

ON THE REACTIONS IN ILMENITE, ALUMINUM AND GRAPHITE SYSTEM

R. Khoshhal¹, M. Soltanieh^{*2} and M. A. Boutorabi²

^{*} mansour_soltanieh@iust.ac.ir

Received: April 2015

Accepted: January 2016

¹ Birjand University of Technology, Birjand, Iran.

² Iran University of Science and Technology, Tehran, Iran.

Abstract: Al₂O₃/TiC composites are used as cutting tools for machining gray cast iron and steels. The addition of iron improves the toughness of Al₂O₃/TiC composites. Ilmenite, aluminum and graphite can be used to produce in-situ Al₂O₃/TiC-Fe composites. However, the formation mechanism and reaction sequences of this system are not clear enough. Therefore, the present research is designed to determine the reactions mechanism of the first step of reactions that may be occurred between raw materials.

In this research, pure ilmenite was synthesized to eliminate the effects of impurities available in the natural ilmenite in the system. The milled and pressed samples, prepared from the synthesized ilmenite, aluminum and graphite mixture with a molar ratio of 1:2:1, were heat treated at 720°C for 48h. In addition, two samples one containing ilmenite and aluminum with a molar ratio of 1:2 and ilmenite and graphite with a molar ratio of 1:1 were heat treated at 720°C for 48h. The final products were analyzed with XRD. It was found that at 720°C, aluminum reacts with FeTiO₃, forming Fe, TiO₂ and Al₂O₃. Since the aluminum content used in the mixture was more than the stoichiometry for reaction of ilmenite and aluminum, some unreacted aluminum remains. Therefore, the residual aluminum reacts with the reduced Fe to form Fe₂Al₅.

Keywords: Ilmenite, Aluminum and Graphite, First step mechanism

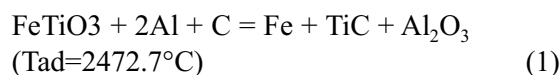
1. INTRODUCTION

Lately, the interest in the use of Al₂O₃/TiC composites [1] as cutting tools for machining of gray cast iron and steels is growing due to the reason that they can machine with high cutting speeds and produce a good surface finish [2]. Composites with a Al₂O₃ matrix containing dispersed titanium carbide is mainly used and it is expected to be used more widely compared to pure Al₂O₃, as its toughness is increased by the addition of TiC [3]. Nevertheless, low toughness is their major deficiency. Addition of ductile metal such as Fe can improve the tensile stress and toughness of the final composites [4-7].

These composites can be produced by a number of methods, among them, the combustion synthesis method requires the least energy [8]. Moreover, ilmenite is a cheap mineral consisting of Iron and titanium. Furthermore, in-situ growth of TiC can greatly reduce the cost and environment pollution [3]. Therefore, the advantage of this project is to use cheap ilmenite as raw material for the in-situ synthesis of Fe-

TiC/Al₂O₃ to simultaneously obtain a combination of the all mentioned benefits.

Based on equation 1, Fe, TiC and Al₂O₃ are produced in the form of a composite material by reaction between FeTiO₃, Al and C:



Fortunately, the adiabatic temperature of this system is higher than the Merzhanov index ($\text{Tad} > 1800 \text{ K}$), therefore this system undergoes a self propagating high temperature synthesis reaction (SHS) [8].

Few research [9-13] have been performed using ilmenite as a raw material, for the synthesis of Al₂O₃-TiC/Fe composites. Tang et al [13] presented a relatively comprehensive research on this system, but there are some vague and contradictory notes on the work such as wrong identification of the present compound according the XRD analysis and therefore an incorrect proposed mechanism based on the wrong discussion. Zou et al [9-11] have investigated on

the effect of some factors such as the graphite source, additives such as Mo and Cr and the preheating time on the FeTiO₃-Al-C system. They have also proposed a mechanism based on the TiO₂-Al-C system. Accordingly, at first the ilmenite was reduced to different valent of titanium oxides and iron by molten aluminum, including TiO₂, Ti₃O₅, Ti₂O₃ and a number of Ti_xO_y phases. When the Ti/O ratio in the Ti-Al-O system comes to equilibrium and the residual aluminum combines with α -Fe, a Fe-Al solid solution is formed. However at this stage there is not anymore free aluminum to deoxidize the Ti_xO_y's, therefore, low valent titanium oxides react with C, and as a result TiC phase is formed. However Zou et al [9-11] did not mention the effect of the released Fe in the mechanism. Furthermore all of their claims were based on the final product and the intermediate steps, were not explicit to clarify the sequence of the reactions. Zargaran determined the effect of temperature, heating rate, pressure and the various molar ratios of FeTiO₃:Al:C on the formation of TiC. He proposed the optimum condition to produce the TiC. However the reaction mechanism was not determined. In another investigation [14-18], the conversion of TiO₂ to TiC has been considered [19, 20]. Also, there is no agreement on the type and the conversion steps of these titania sub oxides.

The aim of this paper is to determine the

mechanism of the first step of reactions occurring between ilmenite, aluminum and graphite. In the presented research by others [21-23], the ilmenite concentrate was used. Since the ilmenite concentrate consists of several impurities, and the effects of these impurities on the reactions are not clear, they may possibly change the reaction mechanisms. Furthermore Fe²⁺ and Fe³⁺ coexist in ilmenite concentrate, while in the synthesized ilmenite only Fe²⁺ is present. Therefore, to avoid confusion, pure ilmenite was synthesized and used in this study.

In this research, the milled and pressed samples, prepared from the synthesized ilmenite, aluminum and graphite mixture with a molar ratio of 1:2:1 (according to stoichiometry of equation 1), were heat treated at 720 °C for 48h. In addition, two samples one containing ilmenite and aluminum with a molar ratio of 1:2 and the other containing ilmenite and graphite with a molar ratio of 1:1 were heat treated at 720 °C for 48h to compare the result of ilmenite-aluminum sample and ilmenite-graphite sample with the result of ilmenite-aluminum-graphite sample. The final products were analyzed with XRD. It was found that at 720 °C (the first step of reactions in the ilmenite-aluminum and graphite system), aluminum reacts with FeTiO₃, forming Fe, TiO₂ and Al₂O₃. Then because of this fact that the aluminum content at the begging raw materials is more than needed for reaction of

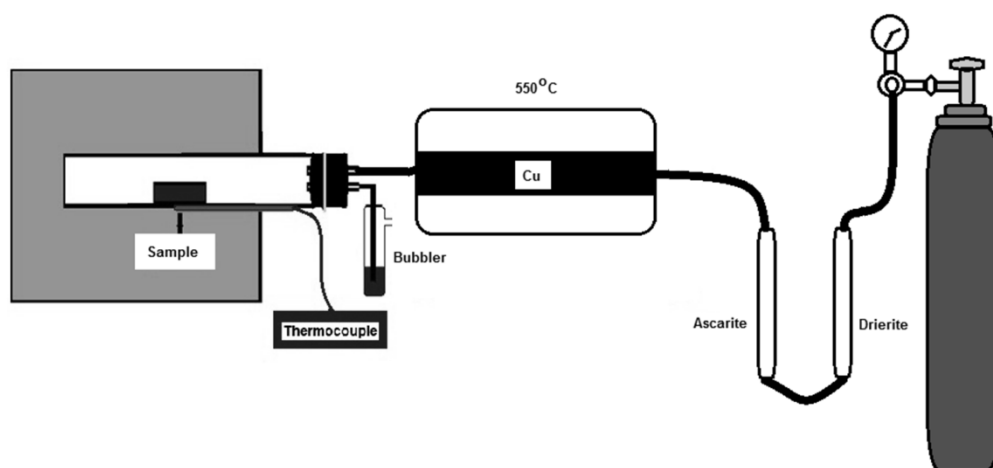


Fig. 1. The setup used for heat treatment of samples

analysis of the products using a PHILIPS model PW 1800 machine with CuK α radiation ($\lambda = 1.54$ Å) under a voltage and current of 40 kV and 30 mA, respectively.

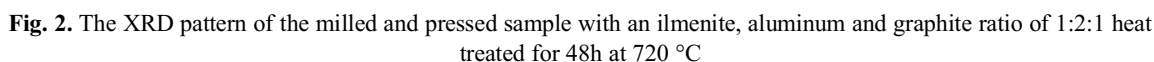
3. RESULTS AND DISCUSSIONS

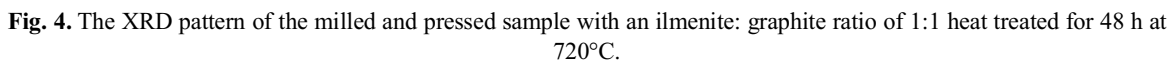
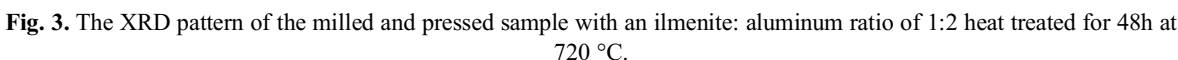
As was mentioned before, three samples, namely, ilmenite-aluminum-graphite, ilmenite-aluminum and ilmenite-graphite were investigated which their results will be discussed here.

According to figure 2, the XRD pattern of the sample of ilmenite-aluminum-graphite with a molar ratio of 1:2:1, heat treated at 720 °C for 48 hours shows that Fe, Al₂O₃, TiO₂, Fe₂Al₅ and remained graphite are detected in the final product of reactions.

The XRD pattern of the sample of ilmenite-aluminum with the molar ratio of 1:2, heat treated at 720°C for 48 hours was shown in figure 3. It shows that Fe, Al₂O₃, TiO₂ and Fe₂Al₅ are the final product of the reaction of raw material at this temperature. These compounds are similar to final product of the sample of ilmenite-aluminum-graphite with the molar ratio of 1:2:1, heat treated at 720 °C for 48 hours.

In figure 4, The XRD pattern of the sample of ilmenite-graphite with the molar ratio of 1:1, heat treated at 720 °C for 48 hours was shown. As can be seen there is very few amount of Fe and TiO₂ as the reaction products between raw materials, but there are lots of remained FeTiO₃ in the





at 720 °C. It shows that graphite doesn't react with the either ilmenite or aluminum, so it remained unchanged.

4. THERMODYNAMIC ANALYSIS

To understand the possible reactions in this system, the HSC software was used [24]. As can be seen in figure 5, the reaction of FeTiO_3 and Al has the least standard Gibb's free energy; thereupon this reaction can be occurred easier than the others. Therefore, at the first step of ilmenite, aluminum and graphite system reactions, ilmenite reacts with aluminum and Fe,

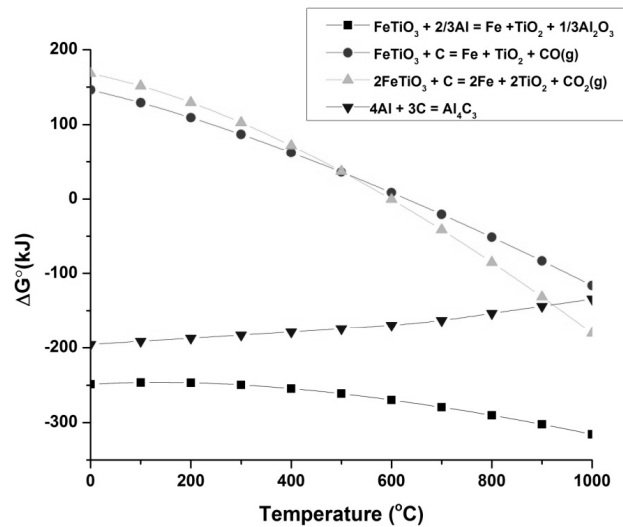


Fig. 5. The standard Gibb's free energy of reactions may occur between materials used in the mixture calculated with HSC software

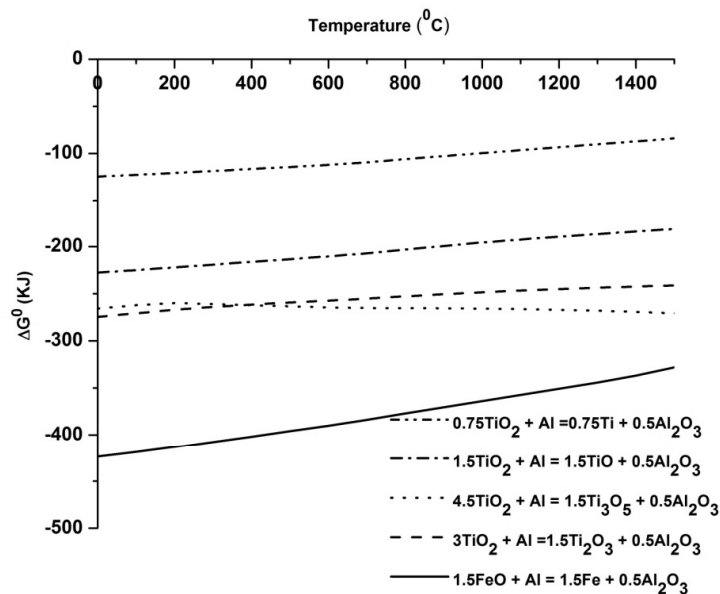


Fig. 6. The standard Gibb's free energy of FeO and TiO₂ by Al calculated with HSC software

TiO₂ and Al₂O₃ form. The amount of aluminum required to react with ilmenite is 2/3 of ilmenite molar ratio. The amount of aluminum used in raw materials is more than this ratio; therefore, after reaction of ilmenite with the aluminum, some unreacted aluminum remains. This aluminum may react with Fe (the production of ilmenite and aluminum reactions) and Fe₂Al₅ forms.

As was discussed earlier, it was shown that the FeO was reduced to Fe but the TiO₂ remained unchanged. To address this result, Figure 6 could be useful. As can be seen in Figure 6, the reaction of FeO and aluminum has the least Gibb's free energy; therefore, FeO can be reduced easily by aluminum while TiO₂ remains unchanged.

5. CONCLUSION

As a conclusion, the first mechanism step of reactions in the ilmenite, aluminum and graphite system to produce $\text{Al}_2\text{O}_3/\text{TiC}$ -Fe composites were discussed. It seems that the first reaction may occur in this system after the melting of aluminum. At this step ilmenite reacts with aluminum to form Fe, TiO_2 and Al_2O_3 . Because the aluminum content at the begging raw materials is more than needed for reaction of ilmenite and aluminum, some of the aluminum remains. The residual aluminum may react with the produced Fe and Fe_2Al_5 forms.

REFERENCES

- Hajalilou, A., Hashim, M., Nahavandi, M. and Ismail, I., "Mechanochemical carboaluminothermic reduction of rutile to produce $\text{TiC}-\text{Al}_2\text{O}_3$ nanocomposite". *Adv. Powder. Technol.*, 2014, 25, 423-429.
- Senthil Kumar, A., Raja Durai, A. and Sornakumar, T., "Machinability of hardened steel using alumina based ceramic cutting tools", *Int. J. Refract. Met. H.*, 2003, 21, 109-117.
- Geric, K., "Ceramics Tool Materials with Alumina Matrix". ADEKO, May 18th 2010.
- Chen, X., Zhai, H., Wang, W., Li, S. and Huang, Z., "A TiC_x reinforced Fe (Al) matrix composite using in-situ reaction". *Progress in Nat. Sci: Mat. Int.*, 2013, 23, 13-17.
- Yin, Z., Huang, C., Zou, B., Liu, H., Zhu H. and Wang, J., "High temperature mechanical properties of $\text{Al}_2\text{O}_3/\text{TiC}$ micro-nano-composite ceramic tool materials". *Ceram. Int.*, 2013, 39, 8877-8883.
- Yin, Z., Huang, C., Zou, B., Liu, H., Zhu, H. and Wang, J., "Study of the mechanical properties, strengthening and toughening mechanisms of $\text{Al}_2\text{O}_3/\text{TiC}$ micro-nano-composite ceramic tool material". *Mater. Sci Eng: A.*, 2013, 577, 9-15.
- Arsenault, R. J., Fishman, S. and Taya, M. "Deformation and fracture behavior of metal-ceramic matrix composite materials". *Prog. Mater. Sci.*, 1994, 38, 1-157.
- Suryanarayana, C., Non - Equilibrium Processing of Material, chapter 11, Combustion Synthesis 1st ed, Pergamon, 1999, pp 289-300.
- Zou, Z., Li, J. and Wu, Y., "The study of self-propagating high-temperature synthesis of $\text{TiC}-\text{Al}_2\text{O}_3/\text{Fe}$ composites from natural ilmenite", *Key. Eng. Mat.*, 2005, 280-283, 1103-1106.
- Zou, Z., Yin, C., Wu, Y. and Li, X., "Fabrication of Fe-Al intermetallic/ $\text{TiC}-\text{Al}_2\text{O}_3$ ceramic composites from ilmenite by reaction sintering". *Key. Eng. Mat.*, 2007, 336-338, 1501-1504.
- Zou, Z., Wu, Y., Yin, C. and Li, X., "Preparation of Fe-Al intermetallic / $\text{TiC}-\text{Al}_2\text{O}_3$ ceramic composites from ilmenite by SHS", *J. Wuhan. Univ. Technol, Mater. Sci.*, 2007, 22, 706-709.
- Zargarani, I., "Preparation of $\text{TiC}-\text{Al}_2\text{O}_3/\text{Fe}$ composites using combustion synthesis from ilmenite in Departman of material engineering Tehran University, Iran", 2005.
- Tang A., Liu S. and Pan F., "Novel approaches to produce $\text{Al}_2\text{O}_3-\text{TiC}/\text{TiCN}-\text{Fe}$ composite powders directly from ilmenite". *Prog. Natur. Sci: Mater. Int.*, 2013, 23, 501-507.
- Dewan, M., Zhang, G. and Ostrovski, O., "Carbothermal reduction of titania in different gas atmospheres". *Metall. Mater. Trans B.*, 2009, 40, 62-69.
- Dewan, M., Zhang G. and Ostrovski, O., "Carbothermal reduction of a primary ilmenite concentrate in different gas atmospheres. Metall". *Mater. Trans B.*, 2010, 41, 182-192.
- Sen, W., Xu, B., qiang, Yang, B., Sun, H., yan, Song, J., Xun, Wan, H. and li., "Preparation of TiC powders by carbothermal reduction method in vacuum", *Trans. Non ferrous. Met. Soc. China.*, 2011, 21, 185-190.
- Woo, Y., Chul, Kang, H. and Jae, Kim, D., J., "Formation of TiC particle during carbothermal reduction of TiO_2 ", *J. Eur. Ceram. Soc.*, 2007, 27, 719-722.
- Kucukkaragoz, C. and Eric, R., "Solid state reduction of a natural ilmenite". *Miner. Eng.*, 2006, 19, 334-337.
- Tavakoli, A. and Goudarzi, M., "Effect of Mechanical Activation on Carbothermic Synthesis of Titanium Carbide from Ilmenite Concentrate", *Iran. J. Mat. Sci. Eng*, 2004, 1, 9-15.
- Alizadeh, R. and Ostrovski, O., "Kinetic Study

- of Synthesis of Titanium Carbide by Methanothermal Reduction of titanium Dioxide”, *Iran. J. Mat. Sci. Eng.*, 2011, 8, 1-8.
21. Anovitz, L., Treiman, A., Essene, E., Hemingway, B., Westrum, J., Wall, V., “The heat-capacity of ilmenite and phase equilibria in the system Fe-Ti-O”. *Geochimic Cosmochim Ac.*, 1985, 49, 2027-2040.
 22. Duchesne, J. and Bologne, G., “Synthetic ilmenite as a blank to XRF trace element determination. *Geologica Belgica.*, 2011, 14, 103-106.
 23. Gupta, S., Rajakumar, V. and Grieveson, P., “Kinetics of reduction of ilmenite with graphite at 1000 to 1100 °C”. *Metall. Mater. Trans B.*, 1987, 18, 713-718.
 24. *HSC Chemistry 5.11 ed.* Finland: Outokumpu Research; 2002.