Explosive welding : Crossland and Williams Table I. Properties of explosives²⁰

More recently, Shribman and Crossland³⁰ have published data on the detonation velocity of the following explosives, which are readily available in Great Britain:

I. Metabel sheet explosive, produced by Imperial Chemical Industries, Ltd., and normally provided in sheets 10×5 $\times \frac{1}{8}$ in (254 \times 126 \times 3 mm). It has a density of 1.47 g/cm³, a detonation velocity of 7000 m/s, and an energy release of 900–1050 cal/g (3760–4500 J/g).

2. Trimonite No. 1, a powder explosive produced by Imperial Chemical Industries, Ltd., with a density of 1.10 g/cm^3 (and in the granulated form 0.7 g/cm^3) and an energy release of 1260 cal'g (5260 J/g). A detonation velocity is not given as it is very sensitive to thickness of layer.

3. Trimonite No. 3, as for No. 1 but with a density of 0.98 g/cm³ and an energy release of 1034-1260 cal/g (4330-5260 J/g).

4. Nitroguanadine (picrite) is a powder explosive that is extremely difficult to handle because of its light feathery nature. At a density of 0.16 g/cm³, and a layer thickness of I-2 in (25-50 mm), it has a detonation velocity of ~ 2300 m/s and an energy release of 950 cal/g (3960 J/g).

The detonation velocity was measured by three methods: Dautriche, parallel plate with pin contactors, and insertion of pins in the explosive at a known distance apart.

n

is

a

ta

Oin

nation

sertion

EVIEWS

For Nitroguanadine the detonation velocity for thicknesses from I to 2 in was found to be $2400 \pm 4.50_{4}$ m/s and for Metabel sheet explosive the detonation velocity for thicknesses of 0.125-0.5 in (3.175-12.7 mm) was $7000 \pm 5\%$, $6990 \pm 3.8\%$, and $7100 \pm 2.8\%$ m/s, respectively, for the three methods used. For Trimonite No. I and No. 3, the detonation velocity varied considerably with thickness, and the data are given in Fig. 8 and 9.

Experimental information on flyer-plate, velocity is very sparse. However, Shribman and Crossland³⁰ give data for the explosives mentioned above. For *Metabel* sheet explosive they cite the values of the ratio V_P/V_D for various values of R, the ratio of mass of explosive to mass of flyer plate, where the explosive is uniformly distributed over the plate. They compared these data wth various equations that have been proposed and found that the best agreement was obtained with the equation proposed by Gurney³¹

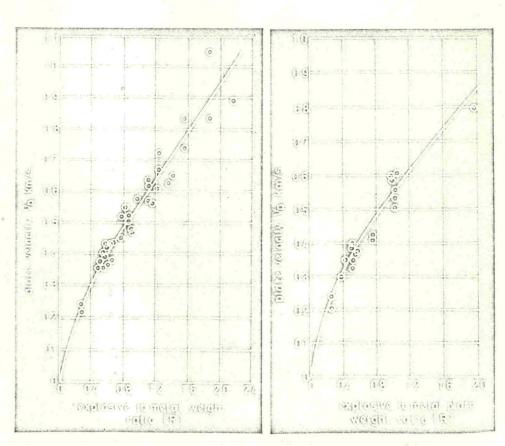
$$\frac{V_P}{V_D} = \frac{0.612R}{2+R} \qquad \dots [8]$$

Table III gives the experimental values and those predicted by this equation. METALLURGICAL REVIEWS

| Explosive | Calorific value, cal/g J/g | | Detonation velocity, m/s | Density, g/cm³ |
|---------------|-------------------------------|------|-----------------------------|-------------------|
| TNT | 1080 | 4500 | 6700 | 1.56 |
| RDX | 1280 | 5350 | 8180 | 1.65 |
| PETN | 1390 | 5400 | 8300 | 1.70 |
| PETN | 1390 | 5400 | 3500 | 0.5 |
| Tetryl | 1100 | 4600 | 7850 | 1.71 |
| Composition B | 1240 | 5190 | 7840 | 1.68 |
| EL-506D | 870 | 3640 | 7100 | 1.40 |

Table II. Effect of diameter on detonation velocity29

| Diameter | | | Velocity of Detonation, m/s | | |
|----------|------|-----|-----------------------------|-----------------------|--|
| | in | mm | TNT powder | Nitroglycerine powder | |
| | 0.75 | 19 | 3190 | 1830 | |
| | 1.25 | 32 | 3680 | 2250 | |
| | 2.00 | 51 | 4060 | 2610 | |
| | 2.5 | 64 | 4030 | | |
| | 3.0 | 76 | 4100 | 3150 | |
| | 4.0 | 102 | 4560 | 3290 | |
| | 5.0 | 127 | _ | 3440 | |
| | 6.0 | 152 | 4815 | - | |
| | 8.5 | 216 | | 3920 | |



10 Variation of V_P with R for Trimonite No. 1 explosive. $\rho = 1.1$ g/cm³. 11 Variation of V_P with R for Trimonile No. 3 explosive. p = 0.98 g/cm³.