

Studies on the formation and corrosion resistance of phosphate coatings on steel

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- 10-Adsorption
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ABSTRACT

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This work has been carried out to investigate the possibility of use of the fire extinguisher powder which contain at least 88% mono-ammonium phosphate in the iron phosphate process. The obtained results indicated that the fire extinguisher powder can be used in the bath of iron phosphating process. Also the zinc phosphate process was studied and the characterization of zinc phosphating coatings was performed using the different tests. The effect of time and bath temperature on the mass of zinc phosphate coatings was also studied; the result showed that the coating mass increases with increase in time and increase in temperature. The pitting corrosion resistance of zinc phosphated specimens and zinc phosphated then painted specimens at different immersion time in NaCl solution of different concentrations using Potentiodynamic polarization measurements. The obtained results indicate that the optimum immersion time for phosphating process was 20 min. Also, the painting of the phosphated layer greatly decreased the porosity of the coating and increases the corrosion and pitting corrosion resistance.

Key words: Iron phosphate; fire extinguisher powder ; Zinc phosphate ; Zinc phosphate coatings; pitting corrosion resistance ; ammonium phosphate

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List of Contents

List of Tables	
List of Figures	
CHAPTER ONE :INTRODUCTION AND AIM OF THE PRESENT WORK	1
Aim of the present work	2
CHAPTER TWO:LITERATURE SURVEY	3
Phosphate Coatings	3
Composition of Phosphate Coating	6
Applications	9
Process Fundamentals	18
Cleaning	19
Pickling and Descaling	19
Rinsing after Cleaning	22
Phosphating Methods	23
Rinsing after Phosphating	26
Chromic Acid Rinsing	27
Solution Maintenance Schedules	27
Break-in of Phosphating Solutions	29
Control of Coating Weight	29
Control of Crystal Size	30
Repair of Phosphate Coatings	33
Phosphate Coating Selection	33
CHAPTER THREE :EXPERIMENTAL AND TESTS	38
Experimental	38
Sample preparation	38
Sequence of phosphating Process	38
Sequence and details of operations for spraying iron phosphate	39
Sequence and details of operations for spraying iron phosphate by using	

fire extinguisher powder	
Sequence and details of operations for zinc phosphate	42
Testing for phosphating process	47
Phosphate Bath Testing	50
Phosphate coating analysis	51
Paint ability Tests	54
Pitting corrosion resistance	59
CHAPTER FOUR: RESULTS AND DISCUSSION	59
Results of spraying iron phosphate	60
The results of zinc phosphate	60
Pitting corrosion resistance	66
Potentiodynamic polarization measurements of phosphated specimens	80
Potentiodynamic polarization measurements of phosphated and painted specimens	80
SUMMARY AND CONCLUSION	103
REFERENCES	128
SUMMARY IN ARABIC	132

List of Tables

Table (1) A typical formulation for an iron phosphate bath	4
Table (2) Accelerators used in phosphate coating processes	8
Table (3) the protective effect of the inhibitors	12
Table (4) Mean values of I_{corr} , E_{corr} and corrosion inhibiting efficiency (θ) obtained from the cathodic polarization curves	14
Table (5) Corrosion resistance of phosphate coatings obtained by anodic electrochemical treatment in 3.5% NaCl evaluated by immersion test, potentiodynamic polarization and EIS studies	15
Table (6) Operating temperature ranges for phosphating solutions in phosphating applications	26
Table (7) Sequence of operations for spray zinc phosphating; coating weight ranged from 1.7 to 2.1 g/m ²	28
Table (8) Process parameters for selected phosphate coatings	34
Table (9) Chemical composition of carbon steel used as substrate	38
Table (10) Chemical composition of concentrated iron phosphate bath	39
Table (11) Sequence and details of operations for Spraying Iron phosphate	40
Table (12) Sequence and details of operations for spraying iron phosphate by using fire extinguisher powder	45
Table (13) Chemical composition of concentrated zinc phosphate bath	47
Table (14) Sequence and details of operations for zinc phosphate	48
Table (15) The results of phosphate bath for spraying Iron phosphate	61
Table (16) The results of phosphate bath for spraying iron phosphate using fire extinguisher powder	61
Table (17) comparison table between spraying iron phosphate and spraying iron phosphate using fire extinguisher powder	65
Table (18) The results of phosphate bath for immersion zinc phosphate	67

Table(19)the phosphate coating mass against time	72
Table (20) The phosphate coating mass(g/m^2) at different temperatures	73
Table(21) Corrosion resistance of phosphated and painted steel after 72 h	77
Table (22) a comparison table between iron phosphate and zinc phosphate	78
Table (23) The Potentiodynamic anodic polarization measurements of phosphated specimens	86
Table(24) The Potentiodynamic anodic polarization measurements of phosphated specimens	87
Table(25) The Potentiodynamic anodic polarization measurements of phosphated and painted specimens	109
Table(26) The Potentiodynamic anodic polarization measurements of phosphated and painted specimens	110

List of Figures

Fig (1) Corrosion resistance of selected metal finishes relative to type Of phosphate coating applied.	11
Fig. (2) Variations in the cross-sectional shape of pits.	16
Fig. (3) Standard rating chart for pits.	17
Fig. (4) Plot of manganese phosphate coating weight vs. time of exposure of steel surface to phosphating solution.	25
Fig. (5) Sequence of operations for light vs. heavy applications of Manganese phosphate coatings.	30
Fig (6) Photomicrographs of microstructures for principal phosphate coatings.	31
Fig (7) Classification of adhesion test results.	57
Fig (8) Photographs of phosphate coating for immersion time 10 min.	69
Fig (9) Photographs of phosphate coating for immersion time 15 min.	69
Fig (10) Photographs of phosphate coating for immersion time 20min.	69
Fig (11) Photographs of phosphate coating for immersion time 25min.	70
Fig (12) Photographs of phosphate coating for immersion time 30min.	70
Fig (13) SEM photographs of phosphate coating and painted for immersion time 10 min	71
Fig (14) The effect of phosphate time on phosphate coating mass.	72
Fig (15) The effect of bath temperature on phosphate coating mass.	73
Fig(16)the potentiodynamic anodic polarization curves of blank specimen.	88
Fig(17)the potentiodynamic anodic polarization curves of specimen phosphated for 10 min.	89
Fig(18)the potentiodynamic anodic polarization curves of specimen phosphated for 1° min.	90

Fig(19)the potentiodynamic anodic polarization curves of specimen phosphated for 10 min	91
Fig(20)the potentiodynamic anodic polarization curves of specimen phosphated for 20 min	92
Fig(21)the potentiodynamic anodic polarization curves of specimen phosphated for 30 min	93
Fig(22) The variation of pitting corrosion potential , E_{pit} ,with $\log C_{Cl^-}$	94
Fig (23) The plots of E_{pit} values for six specimens(blank +5 phosphated) immersed in 0.01M NaCl and 1.0 M NaCl	95
Fig (24) The potentiodynamic curves for the determination of E_{pit} and repassivation potential, E_p , for the blank specimen	96
Fig (25) The potentiodynamic curves used for the determination of E_{pit} and E_p , for the phosphated specimens at 20 minutes	97
Fig(26)the repassivation potential , E_p , for the blank specimen and specimens phosphated at different immersion time in phosphating bath versus $\log C_{Cl^-}$	98
Fig(27) the values of $(E_{pit} - E_p)$ versus $\log C_{Cl^-}$	99
Fig(28) the variation of the integrated charge amount , q_a , with , $\log C_{Cl^-}$	100
Fig (29)The values of $(E_{pit}-E_p)$ for the different specimens immersed in 0.01M &1.0 M NaCl solution	101
Fig (30) The values of q_a for different specimens immersed in 0.01 M& 1.0M NaCl solution	102
Fig(31)the potentiodynamic anodic polarization curves of phosphated and painted specimen at 10 min	111
Fig(32)the potentiodynamic anodic polarization curves of phosphated and painted specimen at 15 min	112
Fig(33)the potentiodynamic anodic polarization curves of phosphated and painted specimen at 20 min	113
Fig(34)the potentiodynamic anodic polarization curves of phosphated	114

and painted specimen at 20 min	
Fig(35)the potentiodynamic anodic polarization curves of phosphated and painted specimen at 20 min	115
Fig. (36). the variation of pitting corrosion potential, E_{pit} , with, $\log C_{Cl^-}$, for the investigated specimens	116
Fig (37) E_{pit} values for the investigated specimens in 0.01 M & 1.0M NaCl solution	117
Fig (38) The potentiodynamic curves used for the determination of E_{pit} and E_p , for the phosphated and painted specimen at 20 minute	118
Fig. (39) The repassivation potential, E_p , for the blank specimen and specimens phosphated and painted are plotted versus $\log C_{Cl^-}$.	119
Fig.(40) The values of ($E_{pit} - E_p$) versus the $\log C_{Cl^-}$	120
Fig(41) The integrated charge amount q_a versus $\log C_{Cl^-}$	121
Fig (42) ($E_{pit} - E_p$) for the blank and phosphated and painted specimens in 0.10 M & 1.0 M NaCl solution	122
Fig (43) q_a for the blank and phosphated and painted specimens in 0.01 M & 1.0 M NaCl solutions	123
Fig (44) ($E_{pit} - E_p$) values for the phosphated and (phosphated & painted) in 0.01M NaCl solution	124
Fig (45) ($E_{pit} - E_p$) values for the phosphated and (phosphated & painted) specimens in 1.0 M NaCl solution	125
Fig (46) q_a values for the phosphated and (phosphated & painted) specimens in 0.01 M NaCl	126
Fig (47) q_a values for the phosphated and (phosphated & painted) specimens in 1.0 M NaCl	127

CHAPTER ONE

INTRODUCTION AND AIM OF THE PRESENT WORK

Phosphate conversion coatings are employed in many industries either for corrosion protection, preparation of the metal surface for improved paint adhesion, or for decoration. Less commonly, phosphatizing is used to improve the lubrication, or as a base for adhesives in plastic-metal laminations or rubber-to-metal applications [1,2]. It serves as a conversion coating in which a dilute solution of phosphoric acid, which is applied via spraying or immersion, chemically reacts with the surface of the part being coated to form a layer of insoluble, crystalline phosphates [1, 2]. This type of coating can be applied on steels [3-7], galvanized steel [6,12], iron [7,8], magnesium [10,13,14], aluminum [11-15] and zinc [16]. There are many types of phosphating baths such as, zinc based [3,16-19], manganese based [6,20-22], iron based [23]. A fourth type, lead phosphate, more recently introduced, or even a combination of them. The type of coating used depends on the phosphated material application (Manganese phosphates are used both for corrosion resistance and lubricity and are applied only by immersion. Iron phosphates are typically used as a base for further coatings or painting and are applied by immersion or by spraying. Zinc phosphates are used for rust proofing, lubricity, and as a paint/coating base and can also be applied by immersion or spraying). The chemical compounds that act as accelerators (accelerate the phosphating process) might be oxidant compounds or salts of metals nobler than the metal to be phosphated.

The purposes of these accelerators are:

- 1-Speed up the rate of coating to oxidize ferrous iron
- 2- Reduce crystal size.

Various types of chemical accelerators for phosphating can be used such as sodium nitrite [3,9,13,24-26], nitrates [5,9,10,13,14,24,25,27,28], and chlorates [27,29].

Besides the chemical accelerator other additives are used to afford other specific properties.

Various additives are used such as calcium ions [9,29-32], manganese ions [18,20,22,27,32-34], tartaric acid [10,14], fluoride ions [10,13-15,24,26], nickel ions [3,15,18,25,27,29,35], copper ions [36] molybdenum ions [14,34] and, more recently, niobium [36].

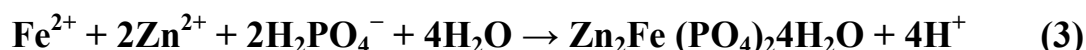
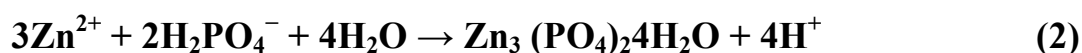
Aim of the present work:

- 1- Investigate the possibility of use the available materials such as fire extinguisher powder which contain at least 88% mono-ammonium phosphate which represent an environmental problem to get rid of it in our factory in the iron phosphate process
- 2- Study the zinc phosphate process and the characterization of phosphate coatings.
- 3- Study the effect of time and bath temperature of zinc phosphate process on the zinc phosphate coating mass.
- 4- Study the corrosion behaviour (pitting corrosion resistance) of zinc phosphated and zinc phosphated then painted steel using Potentiodynamic polarization measurements.

CHAPTER TWO

LITERATURE SURVEY

According to literature [1] and [37] phosphating of metallic substrates occurs through the following reactions:



The first reaction corresponds to the metal attack by the acid phosphating solution and the two following reactions lead to phosphate crystals formation and deposition on the metallic surface.

The weight and crystalline structure of the coating and the extent of penetration of the coating into the base metal can be controlled by:

- 1-Method of cleaning before treatment.
- 2-Use of activating rinses containing titanium and other metals
- 3-Method of applying the solution.
- 4-Temperature, concentration, and duration of treatment.
- 5-Modification of the chemical composition of phosphating solution.

Phosphate coatings range in thickness from less than 3 to 50 μm . Coating weight (grams per square meter of coated area), rather than coating thickness, has been adopted as the basis for expressing the amount of coating deposited.

Phosphate coatings

Three principal types of phosphate coatings are in general use: Zinc, Iron, and Manganese. A fourth type, Lead phosphate, more recently introduced.

Zinc phosphate coatings

It encompasses a wide range of weights and crystal characteristics, ranging from heavy films with coarse crystals to ultrathin microcrystalline deposits.