Contents

		page
Abstract		*i*
Acknowledgements		*iii*
Contents		*v*
List of Figures		*vii*
List of Tables		*xi*
Nomenclature		*xiii*
List of Abbreviations		*xv*
Chapter 1:	**Introduction**	1
1.1	Solidification process	1
	1.1.1 Solidification length scales	2
1.2	Macroscopic Solidification and Associated Mechanisms	3
	1.2.1 Hydrodynamic Attributes	4
	1.2.2 Thermal Attribute	6
	1.2.3 Solutal Attribute	7
1.3	Important Outcomes from Macroscopic Solidification Modeling	8
	1.3.1 Macro-shrinkage Defects	9
	1.3.2 Macrosegregation	10
1.4	Objectives	10
1.5	Review of literature	11
	1.5.1 Analytical macro-scale modeling of solidification shrinkage	11
	1.5.2 Numerical macro-scale modeling of solidification shrinkage	13
	1.5.3 Experimental investigation of directional solidification	17
1.6	Scope of the thesis	20
Chapter 2:	**One-dimensional diffusion based solidification model with volumetric expansion and shrinkage effect: semi-analytical approach**	23
2.1	Introduction	23
2.2	Mathematical model	24
2.3	Validation and case studies	28
2.4	Summary	31
Chapter 3:	**Cooling curve prediction for controlled unidirectional solidification under influence of shrinkage: semi-analytical approach**	33
3.1	Introduction	33
3.2	Mathematical Model	34
3.3	Validation and case studies	39
3.4	Summary	45
Chapter 4:	**Shrinkage induced flow during directional solidification of pure substance in a bottom cooled cavity: A study on flow reversal phenomena**	47
4.1	Introduction	47
4.2	Mathematical Modeling	49
4.3	Numerical approach and volume fraction updating methodology	51
4.4	Experimental setup	54
	4.4.1 Experimental procedure	55
4.5	Results and Discussion	56
	4.5.1 Comparison 2-D shrinkage models with and without considering buoyancy effect	56
	4.5.2 Experimental validation	59
	4.5.3 Case studies	62
4.6	Summary	68
Chapter 5:	**Effect of shrinkage induced flow on solutal instability and macro-segregation during directional solidification of binary alloys**	69
5.1	Introduction	69
5.2	Mathematical modeling	71
5.3	Numerical approach and physical domain	73

5.4 Results and discussion 74
5.4.1 *Solidification of Al-4.1 wt.% Cu* 74
5.4.2 *Solidification of Al-30 wt.% Mg* 76
5.4.3 *Effect of grid size and time-step on numerical simulation* 78
5.4.4 *Effect of shrinkage induced flow on freckle formation* 80
5.4.5 *Effect of inlet opening size on macro-segregation during freckle formation* 81
5.4.6 *Effect of cold boundary temperature on macro-segregation* 84
5.4.7 *Scaling analysis* 93
5.5 Summary 97

Chapter 6: Shrinkage defects: Free surface deformation during solidification of Metal Alloys 99
6.1 Introduction 99
6.2 Mathematical Modelling 99
6.3 Result and Discussion 102
6.3.1 *Validation* 102
6.3.2 *Solidification of pure aluminium in a rectangular mould with riser* 103
6.3.3 *Solidification of pure aluminium in a rectangular mould cavity with open top* 104
6.3.4 *Solidification of pure Al-4.1 wt.% Cu alloy in a rectangular mould cavity with open top* 107
6.4 Summary 108

Chapter 7: Concluding remarks and scope for future work 111
7.1 Conclusions 111
7.1.1 *One-dimensional diffusion based solidification model with volumetric expansion and shrinkage effect: semi-analytical approach* 111
7.1.2 *Cooling curve prediction for controlled unidirectional solidification under influence of shrinkage: semi-analytical approach* 111
7.1.3 *Shrinkage induced flow during directional solidification of pure substance in a bottom cooled cavity: A study on flow reversal phenomena* 112
7.1.4 *Effect of shrinkage induced flow on solutal instability and macro-segregation during directional solidification of binary alloys* 113
7.1.5 *Shrinkage defects: Free surface deformation during solidification of Metal Alloys* 114
7.2 Future scope 115

References 117

Appendix A: Derivation of energy conservation equation as scalar variable temperature 125
1 Energy equation for pure and alloy system without integrating free surface 125
2 Energy equation for pure and alloy system in presence of free surface 126

Appendix B: SIMPLER algorithm for solution of continuity and momentum equations 127

Appendix C: Volume of Fluid Method 129

Appendix D: List of publications from the present investigation 131
D1 Journal Articles 131
D2 Conferences 131