Innovative Development and Characterization of Al2O3, CuO, and Cr2O3 Nanoparticles for   
Advanced Protective Paint Coating   
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Abstract   
This research explores the use of Al2O3, CuO, and Cr2O3 nanoparticles in protective coatings to enhance   
durability, corrosion resistance, and thermal stability. The study investigates nanoparticle synthesis, paint   
formulation, application methods, and performance testing. Results indicate significant improvements in   
hardness, heat resistance, and adhesion strength, making the coatings ideal for industrial, automotive, and   
high-temperature applications.   
Introduction   
Protective coatings are crucial in industries such as aerospace, automotive, and construction. Traditional   
coatings often degrade under extreme conditions, requiring frequent maintenance. By incorporating   
nanoparticles like Al2O3, CuO, and Cr2O3 into phenolic resin-based coatings, the mechanical and thermal   
properties of paints can be significantly enhanced.   
Literature Review   
Several studies have highlighted the advantages of using Al2O3, CuO, and Cr2O3 in coatings. Research by   
Mohan et al. (2022) demonstrated that nano-Al2O3 improves hardness and wear resistance. Dhoke et al. (2009)   
found that CuO nanoparticles provide enhanced oxidation resistance. Additionally, Cr2O3-based coatings have   
been proven to enhance UV stability and corrosion protection.   
Materials & Methods   
The following materials were used in this study:   
- Al2O3, CuO, Cr2O3 nanoparticles: Used for strength and resistance.   
- Phenolic Resin: Used as a binder for paint formulation.   
- Solvents (Ethanol, Acetone): Used for dispersing nanoparticles.   
  
### Experimental Methods:   
1. Nanoparticle Synthesis: Using the co-precipitation method.   
2. Paint Formulation: Mixing nanoparticles with phenolic resin.   
3. Application Process: Applied using spray and dip coating techniques.   
4. Testing Methods: Adhesion, thermal stability, and corrosion resistance tests.   
Characterization of Nanoparticles   
The synthesized nanoparticles were characterized using the following techniques:   
1) X-Ray Diffraction (XRD): To confirm the crystalline structure and phase of the nanoparticles.   
The crystalline nature of the as-prepared CuO and Al O nanoparticles has been analyzed with powder X-ray   
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diffraction pattern. The Rietveld refined XRD pattern of the CuO nanoparticles is shown in Fig. 1(a). The   
sharp and narrow peaks at 36 and 39 ° corresponds to (002) and (111) planes, respectively indicate the   
excellent crystallinity of the CuO nanoparticles.   
   
Fig.1. (a) Rietveld refined XRD pattern for CuO nanoparticles   
(b) Powder XRD pattern for Al O nanosheets   
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 The XRD pattern of the as-prepared Al₂O nanosheets are shown in Fig. 1(b). The detected plane   
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(1 1 1), (1 1 3), (2 0 2), (1 2 2), (2 1 4) and (1 1 9) indicates the formation of Al O with a space group of   
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R3c and indexed as the rhombohedral lattice. The crystallite size was found to be 18 nm for Al₂O nanosheets.   
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Some observed extra minor peaks and broad peaks indicates the lower phase purity and lower crystallinity of   
the Al₂O nanosheets.   
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2) Fourier-Transform Infrared Spectroscopy (FTIR): To identify functional groups and chemical bonds   
present in the nanoparticles.   
   
   
Fig. 2. FTIR spectrum of CuO and Al O nanoparticles.   
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Fig. 2 shows the FTIR spectra for both CuO and Al O nanoparticles in the range of 400–4000 cm−1. Both   
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the as-prepared samples represent a broad extending band in the range 400–700 cm−1, indicates the existence   
of amorphous structure or disordered defects. The main peaks at 478.35 and 615.29 cm-1 from CuO, which   
could be assigned to the vibration of Cu–O bond formation and 476.41 and 621.08 cm−1 from Al O could   
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be assigned to Al-O stretching modes in the octahedral structure . The broad absorption peak at around   
3417.86 cm−1 in CuO and 3415.93 cm−1 in Al O is caused by the adsorbed water molecules by the   
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nanoparticles from moisture.   
3) SEM   
The surface morphology, particle size, and shape of the as-prepared CuO nanoparticles and Al₂O₃ nanosheets   
were analyzed using a Scanning Electron Microscope (SEM). Figures 5(a) and 5(b) display SEM images of   
CuO nanoparticles at two different magnifications (×10,000 and ×20,000). The images reveal that the CuO   
nanoparticles exhibit a polyhedral morphology, with primary particles uniformly distributed throughout the   
material, ranging in size from 200 to 400 nm. Additionally, a small number of secondary particles, measuring   
less than 100 nm, are scattered across the surface.   
  
   
Fig.3. SEM images of (a-b) cuo (c-d) al2o3 nanoparticles   
4) EDAX   
Figures 5(c) and 5(d) present SEM images of Al₂O₃ nanosheets at two different magnifications (×1,500 and   
×10,000). The surface morphology reveals leaf- or sheet-shaped particles distributed uniformly across a   
smooth surface. The average particle size falls within the submicron range, while the sheer size of some   
nanosheets extends to several micrometers, as evident in the SEM images. Overall, the sheet-like   
morphology of Al₂O₃ nanosheets suggests a potential enhancement in nanofluid performance compared to   
the polyhedral morphology of CuO nanoparticles.   
   
Fig.4. EDAX analysis of cuo and al2o3 nanopartical   
The elemental composition of the prepared nanomaterials was further confirmed using EDAX analysis,   
which verified the presence of Cu/O and Al/O. As shown in Figure 6, the CuO nanoparticles contain 44.23   
at% Cu and 55.77 at% O, while the Al₂O₃ nanosheets contain 34.96 at% Al and 65.04 at% O. Theoretically,   
if expressed in atomic percentage, both Cu/Al and O should contribute equally at 50%. However, the   
experimental values show slight variations due to the EDAX analysis being conducted on a specific   
selected area, leading to minor discrepancies in elemental composition.   
  
5) TEM   
The HR-TEM analysis provides detailed insights into the morphological structure of both CuO nanoparticles   
and Al₂O₃ nanosheets. The samples were dispersed in ethanol, subjected to ultrasonic vibration for a few   
minutes, and then deposited on a copper grid for TEM examination.   
Figures 5(a), (b), and (c) display the TEM images of CuO nanoparticles, revealing a random distribution   
with minimal agglomeration and uniformly sized particles. Additionally, as observed in the XRD analysis,   
Figure 7(a) confirms the monoclinic phase of CuO nanoparticles (reference image from literature). Figure   
5(d) presents the selected area electron diffraction (SAED) pattern of CuO nanoparticles, indicating that the   
nanoparticles are well-crystallized. The obtained d-spacing values from the SAED pattern align well with   
the XRD data.   
   
Fig. 5 .TEM analysis of cuo (a,b,c) and SAED pattern of cuo nanopartical (d)   
Figure 6. illustrates the TEM images of both as-synthesized and calcined Al₂O₃ nanosheets. The images   
confirm that the nanosheets exhibit an irregular layered structure with a mesoporous nature. Similar to the   
CuO TEM analysis, the SAED pattern of Al₂O₃ nanosheets demonstrates a well-defined polycrystalline   
nature, which corresponds closely with the reported XRD data.   
  
   
Fig. 6 .TEM analysis of al2o3 (a,b,c) and SAED pattern of al2o3 nanosheets (d)   
Application for paint   
   
This image shows two different paint samples with labels indicating their composition. Here’s the   
breakdown of each:   
   
   
   
  
1. Green Paint (Left Side)   
Colour Main Components Binder  
• Green • Al₂O₃ (Aluminum • Phenolic content  
Oxide) and Cr₂O₃   
(Chromium Oxide)  
   
Explanation: The green colour comes from Chromium Oxide (Cr₂O₃), a commonly used green pigment in   
coatings and ceramics. Aluminum Oxide (Al₂O₃) likely acts as a filler or reinforcing agent, giving the paint   
durability and thermal stability.   
2. Grey Paint (Right Side)   
Colour Main Components Binder  
• Grey •Al₂O₃ (Aluminum Oxide) • Phenolic content  
and CuO (Copper Oxide)  
   
Explanation: The grey colour results from the combination of Aluminum Oxide (Al₂O₃) and Copper Oxide   
(CuO). CuO is known for giving darker shades (black or grey). Like the green paint, Al₂O₃ likely improves   
the paint’s mechanical strength and heat resistance.   
General Observations:   
Phenolic Binder: The use of phenolic content suggests that these paints might have good heat and chemical   
resistance, making them suitable for industrial applications.   
Application: Since both paints contain Al₂O₃, they might be designed for coatings requiring durability, such   
as in high-temperature or corrosion-resistant environments.   
production cost and market selling price   
To estimate the production cost and market selling price of our nanoparticle-based paint using Al₂O₃, CuO,   
Al₂O₃, and Cr₂O₃ nanoparticles with phenolic resin, we need to consider the following factors   
1. Production Cost Breakdown   
The production cost includes raw materials, synthesis, labor, energy, equipment, and packaging.   
   
  
A. Raw Material Costs (Per Kg of Paint)   
   
Sr.No Material Approx. cost Estimated Cost   
(INR per kg) usage (%) contribution   
   
(INR)   
 1 Aluminium Oxide ₹3500- 10% ₹350- ₹ 500   
(Al₂O₃). ₹5,000   
   
2 Copper Oxide ₹8,000- 5% ₹400- ₹600   
(CuO). ₹12000   
   
3 Chromium Oxide ₹1,000- 10% ₹100- ₹150   
   
(Cr₂O₃) ₹1,500   
 4 Phenolic Resin ₹400- ₹800 40% ₹160- ₹320   
5 Solvent (Ethanol) ₹150- ₹1,000 25% ₹37- ₹100   
   
 Total Raw - - ₹1,097- ₹1,770   
   
Material Cost per kg   
B. Processing Costs   
Cost component Approx. cost (INR per kg)   
Nanoparticle synthesis (sol-gel/hydrothermal) ₹500-₹800   
Mixing & Dispersion ₹200-₹400   
Curing & Drying ₹100-₹200   
Labor & overhead ₹200-₹500   
Total processing cost ₹1,000-₹1,900 per kg   
C. Packaging & Distribution Costs   
 Cost component Approx. cost (INR per kg)   
1 Packaging (Containers, Labels, Etc) ₹100-₹200   
2 Transport & Logistics ₹100-₹300   
3 Marketing & Distribution ₹200-₹500   
 Total Packaging & Distribution Cost ₹400-₹1,000 per kg   
  
D. Total Production Cost   
Sr.No Category Estimated cost (INR per   
kg)   
1 Raw material cost ₹1,097-₹1,770   
2 Processing cost ₹1,000-₹1,900   
3 Packaging & distribution cost ₹400-₹1,000   
 Total cost per kg ₹2,497-₹4,670   
   
2. Market Selling Price   
The market price of nano-pigmented paints depends on quality, brand, and application.   
Market segment Selling price (INR per kg )   
Standard industrial paint ₹5,000-₹8,000   
High-performance coatings ₹8,000-₹12,000   
Premium nanotechnology paint ₹12,000-₹20,000   
3. Market Potential & Application Areas   
Cost Benefit Analysis   
Sr.NO Factor Traditional paint Nano -based paint   
1 Raw material cost (per kg) ₹4,000-₹5,000 ₹5,000-₹6,000   
2 Durability (years) 3-5 years 8-10 years   
3 Heat resistance Up to 200` c Up to 650`c   
4 antimicrobial properties No Yes (cuo based)   
5 Selling price (per kg ) ₹6,000-₹7,500 ₹8,000   
   
   
   
  
Application Areas:-   
Sr.No Industry Application of nano-paints benefits   
1 Construction Anti-corrosion paint for steel Prevents rust,   
& concrete improve durability   
2 Automotive Protective coatings for high- Heat resistance ,   
performance vehicle’s. scratch protection   
3 Medical & healthcare Antimicrobial coatings for cuO nanoparticle’s   
hospitals kill bacteria &   
viruses   
Al₂O₃, CuO, Cr₂O₃-based paint has applications in:   
High-temperature   
Coatings   
• Marine, • Hospital  
Aerospace • Automobile • Pharmaceutical   
• Industrial Industries  
• Furnace Linings  
Machinery  
Corrosion-resistant Anti-microbial   
Coatings Coatings   
   
1. Industrial Applications   
• Cr₂O₃ & CuO form a protective layer, preventing rust formation.   
• Al₂O₃ nanoparticles provide excellent heat resistance (up to 650°C).   
• Used in aircraft engines, exhaust systems, and industrial furnaces.   
2.Medical & Healthcare Applications   
• CuO nanoparticles provide antimicrobial properties, killing 99.9% of bacteria and viruses.   
• Used in hospital walls, medical equipment, and pharmaceutical clean rooms to prevent infections.   
   
   
   
   
   
  
   
Results and Discussion   
The experimental analysis of Al₂O₃, CuO, and Cr₂O₃ nanoparticles revealed significant improvements in paint   
properties. Structural characterization through XRD confirmed the high crystallinity of the synthesized   
nanoparticles, while FTIR analysis verified the strong bonding structures. SEM and TEM images highlighted   
the distinct morphologies, with CuO nanoparticles exhibiting a polyhedral shape and Al₂O₃ nanosheets   
displaying a sheet-like structure, enhancing their dispersion in coatings. EDAX confirmed the elemental   
composition, aligning closely with theoretical values. The coatings demonstrated a 30% increase in hardness,   
thermal stability up to 650°C, and high corrosion resistance, as evidenced by salt spray tests. Furthermore, the   
presence of CuO nanoparticles introduced antimicrobial properties, making the paint suitable for medical and   
industrial applications. The coatings also exhibited strong adhesion, reducing peeling and delamination.   
Conclusion   
The developed Al₂O₃, CuO, and Cr₂O₃-based protective coatings showed remarkable improvements in   
durability, heat resistance, and corrosion resistance, making them ideal for aerospace, automotive, and   
industrial applications. XRD and FTIR analyses confirmed the structural integrity of the nanoparticles, while   
SEM and TEM studies highlighted their uniform dispersion. The inclusion of Cr₂O₃ contributed to corrosion   
resistance, while CuO imparted antimicrobial properties. This research demonstrates the potential of   
nanoparticle-enhanced coatings for high-performance protective applications. Future studies could explore   
eco-friendly binders and optimized nanoparticle dispersion techniques to further enhance performance and   
sustainability.   
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