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THE ESTIMATION OF YIELD STRENGTH FROM HARDNESS
MEASUREMENTS

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TABLE OF CONTENTS

	Page
DD Form 1473	
Acknowledgment	ii
Introduction	1
Procedure	2
Results and Discussion	2
Conclusions	5

FIGURES

1. Location of hardness tests and tensile test specimens in the disc sections	6
2. Yield strength vs hardness (R_C)	7

TABLES

1. Chemical compositions (Nominal)	8
2. Yield strength - hardness data - 175mm M113 tubes	9
3. Yield strength - hardness data - reheat treated 175mm M113 tubes	11
4. Yield strength - hardness data - 105mm M137 tube	12
5. Yield strength - hardness data - low alloy steel	13
6. Yield strength - hardness data - literature	14

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INTRODUCTION

Correlations between yield strength and hardness have been developed for many alloy steels in the quenched and tempered condition¹⁻³. It has also been shown⁴ that the yield strength of a severely cold-worked material can be calculated using the expression, $YS = H/K$, where K is a constant and H is the diamond pyramid hardness assuming that the strain hardening coefficient equals zero. Similarly, it has been shown that $YS = H/4$ is valid for some low carbon martensites and Fe-Ni alloys⁵.

This investigation was made to determine if the 0.1% yield strength within a cannon tube forging can be determined from the R_c hardness measurements on the OD of the tube and to derive an expression which correlates yield strength with hardness for quench and tempered martensitic gun tube materials.

-
1. DeFries, R.S., "The Mechanical Properties and Microstructure in 175mm Gun Tube Forgings," Watervliet Arsenal Technical Memorandum, Oct 1977.
 2. Bain, E.C. and Paxton, H.W., "Alloying Elements in Steel," 2nd Ed., p. 225, ASM, 1966.
 3. Lubahn, J.D., and Chu, H.P., "Optimum Carbon Content for Tempered Martensitic Steels," Journal of Basic Engineering, ASME Trans. Series D, Vol. 90, March 1968.
 4. Tabor, D., "The Hardness of Metals," p. 102, Clarendon Press, Oxford 1951
 5. Speich, G.R. and Warlimont, H.J., Iron and Steel Inst. 1968 Vol. 206, pp. 385-392.

With these correlations, it would be possible to nondestructively measure the yield strength within large gun tube forgings.

PROCEDURE

Data were developed from a variety of material as shown below:

1. Six large (175mm M113) tube forgings, from several vendors, as received (SN3276-01, 3276-02, 4541-3, 1368, 1139C and 349A).
2. Three additional 175mm M113 forgings, sectioned and re-heat treated to insure a predominantly martensitic microstructure (SN113, 967 and 1144).
3. One autofrettaged 195mm M137 tube (SN 64261).
4. Alloy steel (4337 Mod., 4340 and 4140) heat treated in small sections to insure through quenching.
5. Published data on 4340 and 4140 steel.

The nominal chemical composition of the gun steel alloy and the other materials from which hardness and yield strength data were obtained is shown in Table 1. Discs were machined from six or more locations along the length of the tubes. Tensile mechanical properties were measured through the wall in each of the discs. Also, a one inch wide flat spot was ground on the OD of each of the sections and Rockwell hardness measurements were made. The location of the tensile specimens and the flat spot ground on the OD of the tube sections are shown in Figure 1.

RESULTS AND DISCUSSION

The yield strength (YS)* and the Rockwell C hardness (R_C)

*In all cases, 0.1% offset, unless otherwise indicated.

for the tubes are given in Tables 2 - 6 for the large gun steel alloy forgings, for the 105mm tube and for the reheat treated 4337 Mod., 4340 and 4140 alloys, respectively. Table 6 which shows the YS vs. R_C data as determined from the work of Lubahn³ and an American Society for Metals Data Table published in a Metals Progress reference publication, is presented for comparison.

A regression analysis to determine an empirical relationship between yield strength (YS) and Rockwell C hardness (R_C) was performed using the model $YS = KR_C$, where K represents the slope of a line passing through the origin (0,0). The results of this analysis for the large gun steel alloy forgings, for the 105mm tube and for the reheat treated 4337 Mod., 4340 and 4140 alloys, are summarized in Figure 2 where all the data are combined, the relation, $YS = 4.226 R_C$ fits the data. In all cases, except one (Tube #3276-02), the "fitted" line is very good based on the coefficient of determination, R^2 of .9467.

The coefficient of determination $R^2 = \frac{\sum_{i=1}^n (\hat{Y}_i - \bar{Y})^2}{\sum_{i=1}^n (Y_i - \bar{Y})^2}$ is defined for the general linear mode, $Y = A + KX$. When using the form $Y = KX$, i.e. adding a zero constraint on the model, the definition no longer holds. It was decided to take the proportion of the total variability unexplained by the fitted regression equation and subtract

3. Lubahn, J.D., and Chu, H.P., "Optimum Carbon Content for Tempered Martensitic Steels," Journal of Basic Engineering, ASME Trans. Series D, Vol. 90, March 1968.

that quantity from 1 and assume that difference to be a measure of explained variation. Thus, $1 - \frac{\sum_{i=1}^n (Y_i - \hat{Y}_i)^2}{\sum_{i=1}^n (Y_i - \bar{Y})^2}$ becomes the measure of precision for the fitted line. This is also a standard form for coefficient of determination.

Brinell Hardness (BHN) measurements were also made on Tube 3276-01 to compare with the R_C readings. When the BHN readings were converted to R_C , the hardness was about 2 points higher than the actual readings obtained on the same pieces. It can be seen that the R_C measurements are slightly better than the BHN measurements (4 ksi vs. 7 ksi YS variation) for predicting the yield strength of the quench and tempered gun steel alloy.

The R_C readings obtained on Tubes 113 and 967 were converted to Diamond Pyramid Hardness (DPH) numbers to determine the K value for comparison or substantiation of the K values previously cited in the literature^{4,5,6}. The average K value obtained on these tubes of 2.345 was lower than the values of 3 and 4 previously reported. This difference could be caused by converting the R_C numbers to the DPH numbers, and/or a difference in alloy composition.

4. Tabor, D., "The Hardness of Metals," p. 102, Clarendon Press, Oxford, 1951.
5. Speich, C.R. and Warlimont, H.J., Iron and Steel Inst., 1968, Vol. 206, pp. 385-392.
6. Cahoon, J.R., Proughton, W.H., and Kutzak, A.R., "The Determination of the Yield Strength from Hardness Measurements," Met Trans., Vol. 2, July 1971.

The 4340, 4337 Mod. and 4140 data, Table 5, also showed that the average K value for these alloys is about the same value as calculated for the gun steel alloy. Therefore, the expression shown earlier could also be used to estimate the YS for 4337 Mod., 4340 and 4140.

The average K value of 4.226 was also calculated from the YS and R_c figures from Lubahn's data³ and an ASM Data Table, Table 6, which applies only to fully quenched and tempered steels containing more than .30 percent carbon.

CONCLUSIONS

Despite the heavy wall of cannon tube forgings, hardness measurements can be utilized to determine the yield strength (ksi) of large gun tube forgings of quench and tempered gun steel.

The yield strength can be determined from the relationship $YS = 4.226 R_c$ in the 130 to 190 ksi YS range considered in this investigation. This relationship was statistically determined.

The YS vs. R_c data on large tube forgings was in close agreement with that presented by Lubahn and ASM.

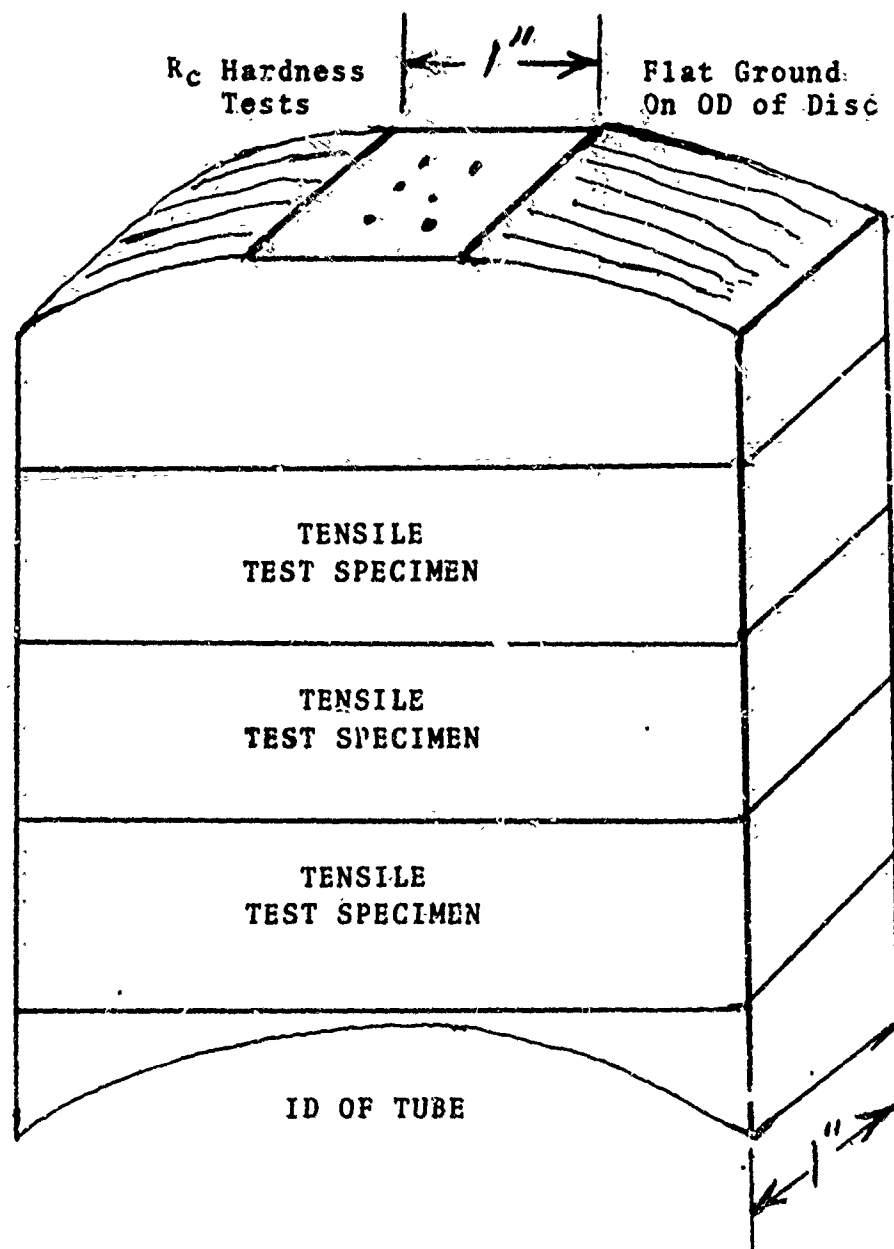


Figure 1. Location of hardness tests and tensile test specimens in the disc sections.

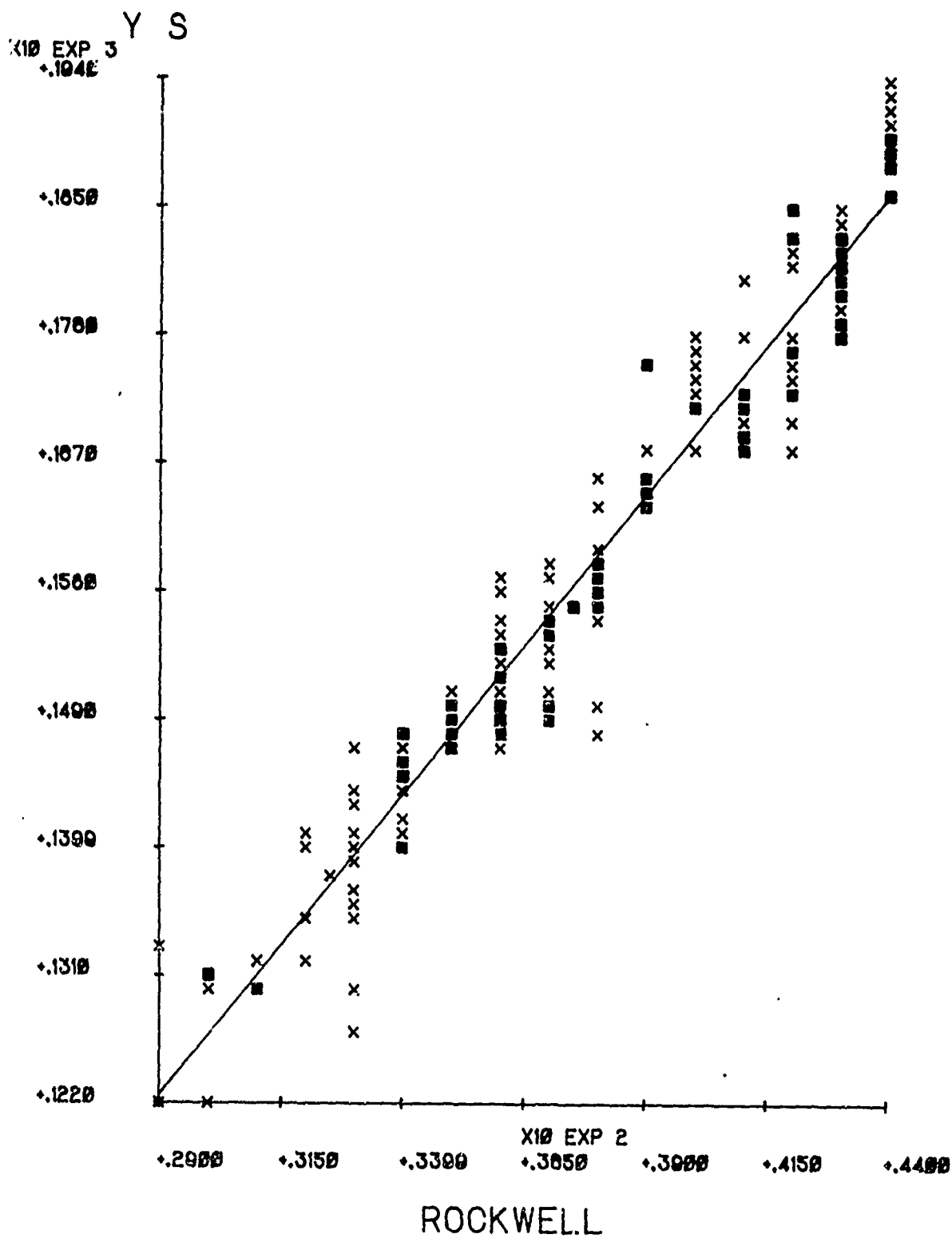


Figure 2. Yield strength vs hardness (R_c)

TABLE 1. CHEMICAL COMPOSITIONS
(Nominal)

<u>TYPE</u>	<u>C</u>	<u>Mn</u>	<u>P</u>	<u>S</u>	<u>Si</u>	<u>Ni</u>	<u>Cr</u>	<u>Mo</u>	<u>V</u>	<u>Cu</u>
Gunsteel	.36	.50	.01	.01	.35	3.0	.90	.50	.10	-
4337 Mod	.37	.72	.01	.01	.30	1.8	.77	.35	-	.10
4340	.40	.70	.03	.03	.30	1.8	.80	.25	-	-
4140	.40	.85	.03	.03	.30	-	.95	.20	-	-

TABLE 2. YIELD STRENGTH HARDNESS* DATA

175MM M113 TUBES

TUBE NO. 3276-01		TUBE NO. 3276-02		TUBE NO. 1368	
YS	R _C	YS	R _C	YS	R _C
148 ksi	35	149 ksi	36	176 ksi	41
157	38	149	36	174	39
146	34	149	37	171	40
150	35	148	35	175	40
154	36	150	37	174	40
154	36	150	37	181	42
147	34	151	36	183	42
147	35	150	36	182	42
157	37	160	38	180	41
157	37	161	38	185	42
154	36	160	38	183	42
148	34	160	37	185	43
157	37	159	38	185	42
148	34	158	36	174	39
148	34	159	36	173	40
		159	37	176	40
		149	37	171	40
		151	37	168	39
		150	38	172	40
		148	35	171	40
		150	35	166	38
		149	35	164	38
		148	38	165	39
		150	37	166	39

*Average of six readings

TABLE 2. YIELD STRENGTH - HARDNESS* DATA (cont)
175MM M113 TUBES

TUBE NO. 1139C		TUBE NO. 349A		TUBE NO. 4541-3	
YS	Rc	YS	Rc	YS	Rc
142 ksi	34	145 ksi	34	141 ksi	32
140	34	143	33	140	32
130	33	141	33	132	32
127	33	137	33	135	33
130	30	144	33	130	31
130	31	147	33	139	33
131	30	122	29		
131	30	133	29		
131	30	122	30		
132	31	130	31		
151	35	136	33		
152	36	140	34		
152	36	141	34		
155	37				
156	37				
158	38				
156	36				
157	37				
147	36				
148	36				
148	36				
145	34				
145	34				
147	35				
147	35				
146	34				
148	34				
149	35				
153	36				

*Average of six readings.

TABLE 3. YIELD STRENGTH - HARDNESS DATA
REHEAT TREATED
175MM M113 TUBES

TUBE NO. 1144		TUBE NO. 1144		TUBE NO. 113 and 967	
YS	Rc	YS	Rc	YS	Rc
194 ksi	44	177 ksi	43	130 ksi	31
190	44	176	43	135	32
191	44	179	43	138	32
190	44	176	43	140	33
190	44	168	42	144	34
188	44	170	42	147	35
190	44	175	42	150	36
188	44	174	42	154	37
189	44	181	43	157	38
193	44	179	43	164	39
190	44	172	42	166	39
189	44	176	42	168	40
188	44	168	41	170	41
186	44	169	41	171	41
186	44	169	41	173	42
189	44	168	41	172	42
184	43	171	41	175	42
183	43	172	41	176	43
183	43	164	39	180	43
183	43	165	39	182	43
182	43	158	38	190	44
181	43	156	38	192	44
181	43	153	37		
180	43	156	37		
177	43	150	36		
178	43	150	36		

TABLE 4. YIELD STRENGTH - HARDNESS DATA

105MM M137 TUBE

TUBE NO.

64261

<u>YS</u>	<u>Rc</u>
188 ksi	42
187	42
186	43
188	42
189	42
187	41
187	42
188	42

TABLE 5. YIELD STRENGTH - HARDNESS DATA
LOW ALLOY STEEL

4340		4337 Mod		4140	
YS	Rc	YS	Rc	YS	Rc
117 ksi	28	175 ksi	40	96 ksi	22
118	28	177	41	114	29
131	31	157	37	127	30
132	31	158	38	129	30
140	33	155	38	132	33
143	33	161	37	133	30
150	36	149	39	134	31
150	36	155	38	146	36
152	36	145	38	168	41
157	37	154	39	189	45
165	39	157	39	206	47
168	39			222	50
174	40			235	53
176	40			246	57
182	45				
191	42				
186	46				
202	47				
210	48				
215	50				
220	52				
227	55				

TABLE 6. YIELD STRENGTH - HARDNESS DATA
LITERATURE

Lubahn Data		ASM Data Table	
<u>YS</u>	<u>Rc</u>	<u>YS</u>	<u>Rc</u>
85 ksi	20	69-78 ksi	14
90	22	73-84	16
97	24	76-90	18
104	26	79-93	20
111	28	85-99	22
120	30	92-107	24
132	32	99-114	26
139	34	107-122	28
148	36	116-131	30
156	38	125-141	32
166	40	131-146	34
178	42	141-157	36
187	44	153-170	38
200	46	163-179	40
214	48	176-185	42
230	50		