Surface Phenomena

Formations:

- Surface Phenomena
  - In the case of organic binders, too high a urea content.
  - Too much moisture in mold and core.
  - From mold and core materials.
    - Excessive temperature.
    - Excessive concentration of hydroxides.
    - Excessive concentration of sodium.
    - Acids in mold and core materials.

Possible Causes:

- Organic binders
- Excessive temperature
- Excessive concentration of hydroxides
- Excessive concentration of sodium
- Acids in mold and core materials
- Organic binders

Case I: 7 in.
- Especially in casting sections whose thickness is on the order of 1/2 in. (0.64 cm)
- Cast Steel

Occurrence of Surface Phenomena:

- In the vicinity of surfaces formed by cores made with organic binders.
- Clean sand castings
- Especially in sections
- Cast Iron

0.12 in. (0.3 cm)
- Especially in casting sections whose thickness is on the order of 0.12 in. (0.3 cm)