

Residual stress determination in cold drawn steel wire by FEM simulation and X-ray diffraction

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Abstract

This paper presents a study on residual stress in cold drawn wire of low carbon steel by means of finite-element method (FEM) simulation and X-ray diffraction. A thick wire with a diameter of 17.9 mm drawn from an annealed wire with a diameter of 20.1 mm was investigated. First, FEM simulations were performed based on a suitable model describing the boundary conditions and the exact material behavior. Due to the initial texture in the original material, the anisotropy of the material plastic behavior was taken into account on the basis of the texture measurement of the wire. Instead of the isotropic von Mises yield criterion, a texture-based anisotropic yield locus was incorporated into the model to simulate the wire drawing process and calculate residual stresses. Next, X-ray diffraction measurements were carried out at the surface of the wire to obtain the distribution of the lattice spacing versus $\sin^2 \psi$, from which the macroscopic residual stresses at the wire surface were calculated. The comparison between the results from the simulations and the measurements shows that a good agreement has been reached.

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Keywords: Wire drawing; Residual stress; Finite-element analysis; Anisotropy; Crystallographic texture; X-ray diffraction

1. Introduction

Wire drawing is one of the most frequently applied techniques in the wire manufacturing industry. The drawing operation introduces residual stresses in the drawn wires. They may have an important effect on the functional properties of the wire.

In wire drawing process, there are many parameters that determine the deformation and therefore the final state of residual stresses. It is desirable for the industry to find an efficient way to study the influence of these parameters on the residual stress in order to provide process control and product improvements. The finite-element method (FEM) has proved to be successful and powerful in simulating metal forming process such as wire drawing. A great deal of research has been carried out in this field, and an extensive reference list is given by Shemenski [1]. Most of the simulations were, how-

ever, based on the assumption that the material was isotropic during the drawing process and the von Mises yield criterion was used in the FE models. This may lead to some inaccuracy when the material exhibits anisotropic behavior.

To achieve a high level of accuracy, one of the material properties that cannot be neglected is plastic anisotropy, which means that the flow stress of the material depends on the orientation of the axes of the loading system. In engineering materials, especially in annealed condition, this anisotropy is mainly determined by the crystallographic texture in the material. In FE models, taking anisotropy into account can be realized by replacing the isotropic yield criterion by the anisotropic yield locus derived from the texture of the material. This approach has been implemented in many simulations [2,3], showing that it can provide satisfactory predictions of the anisotropic behavior within reasonable computing time. A different method proposed by Kalidindi and Anand [4] and Dawson et al. [5] does not require the calculation of the yield locus. Instead, a discrete set of crystallites is used to represent

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