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- **HAN, Sang Jin**  
35217 Daejeon (KR)
- **PARK, Ki Bum**  
34120 Daejeon (KR)
- **HWANG, Ho Yeon**  
34199 Daejeon (KR)
- **KWON, Min Sung**  
34006 Daejeon (KR)
- **KIM, Kyung Tae**  
16853 Gyeonggi-do (KR)
- **YEO, Pyeong Mo**  
26464 Gangwon-do (KR)
- **JANG, Jeong Jin**  
26354 Gangwon-do (KR)
- **CHOI, Sang Soon**  
26460 Gangwon-do (KR)

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(71) Applicants:

- **Kepeco Nuclear Fuel Co., Ltd**  
Daejeon 34057 (KR)
- **SHL Co., Ltd.**  
Wonju-si, Gangwon-do 26311 (KR)

(74) Representative: **Peterreins Schley**  
**Patent- und Rechtsanwälte PartG mbB**  
**Hermann-Sack-Strasse 3**  
**80331 München (DE)**

(72) Inventors:

- **PARK, Min Young**  
30150 Sejong-si (KR)

(54) **COMPOSITION OF EXTERNAL LUBRICANT FOR COLD PILGERING**

(57) Disclosed is a composition of a lubricant for cold pilgering of zirconium alloy tubes. More particularly, disclosed is a composition of an external lubricant for cold pilgering of a zirconium alloy cladding tube, the composition exhibiting excellent lubricity and decomposition against microbes.

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**Description**

CROSS REFERENCE TO RELATED APPLICATION

5 **[0001]** The present application claims priority to Korean Patent Application No. 10-2020-0012548, filed February 3, 2020, the entire contents of which is incorporated herein for all purposes by this reference.

BACKGROUND OF THE INVENTION

10 Field of the Invention

**[0002]** The present invention relates generally to composition of a lubricant for cold pilgering of zirconium alloy tubes. More particularly, the present invention relates to a composition of an external lubricant for cold pilgering of a zirconium alloy cladding tube, the composition exhibiting excellent lubricity and rot resistance.

15 Description of the Related Art

**[0003]** In a nuclear fuel assembly, cladding tubes serve to protect  $UO_2$  sintered pellets by separating the  $UO_2$  sintered pellets from cooling water in a core, and prevent radioactive fission products generated from the  $UO_2$  sintered pellets from being released into the cooling water, and also separate the cooling water and the  $UO_2$  sintered pellets from each other to prevent prevents chemical reactions therebetween. As a material of the cladding tube, a zirconium alloy having good corrosion resistance to high-temperature cooling water and low neutron absorption properties is used.

20 **[0004]** A manufacturing process of a general cladding tube involves: removing hafnium (Hf) from zirconium ore; adding several alloy elements to prepare an ingot; subjecting the ingot to hot extrusion to prepare a tube reduced extrusion (TREX); subjecting the TREX to cold working called pilgering and heat treatment repeatedly to reduce the thickness and diameter of the TREX, thereby manufacturing zirconium alloy tubes for nuclear fuel.

25 **[0005]** Cooling lubricants, which are used in shaping the dimensions of zirconium alloy tubes that are frequently used as nuclear fuel cladding tubes and structural materials in nuclear power plants, are used in conjunction with a special method called cold pilgering, which is distinct from manufacture of stainless steel pipes or copper alloy pipes for general industry. In order to control the crystallographic texture of the zirconium alloy, the reduction rate of the cross-sectional area for each pilgering step has to be equal to or greater than approximately 70%, and thus a high load is applied to dies, a mandrel, and a tube. Accordingly, properties such as wear resistance and extreme pressure resistance are required.

30 **[0006]** When cooling lubricants lack these properties, this may promote wear of the dies that influence the quality and dimensions of the outer surface of the tube and the mandrel that influences the quality and dimensions of the inner surface of the tube, causing defects on the inner and outer surfaces of the tube, which may significantly affect life time of the dies and mandrel.

35 **[0007]** Here, in cold pilgering, a dedicated lubricant is used to remove heat generated due to friction and lubrication through oil film formation between the dies, the mandrel, and the tube. However, an existing lubricant cannot exert a sufficient effect when applied to the cladding tube due to outer surface defects due to friction, reduction in life time of the dies, and the like.

40 **[0008]** Additionally, in external cooling lubricants, animal oil and fat are used as base oil, and due to the characteristics of mixing with water, rotting is inevitable. Due to the rotting over time, stability of lubrication quality may be reduced, and odor and harmful substances may be generated, resulting in deterioration of work safety.

45 **[0009]** Therefore, minimizing quality deviation by minimizing deterioration of the degree of rotting over time has a great influence on securing product quality stability.

**[0010]** The foregoing is intended merely to aid in the understanding of the background of the present invention, and is not intended to mean that the present invention falls within the purview of the related art that is already known to those skilled in the art.

50 SUMMARY OF THE INVENTION

**[0011]** Accordingly, the present invention has been made keeping in mind the above problems occurring in the related art, and an objective of the present invention is to provide a composition of a lubricant for cold pilgering of a Zirconium alloy tube and, more particularly, to provide a composition of an external lubricant for cold pilgering of a Zirconium alloy tube, the composition exhibiting improved lubricity and decomposition against microbes.

55 **[0012]** In order to achieve the above objective, according to one aspect of the present invention, there is provided a composition of a lubricant for cold pilgering, the composition including: a base oil; a lubricity enhancer; an anti-wear

agent; and anti-decomposition agent, wherein the lubricity enhancer may be a vegetable wax and may be included in an amount of 2.2 to 2.6% by weight.

[0013] The vegetable wax may be Brazil wax.

[0014] The anti-wear agent may be included in an amount of 0.6 to 1.0% by weight.

[0015] The anti-decomposition agent may be included in an amount of 0.8 to 1.2% by weight.

[0016] The anti-wear agent may include at least one selected from benzenesulfonic acid, C<sub>10</sub> to C<sub>16</sub> alkyl groups, calcium salts, sulfuric acid, and C<sub>16</sub> to C<sub>24</sub> alkyl derivatives.

[0017] The anti-decomposition agent may include at least one selected from 1,2-benzisothiazolin-3-one, potassium hydroxide, sodium hydroxide, ethylene glycol, and dihydrogen oxide.

[0018] The present invention can provide a composition of a lubricant for outer surface of tube during cold pilgering, the composition exhibiting excellent decomposition against microbes thus being capable of long-term use and storage without deterioration in performance due to decomposing, and exhibiting excellent lubricity.

BRIEF DESCRIPTION OF THE DRAWINGS

[0019] The above and other objectives, features, and other advantages of the present invention will be more clearly understood from the following detailed description when taken in conjunction with the accompanying drawings, in which:

FIG. 1 is a photograph illustrating a micro-tapping torque test machine for measuring lubricity of lubricants;

FIG. 2 is a view illustrating data of results of measuring the lubricity of the lubricants using the micro-tapping torque test machine;

FIG. 3 is a photograph illustrating a 4-ball test machine for measuring extreme pressure resistance and wear resistance of lubricants;

FIG. 4 is a photograph illustrating results of a 4-ball test for lubricants according to Comparative Example and Examples;

FIG. 5 is a photograph illustrating results of bacteria/fungi measurement of lubricants according to Comparative Example and Examples;

FIG. 6 is a view illustrating a graph and a table, the graph on the left illustrating a change in pH according to time course of lubricants according to Comparative Example and Examples, and the table on the right illustrating the change in pH according to time course of lubricants according to Comparative Example and Examples.

DETAILED DESCRIPTION OF THE INVENTION

[0020] Hereinafter, the present invention will be described in detail with reference to examples. However, these examples are merely exemplary and are not intended to limit the present invention.

Comparative Example 1 and Examples 1 to 7 - Lubricity Enhancer

[0021]

Table 1

		Comparative Example	Example						
		1	1	2	3	4	5	6	7
Water		57.2	55.4	55.2	55	54.8	54.6	54.4	54.2
Base oil		8.5	8.5	8.5	8.5	8.5	8.5	8.5	8.5
Fatty acid		16	16	16	16	16	16	16	16
PH enhancer		4.7	4.7	4.7	4.7	4.7	4.7	4.7	4.7
Viscosity modifier		4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Lubricity enhancer	A1	0	1.8	2.0	2.2	2.4	2.6	2.8	3.0
Anti-wear agent	A2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2
Anti-decomposition agent	A3	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8

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(continued)

		Compara tive Example	Example						
			1	2	3	4	5	6	7
Other additives	A4	7.6	7.6	7.6	7.6	7.6	7.6	7.6	7.6
(Unit: % by weight) A1: Brazil wax A2: Mixture of benzenesulfonic acid, C10-16-alkyl derivs., and calcium salts A3: Mixture of 1,2-benzisothiazolin-3-one, potassium hydroxide, sodium hydroxide, ethylene glycol, and dihydrogen oxide. A4: Corrosion inhibitor, natural animal fat, animal fatty acid ester, and other additives									

**Comparative Example 2 and Examples 8 to 14 - Anti-wear Agent**

**[0022]**

Table 2

		Compara tive Example	Example						
			2	8	9	10	11	12	13
Water		56.2	55.4	55.2	55.0	54.8	54.6	54.4	54.2
Base oil		8.5	8.5	8.5	8.5	8.5	8.5	8.5	8.5
Fatty acid		16	16	16	16	16	16	16	16
PH enhancer		4.7	4.7	4.7	4.7	4.7	4.7	4.7	4.7
Viscosity modifier		4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Lubricity enhancer	A1	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2
Anti-wear agent	A2	0	0.8	1.0	1.2	1.4	1.6	1.8	2.0
Anti-decomposi tion agent	A3	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8
Other additives	A4	7.6	7.6	7.6	7.6	7.6	7.6	7.6	7.6
(Unit: % by weight)									

**Comparative Example 3 and Examples 15 to 21 - Anti-decomposition Agent**

**[0023]**

Table 3

		Compara tive Example	Example						
			3	15	16	17	18	19	20
Water		55.8	55.4	55.2	55.0	54.8	54.6	54.4	54.2
Base oil		8.5	8.5	8.5	8.5	8.5	8.5	8.5	8.5
Fatty acid		16	16	16	16	16	16	16	16
PH enhancer		4.7	4.7	4.7	4.7	4.7	4.7	4.7	4.7
Viscosity modifier		4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Lubricity enhancer	A1	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2
Anti-wear agent	A2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2
Anti-decomposi tion agent	A3	0	0.4	0.6	0.8	1.0	1.2	1.4	1.6

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(continued)

		Compara tive Example	Example						
		3	15	16	17	18	19	20	21
Other additives	A4	7.6	7.6	7.6	7.6	7.6	7.6	7.6	7.6
(Unit: % by weight)									

**Experimental Example 1 - Measurement of Lubricity and Extreme Pressure Performance**

**[0024]** Measurement of lubricity and extreme pressure performance was performed under conditions of S45C, 600 rpm, 400 N/m, 5.5 mm using a micro-tapping torque test machine. The smaller the value of column max, the smaller the friction and resistance with the machine, and it can be seen that the lubricity and extreme pressure performance were increased. Column mean% is a value indicating the average of data when one product is designated as 100, and it can be seen that the lubricity and extreme pressure performance were relatively decreased when exceeded 100. The experiment was conducted using Comparative Example 1 and Examples 1 to 7, and the results are shown in the table below.

Table 4

	Compara tive Example 1	Example 1	Example 2	Example 3	Example 4	Example 5	Example 6	Example 7
Column MAX(Y axis)	260.0	260.0	260.0	240.0	249.0	228.0	229.0	250.0
Column Mean%	100.0	99.8	99.5	95.2	97.1	93.3	95.9	97.2

**[0025]** Through comparison of Comparative example and Examples, it can be seen that when vegetable wax is added, the extreme pressure performance and lubricity were increased. Additionally, through comparison of Examples, it can be seen that the extreme pressure performance and lubricity were significantly increased when the vegetable wax was added in an amount of equal to or greater than 2.2, and the extreme pressure resistance and lubricity were significantly reduced when the vegetable wax was added in an amount of equal to or greater than 2.6.

**Experimental Example 2 - Measurement of Wear Resistance**

**[0026]** Measurement of wear resistance was performed for 30 minutes under conditions of 75° C, 1200 rpm, and 50kg using a 4-ball test machine, and the results are shown in the table below.

Table 5

	Compara tive Example 2	Example 8	Example 9	Example 10	Example 11	Example 12	Example 13	Example 14
Wear scar value (mm)	1.35	1.10	1.05	0.90	0.88	0.88	0.90	0.92

**[0027]** The smaller the wear scar (mm), the smaller the wear rate. Through comparison of Comparative Example and Examples in the table above, it can be seen that the wear resistance was increased when an anti-wear agent was added. Additionally, it can be seen that the wear rate was significantly reduced when a wetting additive was added in an amount of 1.2% by weight, and the wear rate was increased again when the wetting additive was added in an amount of equal to or greater than at 1.6% by weight.

**Experimental Example 3 - Measurement of Anti-decomposition performance**

**[0028]** For Comparative Example 3 and Examples 15 to 21, measurement of anti-decomposition performance was

performed using bacteria and fungi, and the results are shown in FIGS. 5 and 6. After a fixed amount of used oil (1 ml) was placed into a bacteria/fungi culture medium kit, emulsion was spread using a spreader and then placed into a shaking incubator to incubate bacteria at 35°C. After 48 hours, bacteria/fungi occurrence was measured, and the anti-decomposition performance was evaluated through the number of dots. Referring to FIG. 6, it can be seen that pH was stabilized when using an anti-decomposition agent. In particular, it can be seen that even if the anti-decomposition agent was added in an amount of equal to or greater than 1.2% by weight, this did not affect the change in pH.

**[0029]** Referring to FIG. 5, it can be seen that bacteria and fungi did not occur when the anti-decomposition agent was added in an amount of equal to or greater than 0.8% by weight.

## Claims

1. A composition of a lubricant for cold pilgering, the composition comprising:

a base oil;  
a lubricity enhancer;  
an anti-wear agent; and  
an anti-decomposition agent,  
wherein the lubricity enhancer is a vegetable wax and is included 2.2 to 2.6% by weight.

2. The composition of claim 1, wherein the vegetable wax is Brazil wax.

3. The composition of claim 1, wherein the anti-wear agent is included 0.6 to 1.0% by weight.

4. The composition of claim 1, wherein the anti-decomposition agent is included 0.8 to 1.2% by weight.

5. The composition of claim 1, wherein the anti-wear agent comprises at least one selected from benzenesulfonic acid, C<sub>10</sub> to C<sub>16</sub> alkyl groups, calcium salts, sulfuric acid, and C<sub>16</sub> to C<sub>24</sub> alkyl derivatives.

6. The composition of claim 1, wherein the anti-decomposition agent comprises at least one selected from 1,2-benzisothiazolin-3-one, potassium hydroxide, sodium hydroxide, ethylene glycol, and dihydrogen oxide.

7. A method of cold pilgering structural materials, in particular zirconium alloy tubes for nuclear fuel, comprising applying a composition of a lubricant for cold pilgering as defined in any of claims 1 to 6.

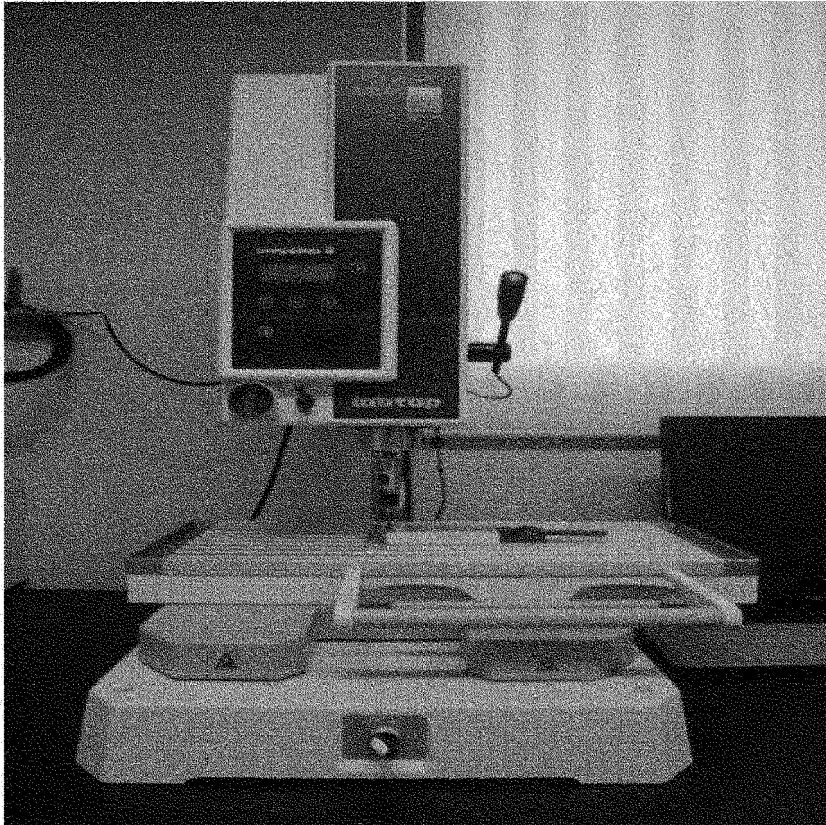


FIG. 1

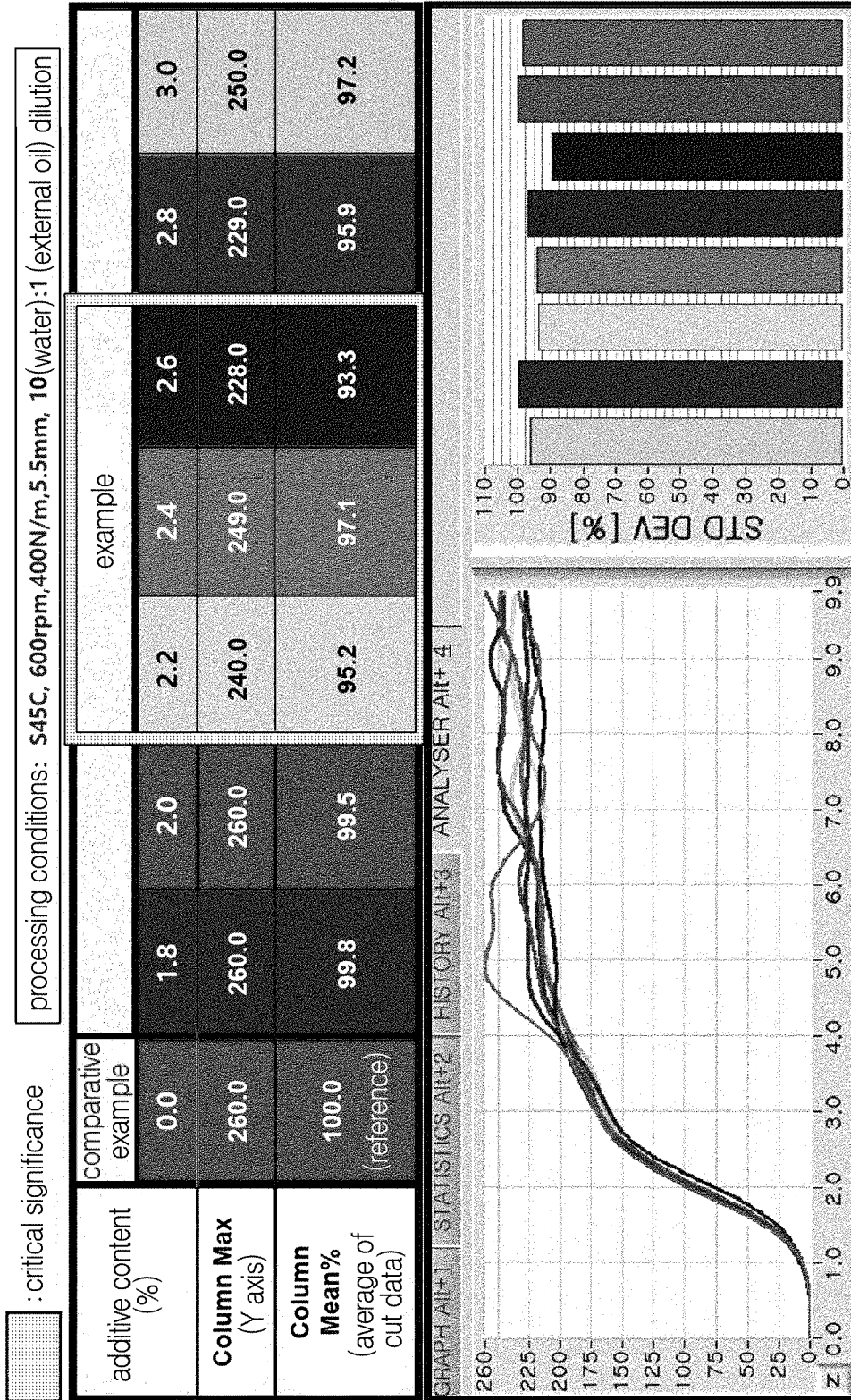


FIG. 2



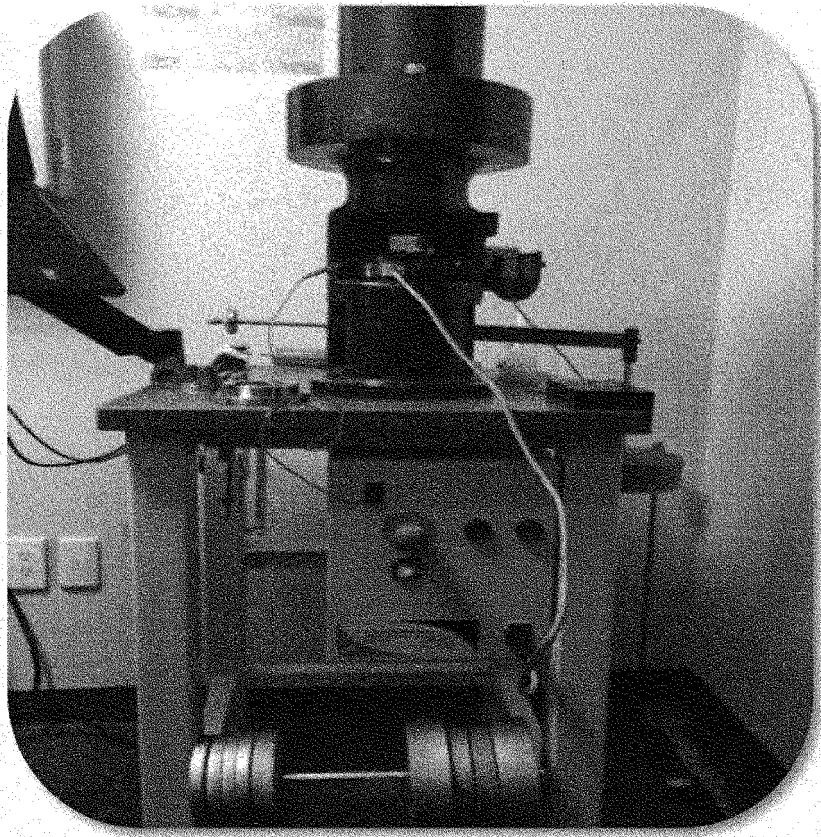


FIG. 3

<b>4-BALL Test Condition</b>		: critical significance										processing conditions: 10 water 1 (external oil) dilution			
		example										example			
		comparative example	0.8	1.0	1.2	1.4	1.6	1.8	2.0						
<b>EP</b> (kgf/cm <sup>2</sup> )	40°C, 10 sec at 1760 rpm	126 PASS	250 PASS	250 PASS	250 PASS	250 PASS	250 PASS	250 PASS	250 PASS	250 PASS	250 PASS	250 PASS	250 PASS		
<b>Wear</b> (mm)	75°C, 30 min, 50 kg at 1200 rpm	1.35	1.10	1.05	0.90	0.88	0.88	0.90	0.88	0.90	0.92				
<b>Wear</b>															

FIG. 4

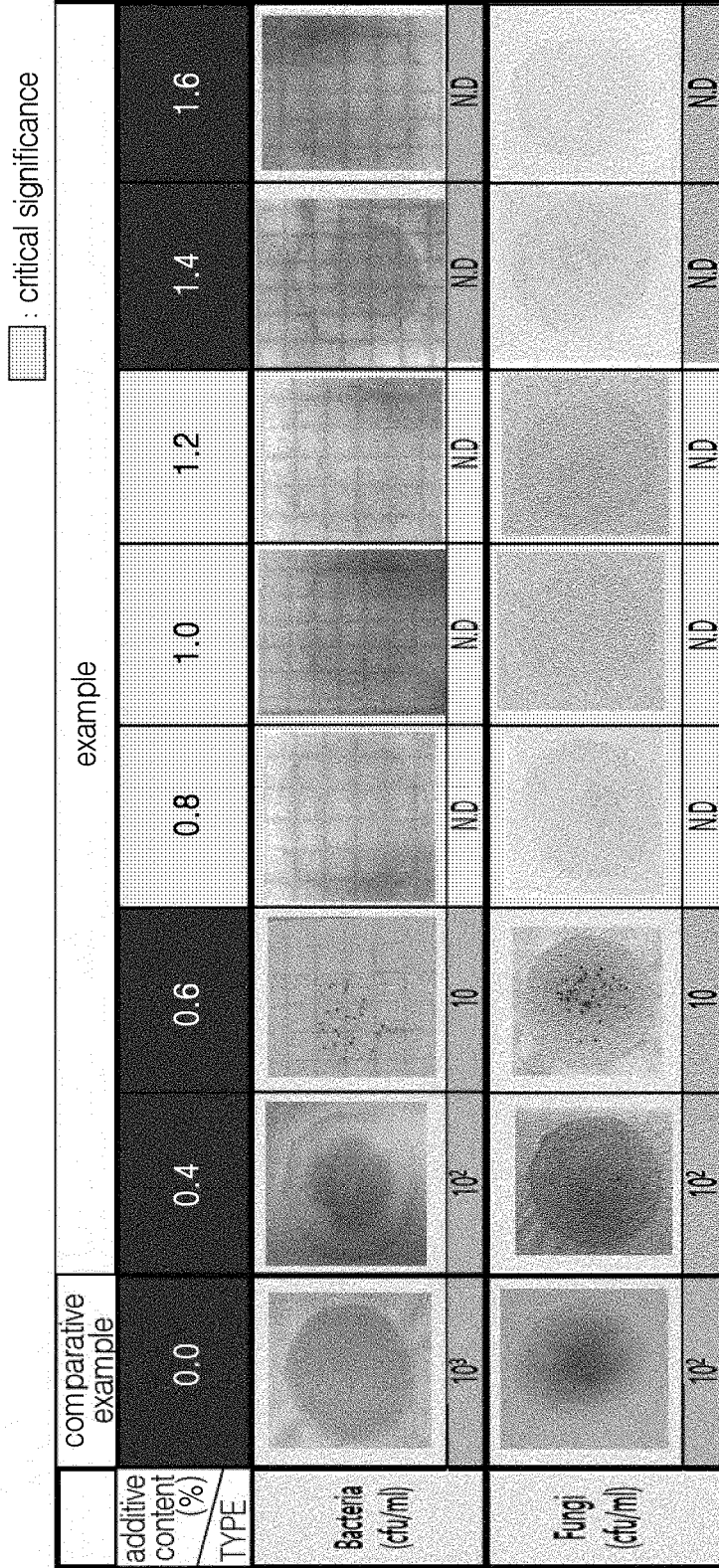
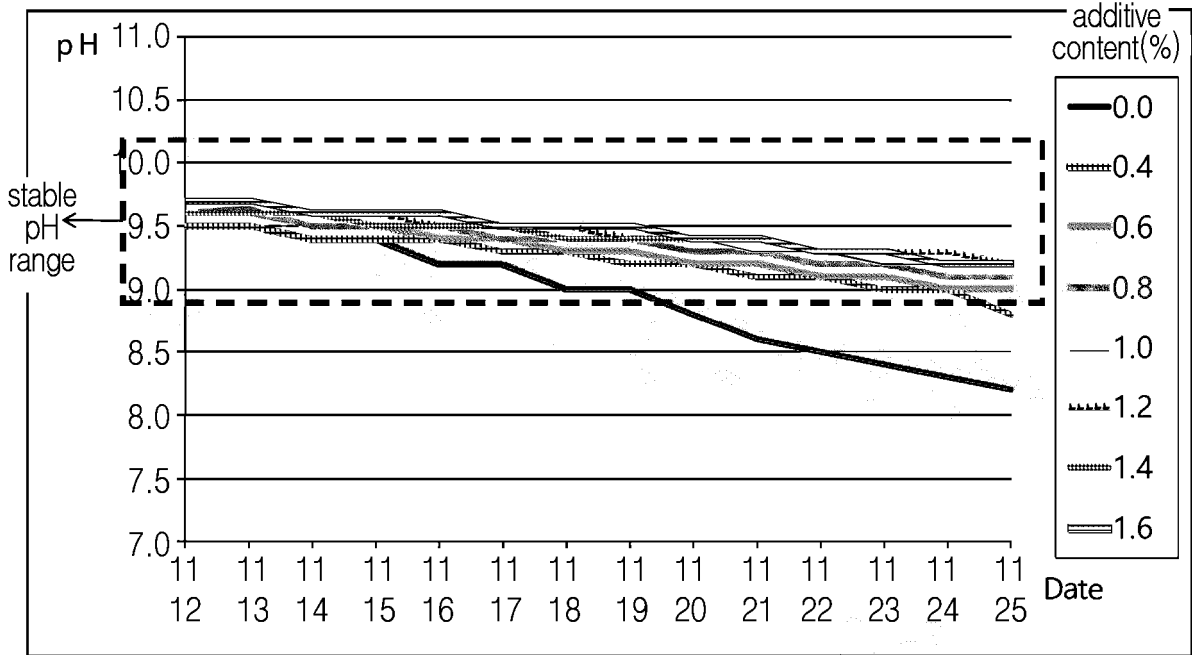


FIG. 5



critical significance

	0.0	0.4	0.6	0.8	1.0	1.2	1.4	1.6
11.12	9.5	9.5	9.6	9.6	9.6	9.6	9.6	9.7
11.13	9.5	9.5	9.6	9.6	9.6	9.6	9.6	9.7
11.14	9.4	9.4	9.5	9.5	9.6	9.6	9.6	9.6
11.15	9.4	9.4	9.5	9.5	9.5	9.6	9.5	9.6
11.16	9.2	9.4	9.4	9.5	9.5	9.5	9.5	9.6
11.17	9.2	9.3	9.4	9.4	9.5	9.5	9.5	9.5
11.18	9.2	9.3	9.3	9.4	9.4	9.5	9.4	9.5
11.19	9.0	9.2	9.3	9.4	9.4	9.4	9.4	9.5
11.20	8.8	9.2	9.2	9.3	9.4	9.4	9.4	9.4
11.21	8.6	9.1	9.2	9.3	9.3	9.4	9.4	9.4
11.22	8.5	9.1	9.1	9.2	9.3	9.3	9.3	9.3
11.23	8.4	9.0	9.1	9.2	9.2	9.3	9.3	9.3
11.24	8.3	9.0	9.0	9.1	9.2	9.3	9.2	9.2
11.25	8.2	8.8	9.0	9.1	9.2	9.2	9.2	9.2

FIG. 6



EUROPEAN SEARCH REPORT

Application Number  
EP 20 21 5347

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A	* claims 1, 2, 6, 10; p. 4, l. 31-36 * -----	2	ADD. C10N30/06 C10N30/16 C10N40/20
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			TECHNICAL FIELDS SEARCHED (IPC)
			C10M C10N
The present search report has been drawn up for all claims			
Place of search <b>Munich</b>		Date of completion of the search <b>26 May 2021</b>	Examiner <b>Greß, Tobias</b>
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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ANNEX TO THE EUROPEAN SEARCH REPORT  
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5 This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.  
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26-05-2021

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