Lecture 30: Exercise in ladle metallurgy

Contents

Exercise on desulphurization

Exercise on degassing

Exercise on deoxidation

Exercise on gas stirring

Exercise on momentum flow rate

1) Problem of desulphurization

(A) Calculate $K_s$ for a synthetic slag composed of $X_{CaO} = 0.65$ and $X_{Al_2O_3} = 0.35$. The slag is in contact with molten steel at temperature $T$, with dissolved aluminum 0.01 wt %. In slag activity of alumina is 0.38. Use $T = 1773K$ and 1850 K and interpret the results.

$log C_s$ by equation 4 of lecture 22 = -1.96.

$log K_s = log C_s + \frac{20397}{1773} + \frac{2}{3} log 0.01 + \frac{1}{3} log 0.38 - 5.482$

$= -1.96 + 11.50 - 1.33 - 0.14 - 5.482$

$= 2.588$

$K_s = 387$ at $T = 1773K$

$K_s = 130$ at $T = 1850K$

We note the partition coefficient is higher at 1773K as compared with that at 1850K. We can conclude that lower temperature favours desulphurization.

(B) Discuss the transitory and permanent contact mode of desulphurization based on the following calculations: Molten steel is desulphurised by injecting powder at the rate of 4 kg/ton. The partition coefficient of sulphur is 50. Now we select a slag whose partition coefficient is 400. We also increase the powder injection rate in one case to 4 kg/ton and in other case to 6 kg/ton. What will be the effect of a) sulphur partition coefficient and b) powder injection rate on desulphurization modes

Note a Similar problem is solved in lecture 23.
2) Problem on degassing

(A) In RH degassing, liquid steel is circulated through the vacuum chamber in order to lower the hydrogen content from 6ppm to 3ppm in 15 minutes. Molten steel attains equilibrium with to hydrogen.

Given: temperature = 1600°C

Molten steel in ladle = 60 tons.

Pressure inside vacuum chamber = 0.2 torr

The molten steel analyzes C = 0.06%, Cr = 6%, Ti = 0.5%, Ni 2% and rest iron.

Interaction parameter $e_{H}^{C} = 0.045$, $e_{H}^{Cr} = 0.005$ and $e_{H}^{Ti} = -0.22$

Calculate rate of circulation of molten steel.

Solution

\[ R = \frac{m}{t} \ln \frac{[PPmH]_1 - [PPmH]^*}{[PPmH]_2 - [PPmH]^*} \]

\[ \log f_{H} = 0.045 \times 0.06 + 0.005 \times 6 - 0.22 \times 0.5 \]

\[ = 0.0027 + 0.03 - 0.11 \]

\[ f_{H} = 0.837. \]

\[ [PPmH]^* = k_{H} \sqrt{pH_{2}} \]

\[ \log k_{H} = -\frac{1905}{T} + 2.409 \]

\[ k_{H} = 24.65 \]

\[ [PPmH]^* = \frac{24.65}{f_{H}} \sqrt{0.2 \times 1.315 \times 10^{-3}} \]

\[ = 0.465 \]

\[ R = \frac{60}{15} \ln \frac{6 - 0.465}{3 - 0.465} \]

\[ = 3.12 \text{ tonnes/min Ans.} \]

(B) Repeat the above calculations when $T = 1650°C$ and when pressure inside the chamber = 0.1 Torr

Discuss the results in terms of technology development and requirements (refer lecture 25, 26)
3) Problems on deoxidation (Refer lecture 24)

(A) Calculate the time required to float $\text{Al}_2\text{O}_3$ deoxidation product through a 2 meters steel bath height from the following data:

Density of liquid steel and $\text{Al}_2\text{O}_3 = 7 \times 10^3$ and $4 \times 10^3$ kg/m$^3$ viscosity of liquid steel $= 6 \times 10^{-3}$ kg m$^{-1}$s$^{-1}$

Size of deoxidation product = 10 micron, 50 micron and 100 micron

Repeat the calculation when deoxidation product is silica and its density is $2.3 \times 10^3$ kg/m$^3$

Interpret the result and get a feel about the importance of size of deoxidation products on velocity.

(B) Aluminum, titanium and zirconium are the strongest deoxidizers compared with manganese. Deoxidation with either aluminium or zirconium or titanium shows a minimum solubility of oxygen in steel. Determine the expression to calculate the value of Al in weight percent at minimum oxygen content in Fe-Al-O system

Given: $\log f_{\text{Al}} = e_{\text{Al}}^{\text{Al}} W_{\text{Al}} + e_{\text{Al}}^{\text{O}} W_{\text{O}}$ and $\log f_{\text{O}} = e_{\text{O}}^{\text{Al}} W_{\text{Al}} + e_{\text{O}}^{\text{O}} W_{\text{O}}$

Let us consider the following reaction;

$\text{Al}_2\text{O}_3 (S) = 2[\text{Al}] + 3[\text{O}]$  

1)

Assume activity of alumina, $a_{\text{Al}_2\text{O}_3} = 1$, since it is pure,

$\log K_{\text{Al}} = 2\log h_{\text{Al}} + 3\log h_{\text{O}}$  

2)

Substitute $h_{\text{Al}} = f_{\text{Al}} W_{\text{Al}}$ and $h_{\text{O}} = f_{\text{O}} W_{\text{O}}$ and expression for $f_{\text{Al}}$ and $f_{\text{O}}$ in equation 2. Differentiate the expression 2 with respect $W_{\text{Al}}$ to get

$$\frac{dW_{\text{O}}}{dW_{\text{Al}}} = - \frac{0.868 \frac{1}{W_{\text{Al}}} + 2e_{\text{Al}}^{\text{Al}} + 3e_{\text{Al}}^{\text{O}}}{1.30 \frac{1}{W_{\text{O}}} + 2e_{\text{O}}^{\text{Al}} + 3e_{\text{O}}^{\text{O}}}$$

For the minima $\frac{dW_{\text{O}}}{dW_{\text{Al}}} = 0$ and $W_{\text{Al}} = W_{\text{Al}}^{\text{e}}$ we get

$$W_{\text{Al}}^{\text{e}} = \frac{0.434}{e_{\text{Al}}^{\text{Al}} + 1.5e_{\text{O}}^{\text{Al}}}$$
The readers may substitute the values of the interaction parameters to get a feel of the value of Al and to understand the role of interaction parameters in calculations.

4) **Problems on gas stirring** *(Reference lectures 21,22)*

**(A)** Calculate the recirculation rate of molten steel due to injection of gas in a ladle containing 250 tons of steel for the following conditions:

**Gas flow rate:** 400 m$^3$/s, 600 m$^3$/s and 800 m$^3$/s. (Volume is expressed at 1 atmospheric pressure and 273 K). **Bath height:** 3 meter and **temperature** 1200°C

Discuss the result in terms of effect of gas rate on recirculation and the benefits accrued.

**(B)** Calculate stirring energy produced in a bath by injection of gas through the bottom of the vessel for the following conditions:

Argon flow rate: 500 Nl/min in 100 ton ladle. Bath height is 1.2m. Density of steel is 7000 kg/m$^3$. Temperature of steel bath 1600°C. Pressure above the surface =1bar. Temperature of argon 25°C.

Stirring power (W)

\[
W = 6.18 \times 10^{-3} Q T \left[ \left( 1 - \frac{273}{T} \right) + \ln \frac{P_1}{P_2} \right]
\]

\[
6.18 \times 10^{-3} \times 500 \times 1873 \left[ \left( 1 - \frac{273}{1873} \right) - \ln \frac{1.013 \times 10^5 + 7000 \times 981 \times 1.2}{1.013 \times 10^5} \right]
\]

\[= 5787.6[0.85 + 0.595]\]

\[= 8364W\]

\[= 83.64W/ton of steel\]

\[= 585.48W/m^3 of steel melt.\]

Repeat the above calculations for gas flow rates 400Nl/min and 600Nl/min in a ladle of 150 ton capacity. Bath height is 1.5m. Discuss the results of calculations.

5) **Problem on momentum flow rate** *(reference lecture for the problem is 13)*

Calculate the momentum flow rate produced by passing oxygen gas through a lance fitted with four convergent-divergent nozzles in a 300 ton converter. The diameter of each nozzle is 45mm.
Hint: Calculate $P_o$ by equation 6 and use equation 5 to calculate momentum flow rate. Use surrounding pressure $1.013 \times 10^5$ N/m$^2$.

The lance distance to start the blow is 3m upto 25% of the blow time which is then decreased to 2m for 25% to 75% of the blow time. Between 75% and upto the end the lance distance id decreased further to 1.5m. Calculate the depth of penetration of gas jet and discuss the nature of blow and the associated physico-chemical reactions as a function of lance distance. Include in your calculation the depth of penetration of gas jet.

*Hint Calculate dimensionless momentum flow rate from equation 8 and depth of gas jet penetration from equation 9*