Optimization of inner and outer joint for stress management

C. Accettura,
With several contributions from A. Bertarelli, B. Bordini,L. Bottura, A. Dudarev, A. Kolehmainen, F. Sanda

Final Cooling Solenoid Progress Meeting
https://indico.cern.ch/event/1390332/
15/03/2024, CERN

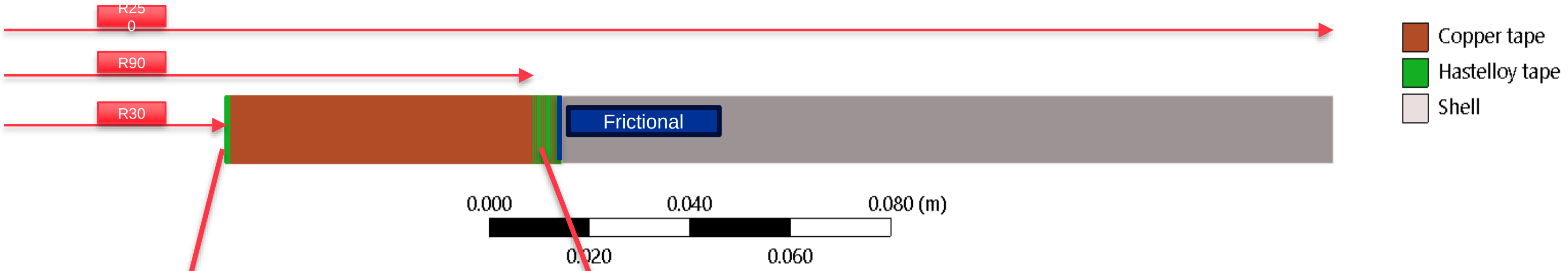
Index

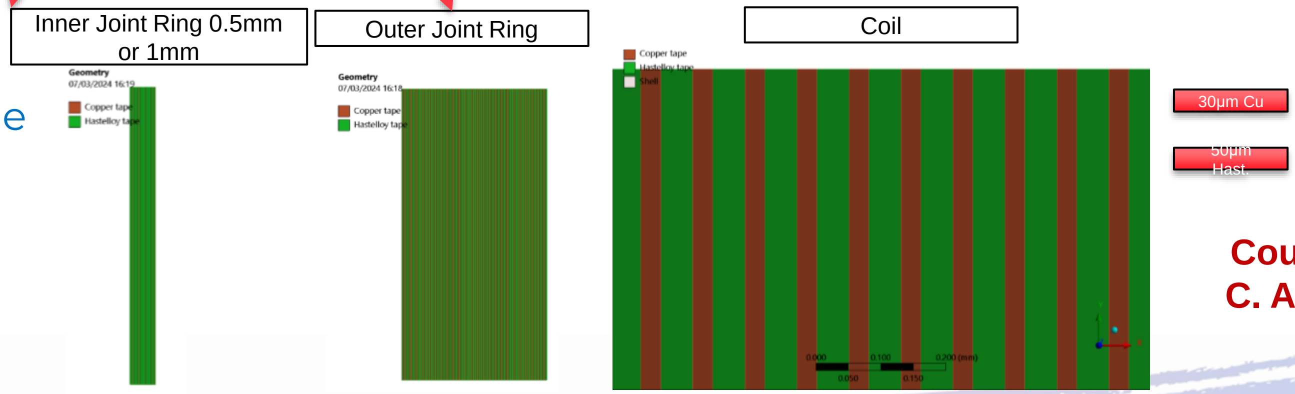
- Review of the model presented at the IMCC2024
- Alternatives

From Annual Meeting
13.03.2024 B. Bordini et al.

Mechanical Analysis
2 D FEM : geometry

- Mechanical **Simulation of a modular coil: all 750 windings are represented**
- The model **accounts** for**: Cu yielding** and; the **thermal contractions** of the different materials





- To further **reduce** the **stresses** on the coils, a **lower amount** of **Cu** in the tape and a much **larger outer-ring** thickness

Courtesy of
C. Accettura

Mechanical Analysis

M : Stress-Strain Profiles

International MUON Collider Collaboration

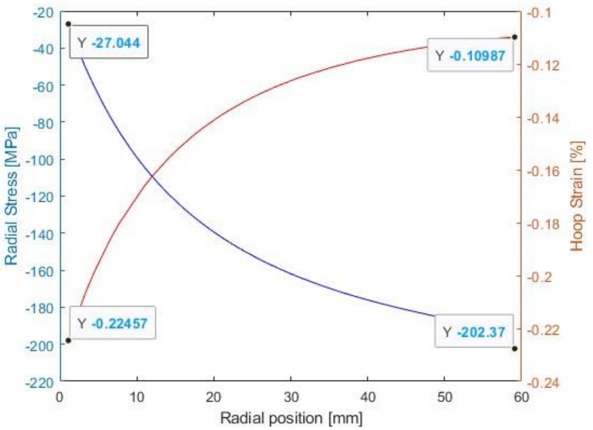
From Annual Meeting
13.03.2024 B. Bordini et al.

Courtesy of C. Accettura

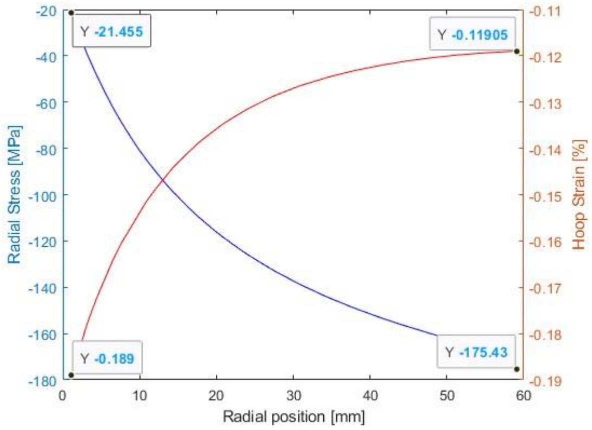
Pre-compression
170 MPa

Inner Joint ring
1 mm thick

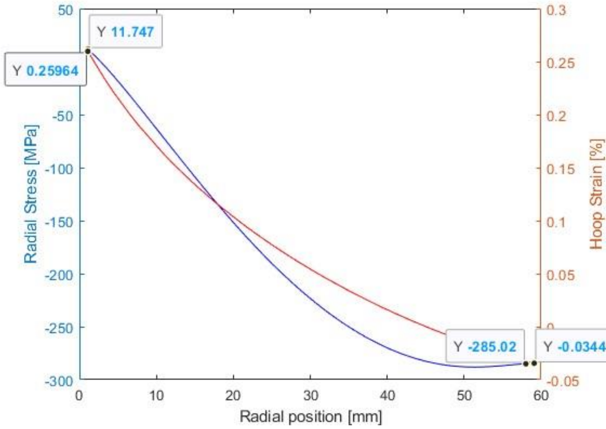
Step 1

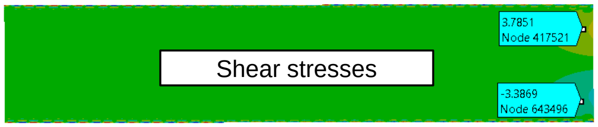


Step 2



Step 3





Mechanical Analysis

FEM : four Case Studies

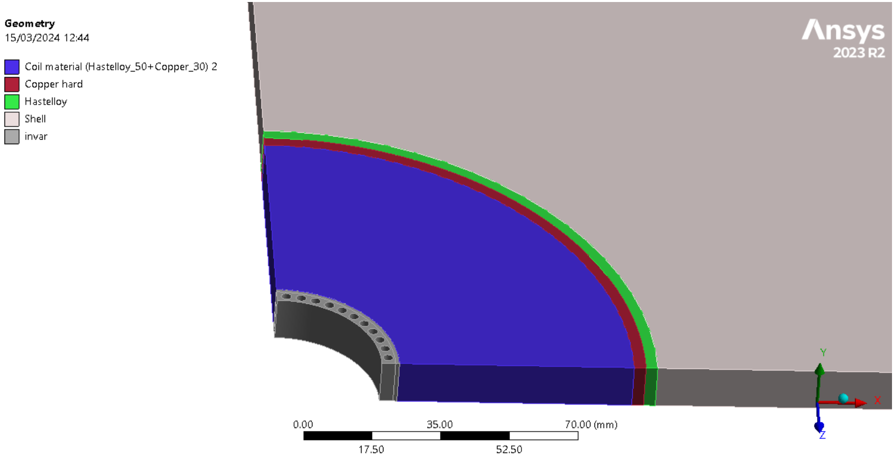
From Annual Meeting
13.03.2024 B. Bordini et al.

Inner Joint ring thickness [mm]	Pre-compression at cold [MPa]	Radial stress[MPa]			Hoop Strain [%]			Shear Stress [MPa]		
		Step 1	Step 2	Step 3	Step 1	Step 2	Step 3	1	2	3
0.5	170	-205/-8	-190/-5	**-290/10**	**-0.25**/-0.10	-0.20/ -0.12	-0.04/**0.28**	6	4.5	4
	250	-318/-12	-258/-8	**-367/7**	**-0.39**/-0.17	-0.31/-0.16	-0.09/**0.18**	10	6	5
1	170	-205/-14	-190/-10	**-288/19**	**-0.25**/-0.10	-0.2/-0.12	-0.05/**0.29**	6	4	5
	250	-320/-21	-259/-15	**-366/13**	**-0.39**/-0.17	-0.3/-0.16	-0.09/**0.18**	10	6	5

Courtesy of C. Accettura

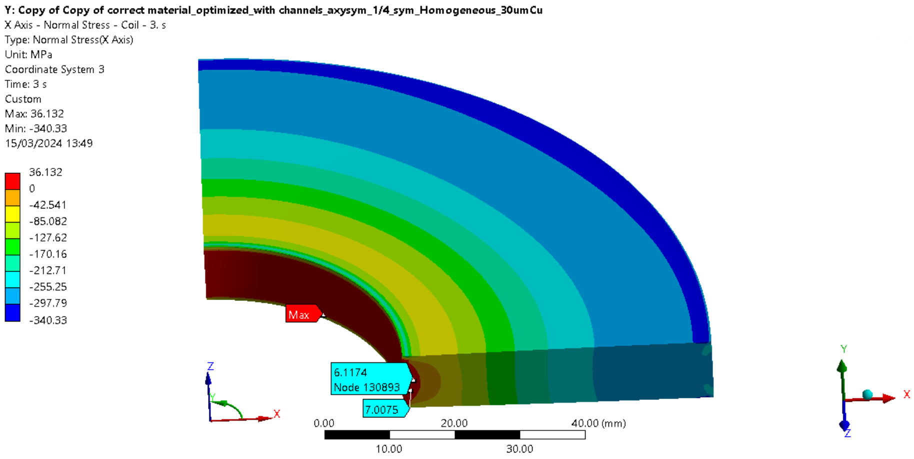
Alternative model

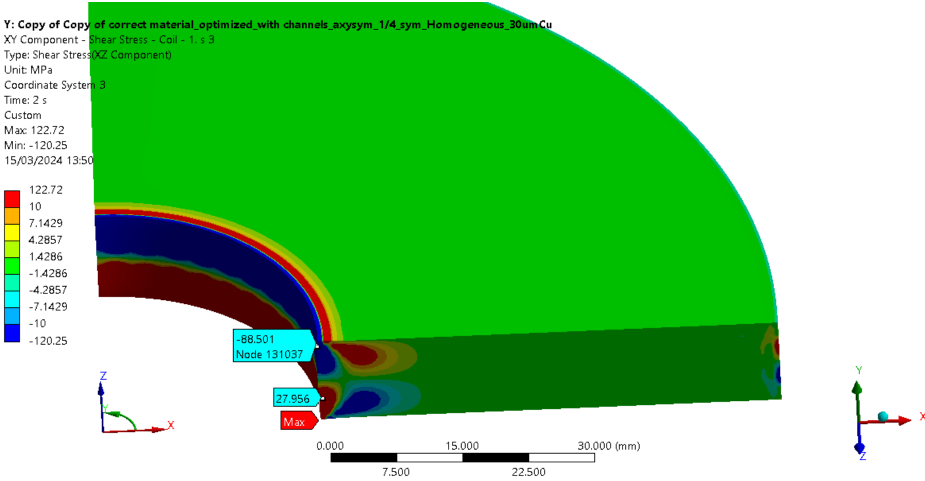
- Invar ring with channels for cooling



Alternative model

- Stresses→ radial tensile ok, but high shear during the cool-down

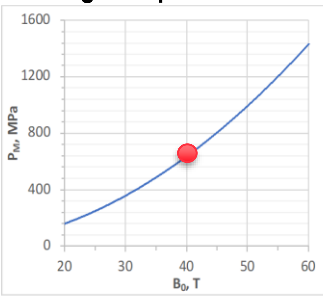


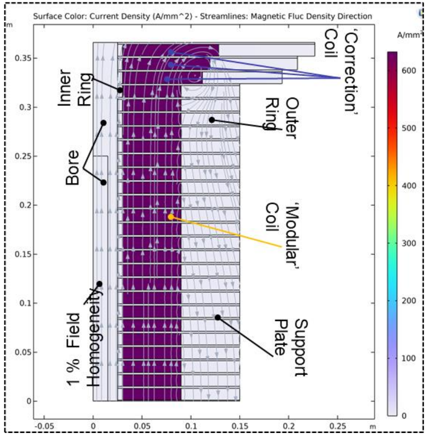


Introduction and Motivations

- Design proposed for the Final Cooling solenoid based on single and compact coil→ critical stress management:
  - $P_M=B_0^2/2\mu_0$~600MPa
  - Hoop stress~ 1.4-2.2P_M (compact coil)

Magnetic pressure vs Field

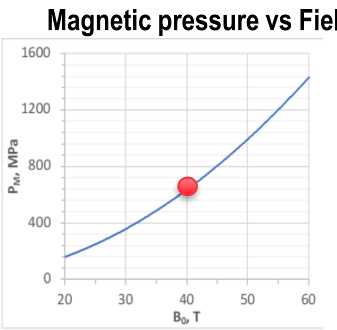


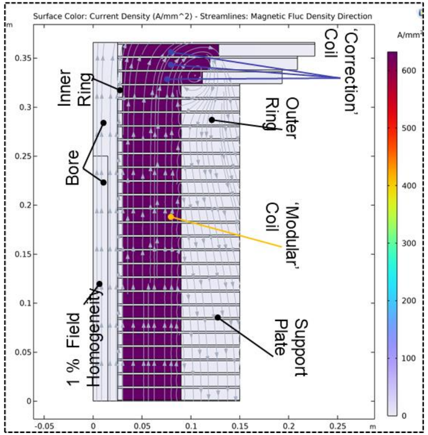


See [B. Bordini, Technology options for the final cooling solenoids, IMCC Annual Meeting 2023, Orsay]

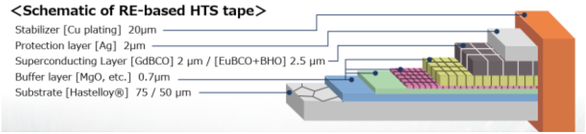
Introduction and Motivations

- Design proposed for the Final Cooling solenoid based on single and compact coil→ critical stress management:
  - $P_M = B_0^2 / 2\mu_0 \sim 600MPa$
  - Hoop stress~ 1.4-2.2P_M (compact coil)
- Non- homogeneous and anisotropic material:
  - Maximum allowable stress very weak in certain direction
  - Scarce literature
  - Reduced safety margin





See B. Bordini, Technology options for the final cooling solenoids, IMCC Annual Meeting 2023, Orsay



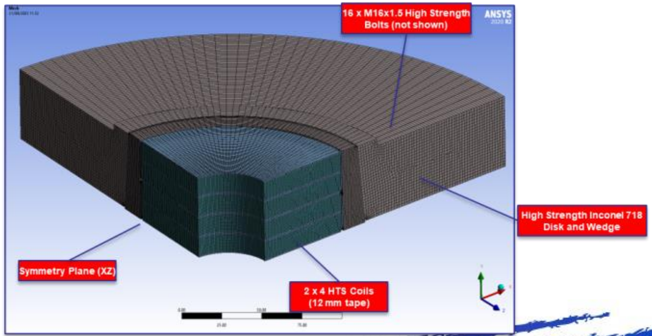
Reference Conductor Fujikura FESC-SH12.
https://www.fujikura.co.jp/eng/products/newbusiness/superconductors/01/superconductor.pdf

REBCO conductor	
Axial tensile stress	700MPa
Axial tensile strain	0.4%
Transverse compressive stress	>100MPa
Transverse tensile stress	10-100MPa
Max shear stress	>19MPa

- A pre-compression of ~200MPa is need to remain below this value

Pre-compression

- How to obtain the pre-compression?
- Mechanical concept is based on **encapsulating** HTS pancake coils in **an external structure**, generating high **radial compressive stresses. Three concepts analysed:**
  1. Thermally-induced shrink fitting
  2. Adjustable shrink-discs with conical surfaces
  3. Hybrid solution (1+2)



C. Accettura et al.,Final Cooling Solenoid Progress Meeting, 15/03/2024

Shrink Fitting

- Coil surrounded by a cylindrical shell with $r_{in\_shell} < r_{ext\_coil}$
- Shell is pre-heated→ fitting of the coil inside→ cool-down of the shell and thermal contraction
- Simple analytical evaluation: σ_{hoop}=-500MPa→200MPa→interference gap ~220μm→ Tshell~170°C

$$\sigma_\theta = -\frac{\rho^2+\beta^2}{\rho^2}\frac{1}{1-\beta^2}p_e$$

$$\delta = \delta_{i2} - \delta_{e1} = \left[\frac{1}{E_2}\left(\frac{1+\beta_2^2}{1-\beta_2^2}+\nu_2\right)+\frac{1}{E_1}\left(\frac{1+\beta_1^2}{1-\beta_1^2}-\nu_1\right)\right]r_{e1}p_f$$

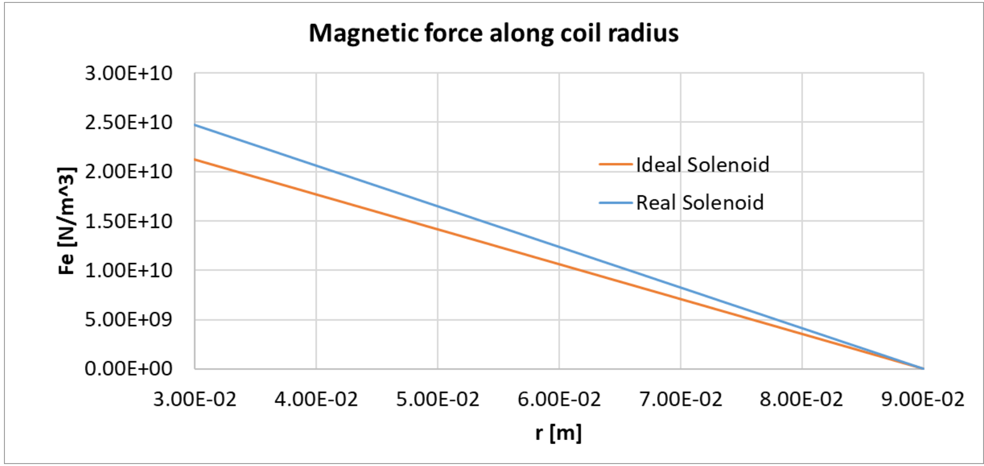
- Some practical aspects must be considered:
  - Differential contraction during cooldown
  - Strength of the cylinder
  - Impact of the joints
  - Plasticity
  - Mechanical tolerances: 1MPa/μm lost
  - Buckling

- FEA simulations at different levels of complexity

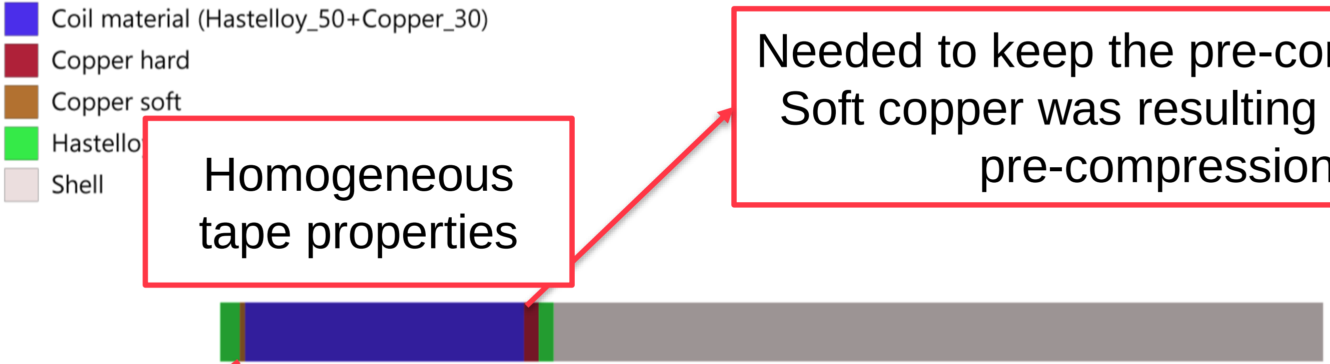
C. Accettura et al.,Final Cooling Solenoid Progress Meeting, 15/03/2024

Assumptions

- 2D axisymmetric
- Electromagnetic Forces
  - Ideal Solenoid ($J_{ideal} = \frac{B_{MAX}}{\mu_0(r_{co}-r_{ci})}$ = 531 A/mm2)
  - Real Solenoid ($J_{real} = J_{ideal}\frac{t_{coil}+t_{supportplate}}{t_{coil}}$ = 620 A/mm2)



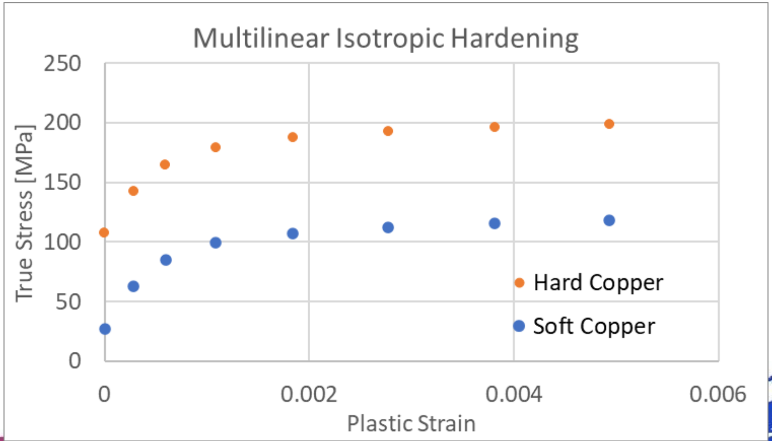
Reference model



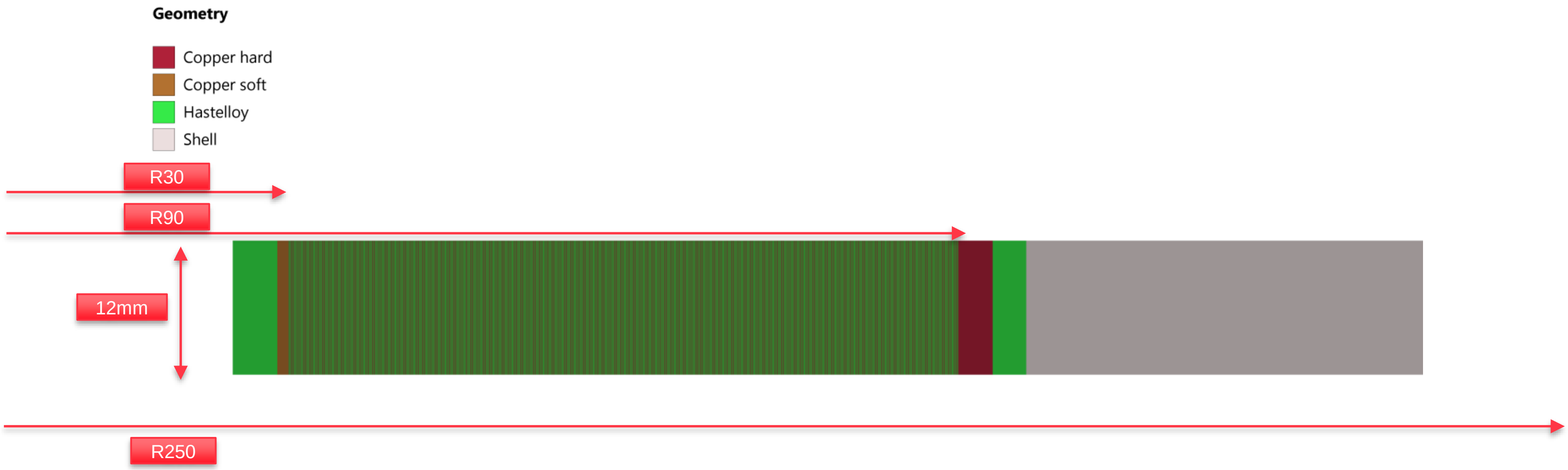
Homogeneous tape properties

Needed to keep the pre-compression. Soft copper was resulting in a lower pre-compression

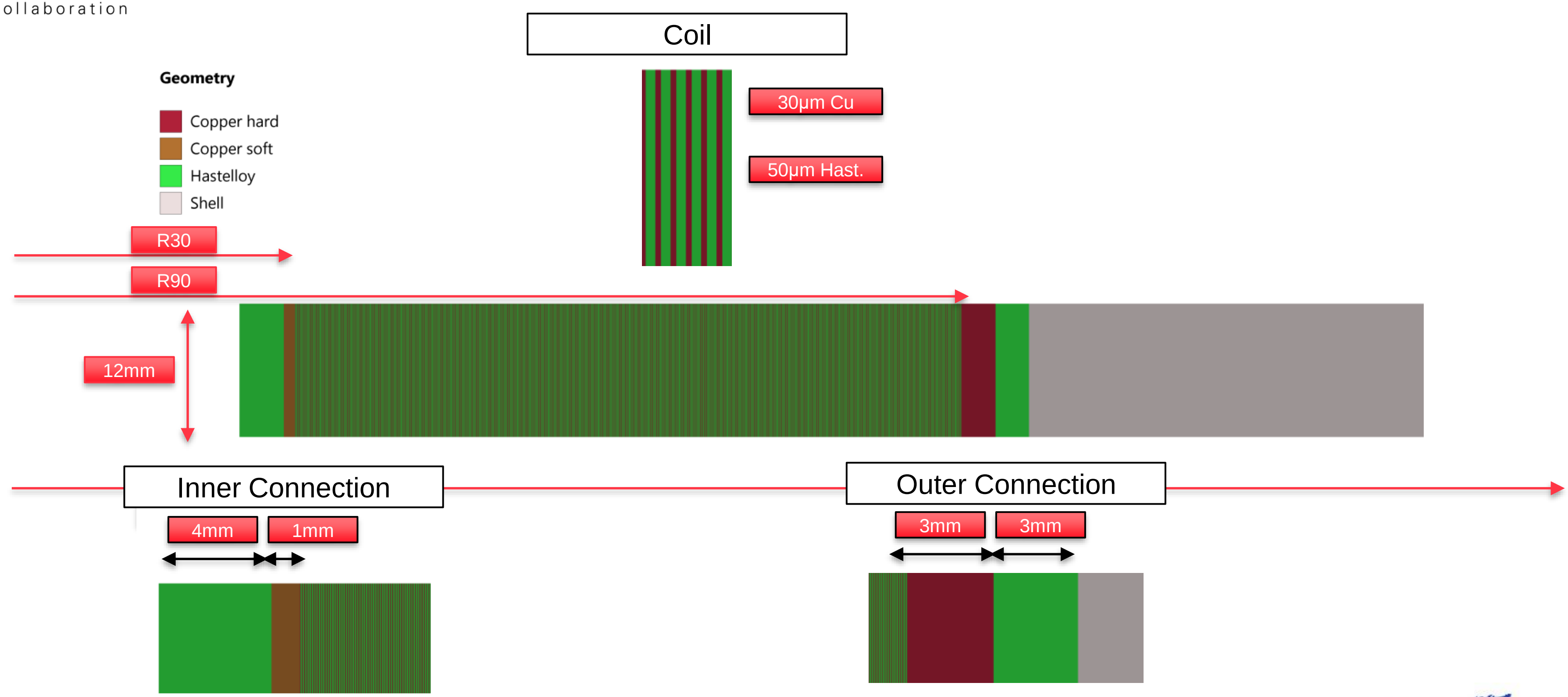
Ha to avoid radial tensile and shear stress after cooldown



Layered model

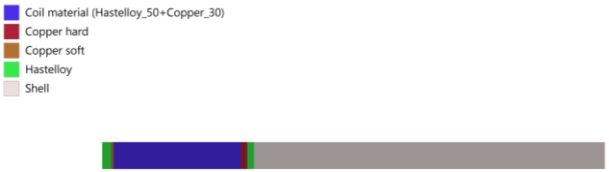


Geometry and Materials



C. Accettura et al.,Final Cooling Solenoid Progress Meeting, 15/03/2024

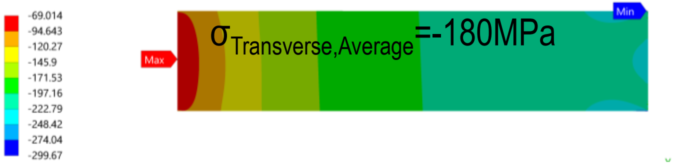
Validity of homogeneous model



Step 1: Shrink fitting (T external shell =250°C)

$\sigma_{Transverse,Average}$=-210MPa

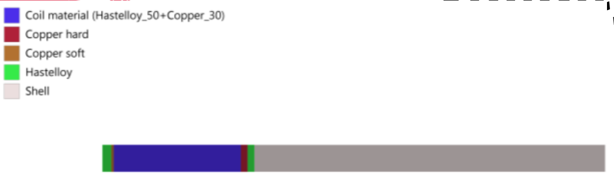
Step 2: Cool-down

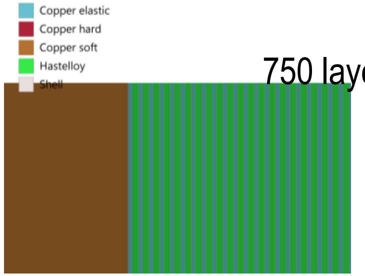


$\sigma_{Transverse,Average}$=-180MPa

Step 3: Energization

Validity of homogeneous model





750 layers: 30µm+50 µm

Step 1: Shrink fitting

$\sigma_{Transverse,Average}$=-210MPa

Step 1: Shrink fitting

$\sigma_{Transverse,Average}$=-215MPa

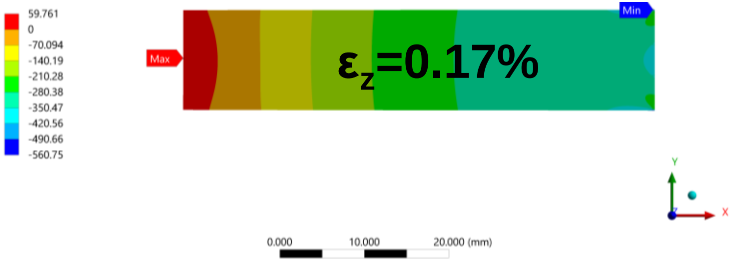
Step 2: Cool-down

$\sigma_{Transverse,Average}$=-180MPa

Step 2: Cool-down

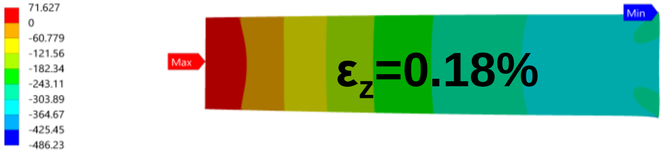
$\sigma_{Transverse,Average}$=-170MPa

Step 3: Energization



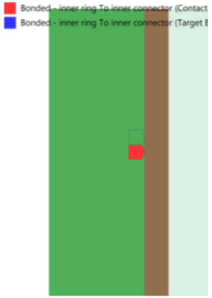
ε_z=0.17%

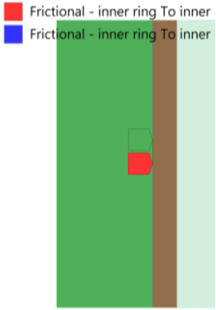
Step 3: Energization



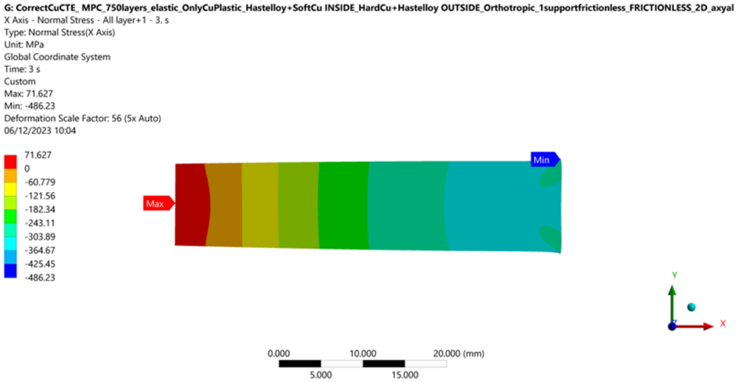
ε_z=0.18%

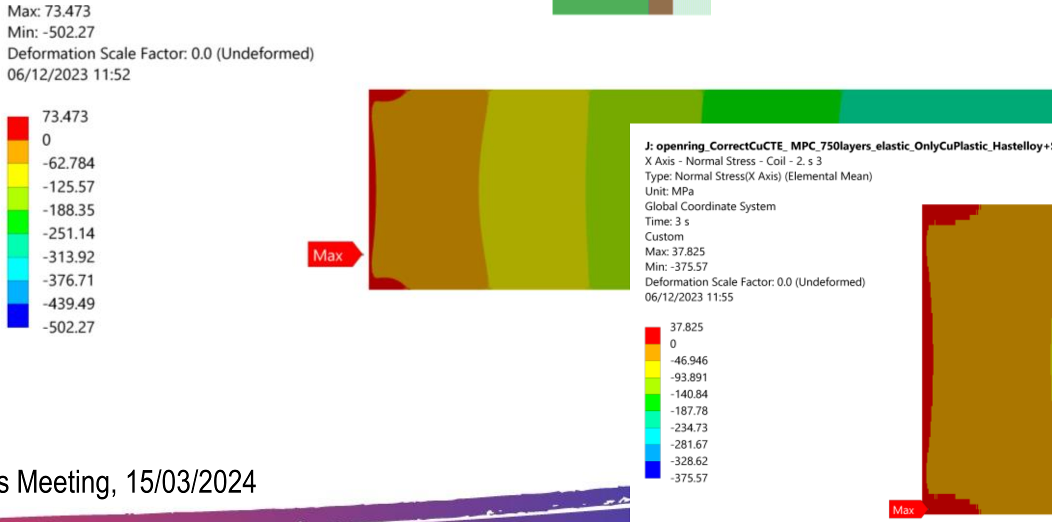
Effect of the inner joint properties





Let the ring detach to limit radial tensile stress





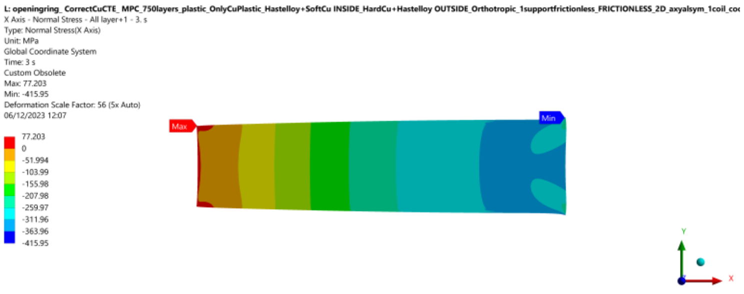
C. Accettura et al.,Final Cooling Solenoid Progress Meeting, 15/03/2024

Effect of the tape plasticity

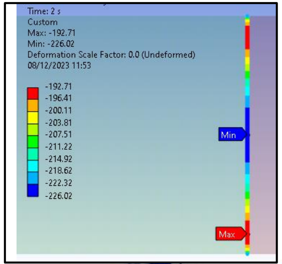
	σ_x-radial[MPa]			ε_z-hoop
step	min	max	ave	max
1	-289	-57	-210	
2	-224	-67	-164 (200*)	
3	-416	77	-213	0.30%
1	-308	-54	-214	
2	-272	-63	-171 (210*)	
3	-502	73	-224	0.22%

Plastic

Elastic



*Average on the external edge



Effect of the tape properties

	σ_x-radial[MPa]			ε_z-hoop
step	min	max	ave	max
1	-291	-55	-208	
2	-264	-60	-171 (215*)	
3	-484	75	-218	0.24%
1	-289	-57	-210	
2	-224	-67	-164 (200*)	
3	-416	77	-213	0.30%

*Average on the external edge

Experiments and FE modeling of stress–strain state in ReBCO tape under tensile, torsional and transverse load

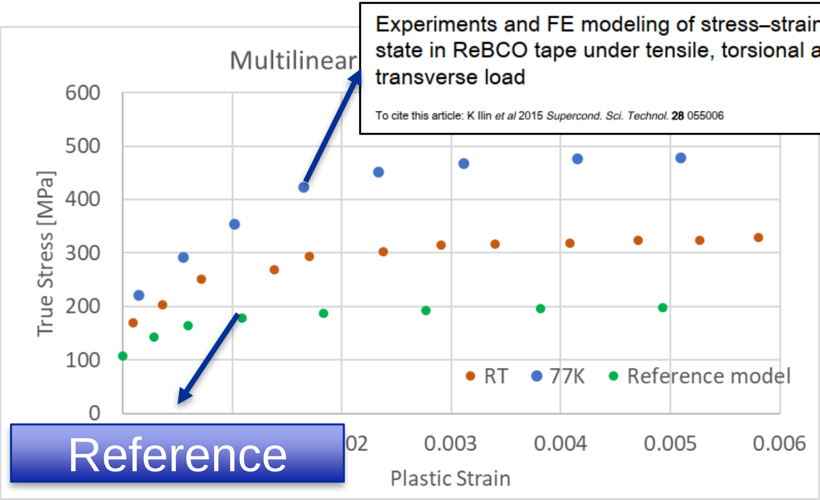
To cite this article: K Ilin *et al* 2015 *Supercond. Sci. Technol.* **28** 055006

Reference

Effect of the tape properties

	σ_x-radial[MPa]			ε_z-hoop
step	min	max	ave	max
1	-291	-55	-208	
2	-264	-60	-171(215*)	
3	-484	75	-218	0.24%
1	-289	-57	-210	
2	-224	-67	-164 (200*)	
3	-416	77	-213	0.30%

*Average on the external edge



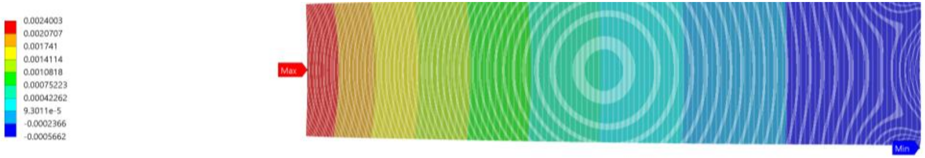
Effect of the tape properties

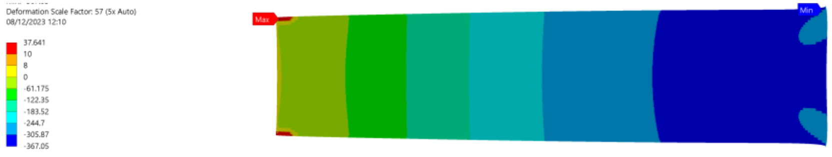
	σ_x-radial[MPa]			ε_z-hoop
step	min	max	ave	max
1	-291	-55	-208	
2	-264	-60	-171(215)	
3	-484	75*	-218	0.24%

*Localized effect

ε_z=0.24% ☑

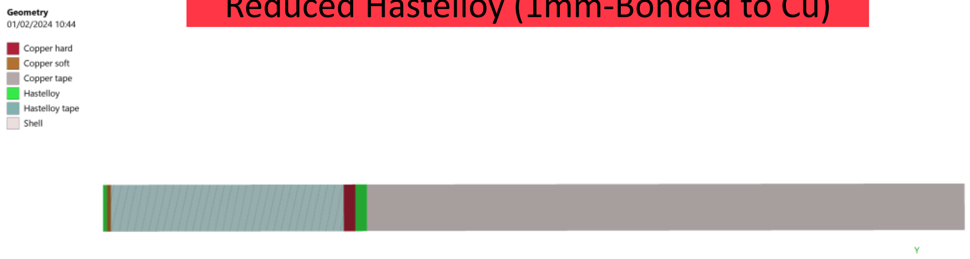
σ_x~10MPa ☑





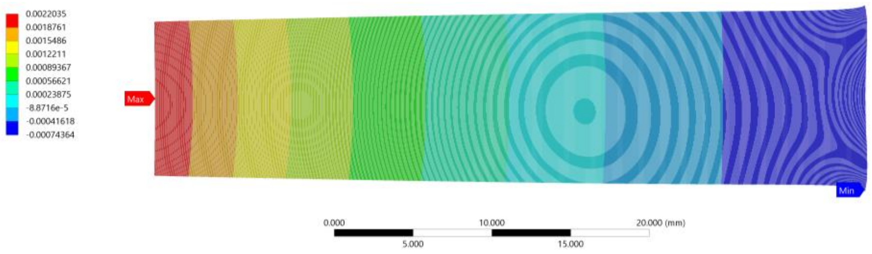
Alternative Inner Joint-1

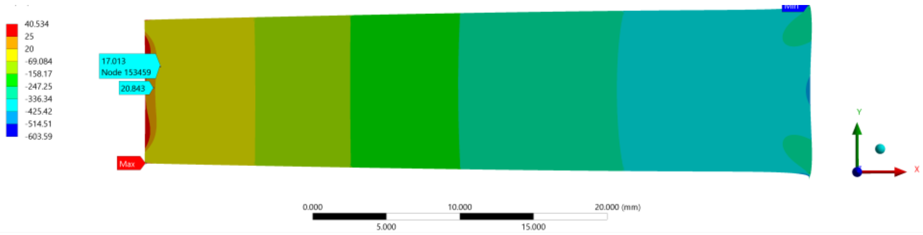
Reduced Hastelloy (1mm-Bonded to Cu)



ε_z=0.22% ☑

σ_x~20MPa
(p~250MPa)



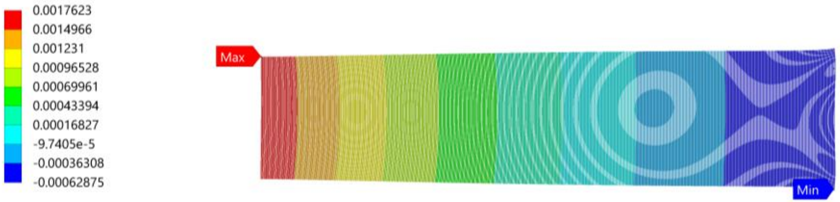


Alternative Inner Joint-2

Hastelloy orthotropic	
Ex-radial[GPa]	Ey,z-hoop[GPa]
100	200

ε_z=0.17% ☑

σ_x=80MPa ☒



Alternative Inner Joint-3

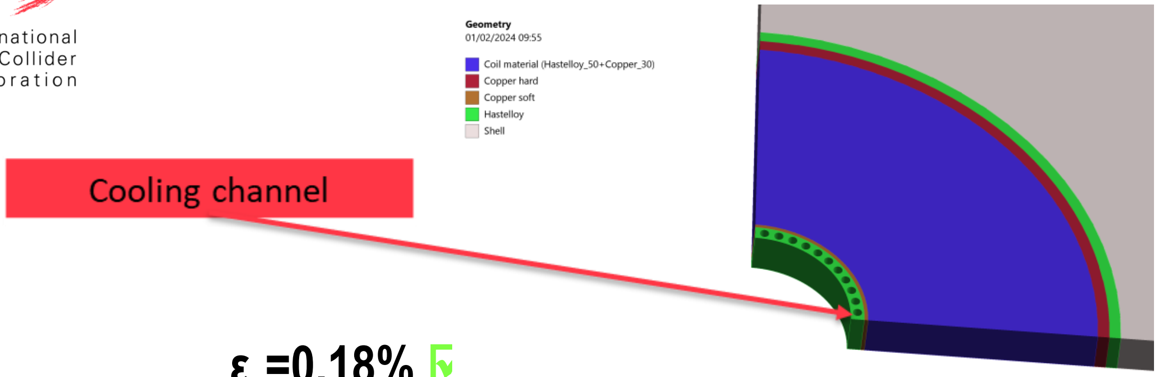
Soft Hastelloy isotropic
E [GPa]
20

Model simplification, important to have a 3D design of the inner ring to take into account the real stiffness of the structure

ε_z=0.27% ☑

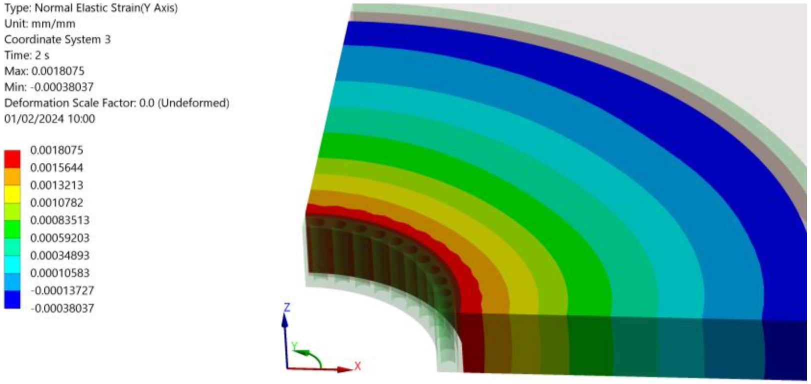
σ_x=12MPa ☑

Alternative Inner Joint-4

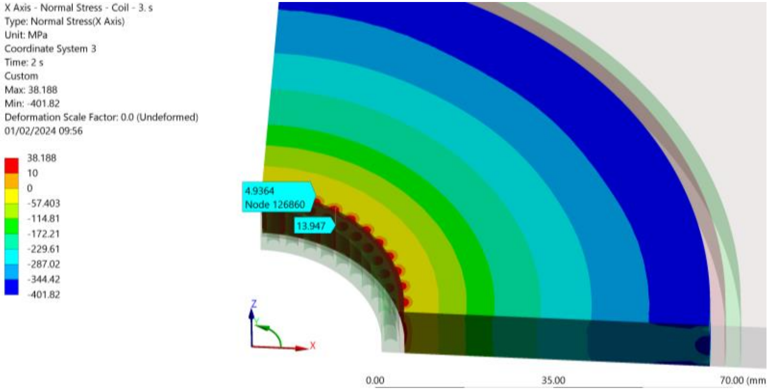


3D model more time-consuming, homogeneous material and mesh to be refined→ **INCREASE OF at least~50% expected**

ε_z=0.18%



σ_x<20MPa



Shrink Fitting

- Coil surrounded by a cylindrical shell with rin<rext_coil
- Shell is pre-heated→ fitting of the coil inside→ cool-down of the shell and thermal contraction
- Simple analytical evaluation: 600MPa→200MPa→interference gap ~300μm→ ~250°C

$$\sigma_\theta = -\frac{\rho^2+\beta^2}{\rho^2}\frac{1}{1-\beta^2}p_e$$

$$\delta = \delta_{i2} - \delta_{e1} = \left[\frac{1}{E_2}\left(\frac{1+\beta_2^2}{1-\beta_2^2}+\nu_2\right)+\frac{1}{E_1}\left(\frac{1+\beta_1^2}{1-\beta_1^2}-\nu_1\right)\right] r_{e1} p_f$$

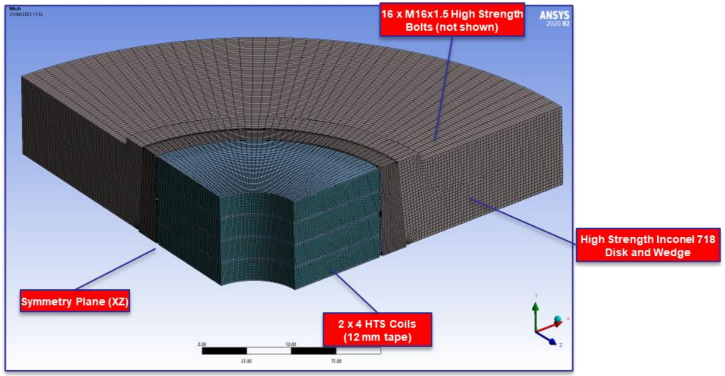
- Some practical aspects must be considered:
  - Differential contraction during cooldown
  - Strength of the cylinder
  - Impact of the joints
  - Plasticity
  - **Mechanical tolerances: 2MPa/μm lost**
  - **Buckling**

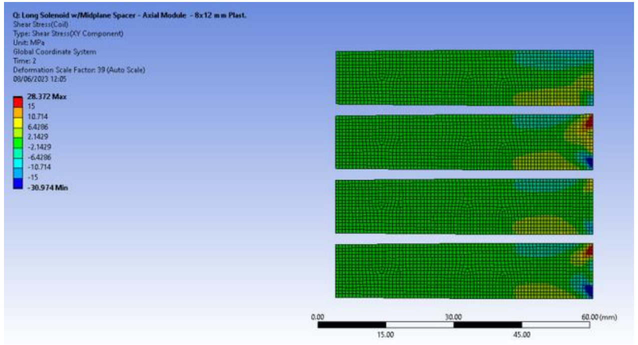
- FEM simulations at different levels of complexity

C. Accettura et al.,Final Cooling Solenoid Progress Meeting, 15/03/2024

Mechanical considerations - Second concept

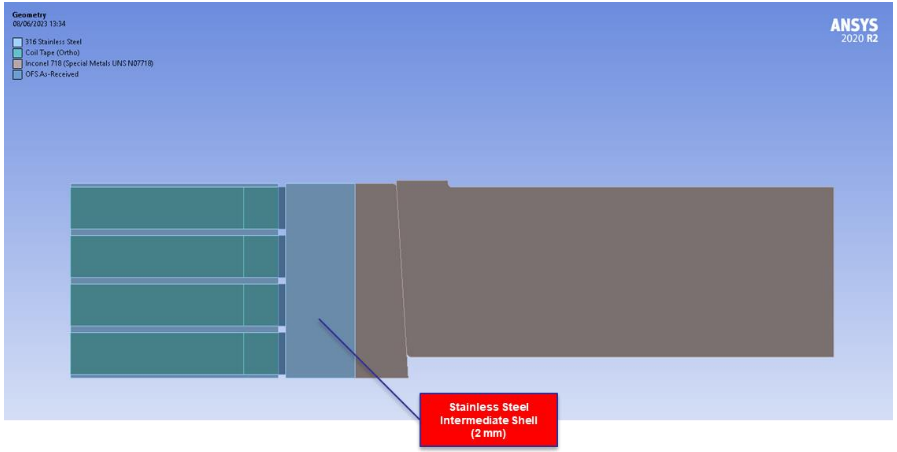
- 2 Load Steps:
  - Shrink Disk displacement (5 mm)
  - Energization
- Max. Hoop Stress (after energization): 620.4 MPa
- Max. Hoop Strain (after energization): 0.344 %
- Shear Stresses globally lower than 15 MPa
- However, locally they can reach after energization ~ |30| MPa





Mechanical considerations - Third concept

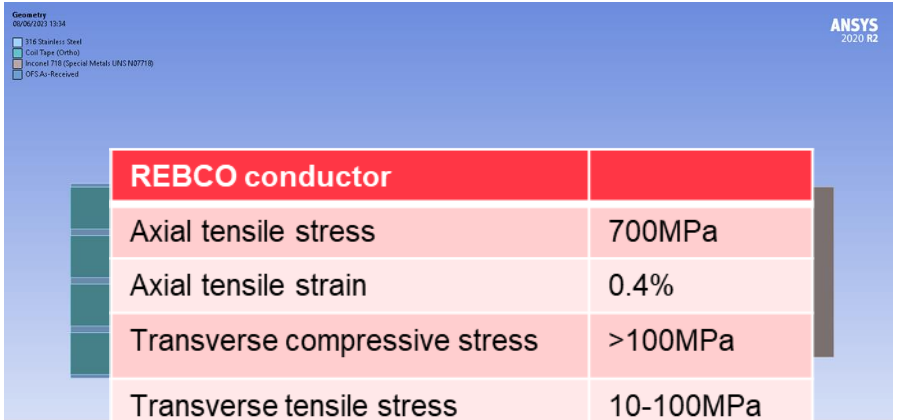
- To limit shear stresses, an intermediate steel shell is added (ID 184 mm; OD 224 mm)
- ~ 150 µm interference with coil pack created by differential heating
- 3 Load Steps: 1. Shell/Coil Interference; 2. Shrink Disk Displacement (2.2 mm); 3. Energization
- Min. Hoop Stress after shrinking: -426 MPa
- Max. Hoop Stress after energization: 598 MPa
- Max. Hoop Strain after energization: 0.332 %
- Local peak shear stress ~ 10 MPa
- Max Shear after energization |9.2| MPa



C. Accettura et al.,Final Cooling Solenoid Progress Meeting, 15/03/2024

Mechanical considerations - Third concept

- To limit shear stresses, an intermediate steel shell is added (ID 184 mm; OD 224 mm)
- ~ 150 µm interference with coil pack created by differential heating
- 3 Load Steps: 1. Shell/Coil Interference; 2. Shrink Disk Displacement (2.2 mm); 3. Energization
- Min. Hoop Stress after shrinking: -426 MPa
- Max. Hoop Stress after energization: 598 MPa
- Max. Hoop Strain after energization: 0.332 %
- Local peak shear stress ~ 10 MPa
- Max Shear after energization |9.2| MPa

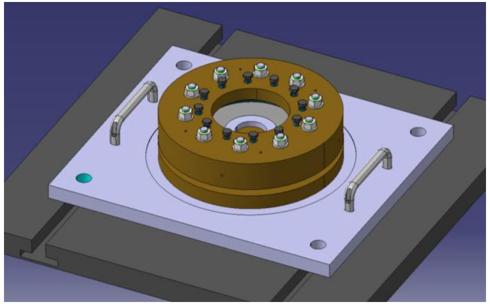


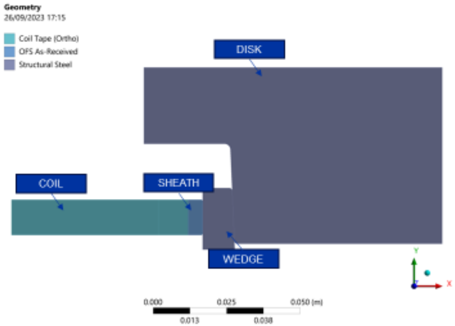
REBCO conductor	
Axial tensile stress	700MPa
Axial tensile strain	0.4%
Transverse compressive stress	>100MPa
Transverse tensile stress	10-100MPa
Max shear stress	>19MPa

- Preliminary is ok, but **limited safety margins**→ Fundamental to have a good understanding of the **material limits** and **failure mode**

C. Accettura et al.,Final Cooling Solenoid Progress Meeting, 15/03/2024

Testing



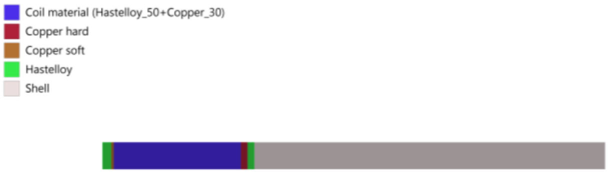


- σ_{hoop}~-600MPa reached on the inner radius of the coil
- The required compression is achieved with 10 M16 bolts
- System equipped with strain gauges and digital image correlation to characterize the coil

Conclusion and next step

- The final cooling solenoid requires a pre-compression to operate at 40T:
  - Shrink fitting, mechanical jigs or a combined solution can provide the required pre-compressions
  - Tape properties impacting the results→ important to benchmark them with experimental tests
  - The design of the inner and outer rings is critical: some possible solutions identified, more modelling work is needed to finalize the design
  - Different FEM models ready to investigate more options
  - Extensive work of design of the tooling for the experimental characterization of the tape

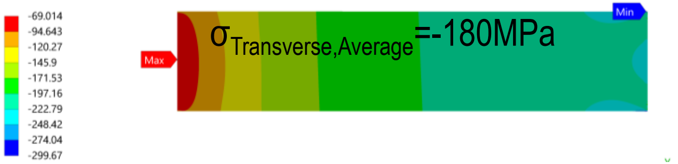
Validity of homogeneous model



Step 1: Shrink fitting (T external shell =250°C)

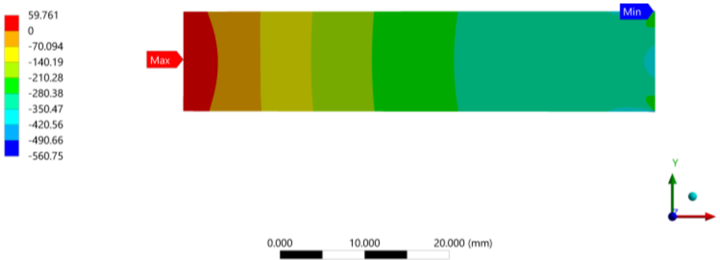
$\sigma_{Transverse,Average}$=-210MPa

Step 2: Cool-down

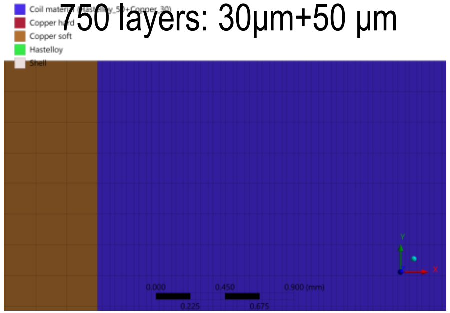


$\sigma_{Transverse,Average}$=-180MPa

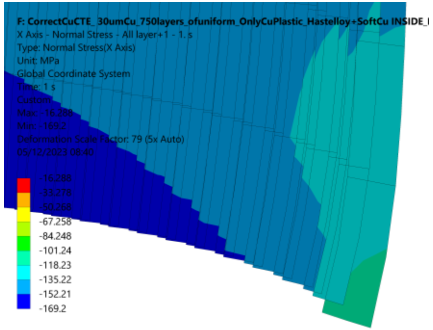
Step 3: Energization



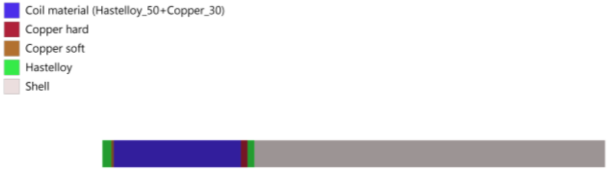
750 layers: 30μm+50 μm



$\sigma_{Transverse,Average}$=-85MPa



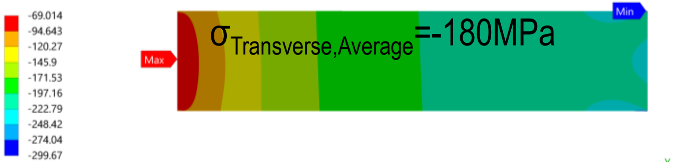
Validity of homogeneous model



Step 1: Shrink fitting (T external shell =250°C)

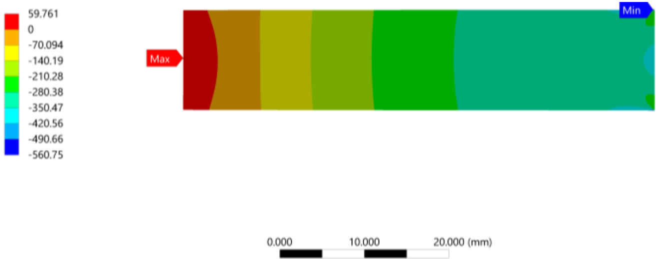
$\sigma_{Transverse,Average}$=-210MPa

Step 2: Cool-down

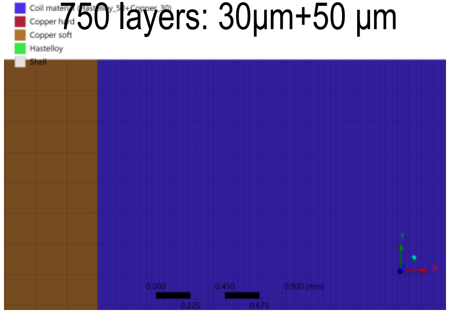


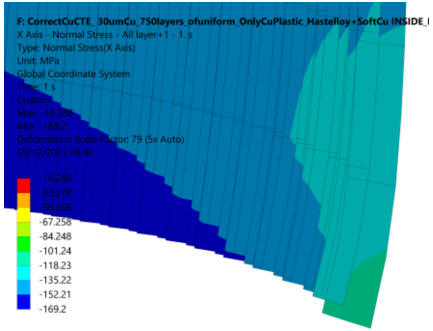
$\sigma_{Transverse,Average}$=-180MPa

Step 3: Energization



750 layers: 30μm+50 μm

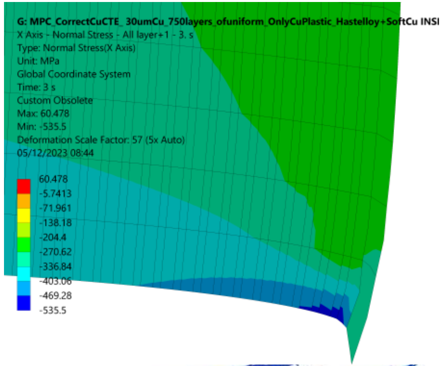




$\sigma_{Transverse,Average}$=-85MPa

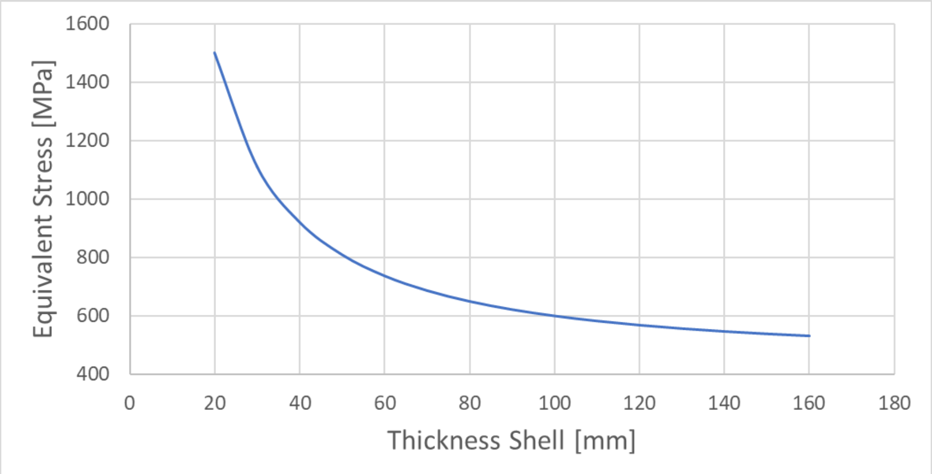
MPC CONTACT

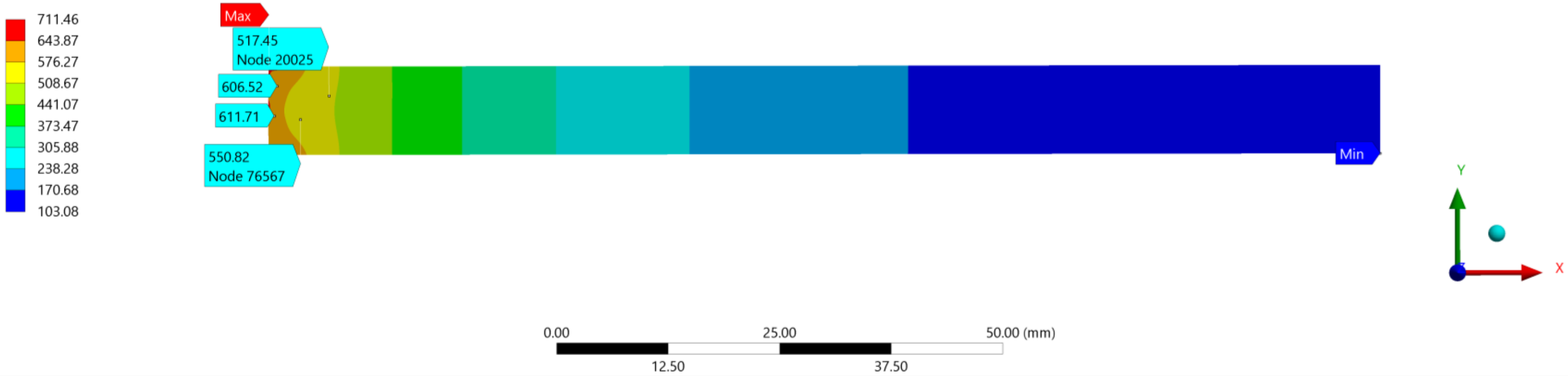
$\sigma_{Transverse,Average}$=-215MPa



Why thick shell?

Before energization



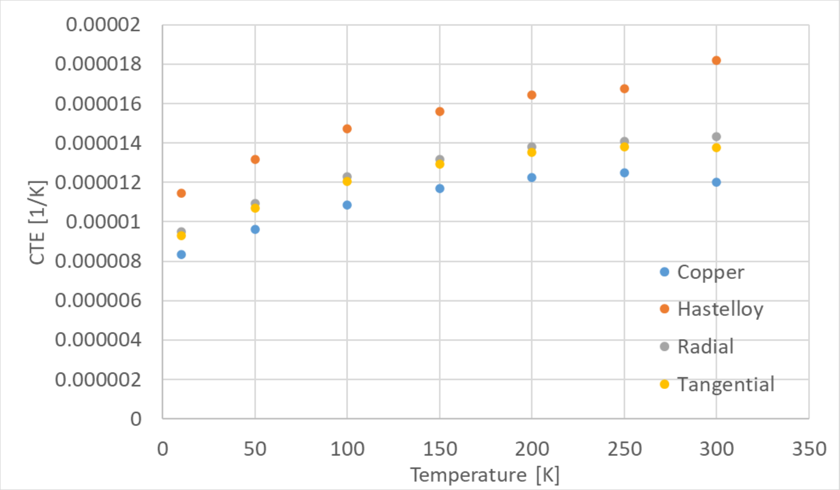


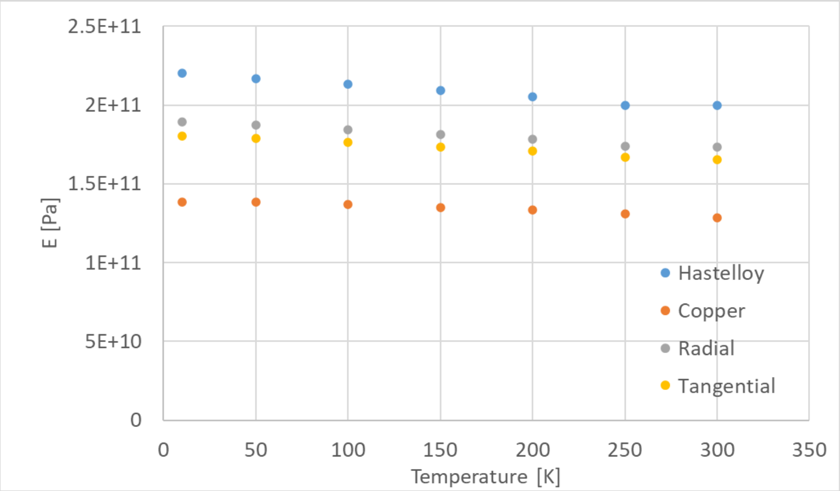
Homogeneization

- Radial direction→ springs in series
- Tangential direction→ springs in parallel

$$E_{radial} = \frac{E_{Cu} \cdot t_{Cu} + E_{Ha} \cdot t_{Ha}}{t_{tot}}$$

$$E_{tangential} = t_{tot} \cdot \left(\frac{t_{Cu}}{E_{Cu}} + \frac{t_{Ha}}{E_{Ha}} \right)^{-1}$$





C. Accettura et al.,Final Cooling Solenoid Pr