8620 Carburized Case Steel
Iteration #90

Fatigue Behavior, Monotonic Properties and Microstructural Data

Prepared by:

A.A. Rteil
and
T.H. Topper

Department of Civil Engineering
University of Waterloo
Waterloo, Ontario Canada

Prepared for:
The AISI Bar Steel Applications Group

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American Iron and Steel Institute

American Iron and Steel Institute
2000 Town Center, Suite 320
Southfield, Michigan 48075
tel: 248-945-4777
fax: 248-352-1740
www.autosteel.org

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SUMMARY

This report presents the monotonic and fatigue test results obtained for 8620 carburized case-25% Martensite, 75% Bainite (It 90) steel. The material was provided by the American Iron and Steel Institute (AISI). Monotonic tensile tests were performed to measure the yield strength, the tensile strength and the reduction of area. Strain-controlled constant-amplitude fatigue tests were to obtain the strain-life curve, cyclic stress-strain curve and fatigue data for this material. Also the microstructure data was obtained.

INTRODUCTION

This report presents the results of tensile and fatigue tests performed on a group of 8620 carburized case-25% Martensite, 75% Bainite (It 90) steel sample. The material was provided by the American Iron and Steel Institute. The objectives of this investigation were to obtain the microstructure data, mechanical properties, cyclic stress-strain data and strain-life fatigue data requested by the AISI bar group.

EXPERIMENTAL PROCEDURE

Specimen Preparation

The material for the study was received in the form of 1.19” round bars. Smooth cylindrical fatigue specimens, shown in Figure 1, were machined from the cylindrical bars and case carburized reaustenitized and isothermally transformed to achieve 25% martensite and 75% bainite microstructure. Then, the gauge sections of the fatigue specimens were mechanically polished in the loading direction. Before testing, the specimens had a final polish in the loading direction in the gauge sections using 600-emery paper and a thin band of M-coat D acrylic coating was applied along the central gauge section. The purpose of the M-coat D application was to prevent scratching of the smooth surface by the knife-edges of the strain extensometer, thus reducing the incidence of knife-edge failures.

Test Equipment and Procedure

Monotonic tension tests were performed to determine the yield strength, the tensile strength, the percent elongation and the percent reduction of area. Hardness tests were performed on the surface of three fatigue specimens using a Rockwell C scale. The hardness measurements were repeated three times for each specimen and the average value was recorded.

All fatigue tests were carried out in a laboratory environment at approximately 25^oC using an MTS servo-controlled closed loop electro-hydraulic testing machine. A process control computer, controlled by FLEX software [1] was used to output constant strain and stress amplitudes in the form of a sinusoidal wave.

Axial, constant amplitude, fully reversed (R=-1) strain-controlled fatigue tests were performed on smooth specimens. The stress-strain limits for a given cycle of each specimen were recorded at logarithmic intervals throughout the test via a peak reading voltmeter. Failure of a specimen was defined as a 50 percent drop in tensile peak load from the peak load observed at one half the expected specimen life. For fatigue lives greater than 100,000 reversals, the specimens were tested in stress-control once the stress-strain loops had stabilized. For the stress-controlled tests, failure was defined as the separation of the smooth specimen into two pieces. For strain-controlled tests the loading frequency varied from 0.03 Hz to 3 Hz while in stress-controlled tests the frequency used was up to 75 Hz.

RESULTS

Chemical composition and microstructure Data

The chemical composition as provided by the supplier is shown in Table 1. Daimler Chrysler did the microstructure on this material. Their report is included in Appendix 1.

Strain-Life Data

Constant amplitude test data obtained in this investigation are given in table 2. The stress amplitude corresponding to the strain amplitude was calculated from the peak load amplitude at the specimen half-life.

A fatigue strain life curve is shown in Figure 2, and is described by the following equation:

$$\frac{\Delta\varepsilon}{2} = \frac{\sigma'_f}{E}(2N_f)^b + \varepsilon'_f(2N_f)^c \qquad \text{Eq 1}$$

where $\frac{\Delta\varepsilon}{2}$ = True total strain amplitude

$2N_f$ = Number of reversals to failure

σ'_f = Fatigue strength coefficient

b = Fatigue strength exponent

ε'_f = Fatigue ductility coefficient

c = Fatigue ductility exponent

The values of the strain-life parameters were determined from the best fit curve of the fatigue testing data and presented in table 3.

Cyclic Stress-Strain Curves

Stabilized, half-life stress data obtained from strain-life fatigue tests were used to obtain the companion cyclic stress-strain curve shown in Figure 3. The cyclic stress-strain curve is described by the following equation:

$$\varepsilon = \frac{\sigma}{E_c} \qquad \text{Eq 2}$$

where ε = True total strain amplitude

σ = Cyclically stable true stress amplitude

Ec = Cyclic modulus of elasticity

The value of Ec obtained from a best fit of the above equation to the test data are given in table 3.

Mechanical Properties

The engineering monotonic tensile stress-strain curves are given in Figure 4. The true monotonic and true cyclic stress-strain curves plotted together are given in Figure 5. The monotonic properties along with the average hardness test results are included in table 3. The individual hardness measurements are given in Table 2.

REFERENCES

[1] Pompetzki, M.A., Saper, R.A., and Topper, T.H., "Software for High Frequency Control of Variable Amplitude Fatigue Tests," Canadian Metallurgical Quarterly, Vol. 25, No. 2, pp. 181-194, 198.

[2] J. A. Bannantine, J. J. Comer, and J. L. Handrock (1990), In :Fundamentals of Metal Fatigue Analysis, Prentice Hall, London.

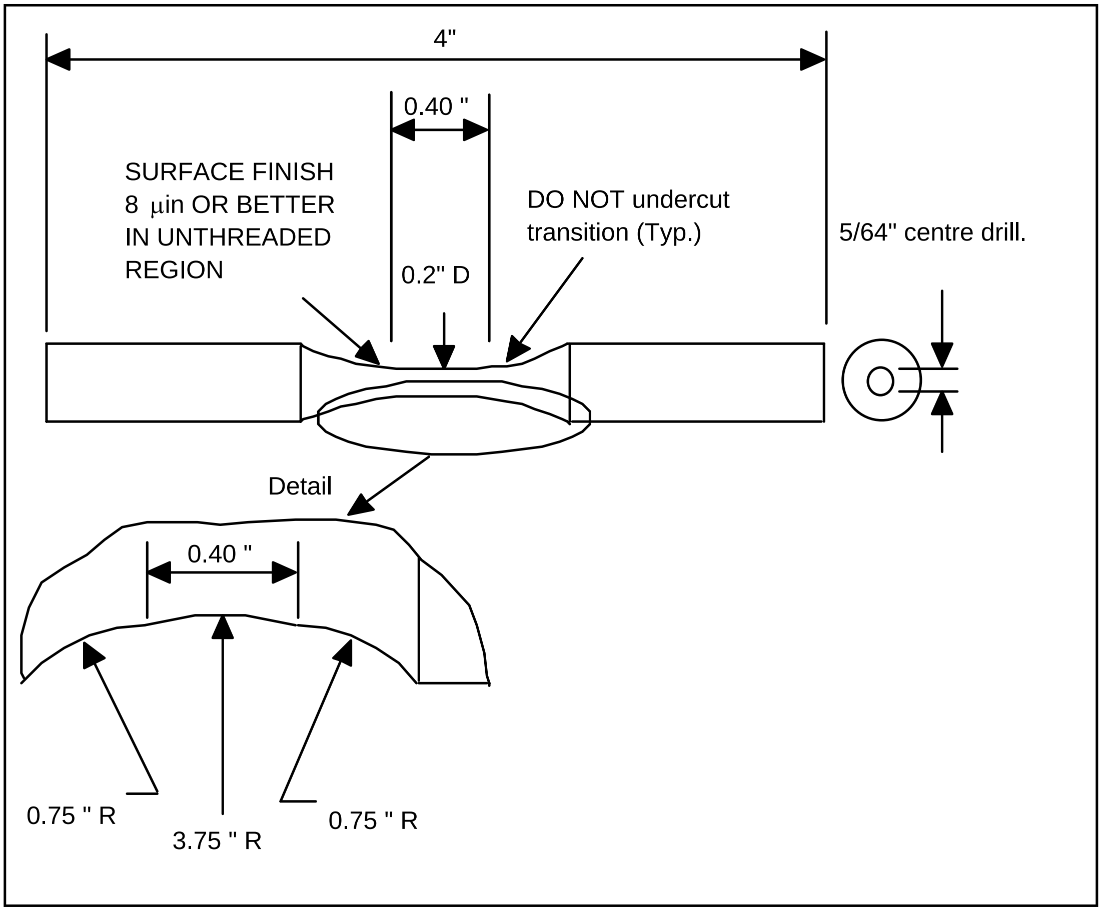

Figure 1 Smooth cylindrical fatigue specimen

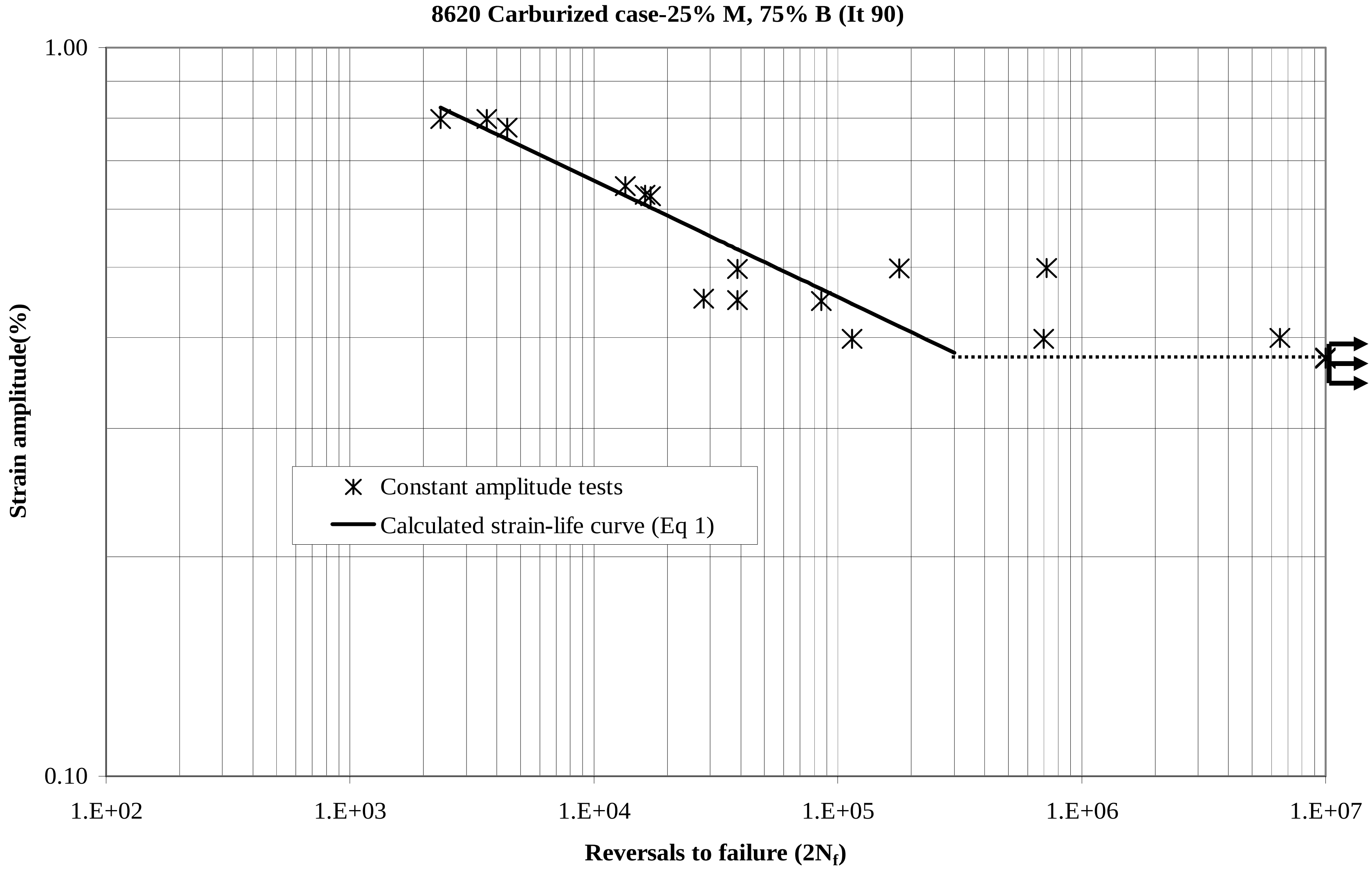

Figure 2. Constant amplitude fully reversed strain-life curve for Iteration 90

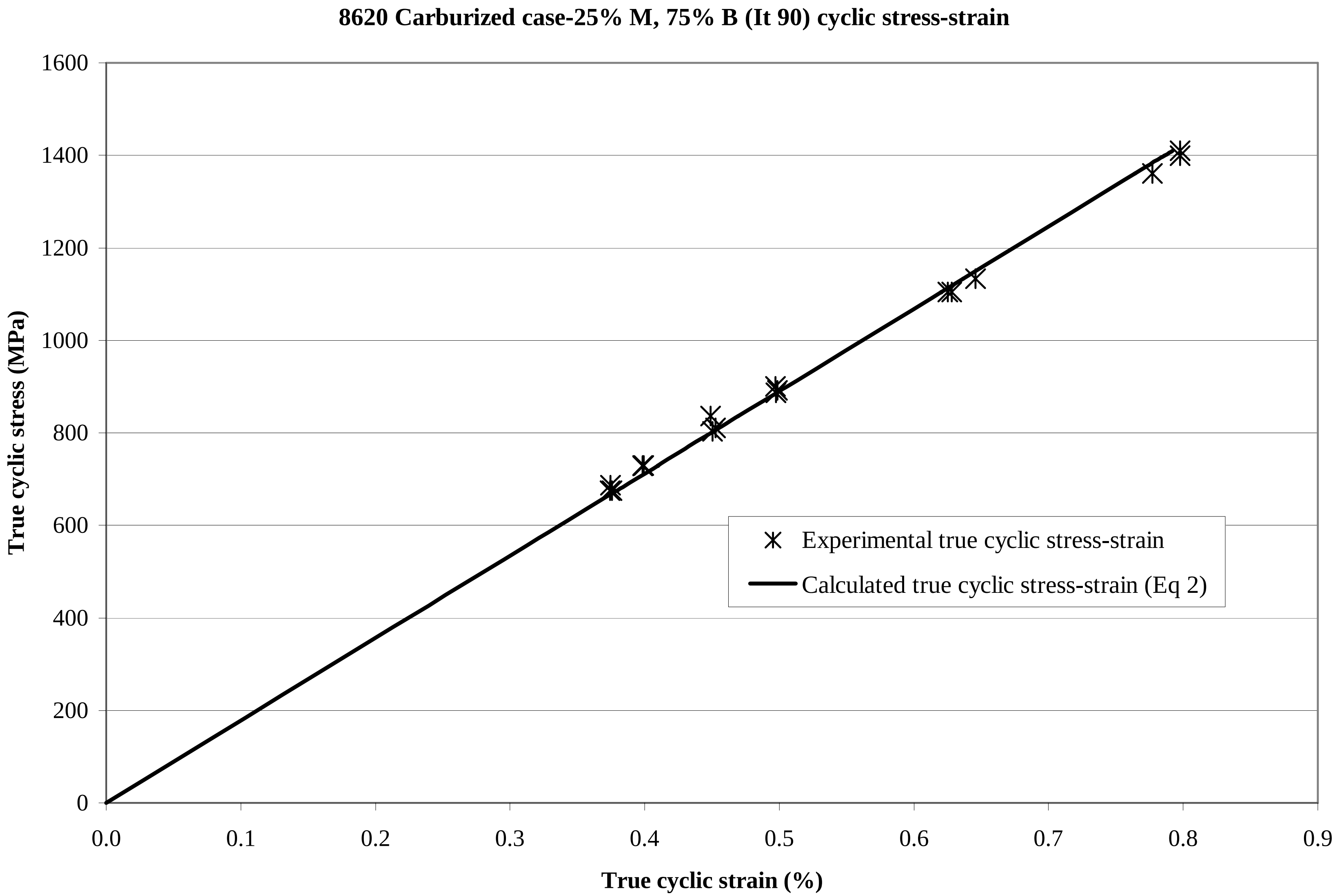

Figure 3. Cyclic true stress-strain curve for iteration 90

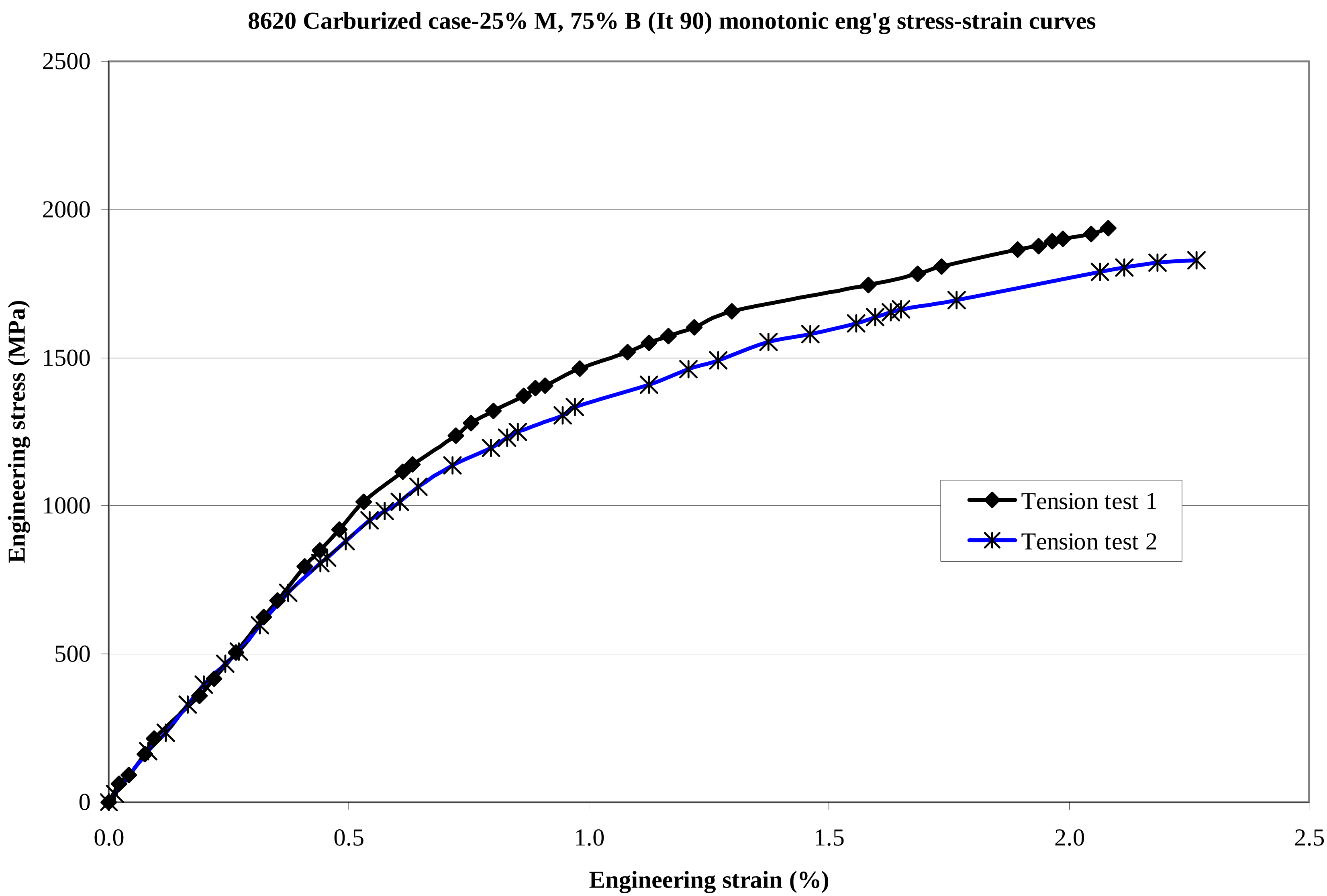

Figure 4. Tensile monotonic engineering stress-strain curves for iteration 90

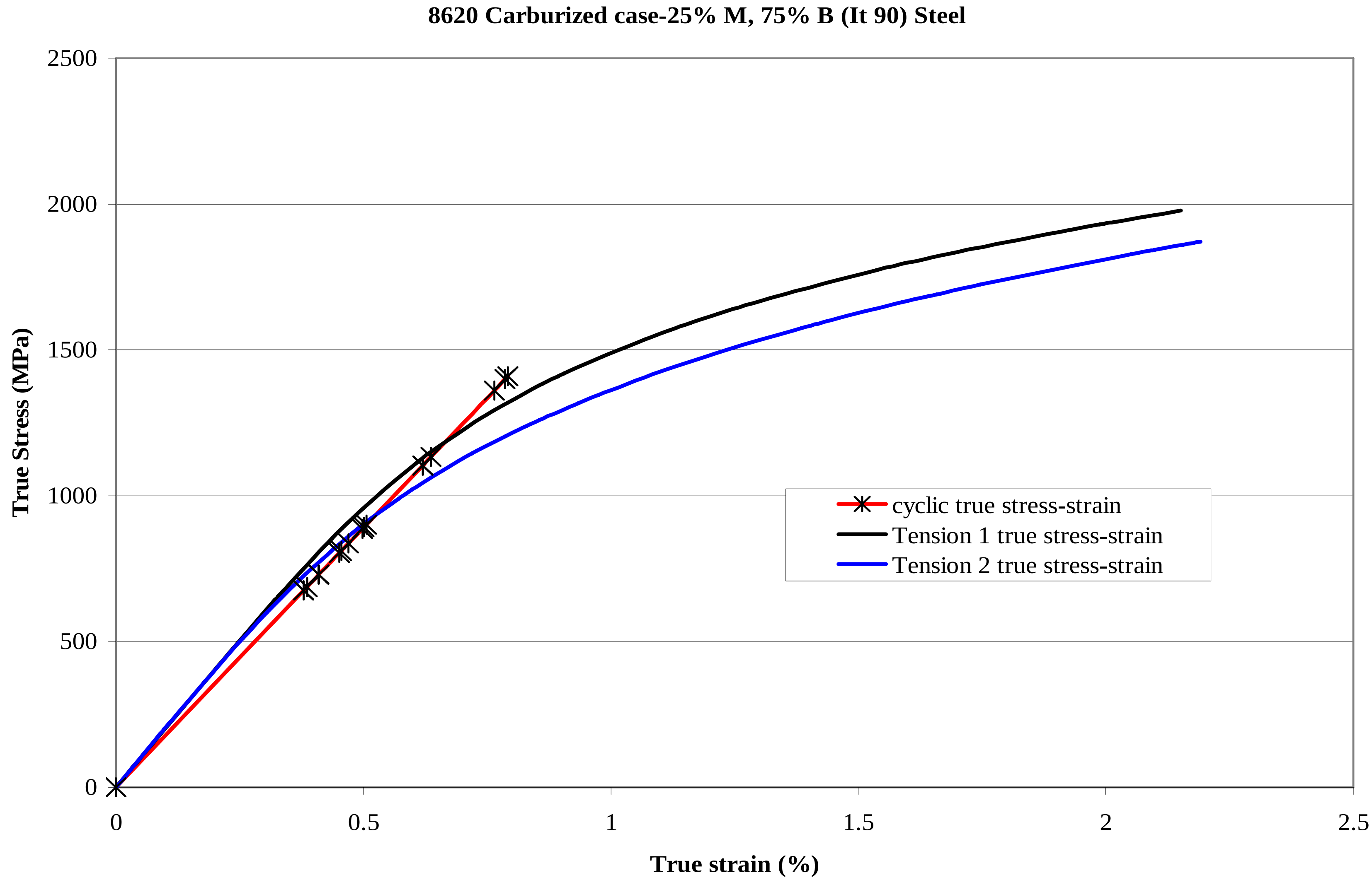

Figure 5. Monotonic and Cyclic true stress-strain curves for iteration 90

Table 1: Chemical composition for Iteration 90

Chemical element	Quantity (%)
Carbon-- C	0.21
Manganese (Mn)	0.83
Phosphorus (P)	0.009
Sulfur (S)	0.032
Silicon (Si)	0.25
Copper (Cu)	0.15
Nickel (Ni)	0.46
Chromium (Cr)	0.5
Molybdenum (Mo)	0.2
Tin (Sn)	0.006
Aluminum (Al)	0.024
Vanadium (V)	0.004
Columbium(Cb) /Niobium (Nb)	0.002
Titanium (Ti)	0.002
Boron (B)	0.0003
Calcium (Ca)	0.0005
Zirconium (Zr)	0.001
Nitrogen (ppm) (N)	0.0063
Oxygen (ppm) (O)	0.0009
Co	0.006
Zn	0.0036
Pb	0.0008
ASA	0.000

Table 2: Fatigue Data for Iteration 90

Sp#	Total Strain Amplitude (%)	Stress Amplitude (MPa)	Plastic Strain Amplitude (%)	Elastic Strain Amplitude (%)	(50% load drop) Fatigue Life (Reversals, 2Nf)	Hardness (Rockwell C)
1	0.777	1360.2	0.000	0.777	4,406	
4	0.798	1410.3	0.000	0.798	2,354	
8	0.798	1399.2	0.000	0.798	3,646	
10	0.625	1104.2	0.000	0.625	17,066	
12	0.628	1104.2	0.000	0.628	16,192	
19	0.646	1133.4	0.000	0.646	13,416	58
2	0.497	900.4	0.000	0.497	38,828	
17	0.497	886.7	0.000	0.497	178,964	
18	0.499	892.2	0.000	0.499	718,456	
5	0.449	836.1	0.000	0.449	85,544	
15	0.450	803.0	0.000	0.450	38,730	57.5
16	0.453	810.2	0.000	0.453	28,142	58
6	0.399	729.9	0.000	0.399	114,526	
14	0.399	729.9	0.000	0.399	6,488,912	
13	0.399	728.8	0.000	0.399	699,662	
7	0.375	687.3	0.000	0.375	10,000,000*	
9	0.374	674.6	0.000	0.374	10,000,000*	
11	0.375	675.2	0.000	0.375	10,000,000*	

* Run out

Table 3: Monotonic and cyclic properties for iteration 90

Monotonic Properties	
Average Elastic Modulus, E (GPa)	202.5
Yield Strength (MPa)	1,314
Ultimate tensile Strength (MPa)	1,883
% Elongation (%)	2.2
% Reduction of Area (%)	0.0
True fracture strain, $Ln\ (A_i / A_f)$ (%)	2.2
True fracture stress, $\sigma_f = \dfrac{P_f}{A_f}$ (MPa)	1,883
Bridgman correction $= \dfrac{P_f}{A_f} \Bigg/ \left(1+\dfrac{4R}{D_f}\right) Ln\left(1+\dfrac{D_f}{4R}\right)$ (MPa)	1,687.5
Monotonic tensile strength coefficient, K (MPa)	4,891
Monotonic tensile strain hardening exponent, n	0.212
Hardness, Rockwell C (HRC)	58
Cyclic Properties	
Cyclic Yield Strength, (0.2% offset)= $K'(0.002)^{n'}$ (MPa)	N/A
Cyclic Elastic Modulus, Ec (MPa)	178,010
Cyclic strength coefficient, K' (MPa)	N/A
Cyclic strain hardening exponent, n'	N/A
Fatigue Strength Coefficient, σ'_f (MPa)	5808
Fatigue Strength Exponent, b	-0.16
Fatigue Ductility Coefficient, ε'_f	N/A
Fatigue Ductility Exponent, c	N/A

P_f: Load at fracture.
A_i and A_f: Specimen cross-section area before and after fracture.
R: Specimen neck radius.
D_f Specimen diameter at fracture

Appendix 1

Microstructure Report

DAIMLERCHRYSLER

UAW - DaimlerChrysler
SCIENTIFIC LABS & PROVING GROUNDS

Materials Engineering Summary Report

LTR Number: 120956

From:	**Peter Bauerle**	**Phone:**	**776-7387**
Location:	**CTC**		

Lab(s):	**Mechanical Properties** **Metallography**	**Completed:**	**12/2/2004**

Subject/Part Name: Fatigue Specimen
Approver: Joe Tarajos
Originator: Peter Bauerle
Originator Phone: 248-576-7387
Number of Parts: 1
Nature of Work: Process/Materials Development
Vendor:
Plant:
P/N:
MS:
PS:

History of Part

The sample that has been submitted is a fatigue specimen that is used for the development of the AISI database. This sample has been identified as iteration 90 and is a grade 8620. The sample has first been through carburized in the gage section and then reaustenitized at 1575F for 30 minutes followed by isothermal transformation at 450F for 150 minutes. The isothermal treatment was used to generate a microstructure with 75% bainite.

Purpose

The purpose of this LTR is to evaluate hardness and microstructure of the gage section of the test specimen.

Mechanical Properties - 120956

Hardness - Rockwell (Performed By: Jim Bolton)

Direct hardness readings were taken on grip area of sample and found to be 57.4/59.6/58.8*
* note a value of 1 has been added for roundness correction

Hardness - Micro (Performed By: Jim Bolton)

120956	
DEPTH	**HARDNESS FROM O.D.**
.005	60.2HRC
.010	61.5
.015	59.9
.020	60.4
.025	60.0
.030	60.8
.040	60.0
.050	59.4
.060	57.7
.070	55.2
.080	54.7
.090	54.9
.100	54.3
.110	54.0
.120	54.8
.130	54.9
.140	55.3
.150	56.0
.160	57.1
.170	58.8
.180	59.5
.190	60.4
.200.	60.6

Metallography - 120956

General Microstructure Description (Performed By: James Shi)

The submitted fatigue specimen was sectioned longitudinally at the grip end and prepared according to the normal procedures for microstructural evaluation. Using optical microscope Olympus PMG3, the microstructures were examined and microphotographs were taken. The results of the evaluation revealed that the part was case carburized. The typical case pattern is shown in Fig.1. The microstructure of the part consisted of some transformation product at the surface followed by bainite region, martensite region, second bainite region, and tempered martensite with a small amount of ferrite to the core. In addition, some inclusions were also observed. The details of the microstructures are shown in Figs.2-5. The bainite at the subsurface (below transformation product) was estimated to be about 80% of the volume.

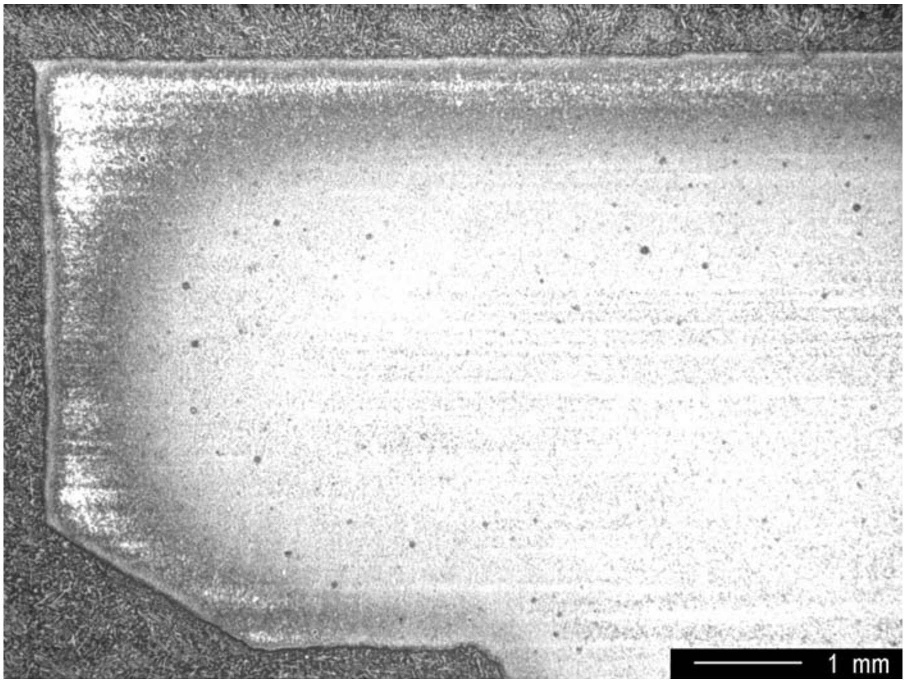

Fig.1 Case pattern inclusions at the grip end, low magnification.

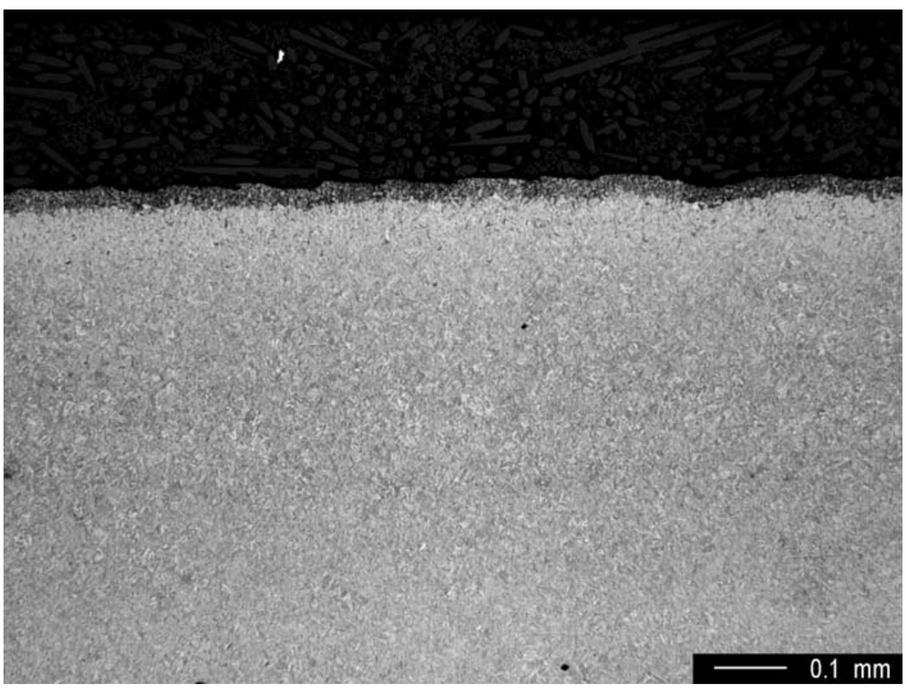

Fig.2 Microstructure at the surface showing bainite regions (darker and lighter phases at the subsurface), 80% bainite estimated, medium magnification.

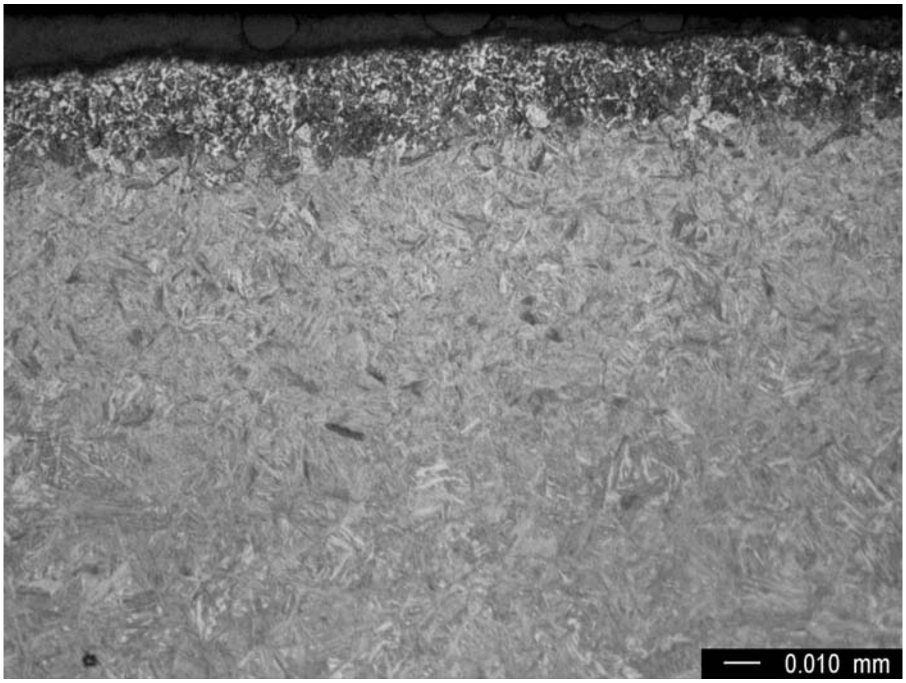

Fig.3 Microstructure at the surface showing transformation product, bainite and martensite, high magnification.

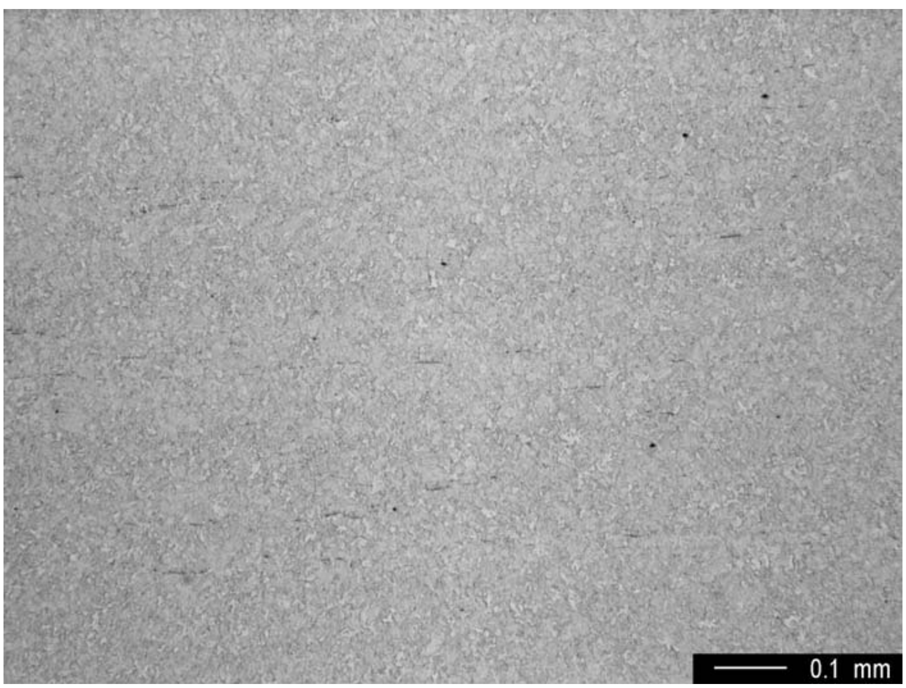

Fig.4 Core microstructure, medium magnification.

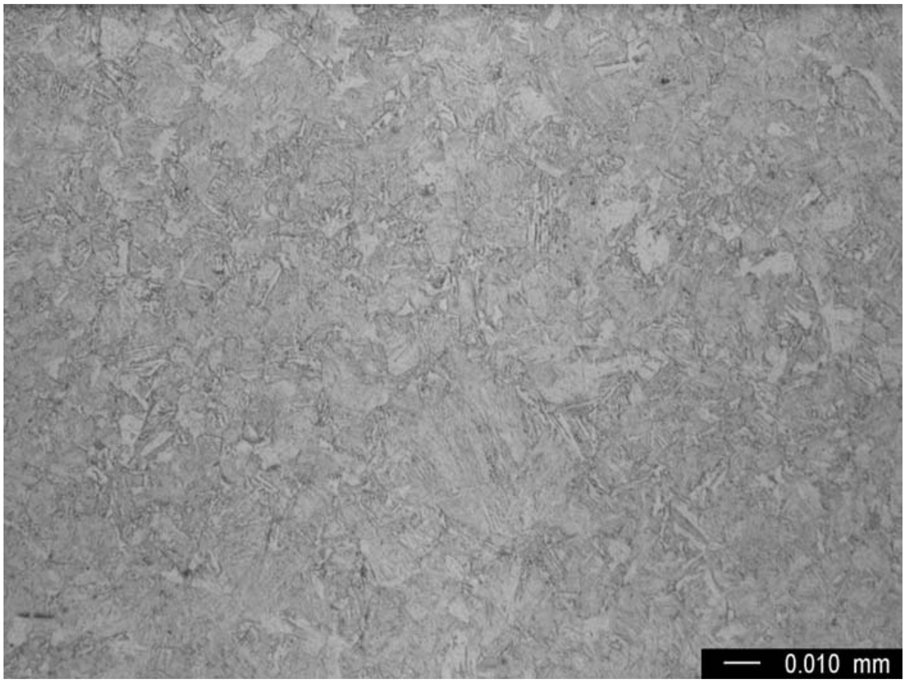

Fig.5 Core microstructure, tempered martensite with a small amount of ferrite, high magnification.

Summary/Conclusion/Recommendations

This sample represents a series of test specimens prepared for iteration 88 of the AISI fatigue properties database. The objective for this iteration was to achieve a microstructure of approximately 25% martensite and 75% bainite. The metallographic examination reveals that approximately 75-80% bainite content has been achieved and the objective met. The results shall be forwarded to AISI and DCX for use in the materials database.