

ANALYSIS OF HEAT TRANSFER IN STEEL BILLETS DURING TRANSPORT

K. N. Cançado^a,
L. Machado^a,
and L. N. Soares^b

^aUniversidade Federal de Minas Gerais
Programa de Pós-Graduação em
Engenharia Mecânica
Campus Pampulha, Bairro Pampulha
CEP 31270-901
Belo Horizonte, MG, Brasil
kancado@hotmail.com.br

^bVallourec Soluções Tubulares do Brasil S.A.
Belo Horizonte, MG, Brasil
CEP 30640-010

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ABSTRACT

During the seamless steel tubes manufacturing process, the temperature decrease between the exit of the furnace and the rolling mill entrance is determinant factor in the rolling process and the quality of the tube. This study aims to model the cooling of the billets during transport in order to evaluate the minimum temperature required for the billet leaves the furnace and also the maximum transport time without compromising the rolling process, allowing a better setup of equipment and reducing the production costs. The cooling profile was determined numerically through energy balances performed on the billet and the results obtained were compared with real values of temperature measurements by thermocouples installed on the billet. Measurements with thermocouples were conducted in billets of 270, 230 and 180 mm diameter. The error relative to the real values for all cases was below than 2.5% and the model is considered validated to use.

Keywords: cooling, transport, rolling mill, heat transfer, cost

NOMENCLATURE

A	surface area of layer, m ²
c _p	steel specific heat at constant pressure, J/(kg.K)
D	billet diameter, m
E	dimensionless error
h	heat transfer coefficient, W/(m ² .K)
K	thermal conductivity, W/ (m.K)
m	mass of a layer, kg
NU	dimensionless mean value of Nusselt number
Pr	dimensionless value of Prandtl number
Ra	dimensionless value of Rayleigh number
re	external radius, m
ri	internal radius, m
T	layer temperature, K
t	time, s

Greek symbols

D	difference between values of a property
ε	dimensionless steel emissivity
σ	constant of Stefan Boltzmann, W/ (m ² . k ⁴)

Subscripts

conv	convection
n	layer index
p	iteration index
rad	radiation
∞	environment

INTRODUCTION

The seamless tube production process has as its first step the heating of steel billet at a temperature of about 1200°C, after heating these billets are transported to the rolling mill. The temperature that the billet reaches the rolling mill is of great importance for the process quality. Thus, in order to understand and predict the cooling process during the transport, the heat transfer present in the cooling processes was studied and mathematically modelled. A tool was developed to simulate the cooling profile during transport. The cooling profile was determined using energy balances performed on the billet, and these were numerically solved using the technique of successive substitutions (Chapra 2004). To validate the results, measurements were made with thermocouples (billets of 270, 230 and 180 mm in diameter).

The knowledge of the cooling mechanism allows determining the cooling profile, the minimum unloading temperature and the maximum transportation time, it also allows a more efficient setup of the equipment, so generating a reduction in production costs and improving of product quality.

MATHEMATICAL MODEL

In the mathematical model, the one-dimensional cooling (radial direction) was considered, and only the central section of the billet was analyzed, so the

edge effect present at the extremities was not considered. Once this was defined, the section was divided into n layers. The surface layer (layer 1) exchanges heat by radiation and natural convection with the external environment, and exchange heat by conduction with layer 2. The internal layers (2 to $n-1$) exchange heat through conduction. The last internal layer (n) has very small area, close to zero, so it is considered that the temperature of this layer is equal to that of layer $n-1$. Figures 1 and 2 illustrate these heat exchanges.

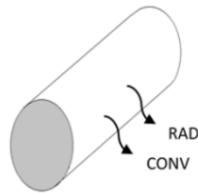


Figure 1. Heat Transfer Surface Layer.

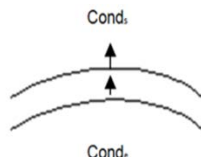


Figure 2. Heat Transfer Layer 2 to $n-1$.

ENERGY BALANCE

According to (Incropera et al. 2014), the energy balance can be solved in a discrete way for each layer, approaching dT/dt by $\Delta T/\Delta t$. The time step, Δt , is equal to 1 s, temperature and dependent properties (C_p , h_{conv} , h_{rad} , and k) were updated every iteration.

$$m.C_p \cdot \frac{\Delta T}{\Delta t} = h_{conv} \cdot A(T - T_\infty) + h_{rad} \cdot A(T - T_\infty) = +k \cdot \frac{2\pi}{Ln} \cdot \frac{re}{ri} \cdot (T_n - T_{n+1}) \quad (1)$$

where: m is the mass of a layer, kg; C_p is the specific heat of the steel, J/(kg.K); T is the layer temperature, K; t is time, s; h_{conv} is the convective heat transfer coefficient, W/(m².K); A is the surface area of layer, m², h_{rad} is the coefficient of heat transfer by radiation, W/(m².K); re is external radius, m; ri is internal radius, m; n is the layer index.

The equation of the layer 1 (surface layer) is given by Eq. (1).

$$h_{rad} = \varepsilon \cdot \sigma \cdot (T_n + T_\infty) \cdot (T_n^2 + T_\infty^2) \quad (2)$$

$$h_{conv} = \frac{\overline{NU} \cdot K}{D} \quad (3)$$

where: ε is the dimensionless emissivity of the surface of the steel billets (equal to 0.91); σ is the constant of Stefan Boltzmann, W/(m².k⁴); \overline{NU} is the dimensionless mean value of the Nusselt number of the billet; k is the thermal conductivity, W/(m.K); D is the diameter, m.

Eqs. (2) - (3) represent the heat transfer coefficients by radiation and convection respectively.

$$\overline{NU} = \left\{ 0.60 + \frac{0.387 \cdot Ra^{\frac{1}{6}}}{\left[1 + \left(\frac{0.559}{Pr} \right)^{\frac{9}{16}} \right]^{\frac{8}{27}}} \right\}^2 \quad (4)$$

where: Ra is dimensionless numbers of Rayleigh; Pr is dimensionless number of Prandtl.

According to Churchill e Chu (1975), Nusselt along the surface, can be estimated for numbers of Rayleigh less than 1012 as in Eq. (4).

$$m \cdot c_p \cdot \frac{\Delta T}{\Delta t} = k \cdot \frac{2\pi}{Ln} \cdot \frac{re}{ri} \cdot (T_n + T_{n+1}) \quad (5)$$

$$T_n = T_{n-1} \quad (6)$$

Eqs. (5) - (6) represent the energy balance for layers 2 to $n-1$ (inner layers) and layer n (inner most layer).

NUMERICAL METHOD

In the energy balance equation Eq. (1), temperature is function of h_{conv} and h_{rad} , which, in turn, are also function the temperature.

$$T = f_T \quad (7)$$

In order to solve the equation it was necessary an iterative method, in this case the technique of successive substitutions, where temperature is calculated exclusively in function the temperature, as in Eq. (7) (Chapra 2004). To implement this method and solve the equations was written a code in c++.

To accelerate the convergence of the method, the value found in the previous iteration was arbitrated as the initial temperature value.

$$\left| \frac{T_p - T_{p-1}}{T_p} \right| \leq E \quad (8)$$

where: E is the dimensionless error (equal to 0.01); p is iteration index.

The criterion of convergence of the method is given by Eq. (8).

Figure 3 illustrates the iteration process:

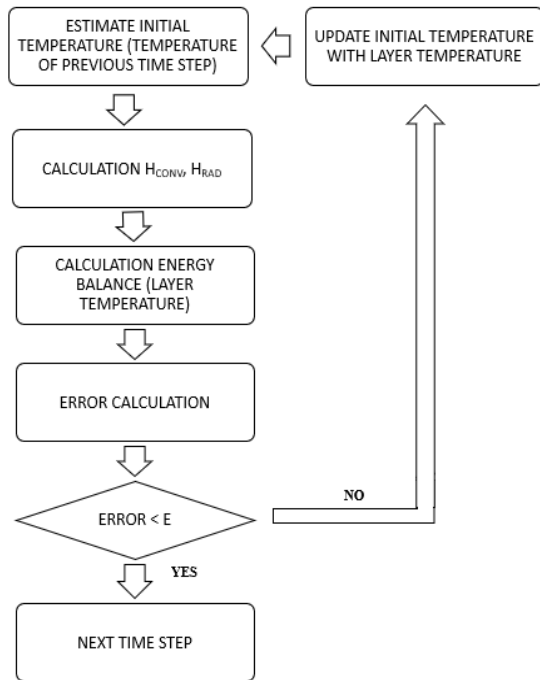


Figure 3. Iteration Process.

MEASUREMENT WITH THERMOCOUPLES

Measurements with thermocouples consist of using pre-instrumented billets with thermocouples type K, these are connected to a logger housed inside a thermal barrier, which function is to protect the logger from high temperatures. After being instrumented the billet is then load, heated, unload and transported to the entrance of the rolling mill. The logger records the temperatures at predetermined time intervals which allows filtering only the range of interest, in this case the time between the furnace exit and the rolling mill entrance. Once this is done, is possible to compare the measured and calculated cooling profiles.

The billet is instrumented with 10 thermocouples. Those of numbers 1, 4, 7 are fixed to a depth of 10 mm from the upper face. Those of numbers 2, 5, 8 are fixed in the center. Those of numbers 3, 6, 9 are fixed to a depth of 10 mm from the lower face of the billet. The number 10 is not connected to the billet and works as an “antenna”, recording the ambient temperature. The thermocouples are distributed in groups of 3 as showed in Fig.4. In this way measurements are made of the upper, lower faces and center in three regions of the billet.

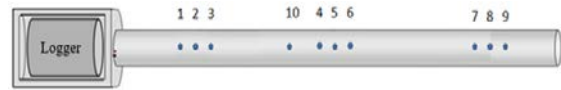


Figure 4. Instrumented Billet.

RESULTS

All the equipment used in the data collection were calibrated. The temperature profile of the billet during the cooling was simulated and can be compared to the profile measured with the thermocouples. The simulated temperature for the layer 2, which corresponds to the depth at which the thermocouple was fixed (10 mm), was used for analysis. The initial temperature value used in the simulation corresponds to the actual value of the thermocouple measurements at the start of the cooling. The cooling profiles for the three measured diameters (270, 230, 180 mm) are showed in Fig.5, Fig.6, Fig.7.

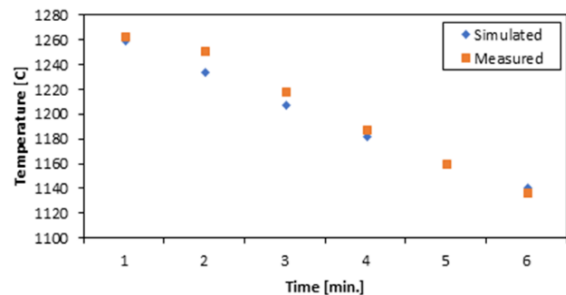


Figure 5. Cooling Profile Billet 270 mm.

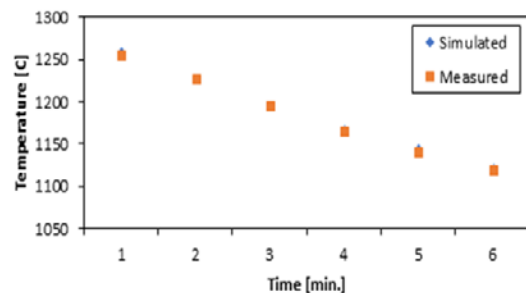


Figure 6. Cooling Profile Billet 230 mm.

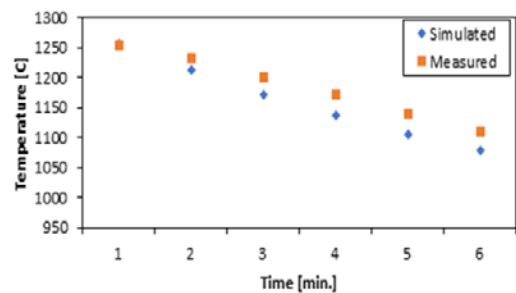


Figure 7. Cooling Profile Billet 180 mm.

The exact temperature measurements and simulations for the three diameters (270, 230, 180 mm) are presented in Tab.1, Tab.2, Tab.3:

Table 1. Simulated and measured temperature values for 270 mm billets.

	0 min.	1 min.	2 min.	3 min.	4 min.	5 min.
Simulated Temperature [C]	1258	1215	1175	1140	1109	1081
Measured Temperature [C]	1258	1234	1204	1173	1143	1114

Table 2. Simulated and measured temperature values for 230 mm billets.

	0 min.	1 min.	2 min.	3 min.	4 min.	5 min.
Simulated Temperature [C]	1257	1229	1175	1169	1145	1122
Measured Temperature [C]	1257	1238	1196	1167	1142	1121

Table 3. Simulated and measured temperature values for 180 mm billets.

	0 min.	1 min.	2 min.	3 min.	4 min.	5 min.
Simulated Temperature [C]	1263	1235	1208	1183	1161	1141
Measured Temperature [C]	1263	1252	1219	1188	1161	1137

$$\text{Relative_error} = \frac{V_{\text{measured}} - V_{\text{simulated}}}{V_{\text{measured}}} \quad (9)$$

The relative error between the simulation and the experimental data was calculated as in Eq. (9).

The calculated error values for the three diameters analyzed are presented in Tab. 4.

Table 4. Simulation Error in Relation to thermocouple Measurements.

	0 min.	1 min.	2 min.	3 min.	4 min.	5 min.
270 mm	-	1.36%	0.90%	0.42%	0.00%	0.35%
230 mm	-	0.08%	0.08%	0.17%	0.26%	0.09%
180 mm	-	1.54%	2.41%	2.81%	2.97%	2.96%

Table 5 presents the calculated average error values for the three diameters analyzed.

Table 1. Average error between Thermocouple Measurements.

	Average Error
270 mm	0.51%
230 mm	0.11%
180 mm	2.12%

CONCLUSION

This work achieved its objective of simulating the cooling profile of the billets in the transport between the exit of the furnace and the entrance of the mill.

The understanding of this cooling allows the correct setup of the equipment, improving the quality of the tubes and reducing the costs with: rework; energy in the unnecessary heating of the billets; energy in the lamination of cold billets; premature wear of tools.

In general, the cooling model showed good accuracy, obtaining an average error of less than 2.5%. In this way, it has satisfactorily allowed the use to help decision making in the industrial environment.

The model results for the billets of 270 and 230 mm presented a relative error lower than 0.5% indicating a good precision of the model. The results for the billets of 180 mm the simulation presented a relative error of approximately 2.12%, being this, the worst result among the three types of billets studied. The reason for this being observed only in the 180 mm billet is that the production line of this billet is different from the 230 and 270 mm billets. Thus, the configuration of these equipment can influence the model boundary conditions, which were studied for the production line of billets of 270 and 230 mm. A more detailed study is needed to refine the model for the production line of the 180 mm billets. However, the error is within the operating limit accepted and the model can be considered validated for use in the three billet diameters.

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