



Electroslag refining with liquid metal for composite rotor manufacturing

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ABSTRACT

Purpose: To develop novel ESR based process for composite ingot with shallow transition zone between layers in order to produce efficient heavy-weight rotors for steam turbines.

Design/methodology/approach: The nowadays heavy-weight rotors for steam turbines for power plants are monoblock or two or more layer in length composite part facilitating operation in different zones withstanding various loads and working medium. However, the joining of various steel in composite rotors by welding has low productivity. The ESR now is recognised as the best available technology for the big-diameter and mass forgings for power generating machines, including rotor ones. The ESR affords the most favourable conditions of solidification resulting in homogenous low-segregation ingot with smooth surface and high-quality structure. The step ahead is the ESR for composite.

Findings: The two-layer model ingot had produced from steel grades 12Cr13 and 35NiCrMoV12-5 were manufactured using the electroslag process with the liquid metal (ESR LM) in the CSM of 180 mm in diameter with ingot withdrawing. The transition zone in two-layer ingot had have the shallow shape and low depth with the even macrostructure without defects of the same type as both joined steels. The metal of the transition zone fully satisfies standard requirements for properties of both steel grades in the heat treated and as-cast conditions.

Research limitations/implications: The ESR LM can provide both the monobloc heavy ingots with uniform structure and composites with low-stress connection between metal layers for heavyweight rotors and other critical products manufacturing.

Keywords: ESR LM, Composite ingot, Heavy rotor, Transition zone, Heat treatment, Microstructure, Mechanical properties

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Table of Contents Electroslag Refining Proceedings Of A Conference On Electroslag Refining

1. Understanding the eBook Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - The Rise of Digital Reading Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Advantages of eBooks Over Traditional Books
2. Identifying Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - User-Friendly Interface
4. Exploring eBook Recommendations from Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Personalized Recommendations
 - Electroslag Refining Proceedings Of A Conference On Electroslag Refining User Reviews and Ratings
 - Electroslag Refining Proceedings Of A Conference On Electroslag Refining and Bestseller Lists

5. Accessing Electroslag Refining Proceedings Of A Conference On Electroslag Refining Free and Paid eBooks
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 - Electroslag Refining Proceedings Of A Conference On Electroslag Refining eBook Subscription Services
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6. Navigating Electroslag Refining Proceedings Of A Conference On Electroslag Refining eBook Formats
 - ePub, PDF, MOBI, and More
 - Electroslag Refining Proceedings Of A Conference On Electroslag Refining Compatibility with Devices
 - Electroslag Refining Proceedings Of A Conference On Electroslag Refining Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Highlighting and Note-Taking Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Interactive Elements Electroslag Refining Proceedings Of A Conference On Electroslag Refining
8. Staying Engaged with Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Electroslag Refining Proceedings Of A Conference On Electroslag Refining
9. Balancing eBooks and Physical Books Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Electroslag Refining Proceedings Of A Conference On Electroslag Refining
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Setting Reading Goals Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Fact-Checking eBook Content of Electroslag Refining Proceedings Of A Conference On Electroslag Refining
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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