

Contents

1. Introduction 1

- 1-0. General 1
- 1-1. Equilibrium between Solid and Liquid 1
- 1-2. Melting Point 2
- 1-3. Equilibrium of Alloys 4
 - Equilibrium Diagrams* 4
 - Congruent Melting* 6
 - Eutectics* 6
 - Peritectics* 7
 - Monotectics* 10
- 1-4. Gas-Metal Equilibrium 11
- 1-5. Ternary and Multicomponent Alloys 12
- 1-6. The Phase Rule 14
- 1-7. The Distribution Coefficient 15
- 1-8. Thermodynamic Criteria for Equilibrium 17

2. Solidification as an Atomic Process 20

- 2-1. Solids and Liquids 20
 - The Nature of Crystalline Solids* 20
 - Nature of Liquids* 22
 - The Differences Between Crystals and Liquids* 24
 - Quasi-chemical Approach* 25
- 2-2. The Solid-Liquid Interface 26
 - Microtopography of the Interface* 28
- 2-3. Equilibrium between a Pure Metal and Its Melt 35
- 2-4. The Process of Crystal Growth 43
 - Kinetics of Crystal Growth* 44

2-5.	Solid-Liquid Equilibrium in Alloys	46
2-6.	Origin of Defects	51
	<i>Vacancies</i>	52
	<i>Dislocations</i>	56
	<i>Lineage Structures</i>	59
3.	Nucleation	62
3-1.	Metastability of Supercooled Liquids	62
3-2.	Equilibrium Conditions for a Curved Interface	63
	<i>Stability of a Curved Interface; Atomic Considerations</i>	63
	<i>Thermodynamic Treatment of Equilibrium across a Curved Interface</i>	64
3-3.	Calculation of Critical Radius	65
3-4.	The Process of Nucleation	68
	<i>Theory of Nucleation Rate</i>	69
	<i>Nucleation Temperature</i>	70
	<i>Comparison between Experiment and Theory</i>	71
	<i>Size of the Critical Nucleus</i>	74
3-5.	Homogeneous Nucleation in Alloys	76
3-6.	Heterogeneous Nucleation	77
3-7.	The Nucleation of Melting	84
3-8.	Dynamically Stimulated Nucleation	86
3-9.	Summary of Present Status of Nucleation Theory	89
4.	Microscopic Heat Flow Considerations	91
4-1.	Qualitative Observations	91
4-2.	Removal of Latent Heat	95
4-3.	Extraction of Latent Heat by Conduction into the Crystal	96
	<i>Effect of Surfaces and of Grain Boundaries</i>	97
4-4.	Conduction of Latent Heat into the Liquid	99
	<i>"Ribbon" Crystals</i>	101
	<i>"Feather" Growth</i>	102
4-5.	Dendritic Growth	103
	<i>Total Amount Solidified</i>	104
	<i>Speed of Growth</i>	104

	<i>Direction of Dendritic Growth</i>	116
	<i>Spacing of Dendrite Arms</i>	120
4-6.	Solidification at Very High Supercooling	122
5.	Redistribution of Solute during Solidification	126
5-1.	General Considerations	126
5-2.	The Distribution Coefficient	126
5-3.	Rejection of Solute	128
	<i>Equilibrium Maintained at All Times</i>	129
	<i>Mixing in the Liquid by Diffusion Only: No Diffusion in the Solid</i>	131
	<i>Influence of Fluid Motion: Convection</i>	138
	<i>Complete or Partial Mixing of Liquid: No Diffusion in Solid</i>	139
	<i>Solidus Temperature of an Alloy</i>	142
5-4.	Zone Refining	143
5-5.	Constitutional Supercooling	150
	<i>Instability Due to Constitutional Supercooling</i>	152
5-6.	Cellular Substructure	154
	<i>Origin of the Cellular Substructure</i>	154
	<i>Quantitative Studies of Cell Formation</i>	157
	<i>Geometry of Cells</i>	160
5-7.	Cellular Dendrites	164
5-8.	Free Dendritic Growth in Alloys	169
	<i>Spacing of Dendrite Arms</i>	170
5-9.	Nucleation of Crystals ahead of the Existing Interface	171
5-10.	Types of Segregation	171
	<i>Normal Segregation</i>	171
	<i>Grain Boundary Segregation</i>	172
	<i>Cellular Segregation</i>	173
	<i>Dendritic Segregation</i>	175
	<i>Inverse Segregation</i>	178
	<i>Coring and Intercrystalline Segregation</i>	183
	<i>Gravity Segregation</i>	183

6. Polyphase Solidification	186
6-1. Evolution of a Gas During Solidification	186
<i>Gas-Metal Equilibrium</i>	186
<i>Bubble Formation</i>	187
<i>Formation of Compounds by Dissolved Gases</i>	194
6-2. Eutectics	194
<i>Microstructure of Eutectics</i>	196
<i>Pure Binary Eutectics</i>	197
<i>Solidification of Lamellar Eutectics</i>	198
<i>Shape of the Interface</i>	200
<i>Lamellar Growth: Theoretical</i>	201
<i>Lamellar Growth: Experimental</i>	204
<i>Degenerate Eutectic Structures</i>	206
<i>Modification of Eutectics</i>	207
<i>Discontinuous Eutectics</i>	211
<i>Noneutectic Compositions</i>	215
<i>Structure of Eutectic Liquids</i>	216
<i>Gravity Segregation of Eutectics</i>	218
<i>Divorced Eutectic</i>	218
<i>Ternary Eutectics</i>	219
<i>Cast Iron</i>	219
6-3. Peritectic Solidification	224
6-4. Solidification in the Presence of a Solid Phase	227
<i>Suspended Particles</i>	227
<i>Solidification of a Liquid in a Porous Solid</i>	229
7. Macroscopic Heat Flow and Fluid Flow	232
7-1. General Considerations	232
7-2. Fluid Flow	232
<i>Viscosity of Liquid Metals</i>	233
<i>Fluidity</i>	234
7-3. Heat Flow	235
<i>Rate of Solidification</i>	237
<i>Continuous Casting</i>	242
<i>Dip Forming</i>	247
7-4. Thermal Stresses in a Solidifying Body	250

8. The Structure of Cast Metals	253
8-1. General Considerations	253
8-2. The Macrostructure of Cast Metals	255
<i>Description of Cast Structures</i>	255
<i>Experimental Observations</i>	257
<i>Solidification in a Mold</i>	259
<i>Structure of Continuous Castings</i>	276
<i>Effect of Vibration on Structure</i>	278
<i>Welding, Brazing and Soldering as Casting Processes</i>	281
8-3. Segregation	282
8-4. The Significance of Small-Scale Experiments	284
8-5. Change of Volume on Freezing	285
<i>Pipe Formation</i>	286
<i>Unidirectional Shrinkage</i>	287
<i>Cavity Formation</i>	287
<i>Control of Unsoundness</i>	287
<i>Porosity</i>	288
<i>Surface Porosity</i>	289
8-6. Blowholes	289
8-7. Surface Topography Resulting from Solidification	290
<i>Surface Tension Effects</i>	291
<i>Cold Shut</i>	292
<i>Trapped Gas</i>	292
<i>Surface Dendrites</i>	292
<i>Exudation and Surface Porosity</i>	294
<i>Topography of the Free Surface</i>	294
<i>Changes of Topography after Solidification</i>	294
<i>Metal Coating by Hot Dipping</i>	295
<i>Tinplate</i>	295
Appendix. The Production of Single Crystals from the Melt	298
A-1. General Considerations	298
A-2. Control of Orientation	299
A-3. Control of Shape	300
A-4. Control of Composition	302
<i>Contamination</i>	302

<i>Evaporation</i>	303
<i>Uniformity of Composition: Short Range</i>	303
<i>Uniformity of Composition: Long Range</i>	303
<i>Peritectic Compound</i>	305
A-5. Control of Perfection	305
<i>Vacancies</i>	305
<i>Dislocations</i>	306
<i>Lineage</i>	306
<i>"Stray Crystals"</i>	307
A-6. Bicrystals	308
Index	311