

B. E. MECHANICAL ENGINEERING
Choice Based Credit System (CBCS) and Outcome Based Education (OBE)
SEMESTER - III

METAL CASTING AND WELDING

Course Code	18ME35B/45B	CIE Marks	40
Teaching Hours/Week (L:T:P)	3:0:0	SEE Marks	60
Credits	03	Exam Hours	03

Course Learning Objectives:

- To provide adequate knowledge of quality test methods conducted on welded and cast components.
- To provide knowledge of various casting process in manufacturing.
- To provide in-depth knowledge on metallurgical aspects during solidification of metal and alloys.
- To provide detailed information about the moulding processes.
- To impart knowledge of various joining process used in manufacturing.
- To impart knowledge about behaviour of materials during welding, and the effect of process parameters in welding,

Module-1

Introduction & basic materials used in foundry:

Introduction: Definition, Classification of manufacturing processes. Metals cast in the foundry-classification, factors that determine the selection of a casting alloy.

Introduction to casting process & steps involved:

Patterns: Definition, classification, materials used for pattern, various pattern allowances and their importance.

Sand moulding: Types of base sand, requirement of base sand. Binder, Additives definition, need and types; preparation of sand moulds. Molding machines- Jolt type, squeeze type and Sand slinger.

Study of important moulding process: Green sand, core sand, dry sand, sweep mould, CO₂ mould, shell mould, investment mould, plaster mould, cement bonded mould.

Cores: Definition, need, types. Method of making cores,

Concept of gating (top, bottom, parting line, horn gate) and risers (open, blind) Functions and types.

Module-2

MELTING & METAL MOLD CASTING METHODS

Melting furnaces: Classification of furnaces, Gas fired pit furnace, Resistance furnace, Coreless induction furnace, electric arc furnace, constructional features & working principle of cupola furnace.

Casting using metal moulds: Gravity die casting, pressure die casting, centrifugal casting, squeeze casting, slush casting, thixocasting, and continuous casting processes.

Module-3

SOLIDIFICATION & NON-FERROUS FOUNDRY PRACTICE

Solidification: Definition, nucleation, solidification variables. Directional solidification-need and methods. Degasification in liquid metals-sources of gas, degasification methods.

Fettling and cleaning of castings: Basic steps involved. Sand Casting defects- causes, features and remedies. Advantages & limitations of casting process

Nonferrous foundry practice: Aluminium castings - advantages, limitations, melting of Aluminium using lift-out type crucible furnace. Hardeners used, drossing, gas absorption, fluxing and flushing, grain refining, pouring temperature. Stir casting set up, procedure, uses, advantages and limitations.

Module-4

Welding process: Definition, Principles, classification, application, advantages & limitations of welding. Arc welding: Principle, Metal arc welding (MAW), Flux Shielded Metal Arc Welding (FSMAW), Inert Gas Welding (TIG & MIG) Submerged Arc Welding (SAW) and Atomic Hydrogen Welding (AHW).

Special type of welding: Resistance welding principles, Seam welding, Butt welding, Spot welding and Projection welding. Friction welding, Explosive welding, Thermit welding, Laser welding and Electron beam welding.

Module-5**METALLURGICAL ASPECTS IN WELDING, SOLDERING, AND BRAZING**

Structure of welds, Formation of different zones during welding, Heat Affected Zone (HAZ), Parameters affecting HAZ. Effect of carbon content on structure and properties of steel, Shrinkage in welds & Residual stresses. Concept of electrodes, filler rod and fluxes. Welding defects- detection, causes & remedy.

Soldering, brazing, gas welding: Soldering, Brazing, Gas Welding: Principle, oxy-Acetylene welding, oxy-hydrogen welding, air-acetylene welding, Gas cutting, powder cutting.

Inspection methods: Methods used for inspection of casting and welding. Visual, magnetic particle, fluorescent particle, ultrasonic. Radiography, eddy current, holography methods of inspection.

Course Outcomes: At the end of the course, the student will be able to:

CO1: Describe the casting process and prepare different types of cast products.

CO2: Acquire knowledge on Pattern, Core, Gating, Riser system and to use Jolt, Squeeze, Sand Slinger Moulding machines.

CO3: Compare the Gas fired pit, Resistance, Coreless, Electrical and Cupola Metal Furnaces.

CO4: Compare the Gravity, Pressure die, Centrifugal, Squeeze, slush and Continuous Metal mold castings.

CO5: Understand the Solidification process and Casting of Non-Ferrous Metals.

CO6: Describe the Metal Arc, TIG, MIG, Submerged and Atomic Hydrogen Welding processes etc. used in manufacturing.

CO7: Describe methods for the quality assurance of components made of casting and joining process

Question paper pattern:

- The question paper will have ten full questions carrying equal marks.
- Each full question will be for 20 marks.
- There will be two full questions (with a maximum of four sub- questions) from each module.
- Each full question will have sub- question covering all the topics under a module.
- The students will have to answer five full questions, selecting one full question from each module.

Sl. No.	Title of the Book	Name of the Author/s	Name of the Publisher	Edition and Year
Textbook/s				
1	Principles of metal casting	Rechard W. Heine, Carl R. Loper Jr., Philip C. Rosenthal	Tata McGraw Hill Education Private Limited	1976
2	Manufacturing Process-I	Dr.K.Radhakrishna	Sapna Book House,	5th Revised Edition 2009.
3	Manufacturing Technology- Foundry, Forming and	P.N.Rao	Tata McGraw Hill	3rd Ed., 2003.
Reference Books				
4	Process and Materials of Manufacturing	Roy A Lindberg	Pearson Edu	4th Ed. 2006
5	Manufacturing Technology	Serope Kalpakjian Steuen. R Sechmid	Pearson Education Asia	5th Ed. 2006


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