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WEAR AND COROSION EFFECTS OFAL356-Al_2O_3 COMPOSITES BY STIR CASTING METHOD

[a] Jakka Sai Goutham [b] B. K. S. V. S. Madhuri [c]V.V. Rama Krishna

[a] Student Advanced Manufacturing system, Pydah college of engineering, Patavala, yanam road, Kakinada 533461

[b]Assistant professor dept. mechanical Pydah college of engineering, Patavala, yanam roaKakinada 533461

[c] Associate professor Head of the dept. mechanical Pydah college of engineering, Patiala, yanam road, Kakinada 533461

Abstract:- Traditional solid materials have restrictions in accomplishing great mix of solidarity, solidness, sturdiness and thickness. To conquer these deficiencies and to fulfill the always expanding need of current innovation, composites are most encouraging materials of late interest. The current exploration work includes the investigation of AL 356-Al2O3 composite through mix projecting course. To conquer these weaknesses and to fulfill the always expanding need of advanced innovation, composites are most encouraging materials of ongoing interest. The current examination work includes the investigation of AL 356-Al2O3 composite through the mix projecting course. Aluminum Oxide(Al2O3) was the support in the grid of AL 356 composite which can be appropriate for space, airplane and auto parts at raised temperatures. The mechanical properties as far as hardness, heat treatment and wear test were done. The example of AL 356 amalgam was additionally projected and tried for correlation.

KEYWORDS :Stir Casting, Micro Hardness, wear ,corrosion etc.

I INTRODUCTION

Composites are synthetic materials comprising of at least one spasmodic stages having close contact with one another, with are cognizable interface between them. These are multifunctional materials frameworks that give attributes not reachable from individual stages. Further, composites are customized to financially savvy, property powerful and application situated.By and large, the broken stage is more earnestly and more grounded than the constant stage and is known as the 'support'; though nonstop stage is named as the 'lattice'. The network holds support to frame the ideal shape and bears the significant part of an applied burden, while the support works on generally speaking mechanical properties of the grid. Support increments the strength, firmness, wear safe and the temperature obstruction limit and brings down the thickness

1.2 CLASSIFICATION OF COMPOSITES

As a general rule, composites are ordered by the kind of network material and afterward nature of support at two particular levels. The principal order incorporates ceramic lattice composites (CMCs), natural framework composites (OMCs) and metal grid composites (MMCs). The term natural grid composite is by and large accepted to incorporate polymer Matrix composites (PMCs) and carbon network composites. The subsequent characterization alludes to the support structure; particulate fortifications, stubbles, persistent fiber, covered composites and woven composites.

1.3 PROCESSING OF COMPONENTS

Contingent on the application in assistance, an assortment of composites with various mixes of grid materials and fortifications are being delivered through various creation strategies, briefs different frameworks and handling courses Proper blending strategy filter limit the agglomeration of their inforcement and settling of the molecule check limited by the quickpouring and utilizing chill projecting procedure. Auxiliary preparing like rolling, producing, and expulsion gives better dispersion of fortifications. However there are numerous applications with MMCs; creation, auxiliary preparing similarity between the network are implementation and portrayal are as yet the serious issues in the assembling of these composites. B4c in different structures has been the most generally utilized support, in aluminum composite. Different fortifications are A12O3, SiO2, TiC, TiO2, ZrO2, Al2O3, borate bristles, quartz, jewel, graphite, fly debris and so forth Among the different metal grid composites (MMC), aluminum combination metal lattice composites have effectively exhibited their potential for even high volume applications. As closed from numerous past search examines, the fortifying of aluminum composites with a scattering of fine earthenware particulates emphatically expands their potential in wear obstruction and primary applications. In the current work, it is legitimized that B 4 c fundamentally works on the mechanical properties of the aluminum amalgam based MMCs.AA2024-B4c composites and AA2024-B4c-gr half breed composites have expected applications in auto industry areas. Customary solid materials have restrictions as for reachable blends of solidarity, solidness and thickness. To beat these weaknesses and to meet the steadily expanding designing requests of present day innovation, metal framework composites are acquiring. Diminishing of the rudimentary, dispersion, some translucent and nano glasslike middle stages are created inside the particles including compound changes. For the current exploration, the parent materials aluminum. The main credits of mechanical alloying are the accompanying

Production of fine scatterings of second-stage particles. Expansions of strong solvency limits Refinement of grain estimates down to nanometer range.

Synthesis of novel glasslike and semi translucent stage Development of shapeless (glass) stageDisordering or requested bury metallic

Fabrication of materials with exact arrangement and controlled microstructure

Possibility of composite in components hard to join by customary softening Methods

Inducement of substance responses at low temperature

Scalable cycle

e speed and recurrence of the balls as follows.

$$I=MV(f/p)M$$

2.LITERATURE REVIEW

[1] Arunkumar D T et.al. [2018], effectively created the Al-356 composites with mica and kaolinite fortifications utilizing mix projecting procedure. They utilized equivalent volume parts of mica and kaolinite are [(2+2)%, (4+4)%, (6+6)%,(8+8)] and directed a wear test for different time stretches at steady burden. The wear misfortune in composites with 8% volume of mica and kaolinite are seen to diminish at a more slow rate. The SEM microstructure of the composite shows a homogeneous support circulation into lattices andno proof of agglomerate. From the above research paper I concluded that the presence of mica and kaolinite in the matrix decreased wear loss by increasing wear resistance.

[2] Pradeep P et.al.[2017], has created Al 5689 and Titanium DI Boride (Al2O3) through the mix projecting method. The amount part of Al2O3 provoked are 3%, 5% and 7% . They assessed the microstructure, wear, hardness properties. At 8% wt of Al2O3 sees the most extreme hardness of 126 VHN and reinforces the base network. Unequivocal wear rate reduces as the sliding rate increases up to revolution speed (1.6 m/s) and weight, considering work setting of the material surface. Insignificant impact of the wear rate got from the 8 Wt. % of Al2O3 strengthened composite. The speed and the sliding distance are in generally outrageous with the unimportant weight. The miniature picture shows the Aluminum flotsam and jetsam are unvaryingly scattered inside the most noteworthy volume part of particulate grid of 8Wt. The Al metal grid composites offer wide scope of properties reasonable for an enormous number of designing applications. Adequate written works are accessible on various parts of tribology and machining of ordinary metals and combinations however restricted writing are accessible for supported metal framework composites. Aluminum-Silicon (Al- -Si) projecting compounds are the most adaptable of all normal foundry cast amalgams in the creation of cylinders for auto motors. Contingent upon the Si fixation in weight percent, the Al- - Si amalgam frameworks fall into three significant classifications: hypoeutectic (<12 wt % Si), eutectic (12-13 wt % Si) and hypereutectic (14-25 wt % Si). Notwithstanding, business applications for hypereutectic amalgams are moderately restricted in light of the fact that Huge variety in the measures of the essential Si particles can be found between various locales of the cast article, bringing about a huge variety in the mechanical properties for the cast article. The essential gems of Si should be refined to accomplish hardness and great wear opposition. Then again, the use of hypoeutectic and eutectic combinations are exceptionally well known for the business, since they are more prudent to deliver by projecting, more straightforward to control the cast boundaries, and simpler to machine than hypereutectic. Notwithstanding, the greater part of them are not appropriate for high temperature applications, for example, in the auto field, for the explanation that their mechanical properties, like rigidity, are not as high as wanted in the temperature range of500°F.- 700°F. Notwithstanding, a large portion of them are not appropriate for high-temperature applications, for example, in the auto field, for the explanation that their mechanical properties, like elasticity,

are not as high as wanted in the temperature range of500°F.-700°F.

3.METHODS AND MATERIALS

3.1 STIR CASTING

Mix projecting is a sort of projecting cycle where a mechanical stirrer is acquainted with structure vortex to blend support in the grid material. It is a reasonable interaction for creation of metal framework composites because of its expense adequacy, pertinence to large scale manufacturing, effortlessness, nearly shapingand simpler control of composite construction. Mix giving arrangement a role as displayed in Figure 1, comprise of a heater, support feeder and mechanical stirrer. The heater is accustomed to warming and softening of the materials. The base poring heater is more reasonable for the mix giving a role as subsequent to blending of the blended slurry moment poring is needed to keep away from the settling of the strong particles in the base the cauldron. The mechanical stirrer is utilized to frame the vortex which drives the blending of the support material which are presented in the soften. Stirrer comprise of the mixing bar and the impeller cutting edge. The impeller sharp edge might be of, different calculation and different number of edges. Level sharp edge with three number are the liked as it prompts hub flow pattern in the cauldron with less force utilization. This stirrer is associated with the variable speed engines, the pivot speed of the stirrer is constrained by the controller appended with the engine. Further, the feeder is connected with the heater and used to take care of the support powder in the soften. A long-lasting mold, sand shape or a lost-wax form can be utilized for pouring the blended slurry. Different advances associated with mix projecting cycle is displayed in Figure 2. In this cycle, the network material are kept in the base pouring heater for dissolving. At the same time, fortifications are preheated in an alternate heater at certain temperature to eliminate dampness, contaminations and so on Subsequent to softening the lattice material at certain temperature the mechanical mixing is begun to frame vortex for certain time-frame then fortifications particles are poured by the feeder gave in the arrangement at steady feed rate at the focal point of the vortex, the mixing system is proceeded for certain time-frame after complete taking care of support.

3.1.1 MELTING OF MATRIX MATERIAL

Out of different heaters, base pouring heater is reasonable for creation of metal network composites in mix projecting course, this kind of heater comprise of programmed base pouring strategy which gives moment pouring of the liquefy blend (grid and support). Programmed base pouring is basically usedin speculation projecting industry. In this strategy, an opening is made in the foundation of liquefying pot to give base pouring and was safeguarded by a chamber molded shell of metals [15]. In mix projecting interaction, the network material is dissolved and kept a specific temperature for 2–3 h in this heater. All the while, fortifications are preheated in an alternate heater. Subsequent to softening of the lattice material, the mixing system has been begun to frame the vortex.

3.2MECHANICAL STIRRING

In mix projecting interaction, the mechanical stirrer is combined with the shifting pace engine to control the speed of the stirrer. There are different phases of impeller stirrer for example single stage, twofold stage and multistage impeller. Twofold stage and multi stage stirrer are essentially utilized in compound enterprises though single stage impeller stirrer is regularly utilized for creation of AMCs and HAMCs due adaptability and to keep away from inordinate vortex stream

3.3MATERIALS

1.356 aluminum amalgam can be additionally improved by how it is fortifying utilizing an interaction known as warmth treatment.

2.Tempering strategy can utilize high heat(300-500 C) to reconfigure metal's gem design to fortify its by and large mechanical properties, and can in a real sense represent the deciding moment a material.

3.There are numerous strategies for treating 356 aluminum, however improve on this article, we will feature T6 tempered 356 aluminum composite.

4.356-T6 is a typical attitude for aluminums plate and bar stock.

5.However, realize that each treating interaction gives 356 aluminum its own unmistakable qualities and attributes.

3.4ALUMINIUM OXIDE

1.Aluminum Oxide is a hard material with high strength and high wear opposition at raised temperatures.

2.Aluminum Oxide is a hard material with high strength and high wear opposition at raised temperatures.

3.It is unaffected by most synthetic reagents, and has phenomenal steadiness and wet capacity in fluid metals like zinc and aluminum.

4.3. It is unaffected by most synthetic reagents, and has phenomenal steadiness and wet capacity in fluid metals like zinc and aluminum.

4.It has high electric conductivity, which has prompted its utilization in Hall-Harold cells for aluminum creation. It is likewise utilized as pots for liquid metals

TYPICAL USES OF AL2O3 :

•Fracture Toughness

•Friction and Wear

•Thermal Transport

3.1.2 MATRIX MATERIAL

AA356 combination was chosen due to its low explicit weight and high solidarity to weight proportion and weakness and furthermore its brilliant mach powerlessness, formability and weld capacity. This compound is generally utilized in car industry, airplane industry and guard enterprises. The substance piece of the pre-owned material is given in Table.

Material	Percentage
Al	balance
Fe	0.5
Cu	1.6
Mn	0.3
Mg	2.5
Cr	0.15
Zn	5.5
Ti	0.2
Others each	0.05
Others total	0.15
Al	Remaining

TABLE -1 COMPOSITION

EXPERIMENTAL WORK

4.1EXPERIMENTAL WORK AND PROCEDURE

a)aluminum powder

b)Aluminum Oxide

Figure 1

•

Aluminum powders of 50µm size are mixed with B4c and aluminum powder and b4c mixed in above given table powders are prepared.

•The mixture was carried out in pestle mortar to ensure uniform distribution of b4c with Aluminum.

4.1 STIR CASTING

Mix projecting is a fluid state technique for the manufacture of composite materials, in which a scattered stage is blended in with a liquid grid metal through mechanical mixing.

4.2 STIR CASTING PROCESS

It's includes mixing of soften, in which the liquefy is blended persistently which uncovered the dissolve surface to the air which keep an eye on ceaseless oxidation of aluminum liquefy. Because of consistent oxidation, the wet capacity of the aluminum decreases and the support particles stay unmixed

Fig.2 stir casing machine

4.3 STIR CASTING MACHINE COMPONENTS

1. Furnace
2. Crucible
3. Stirrer rod
4. Stirrer Impeller
5. Mold
6. Feeder
7. Motor

Figure 3:Specimen

5.RESULTS

5.1 HARDNESS

Hardness is a measure of how much a material resists changes in shape. Ability of material to resist wear, tear, scratching, abrasion cutting is called hardness. Harder materials are more difficult to cut and shape than softer ones. They are also usually more brittle which means they do not bend much but can shatter.

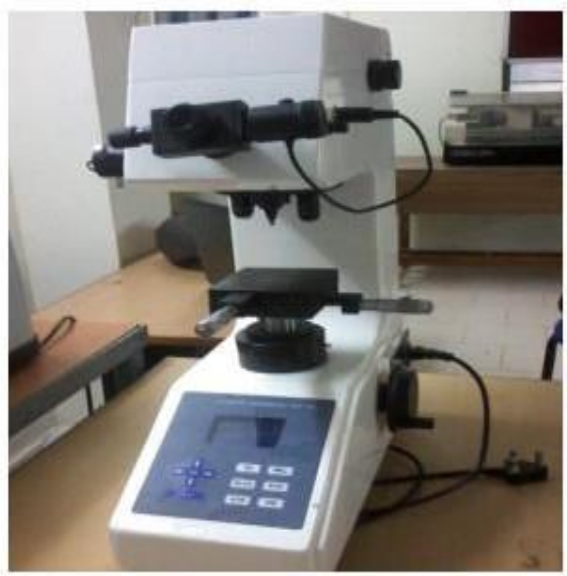
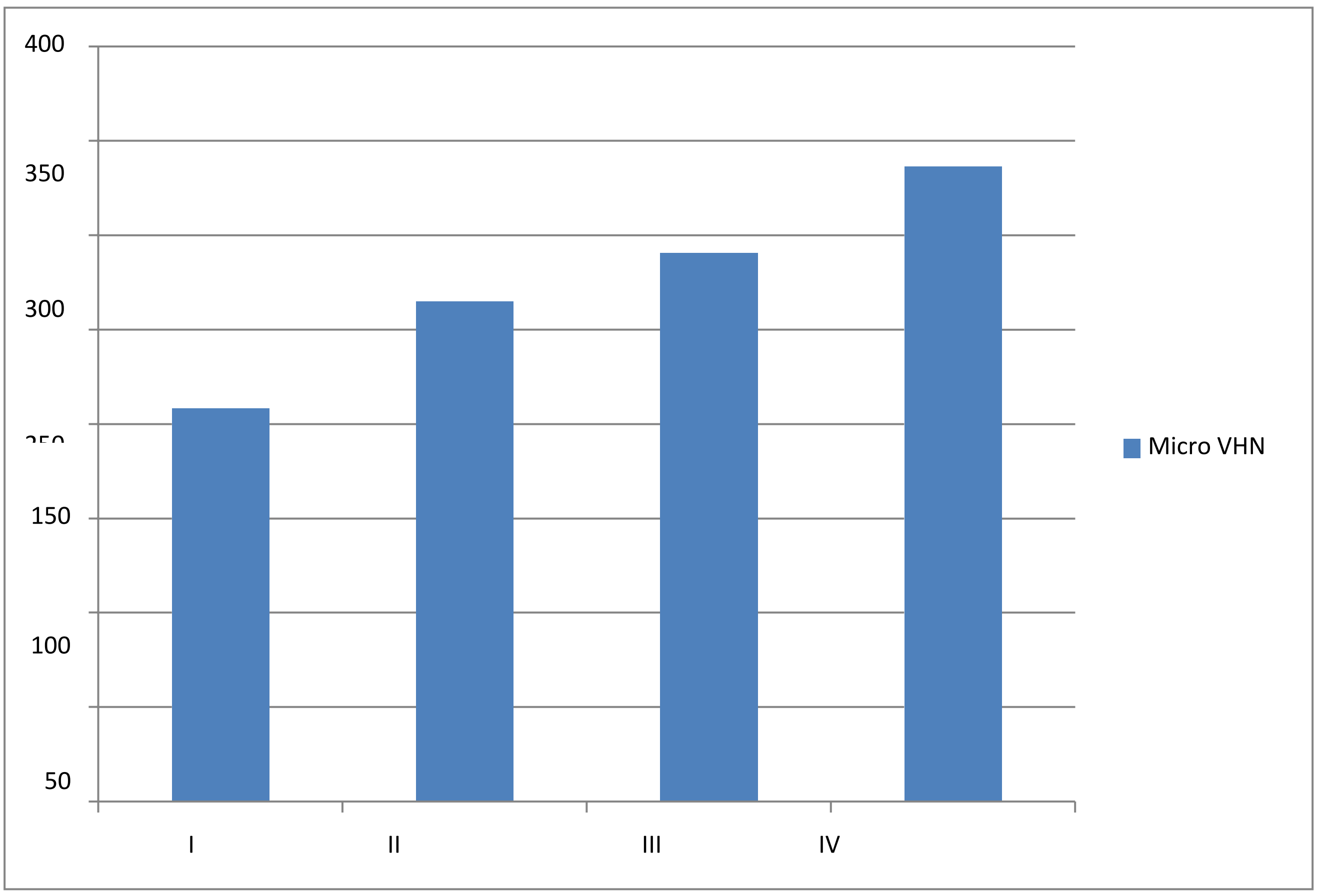


FIG 4 MICRO VICKERS

HARDNESS VALUES

composition	D1	D2	VHN	D1	D2	VHN	Micro VHN
Al 356+2.5% Al_2O_3	94.32	94.25	111.09	82.68	111.09	137.50	144.507
Al 356+5% Al_2O_3	80.15	80.06	157.750	80.71	80.01	159.950	158.850
Al 356+7.5% Al_2O_3	75.96	76.20	174.069	79.71	161.6 0	176.089	175.679
Al 356+10% Al_2O_3	73.84	78.06	199.438	79.09	153.0 0	201.638	200.538

TABLE -2 Hardness values for specimens



GRAPH -1 HARDNESS VALUES

5.2 WEAR TEST

Wear obstruction is characterized as the capacity of stone to oppose extensive outer forces such as scraped area, edge cutting and effect and so on during administration. The wear tests were directed on aluminium(AL356) amalgam and aluminium(AL356) + nano Al2O3 MMCs according to ASTM G99-95 norm at room temperature utilizing a mechanized pin on circle wear test rig displayed in the figure 4.12. The sliding wear test tests were machined of 8 mm ostensible width and measure length of 30 mm were displayed in the. The sliding wear test was led in Pin-on-circle wear testing machine with information securing framework, which was utilized to assess the wear conduct of the aluminium(AL356) composite and aluminum (AL356) + nano Al2O3 MMCs against the hardened steel plate (En-32) with hardnessof 60 HRC and surface harshness (Ra) 0.5 pm. The sliding wear happens when the test tests were slide over turning plate. The circle is coupled to a 1000 rpm limit DC engine and the plate of 120 mm distance across. The heap can be applied to test adding the extra weight up 200N through steel wire and pulley plan.

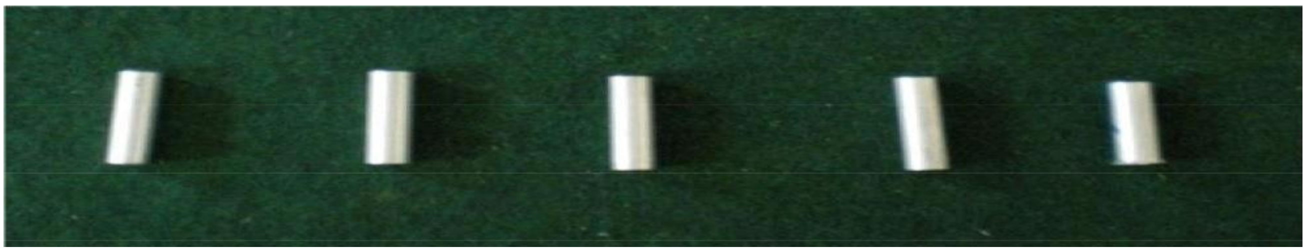


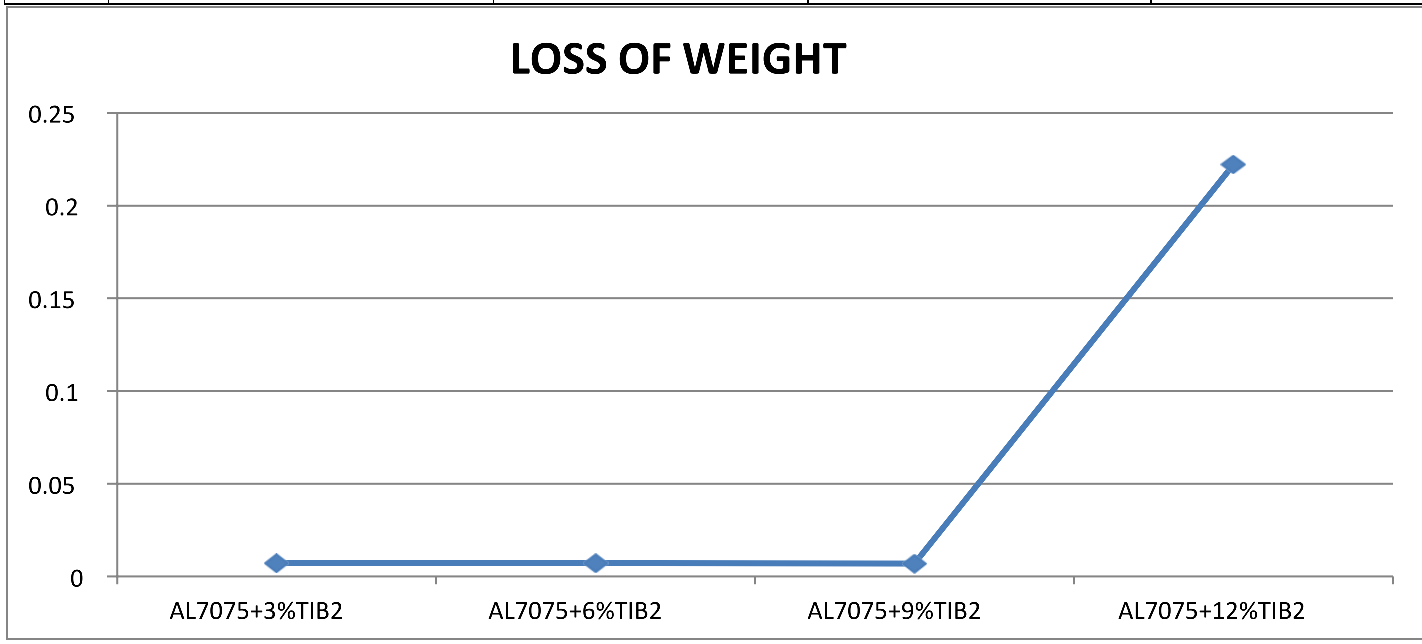
FIG.5 WEAR TEST SAMPLES

The test was fitted to the gather and set at a specific track breadth. The track measurement is to be changed for each example and testconditions. The machine is having the office to differ the sliding wear boundary through regulator. The specific boundaries like sliding speed, applied and time are chosen. The analysis was directed and subsequent to finishing the time, the wear in microns and frictional power in Newton's were recorded. The sliding wear test was directed for the diverse applied heaps of 20N,40N,60N and 80N at sliding speeds of 1.15m/s,1.72 m/s, 2.3 m/s and 2.88 m/s for sliding distances of 1037 m, 2074m, 3111 m and 4147m. After each test the wear and frictional power were reported to decide the wear rate and coefficient of grating of AL356 amalgam and the created AL356 + Nano AL2O3 MMCs. Further, the impact of sliding rate, applied burden and sliding distance on the wear obstruction and coefficient of grinding of aluminium (AL356) combination and aluminium(AL356) + Nano AL2O3 MMCs before and after fake warmth treatment were examined. Comparative test methodology was taken on to investigate the wear conduct of the aluminium Nano composites

Figure 6 wear test machine

Table-3 Wear at 1kg load 200mts

S	Material	Initialwt	Finalwt	Lossof wt
1	AL 356+3%TIB2	11.9 49	11.94 18	0.00 72
2	AL 356+6%TIB2	11.9 68	11.96 09	0.00 71
3	AL 356+9%TIB2	11.4 68	11.46 11	0.00 69
4	AL 356+12%TIB2	11.5 48	11.54 12	0.00 68
5	AL 356+15%TIB2	11.4 56	11.23 4	0.22 2

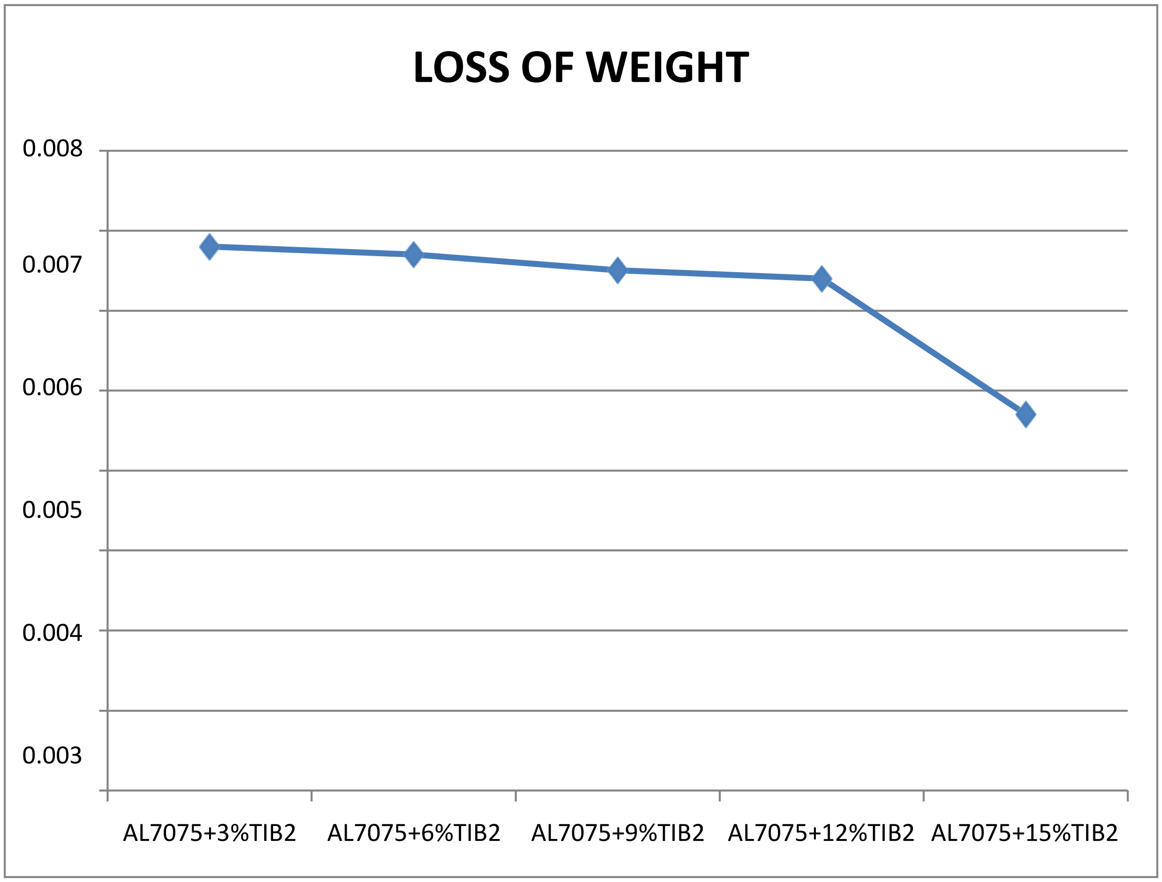


GRAPH -2 WEAR LOSS

Graph 1

S. no	Material	Initial wt	Finalwt	Lossof wt
1	AL 356+3%TI B2	11.94 18	11.93 50	0.00 68
2	AL 356+6%TI B2	11.96 09	11.95 42	0.00 67
3	AL 356+9%TIB2	11.46 11	11.45 46	0.00 65
4	AL 356+12%T IB2	11.54 12	11.53 48	0.00 64
5	AL 356+15%TIB2	11.04 53	11.00 56	0.00 47

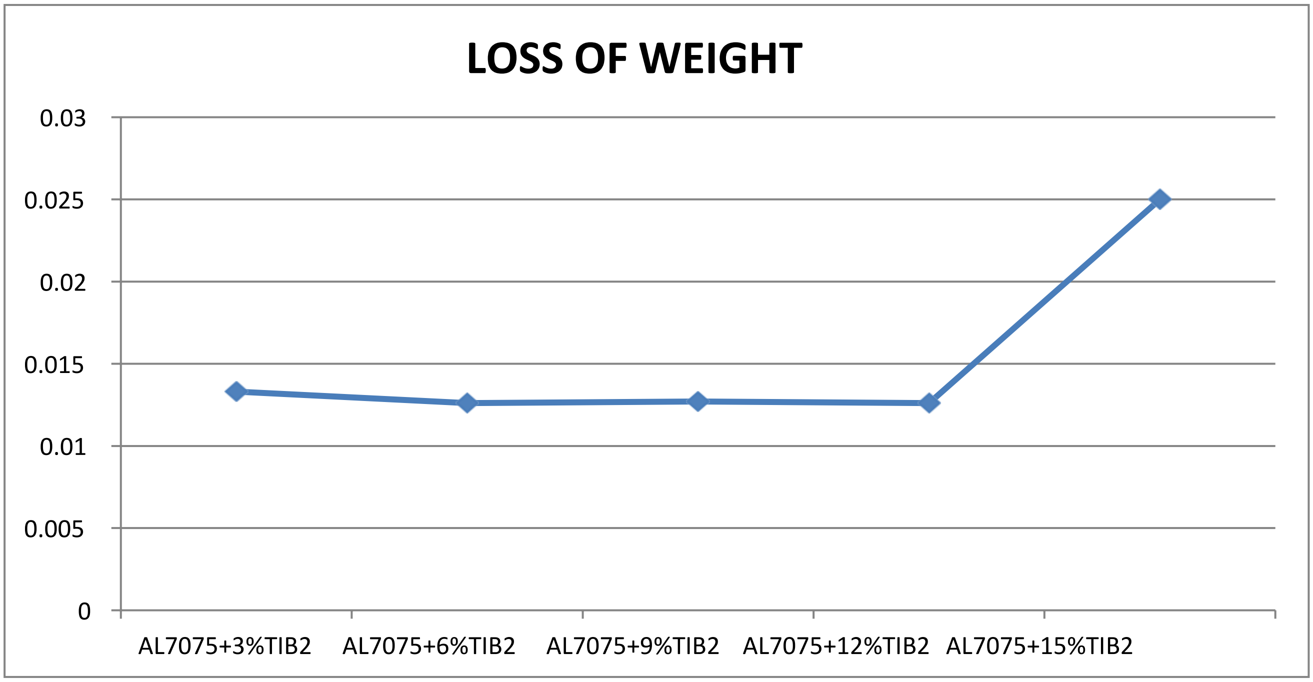
Table 4- Wear at 1kg load 400mts



Graph 3 WEAR LOSS

S. no	Material	Initial wt	Final wt	Lossof wt
1	AL 356+3%TI B2	11.93 37	11.92 04	0.01 33
2	AL 356+6%TI B2	11.95 30	11.94 00	0.01 30
3	AL 356+9%TIB2	11.45 36	11.44 09	0.01 27
4	AL 356+12%TIB2	11.53 39	11.52 13	0.01 26
5	AL 356+15%TIB2	11.04 95	11.02 45	0.02 50

Table-5 Wear at 1kg load 600 mts



GRAPH 3 WEAR LOSS

5.3 Corrosion

Immersion time (hrs)	Weight loss, (gms)			
	AL 356+2.5% Al_2O_3	AL 356+5% Al_2O_3	AL 356+7.5% Al_2O_3	AL 356+10% Al_2O_3
2	0.19	0.18	0.122	0.12
4	0.033	0.026	0.024	0.023
6	0.0018	0.017	0.008	0.008
8	0.02	0.019	0.02	0.006
10	0.033	0.04	0.027	0.022

TABLE -6Effect of corrosive media concentration on time (10% HCl)

Immersion time (hrs)	Weight loss, (gms)			
	AL 356+2.5% Al_2O_3	AL 356+5% Al_2O_3	AL 356+7.5% Al_2O_3	AL 356+10% Al_2O_3
2	0.172	0.151	0.117	0.107
4	0.014	0.012	0.0213	0.023
6	0.006	0.005	0.004	0.003
8	0.027	0.0178	0.008	0.006
10	0.027	0.0232	0.019	0.018

TABLE -7Effect of corrosive media concentration on time (20% HCl)

Immersion time (hrs)	Weight loss, (gms)			
	AL 356+2.5% Al_2O_3	AL 356+5% Al_2O_3	AL 356+7.5% Al_2O_3	AL 356+10% Al_2O_3
2	0.183	0.146	0.123	0.122
4	0.073	0.055	0.039	0.0416
6	0.014	0.013	0.007	0.008
8	0.027	0.021	0.018	0.012
10	0.095	0.078	0.058	0.033

TABLE -7Effect of corrosive media concentration on time (30% HCl)

6.CONCLUSION

The conclusions of the research work undertaken are;

•The AL356-AL2O3 nano metal matrix composite materials have been fabricated by stir casting method followed by extrusion process.

•The nano AL2O3 particulates are evenly dispersed in the matrix alloy. The micro hardness of AL356-AL2O3 nano metal matrix composite material is superior than the matrix material. The micro hardness increases by 12.2% by theaddition of 2 wt.% of AL2O3 nano particulates in aluminum (AL356) matrix alloy.

The inclusion of AL2O3 nano particulates in AL356 matrix alloy significantly enhanced the ultimate tensile strength and yield strength of the AL356-AL2O3 Nano metal matrix composite materials. The 8 wt.% of reinforced aluminum (AL356)-AL2O3 Nano composite shows 54.11% increase in the ultimate tensile strength as compared to ultimate tensile strength of LM 13alloy

•The ductility of AL356-AL2O3 nano metal matrix composite material decreases as compared to matrix alloy. The ductility decreases by 32.72% with the inducing of 2 wt.% of AL2O3 nano particulates in aluminum (AL356) matrix alloy.

•The compression strength increases as the fraction of reinforcement enhances in the matrix material. The 8 wt.% of AL2O3reinforced as-cast aluminum (AL356)- AL2O3 nanocomposite Shows40.32%increase in the compression strength as compared to compression strength of aluminum (AL356) alloy.

•Fracture toughness increases as the reinforcement substance amplifies in the matrix material. The fracture toughness increases by 130% by the addition of 2 wt. % of AL2O3nano particulates in AL356 matrix alloy.

•The wear resistance increases as the wt. O/o of reinforcement substance amplifies in the matrix material. The wear resistance of aluminium (AL356) +6 wt.% nano AL2O3 MMC shows 40.76 0/o increase in the wear resistance as compared to wear resistance of aluminum (AL356) alloy. The wear resistance of 6 hrs heat treated aluminium(AL356) alloy increases by 21.57% and increase 14.28% in the wear resistance of extruded aluminums (AL356) alloy with that of as-cast aluminums (AL356)alloy.

•The sliding distance increases, the coefficient of friction in both the AL356 / nano AL2O3 metal matrix composites and the matrix material enhances.

•The coefficient of friction of the matrix material is more than that of the composites for all sliding velocities and as the proportion of reinforcement boosts, the coefficient of friction of the aluminum (AL356)-nano AL2O3 metal matrix composite decreases.

•The wear resistance is more in AL356 / nano AL2O3 MMC as compared to the matrix material.

•The SEM photograph of the worn surface of NMMC with 8 Wt. % AL2O3 was found higher wear resistance in contrast to the worn surface of matrix alloy.

•The thermal conductivity decreases as the reinforcement content increases in the matrix material. The extruded AL356-AL2O3 nano composite shows decreased thermal conductivity as compared to as cast AL356-AL2O3 nano composite.

•The 6 hrs heat treated AL356-AL2O3 nano composite shows decreased thermal conductivity as compared to as cast and extruded AL356 –AL2O3nanocomposites.

The coefficient of thermal expansion of as-cast aluminum (AL356)-nano AL2O3 metal matrix composites declines as the reinforcement fraction enhances

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