

## **Scientific Program**

**of the Seventh International Conference on**

# **Solidification and Gravity**

**Sept 3-6, 2018 Miskolc-Lillafüred**



## **Organized by:**

Hungarian Academy of Sciences – University of Miskolc  
Materials Science Research Group  
Miskolc Committee of Hungarian Academy of Sciences

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Chairman	A. Roósz
Co-chairmen	Z. Fan
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Members	Zs. Veres, G. Karacs, M. Svéda T. Mende

## *2 September, Sunday*

14:00 - 22:00 **Conference Office Open**

18:00 - 22:00 **Dinner, Happy hour**

## *3 September, Monday*

10:00 - 10:20 **Opening ceremony**  
Chairman: A. Roósz

10:20 - 10:50 **Plenary lecture**  
**Wim Sillekens:** Space for science: ESA's microgravity research programme on materials science

10:50 - 11:20 **Plenary lecture**  
**Martin Glicksman:** Melting in Microgravity: How crystallite shape changes led to new insights about interface dynamics

11:20 - 11:50 **Plenary lecture**  
**U. Hecht at al:** The ESA-MAP project „GRADECET” - An overview of the joint research on solidification of TiAl-based alloys under hypergravity and microgravity conditions

11:50 - 12:20 **Plenary lecture**  
**Laszlo Granasy:** Phase-field modeling of complex polycrystalline structures

12:20 - 14:00 **Lunch**

	<b>Plenary lecture</b> Chairman: Hideyuki Yasuda <b>Silvere Akamatsu:</b> Real-time dynamics of rod-like eutectic growth patterns on board the Iss: first results from TRANSPARENT ALLOYS
14:00 - 14:30	
14:30 - 14:40	<b>Break</b>
	<b>Session A</b> <b>In situ observation I</b> Chairman: Hideyuki Yasuda
14:40 - 15:00	<b>Turlough Hughes, Anthony</b> <b>Robinson, Shaun McFadden:</b> In-situ observation of the effects of gravity direction on directional solidification of the transparent alloys NPG-35wt%-DC
15:00 – 15:20	<b>Fatima Mota, Jorge Pereda, Younggil Song, Damien Tourret, Rohit Trivedi, Alain Karma, Nathalie Bergeon:</b> Interface dynamics and microstructure selection during directional solidification of transparent bulk alloy conducted on DECLIC-DSI
15:40- 16:00	<b>Laszlo Sturz, Martin Hammacher, Janine Eiken, Gerhard Zimmermann:</b> In-situ observation of growth and interaction of equiaxed dendrites in microgravity
16:00 - 16:20	<b>Shaun McFadden, Robin Mooney:</b> The nucleation Progenitor Function (NPF) approach: An alternative approach to modelling equiaxed solidification
16:20 – 16:50	<b>Session B</b> <b>Phase field modelling</b> Chairman: Martin Glicksman
	<b>Peter C. Bollada, Peter K. Jimack, Andrew M. Mullis:</b> Free energy vs. Grand Potential Energy formulations in phase field modelling of alloy solidification
	<b>Tadej Dobravec, Bostjan Mavric, Bozidar Sarler:</b> Meshless phase field modeling of dendritic growth
	<b>Ahmed Kaci Boukellal, Jean-Marc Debierre:</b> Equiaxed growth of Al-Cu denrites: 3D phase-field simulation
	<b>Tamás Pusztai, Bálint Korbuly, Hervé Henry, Mathis Plapp, Markus Apel, László Gránásy:</b> Grain coarsening in two-dimension orientation field-based phase-field models
	<b>Coffee break</b>

## Session A Casting

Chairman: Sonja Steinbach

## Session B Dendritic Solidification I

Chairman: Wim Sillekens

- 16:50 - 17:10 **Michael Bernhard, Cristian Bernhard, Peter Presoly, Dali You:** An Alternative approach for the experimental verification of microsegregation models using an in-situ hot tensile test during solidification of steel

- 17:10 - 17:30 **Waldemar Wolczynski, Anna A. Ivanova, Piotr Kwapisinski, Krzysztof Szwiertnia:** Effect of Pulling Rate on the Structural Zones Localization in the Continuously Cast Brass Ingots

- 17:30 – 17:50 **Lukasz Rogal, Boguslaw Baran, Lidia Litynska-Dobrzanska:** Fabrication and properties of magnesium matrix composite obtained using thixomolding technology

- 17:50 - 18:10 **Attila Diószegi, Péter Svidró:** Pressure driven undercooling at solidification of hypoeutectic cast iron

- 18:10 - 18:30 **Akash Pakanati, Mohammed M'Hamdi, Hervé Combeau, Miha Zaloznik:** 3D modelling of the impact of inlet flow on microsegregation formation in DC casting of aluminium alloys accounting for grain morphology and transport

- Bruno Jacques, Jacques Lacaze, Thierry Mazet, Michael Vynnicky, Olivier Dezellus:** Effect of temperature and heating rate on dissolution of a 3003 core by a 4004 clad during vacuum brazing

- Juan Carlos Hernando, Attila Diószegi:** On the Primary Solidification of Fe-C Alloys: Morphological Evolution of Primary Austenite During Coarsening

- Elif Yilmaz, Emine Acer Erol, Harun Erol, Mehmet Gündüz:** Directional Solidification of the Al-0.25 wt% Zr Overhead Line Conductor

- Peter Presoly, Michael Bernard, Dali You, Christian Bernhard:** High concentrations at the final solidification of advanced steel: Thermodynamic evaluation of replicated „segregation-samples” by means of DTA/DSC-measurements

19:00 - 23:00

**Conference Dinner at Vigadó**

**4 September, Tuesday**

## **Microgravity**

Chairman: Ulrike Hecht

### **Plenary lecture**

08:00 - 08:30    **Gerhard Zimmermann at al:** Columnar and equiaxed solidification within the framework of the ESA MAP project CETSOL

### **Plenary lecture**

08:30 - 09:00    **Yves du Terrail:** Multy mesh modelling

### **Plenary lecture**

09:00 – 09:30    **Fan Zhongyun:** Heterogeneous nucleation, grain initiation and grain refinement

### **Plenary lecture**

09:30 – 10:00    **Markus Rettenmayr at al:** Solidification of Al-Ni melts under terrestrial and microgravity conditions

10:00 - 10:30

## **Coffee break**

### **Session A**

#### **Modelling, simulation I**

Chairman: Menghuai Wu

### **Session B**

#### **Grain refinement I**

Chairman: László Gránásy

#### **Martin Cisternas, Miha Zaloznik,**

10:30 – 10:50    **Hervé Combeau:** Macroscopic modeling of solidification of TiAl alloys in hypergravity    **H. Men, Z. Fan:** Heterogeneous Nucleation by Structural Templating

#### **Mramor Katarina, Vertnik Robert, Sarler Bozidar:** Numerical modelling

10:50 – 11:10    of the effect of electromagnetic stirring direction in continuous casting of steel billets    **C.M Fang and Z. Fan:** A first-principles study of chemical interaction between the substrate and the liquid on prenucleation

	<b>Cs. Nagy, O. Budenkova, Y. du Terrail, A. Rónaföldi, A. Roósz:</b> Numerical simulation series for the investigation and validation of the Lorenz force field in bidirectional travelling magnetic field via thermal gradient shift effect	<b>F. Gao, Z. Fan:</b> grain initiation behavior during solidification
11:10 – 11:30		
11:30 – 11:50	<b>Can Huang at al:</b> Gravity Dependent Columnar-to-Equiaxed Transition in TiAl alloys: Solidification of Ti-46Al-8Nb in hyper gravity and Multi-physics modelling	<b>Z. P. Que, Y. Wang, Z. Fan:</b> A novel grain refiner for effective grain refinement Al- alloys
11:50 – 12:10	<b>László Rátkai, Tamás Pusztai, László Gránásy:</b> Phase-field modeling of mobile dendrites in melt flow	
12:10 - 14:00	<b>Lunch</b>	
14:00 - 14:30	<b>Plenary lecture</b> Chairman: Henri Nguyen-Thi <b>Hideyuke Yasuda, Yuta Tomiyori, Takuya Kawarazaki, Yuichi Kato, Kohei Morishita:</b> Characterization of dendrite shape evolution in Fe-C system by using time-resolved X-ray tomography	
14:30 – 14:40	<b>Break</b>	

**Session A**  
**Modelling, simulation II**  
Chairman: Peter Galenko

14:40 - 15:00

**Tao Wang, Olga Budenkova, Yves Delonnoy, Yves Fautrelle, Engang Wang:** A 3-phase equiaxed solidification numerical model for binary alloy coupling macroscopic transport and grain growth

15:00 - 15:20

**Ayoub Aalilila, Elie Hachem, Charles-André Gandin:** Numerical simulation of chill cooling and solidification of a levitated steel droplet in microgravity

15:20 – 15:40

**H. Tetlow, Z. Fan:** Monte Carlo Simulations of Chemical Segregation at the liquid/substrate interface

15:40 – 16:00

**Min Yang, Jun Zhang, Hua Wei, Lin Liu:** Phase field study on microstructure evolution and creep property in nickel-base superalloys

16:00 – 16:30

**Coffee break**

16:30 – 17:00

**Plenary lecture**  
**Chairman:** Gerhard Zimmermann  
**Damien Tourret ,Sabine Ziri, Laszlo Sturz, Alandre Viardin, Mihail Zaloznik,:** A quantitative benchmark of multiscale models for dendritic growth

17:00 - 17:10

**Session B**  
**In situ observation II**  
Chairman: Henri Nguyen-Thi

**Guillaume Reinhart, Hadjer Soltani, Lucas Julien, Mohamed Cherif Benoudia, Moussa Zahzouh, Henri Nguyen-Thi:** Analysis by in situ X-radiography of the impact of growth velocity and temperature gradient on the grain structure formation during solidification of refined Al-20wt.%Cu alloy

**Florian Kargl, Maike Becker, Joerg Drescher, Mareike Wegener, Christoph Dressinacker:** Equiaxed dendrite growth in non-refined Al-base alloys in real time

**Laszlo Sturz, Angelos Theofilatos:** Comparison of x-ray radiography of equiaxed alloy solidification in grain-refined Al-3.5wt-%Ni with dendrite needle network modelling

**Virkeshwar Kumar, Atul Srivastava, Shyamprasad Karagadde:** Real-time and full-field quantification of buoyant convection during multi-component solidification

**Break**

## Session A

### Modelling, simulation III

Chairman: Markus Rettamayr

- 17:10 - 17:30 **Hao Shi, Houfa Shen:** Numerical Simulation of Heat Transfer and Fluid Flow in Electroslag Remelting Process

- 17:30 – 17:50 **Daniel Molnar, David Halapi, Marianna Bubenko:** The Simulation of Special Gravity Filling Conditions

- 17:50 – 18:10 **Bostjan Mavric, Tadej Dobravec, Robert Vertnik, Bozidar Sarler:** Investigation of the effect of asymmetric thermal conditions on stresses during continuous casting of steel with the use of meshless travelling-slice model

18:10 - 19:30

## Dinner

19:30 - 23:00

### Social event: Cave Bath, Miskolc-Tapolca

## Session B

### Dendritic solidification II

Chairman: Gerhard Zimmermann

- Hannes Engelhardt, Dorothea Mey, Markus Rettenmayr:** Tunable concentration gradients generated by controlled changes in the solidification regime

- Rahul M R, Sumanta Samal, Gandham Phanikumar:** Undercooling studies and growth velocity measurement on multi-component FeCuNi{X} alloys

- Stefanie Koch, Peter Galenko, Olga Shuleshova, Raphael Kobold, Markus Rettenmayr:** Solidification behavior and microstructure analysis of ternary Zr.Cu.(Al<sub>6</sub>Ni) alloys

**5 September, Wednesday**

## **Forced convection I**

Chairman: Damien Tourret

### **Plenary lecture**

08:00 - 08:30 **Sonja Steinbach at al:** The effect of magnetically controlled fluid flow on microstructure evolution in cast technical Al- alloys: The MICAST project

### **Plenary lecture**

08:30 - 09:00 **Peter Galenko:** Effect of forced convection on dendritic growth: theoretical modeling and analysis of recent experimental results

09:00 - 09:20 **Natalia Shevchenko, Olga Keplinger, Sven Eckert:** Investigations of forced flow effects on dendritic solidification

09:20 - 09:40 **Haijie Zhang at al:** Numerical simulation of fluid flow in the mushy zone under rotation magnetic field: influence of permeability

09:40 - 10:00 **Alexandre Viardin at al:** Phase-field modeling of melt flow and directional solidification in Ti48Al alloy

10:00 - 10:30

## **Coffee break**

## **Forced convection II**

Chairman: Waldemar Wolczynski

### **Plenary lecture**

10:30 - 11:00 **Henri Nguyen-Thi at al:** In-situ analysis of thermoelectric magnetic effect by synchrotron X-radiography during directional solidification under static magnetic field

11:00 - 11:20 **Injes Oliveira at al:** The effect of electromagnetic stirring during solidification of Co-Cr alloys

11:20 - 11:40 **Dirk Räßiger, Bernd Willers, Sven Eckert:** Influence of Al-alloy composition on the potential of forced convection to reduce grain size and prevent macrosegregation

11:40 – 12:00 **Yves Du Terrail Couvat, Olga Budenkova, Thiago Takamura Yanaguissava, Annie Gagnoud:** FEM Magneto-thermo-electric modeling around a solid grain during alloy solidification under uniform AC/DC magnetic field

12:00 - 14:00

## **Lunch**

### **Plenary lecture**

14:00 - 14:30

Chairman: Francisco Gracia-Moreno

**Joshua Miller, Sonja Steinbach, Laszlo Sturz, Gerhard Zimmermann, Nils**

**Warnken:** Large Scale 3D tomography analysis of dendritic arrays in Al-10wt%Cu solidified under changing withdrawal rates

14:30 - 14:40

### **Break**

#### **Session A**

#### **Compound Solidification**

Chairman: Francisco Gracia-Moreno

14:40 – 15:00

**Naved Hussain, Andrew M Mullis:**  
Microstructure Characterisation of  
Drop tube Processed SiGe  
Semiconductor alloy

15:00 - 15:20

**Gregorz Boczkal, Paweł Palka,  
Wojciech Spisak, Andrej Chiebicki:**  
Morphology of bismuth precipitates in  
Zn-Bi single crystal for bactericidal  
applications

15:20 – 15:40

**Dongmei Lui, Markus Rettemayr:**  
Applying directional solidification to  
Cu doped Bi<sub>2</sub>Te<sub>3</sub> thermoelectric  
materials for enhanced performance

15:40 – 16:00

16:00 – 17:30

### **Poster session**

17:30 - 23:00

### **Social event: Wine tour to Tokaj region**

#### **Session B**

#### **Grain refinement II**

Chairman: Andrew Mullis

**F. Gao, Z. Fan:** Effect of  
agglomeration of potent nucleant  
particles on grain size in the as-cast  
microstructure

**Jian Gu, Yuanding Huang, Karl  
Ulrich Kainer, Norbert Hort:** Roles of  
Mn in refining the grains of magnesium  
alloys with SiC inoculations

**Feng Wang, Zhongyun Fan:**  
Heterogeneous nucleation on oxide in Al  
alloys

**Z. Fan, H.-T. Li, J. B. Patel:** Grain  
refinement of light alloys without grain  
refiners

*6 September, Thursday*

## **Eutectic, peritectic, monotectic, foam I**

Chairman: Silvere Akamatsu

### **Plenary lecture**

09:00 - 09:30 **Francisco Gracia-Moreno, Tillmann Robert Neu, Paul Hans Kamm, Felix Bülk, Stefan Hutzler, John Banhart:** Overview of the  $\mu$ -Foam ESA MAP project

### **Plenary lecture**

09:30 - 10:00 **Andrew Mullis, Aluwatoyin Jegede and Robert F Cochrane:** Reduced Gravity Processing of Cu-Co Metastable Monotectic alloy

### **Plenary lecture**

10:00 - 10:30 **Menghuai Wu:** A numerical study on the role of fragmentation in the as-cast structure

10:30 - 11:00

## **Coffee break**

## **Eutectic, peritectic, monotectic, foam II**

Chairman: Zongyun Fan

11:00 - 11:20 **Rahul M R, Reliance Jian, Sumanta Samal, Gandham Phanikumar:** Microstructure evolution and mechanical properties of Co-Fe-Ni-Ti-V eutectic high entropy alloys

11:20 - 11:40 **Johann Peter Mogeritsch, Tanja Peifer, Andreas Ludwig:** Investigation on the Liquid Flow ahead of the Solidification Front During the Formation of Peritectic Layered Solidification Structures

11:40 - 12:00 **Dandan Zhao, Jiarong Gao, Dirk Holland-Moritz, Matthias Koble:** Liquid phase separation and rapid solidification in undercooled Ti60Y40 alloys

12:00 - 12:20 **Zsolt Veres, Arnold Rónaföldi, Kassab Al-Omari, András Roósz:** The effect of forced melt flow induced by rotating magnetic field on the structure of Al-Si eutectic

12:20 - 12:40

## **Closing remarks**

12:40 - 14:00

## **Lunch**

14:00 - 17:30

## **MICAST Meeting**

14:00 - 17:30

## **GRADECET Meeting**

## Poster Session

- (1) **Hadi Barati, Menghuai Wu, Abdellah Kharicha, Andreas Ludwig:** Discussion on possible solidification during SEN clogging in steel continuous casting
- (2) **Antonia Betzou, Michael Auinger, Sridhar Seetharaman, Begona Santillana, Prakash Sriringam:** Thermophysical Properties of Electrical Steels under Microgravity conditions
- (3) **Bogdan Borislavov Nenchev, Simon Gill:** Simulation of mechanical deformation during dendritic solidification
- (4) **Dora Janovszky, Ferenc Kristaly, Tamas Miko, Adam Racz, Maria Sveda, Anna Sycheva, Tomasz Koziel:** Phase transformation and morphology evolution of Ti50Cu25Ni20Sn5 during mechanical milling at room temperature and -78 °C
- (5) **M. Sveda, A. Sycheva, A. Ronafoldi, A. Roosz:** Effect of Travelling Magnetic Field on the Solidified Structure of Peritectic Sn–Cd Alloy
- (6) **Daniel Molnar, Adam Kiss, Csaba Majoros:** Simulation of the High Pressure Die Casting Process
- (7) **Gábor Gyarmati, György Fegyverneki, Tamás Mende, Monika Tokár:** The Melt Cleaning Efficiency of Fluxes with Different Physical and Chemical Properties
- (8) **Zoltán Kéri, György Kapitay:** Removal of oxide skin from molten aluminum surface
- (9) **Arnold Rónaföldi, András Roósz:** Effect of grain refinement and the solid/liquid interface velocity on the microstructure of Al-20wt% Cu alloy
- (10) **Jenő Kovács, Arnold Rónaföldi, Árpád Kovács, András Roósz:** The effect of strong melt flow induced by the rotating magnetic field on the structure of Al6Si4Cu alloy
- (11) **Boštjan Mavrič, Tadej Dobravec, Robert Vertnik, Božidar Šarler:** Investigation of the effect of asymmetric thermal conditions on stresses during continuous casting of steel with the use of meshless travelling-slice model
- (12) **Johann P. Mogeritsch, Andreas Ludwig:** Investigation on the Binary Organic Components TRIS-NPG as Suitable Model Substances for Metal-Like Peritectic Solidification
- (13) **Johann P. Mogeritsch, T. Pfeiler, A. Ludwig:** Metastable Solidification of Composites: Novel Peritectic Structures and In-Situ Composites (METCOMP)
- (14) **P.K. Galenko, D.V. Alexandrov, D.A. Danilov, K. Reuther, M. Rettenmayr, D.M. Herlach:** Modeling of dendritic growth under earthly and reduced gravity conditions
- (15) **Markus Rettenmayr:** Solidification of Al-Ni melts under microgravity conditions
- (16) **Natalia Shevchenko, Joerg Grenzer, Olga Keplinger, Hieram Neumann-Heyme, Alexander Rack, Kerstin Eckert, Sven Eckert:** High resolution synchrotron imaging of dendritic coarsening in Ga – In alloys

- (17) **Patrick Fopp, Matthias Kolbe, Florian Kargl, Raphael Kobold**: Effect of the hypercooling limit on the crystal growth velocity in metallic melts
- (18) **Grzegorz Boczkal**: Supergravity 600G effect on crystallization of Zn-25%Bi monotectic alloy
- (19) **Virkeshwar Kumar, Atul Srivastava, Shyamprasad Karagadde**: Plausible Evolution Cycle for Buoyant Double diffusive convection
- (20) **Sara Battaglioli, Shaun McFadden, Anthony Robinson**: A front tracking model of directional solidification under forced convection conditions as part of the GRADECET project
- (21) **B. Jiang, H. Men, Z. Fan**: Effect of surface roughness on prenucleation
- (22) **C. M. Fang, Z. Fan**: An ab initio study of the potency of MgO particles for heterogeneous nucleation of light metals
- (23) **F. Gao, Z. Fan**: Grain initiation behaviour and its effect on grain refinement
- (24) **Feng Wang, Hu-tian Li, Zhongyun Fan**: Effect of high shear on the grain refinement of Al-alloys
- (25) **H. Men, Z. Fan**: Effect of positive lattice misfit on prenucleation
- (26) **Shihao Wang, Yun Wang, Quentin Ramasse, Zhongyun Fan**: Segregation of Y at the Mg/MgO interface and its effect on grain refinement
- (27) **Z. P. Que, Y. Wang, Z. Fan**: Compositional templating for heterogeneous nucleation of intermetallic compounds
- (28) **Z. P. Que, Y. Wang, X. R. Zhou, Z. Fan**: Heterogeneous nucleation of intermetallic compound
- (29) **F. Gao, Z Fan**: Growth restriction and grain refinement











## **Short Program of the Conference on Solidification and Gravity '18**

### **Sunday, Sept. 2, 2018**

18<sup>00</sup> – Happy Hour

### **Monday, Sept. 3, 2018**

10<sup>00</sup> – 10<sup>20</sup> Opening Ceremony  
10<sup>20</sup> – 12<sup>20</sup> Plenary lecture  
12<sup>20</sup> – 14<sup>00</sup> Lunch  
14<sup>00</sup> – 14<sup>30</sup> Plenary lecture  
14<sup>30</sup> – 14<sup>40</sup> Break  
14<sup>40</sup> – 16<sup>20</sup> In situ observation I / Phase field modelling  
16<sup>20</sup> – 16<sup>50</sup> Coffee Break  
16<sup>50</sup> – 18<sup>30</sup> Casting / Dendritic solidification  
19<sup>00</sup> – 23<sup>00</sup> Conference Dinner at Vigadó

### **Tuesday, Sept. 4, 2018**

08<sup>00</sup> – 10<sup>00</sup> Microgravity  
10<sup>00</sup> – 10<sup>30</sup> Coffee Break  
10<sup>30</sup> – 12<sup>10</sup> Modelling, simulation I / Grain refinement I  
12<sup>10</sup> – 14<sup>00</sup> Lunch  
14<sup>00</sup> – 14<sup>30</sup> Plenary lecture  
14<sup>30</sup> – 14<sup>40</sup> Break  
14<sup>40</sup> – 16<sup>00</sup> Modelling, simulation II / In situ observatioin II  
16<sup>00</sup> – 16<sup>30</sup> Coffee Break  
16<sup>30</sup> – 17<sup>00</sup> Plenary lecture  
17<sup>00</sup> – 17<sup>10</sup> Break  
17<sup>10</sup> – 18<sup>10</sup> Modelling, simulation III / Dendritic solidification II  
18<sup>10</sup> – 19<sup>30</sup> Dinner  
19<sup>30</sup> – 23<sup>00</sup> Social event: Cave Bath, Miskolc-Tapolca

### **Wednesday, Sept. 5, 2018**

08<sup>00</sup> – 10<sup>00</sup> Forced convection I  
10<sup>00</sup> – 10<sup>30</sup> Coffee break  
10<sup>30</sup> – 12<sup>00</sup> Forced convection II  
12<sup>00</sup> – 14<sup>00</sup> Lunch  
14<sup>00</sup> – 14<sup>30</sup> Plenary lecture  
14<sup>30</sup> – 14<sup>40</sup> Break  
14<sup>40</sup> – 16<sup>00</sup> Compound solidification / Grain refinement II  
16<sup>00</sup> – 17<sup>30</sup> Poster session  
17<sup>30</sup> – 23<sup>00</sup> Social event: Wine tour to Tokaj region

### **Thursday, Sept. 6, 2018**

09<sup>00</sup> – 10<sup>30</sup> Eutectic, peritectic, monotectic, foam I  
10<sup>30</sup> – 11<sup>00</sup> Coffee Break  
11<sup>00</sup> – 12<sup>20</sup> Eutectic, peritectic, monotectic, foam II  
12<sup>20</sup> – 12<sup>40</sup> Closing remarks  
12<sup>40</sup> – 14<sup>00</sup> Lunch