.1.2.2	External Influences on Fracture Behavior.	254
	Influence of temperature and loading rate. Influence of the stress state.	
B 1.1.2.3	The Processes at Fracture	263
B 1.1.2.4	Methods of Testing Toughness and Fracture Behavior	263
B 1.1.2.5	Influence of Microstructure on Fracture Behavior.	277
B 1.1.2.6	Theoretical Model of the Fracture Process	284
B 1.1.3	Microstructures with Optimal Combinations of Strength and Toughness	308
B 1.1.4	Safety of Structural Members and Failure Conceptions.	211
B 1.2	Behavior under Cyclic Loading and at Temperatures near	
	and below Room Temperature	319
B 1.2.1	Once Alternating Stress (Bauschinger effect)	319
B 1.2.2	Behavior under Cyclic Loading	322

XIV Contents

B 1.2.2.1 B 1.2.2.2	Testing Methods Discussion of the Single Processes Crack free stage. Crack initiation and crack propagation.	323 328
B 1.2.2.3	Factors that Influence Behavior under Cyclic Loading	336
B 1.2.2.4 B 1.2.2.5	Fatigue Strength (Limit) under Service Stresses Prediction of Lifetime	347 350
B 1.3 B 1.3.1 B 1.3.2 B 1.3.2.1 B 1.3.2.2 B 1.3.3 B 1.3.3.1 B 1.3.3.2 B 1.3.3.2 B 1.3.3.3	Behavior at Elevated Temperatures Behavior at Slightly Elevated Temperatures Behavior during Hot-forming Measurement of the Flow Stress Microstructural Processes During Hot Forming of Metallic Materials Creep Behavior Testing the Creep Behavior Behavior under Superimposed Stresses Interpretation	352 353 355 355 359 361 362 368 371
B 2	Physical Properties	379
B 2.1 B 2.1.1 B 2.1.2 B 2.1.3 B 2.1.4 B 2.1.5 B 2.1.6 B 2.1.7	Physical Properties of Pure Iron Crystal Structure and Atomic Volume. Heat Capacity Elastic Properties Magnetic Properties Conductive Properties Optical Properties Properties of γ-iron in the Instable Temperature Range	379 379 382 384 385 388 390 391
B 2.2 B 2.3 B 2.3.1 B 2.3.2	Physical Properties of α -iron Solid Solutions Physical Properties of γ -iron Solid Solutions Magnetism of γ -iron Alloys Thermal Expansion and Heat Capacity	393 397 397 403
B 2.4 B 2.4.1 B 2.4.2	Further Structural Influences on Physical Properties Single-phase Microstructures with Lattice Defects Multi-phase Microstructures	407 407 408
B 3	Chemical Properties	412
B 3.1 B 3.2 B 3.2.1 B 3.2.2 B 3.2.3	Problem	412 413 414 416 418
B 3.3 B 3.3.1 B 3.3.2 B 3.3.3	Kinetics and Mechanism of the Reactions with Gases	420 420 422 425
B 3.3.4 B 3.3.5 B 3.3.6	Sulfidation of Iron and Steel	429 430 434
B 3.4	Electrochemical Equilibria of Iron and the Alloying Elements Nickel and Chromium with Aqueous Electrolytes	437
B 3.5 B 3.5.1 B 3.5.2	Kinetics and Mechanisms of the Electrochemical Corrosion of Iron and Steels Uniform Corrosion	438 438 442

B 3.6	Passivation of Iron, Nickel, Chromium and the Alloys of Iron with Nickel and Chromium	113
B37	Selective Corrosion of Passive Iron and its Alloys	149
B 3.7.1	Pitting Corrosion and Crovice Corrosion	440
B 3.7.2	Intergranular Corrosion	450
B 3.8	Stress Corrosion Cracking.	453
B 3.8.1	General	453
B 3.8.2	Stress Corrosion Cracking in Austenitic Chromium-Nickel Steels.	454
B 3.8.3	Stress Corrosion Cracking of Unalloyed Structural Steels	455
B 3.9	Absorption of Hydrogen by Iron during Corrosion Processes	
D a a a	and Hydrogen Embrittlement	456
B 3.9.1	Hydrogen Absorption	456
в 3.9.2	Hydrogen Emonttiement	458
B4	Heat Treatability, Heat Treatment, and Properties	461
B 4.1	Definitions	461
B4.2	Relationship between Microstructures and Properties.	463
B 4.2.1	Structure-Properties Relationship.	463
	Correlation between strength and toughness. Ferrite and pearlite. Bainite. Martensite. Mixed microstructures. Microstructures after tempering.	
B 4.3	Internal Stresses Arising During Heat Treatment	478
B 4.4	Influence of Workpiece Dimensions on the Microstructure	
	after Heat Treatment	481
B 4.5	Methods to Get a Fine-Grained Microstructure	484
B 4.6	Production of Microstructures Homogeneous over the Cross Section	486
B 4.6.	Production of Microstructures Not in Equilibrium	486
	Microstructures of the pearlite range. Heat treatments to produce bainite. Transformation to martensite.	
B 4.6.2	Change of a Microstructure Towards Equilibrium.	490
	Precipitation from supersaturated solutions.	
B4.6.3	Formation of Microstructures in Combination with a Deformation	495
B4.7	Production of Microstructures Not Homogeneous over the Cross Section	497
B4./.1	Heat Treatments without Change of the Chemical Composition	497
D4./.2	Case hardening. Wear-resisting layers.	498
R5	Weldahility	504
60	Ry H D Hougardy	N 144
	By H. T. Hougardy	
B 5.1	Definitions and Terminology	505
B 5.2	Survey of Welding Processes	507
B 5.3	Time-Temperature Cycles Arising from the Welded Structure	
	and the Welding Parameters	508
B 5.3.1	Heating Cycles.	508
B 5.3.2		512
B 5.4	Influence of Time-Temperature Cycles on Base and Weld Metals.	515
В 5.4.1	Microstructures, Estimated by Continuous Cooling Transformation (CCT)	515
B542	Diagrams	510
J. 1 .2	Mechanical properties. Other properties.	519
B 5.4.3	Origin and Influence of Internal Stresses	524
B 5.4.4	Failures because of Not-Considering the Steel Properties	525
	Hot cracks. Cold cracks. Hydrogen-induced cracks. Precipitation cracks.	
	Lamellar tearing.	
B 5.5	Heat Treatment of Welded Constructions.	531
B 5.6	Assessment of Weldability	533
B561	The Carbon Equivalent	522

Contents

B 5.6.2 B 5.6.3	Welding Tests	534 534
B6	Hot Formability	535
B 6.1	General Remarks	535
B 6.2	Characteristic Values of Hot Formability and their Determination	535
B 6.3	Factors Influencing the Deformability	536
B 6.3.1	Influence of the State of Stress	536
B 6.3.2	Influence of the Material. Hot formability of single-phase alloys. Hot formability of two-phase	537
B 6.4	and multiphase alloys. Hot Formability of Different Groups of Steels	547
B7	Cold Formability (Suitability for Cold Extrusion and Cold Heading) By W. Schmidt	549
B 7.1	General Remarks	549
B7.2	Characteristic Values of Cold Formability and Their Determination	549
B 7.2.1	True Stress for a Given Plastic Strain ("Flow Stress") and Deformability	549
B 7.2.2	True Stress-True Strain Curve	551
B 7.3	Parameters Influencing the Cold Formability	556
B 7.3.1 B 7.3.2	General Remarks	556 558
B8	Cold Formability of Flat Rolled Products	565
	By W. Müschenborn, D. Grzesik and W. Küppers	
B 8.1	General Remarks	565
B 8.2	Criteria for the Evaluation of Cold Formability	566
B 8.2.1	Basic Requirements.	566
B8.2.2 B823	Characteristic values of the Noteh Tensile Test	566
B 8.2.4	Characteristic Values of Simulation and Technological Tests	569
B 8.2.5	Surface Characteristics	570
B 8.2.6	Characterization of the Forming Strains	570
B 8.3 B 8.3.1	Material Effects on Cold Formability of Soft and High-Strength Steels General Characterization of Factors Influencing the Cold Formability of Flat Rolled	573
	Products	573
B 8.3.2	Chemical Composition and Microstructure.	573
B8.3.3 D924	Cleanness (Freedom from Nonmetallic Inclusions)	584
B835	Surface Condition	584
B 8.3.6	Surface Treatment for Corrosion Protection	586
B9	Machinability	588
	Fundamental Principles and Terms Relating to Metal-cutting and Machinability	588
B 9.2	Relationship between Mechanical Properties and Machinability	591
B 9.3	Influence of the Microstructure	593
B 9.3.1	Ferritic/Pearlitic Microstructures.	593
B 9.3.2	Martensitic and Bainitic Microstructures	595
B 9.3.3	Globular Cementite	596
B 9.3.4	Austenitic Microstructures.	596

B 9.4 B 9.4.1 B 9.4.2	Influence of Nonmetallic Inclusions	596 596 599
B 9.5	Improving the Machinability by Alloying with Lead, Bismuth, Selenium, or Tellurium	601
	Hints Regarding Work Planning, Calculation of Cutting Conditions,	001
	and Special Machining Processes.	602
B 10	Wear Resistance	604
B 10.1	Dependence of Wear Resistance on Wear Mechanisms	604
B 10.2	Influence of Microstructure and Properties of Steels on Their Resistance to the Main	
	Wear Mechanisms	605
B 10.2.1		606
B 10.2.2 B 10.2.3	Adhesion	609
B 10.2.5 B 10.2.4	Tribochemical Reactions	610
B 10.2.5	Combined Wear Processes.	611
B 10.3	Influence of Microstructure and Properties of Steels on the Action of Particular Wear	
	Mechanisms	611
B 10.3.1	Prevention of Abrasion.	611
B 10.3.2	Prevention of Adhesion	613
B 10.4	Final Remarks	616
B11	Cutting Tool Life	617
	By HJ. Becker	
B 11.1	Definition of Cutting Tool Life	617
B 11.2	Influences on Cutting Tool Life	617
B 11.3	Dependence of Cutting Tool Life on the Microstructure of Steels	617
B 11.3.1	Classification of the Steel Grades According to Chemical Composition	
D1120	Attainment of the Microstructure Equarchie to Cutting Tool Life	618
D 11.3.2	Attainment of the Microstructure Pavorable to Cutting 1001 Life	020
B11.4 D11.4 1	Sintered Carbides (Hard Metal Alloys) and Oxide Ceramic Tools	620
B11.4.1	Oxide Ceramic Tools	623
B 11.5	Influence of Cutting Edge Geometry and Operating Conditions	025
	on Cutting Tool Life	623
B 11.6	Testing the Cutting Tool Life	625
B 11.6.1	Temperature-Tool Life-Turning Test.	625
B 11.6.2	Wear-Tool Life-Turning Test	625
B11.0.3 B11.64	The Necessity of Test Methods Adapted to Operating Conditions	020 626
2 110.1	The recently of real memory marping to operating conditions	020
B 12	Surface Treatment Processes.	628
	By U. Tenhaven, Y. Guinomet, D. Horstmann, L. Meyer and W. Pappert	
B 12.1	General Remarks	628
B 12.2	Surface Treatment by Application of Metallic Coatings in Hot-dip Processes	629
B 12.2.1	General Aspects of the Processes	629
B 12.2.2	Hot-dip Galvanizing (Zinc Coating)	630
B12.2.3	Hot-dip Coating with Aluminum-Zine-Allovs	636
B 12.2.5	Hot-dip Tinning (Tin Coating)	636
B 12.2.6	Hot-dip Lead Coating	636
B 12.3	Surface Treatment by Electrolytically Applied (Deposited) Metals	637
B 12.3.1	General Remarks on the Processes.	637
B 12.3.2	Electrolytic Tinning (Electrolytically Applied (Deposited) Tin).	638

B 12.4	Surface Treatment by Application of the Metallic Coatings	
	Using Other Processes	638
B 12.4.1	General Remarks	638
B 12.4.2	Cladding	638
B 12.4.3	The Application of Deposits in Vacuum or from Gas Phase	640
B 12.4.4	Diffusion Annealing in a Case (Box) Process	641
B 12.4.5	Spray Coating	641
B 12.5	Surface Treatment by Application of Inorganic Coatings: Vitreous Enameling	642
B 12.6	Application of Inorganic Coatings by Other Processes	645
B 12.7	Application of Coatings of Organic Materials	646
Table 1. kunde S	Comparison of the steel grades mentioned in Volume 1 and Volume 2 of "Werkstoff- tahl" and identified here by their designations according to German standards (DIN t) with corresponding grades according to international. European and some other	

national standards	648
Table 2. Brief definition of the scope and contents of the DIN Standards mentioned in Volume 1 and Volume 2 of "Werkstoffkunde Stahl" and listed in column 1 of Table 1	664
Table 3. International and European standards as well as national standards of some non-German countries which are comparable with DIN. (The standards are identified just by their number: for abbreviated titles of the German standards refer to Table 2)	670
Glossary of Repeatedly Used Symbols and Abbreviations	679
References	683

725

Subject Index

Contents of Volume 2

Part C Steels with Characterizing Properties for Specific Fields of Application

C 1	General Survey of Part C and its Aim
	By W. Schlüter
C2	Normal Strength and High Strength Structural Steels
	By B. Müsgen, H. de Boer, H. Fröber and J. Petersen
C3	Reinforcing Steel for Reinforced Concrete and Prestressed Concrete Structures
	By H. Weise, W. Bartels, WD. Brand and W. Krämer
C4	Steels for Hot-Rolled, Cold Rolled and Surface Treated Flat Products for Cold Forming
	By Chr. Straßburger, B. Henke, B. Meuthen, L. Meyer, J. Siewert and U. Tenhaven
С5	Heat-treatable and Surface Hardening Steels used for Vehicle and Machine Construction
	By G. Tacke, K. Forch, K. Sartorius, A. von den Steinen and K. Vetter
C6	Steels for Cold Forming
	By H. Gulden and I. Wiesenecker-Krieg
C7	Unalloyed Wire Rod for Cold Drawing
	By H. Beck and C. M. Vlad