Contents

List of Contributor *XVII*
Preface to Second Edition *XXIII*

Part I General *1*

1 Microstructure and Properties of Engineering Materials *3*
Helmut Clemens, Svea Mayer, and Christina Scheu
1.1 Introduction *3*
1.2 Microstructure *4*
1.2.1 Crystal Defects *7*
1.2.2 Grain (Phase) Boundaries and Twins *7*
1.2.3 Precipitates and Dispersions *8*
1.3 Microstructure and Properties *10*
1.4 Microstructural Characterization *12*
References *19*

2 Internal Stresses in Engineering Materials *21*
Anke Kaysser-Pyzalla
2.1 Definition *21*
2.1.1 Stress Tensor, Strain Tensor, and Elasticity Tensor *21*
2.1.1.1 Stress Tensor *21*
2.1.1.2 Strain Tensor *22*
2.1.2 Definitions, Residual Stresses *23*
2.1.2.1 Stress Equilibrium *23*
2.1.2.2 Residual Macro- and Microstresses *24*
2.2 Origin of Residual Macro- and Microstresses *25*
2.2.1 Residual Stress Formation in Primary Forming Processes *26*
2.2.2 Residual Stress Formation in Heat Treatment Processes *28*
2.2.2.1 Residual Stresses in a Material without Phase Transformation (Pure Cooling Residual Stresses) *29*
2.2.2.2 Residual Stresses in a Material with Phase Transformation *30*
2.2.2.3 Residual Stress Formation in Surface-Hardening Processes (Nitriding, Carbo-Nitriding, and Case Hardening) *32*
2.2.3 Residual Stress Formation in Forming Processes *32*

2.2.3.1 Deep-Rolling Residual Stresses *33*
2.2.3.2 Cold Extrusion Residual Stresses *34*
2.2.4 Residual Stress Formation in Metal Cutting Manufacturing *36*
2.2.4.1 Grinding Residual Stresses *37*
2.2.5 Residual Stress Formation in Joining Processes *39*
2.2.6 Residual Stress Formation in Coatings *43*
2.3 Relevance *45*
2.3.1 Failure due to Residual Stress Formation or Residual Stress Relief Induced by Temperature Changes *46*
2.3.2 Influence of Residual Stresses on Component Failure under Static and Dynamic Mechanical Loads *47*
2.3.3 Influence of Residual Stresses on Component Failure in Corrosive Environments *49*
2.3.4 Influence of Residual Stresses on Wear *49*
References *51*

3 Textures in Engineering Materials *55*
Heinz G. Brokmeier and Sangbong Yi
3.1 Introduction *55*
3.2 Measurement of Preferred Orientations *58*
3.3 Presentation of Preferred Orientations *59*
3.3.1 Pole Figure *60*
3.3.2 Orientation Distribution Function *62*
3.3.3 Inverse Pole Figures *62*
3.4 Interpretation of Textures *62*
3.5 Errors *67*
3.5.1 Grain Statistics *67*
3.5.2 Pole Figure Coverage *68*
References *71*

4 Physical Properties of Photons and Neutrons *73*
Andreas Schreyer
4.1 Introduction *73*
4.2 Interaction of X-ray Photons and Neutrons with Individual Atoms *74*
4.2.1 Neutrons *75*
4.2.2 X-rays *76*
4.3 Scattering of X-ray Photons and Neutrons from Ensembles of Atoms *79*
Acknowledgment *81*
References *81*

5 Radiation Sources *83*
5.1 Generation and Properties of Neutrons *83*
Ina Lommatzsch, Wolfgang Knop, Philipp K. Pranzas, and Peter Schreiner
5.1.1 Introduction *83*
5.1.2 Generation of Neutrons *83*
5.1.2.1 Research Reactors *83*
5.1.2.2 Spallation Sources *87*

5.1.3 Instrumentation *87*
5.1.3.1 Structure Research *89*
5.1.3.2 Large-Scale Structures *89*
5.1.3.3 Spectroscopy *89*
5.1.3.4 Imaging and Analysis *89*
5.1.3.5 Particle Physics *89*
References *90*
5.2 Production and Properties of Synchrotron Radiation *90*
Rolf Treusch
5.2.1 Introduction *90*
5.2.2 Properties of Synchrotron Radiation *92*
5.2.3 Sources of Synchrotron Radiation *96*
5.2.3.1 Bending Magnets *97*
5.2.3.2 Wigglers and Undulators *98*
5.2.4 Outlook: Free Electron Lasers *100*
5.2.5 Summary *102*
References *102*

Part II Methods *105*

6 Stress Analysis by Angle-Dispersive Neutron Diffraction *107*
Peter Staron
6.1 Introduction *107*
6.2 Diffractometer for Residual Stress Analysis *108*
6.2.1 Setup of a Diffractometer for Strain Scanning *108*
6.2.2 Monochromator *109*
6.2.3 Slit System *110*
6.2.4 Sample Positioning *111*
6.2.5 Detector *111*
6.3 Measurement and Data Analysis *112*
6.3.1 Gage Volume and Sample Positioning *112*
6.3.2 Data Reduction and Analysis *113*
6.3.2.1 Data Reduction and Peak Fitting *113*
6.3.2.2 Calculation of Stresses *114*
6.3.2.3 Macro and Microstresses *115*
6.3.2.4 Stress-Free Reference *116*
6.4 Examples *116*
6.4.1 Residual Stresses in Friction Stir Welded Aluminum Sheets *116*
6.4.2 Residual Stresses in Water-Quenched Turbine Disks *117*
6.5 Summary and Outlook *120*
References *120*

7 Stress Analysis by Energy-Dispersive Neutron Diffraction *123*
Javier Santisteban
7.1 Introduction *123*
7.2 Time-of-Flight Neutron Diffraction *123*

7.2.1 TOF Peak Shape and Data Analysis Packages *124*
7.3 TOF Strain Scanners *126*
7.3.1 Counting Times and Resolution *128*
7.3.2 Neutron Optics and Time Focusing *130*
7.4 A Virtual Laboratory for Strain Scanning *131*
7.5 Type II Stresses: Evolution of Intergranular Stresses *134*
7.6 Type III Stresses: Dislocation Densities *135*
7.7 Strain Imaging by Energy-Dispersive Neutron Transmission *138*
7.8 Conclusions *140*
Acknowledgments *141*
References *141*

8 Residual Stress Analysis by Monochromatic High-Energy X-rays *145*
René V. Martins
8.1 Basic Setups *145*
8.2 Principle of Slit Imaging and Data Reconstruction *148*
8.3 The Conical Slit *149*
8.3.1 Working Principle *149*
8.3.2 Capabilities *149*
8.3.3 Example *151*
8.4 The Spiral Slit *152*
8.4.1 Functional Principle *152*
8.4.2 Capabilities *152*
8.4.3 Example *153*
8.5 Simultaneous Strain Measurements in Individual Bulk Grains *155*
8.6 Coarse Grain Effects *156*
8.7 Analysis of Diffraction Data from Area Detectors *157*
8.8 Matrix for Comparison and Decision Taking Which Technique to Use for a Specific Problem *158*
References *159*

9 Residual Stress Analysis by Energy-Dispersive Synchrotron X-ray Diffraction *161*
Christoph Genzel and Manuela Klaus
9.1 Introduction *161*
9.2 Fundamentals of Energy-Dispersive X-ray Diffraction Stress Analysis *162*
9.2.1 The Basic Equation of Energy-Dispersive X-ray Diffraction *162*
9.2.2 Near-Surface Depth Profiling in the Energy-Dispersive Diffraction Mode *162*
9.2.3 Principles of Depth-Resolved X-ray Stress Analysis and Application to the Energy-Dispersive Case of Diffraction *164*
9.3 Experimental Setup *167*
9.4 Examples for Energy-Dispersive Stress Analysis *168*
9.4.1 Near Surface Residual Stress Depth Profiling *168*
9.4.2 Fast *In situ* Stress Analysis by Means of Energy-Dispersive Diffraction *171*
9.5 Final Remarks *173*
References *175*

10 Texture Analyses by Synchrotron X-rays and Neutrons *179*
Sangbong Yi, Weimin Gan, and Heinz G. Brokmeier
10.1 Texture Measurements on Laboratory Scale *179*
10.1.1 X-ray Diffraction *179*
10.1.2 Electron Diffraction *181*
10.2 Texture Measurements at Large Scale Facilities *182*
10.2.1 Neutron Diffraction *182*
10.2.2 Texture Analysis Using Synchrotron X-rays *185*
10.2.3 Examples of Texture Analyses Using Neutrons and Synchrotron X-rays *189*
10.2.3.1 Local Texture Measurement of a Friction Welded Rod *189*
10.2.3.2 Global Texture in Cu Wire *190*
10.2.3.3 *In situ* Texture Measurement of Steel at Elevated Temperature *191*
10.2.3.4 *In situ* Texture Measurement under Loading *192*
10.3 Conclusion *193*
References *194*

11 Basics of Small-Angle Scattering Methods *197*
Philipp K. Pranzas
11.1 Introduction *197*
11.2 Common Features of a SAS Instrument *197*
11.3 Contrast *198*
11.4 Scattering Curve *198*
11.5 Power Law/Scattering by Fractal Systems *200*
11.6 Guinier and Porod Approximations *201*
11.7 Macroscopic Differential Scattering Cross-section *202*
11.8 Model Calculation of Size Distributions *202*
11.9 Magnetic Structures *203*
References *204*

12 Small-Angle Neutron Scattering *207*
Philipp K. Pranzas and André Heinemann
12.1 Introduction *207*
12.2 Nanocrystalline Magnesium Hydride for the Reversible Storage of Hydrogen *208*
12.3 Precipitates in Steel *210*
12.4 SiO_2 Nanoparticles in a Polymer Matrix – An Industrial Application *213*
12.5 Green Surfactants *213*
Acknowledgments *215*
References *215*

13 Anomalous Small-Angle X-ray Scattering *217*
Ulla Vainio
13.1 Introduction *217*
13.2 Theory *218*
13.2.1 Scattering Power of Elements *218*
13.2.2 Contrast Variation *219*

13.2.3 Partial Structure Factor Formalism *219*
13.2.4 Model-Dependent ASAXS *221*
13.2.5 Subtraction Method *221*
13.3 Experiments *223*
13.4 Example: ASAXS on Catalyst Nanoparticles *223*
13.5 Summary and Outlook *223*
References *224*

14 Imaging *227*
Wolfgang Treimer
14.1 Radiography *227*
14.1.1 Fundamentals *227*
14.1.2 Interactions of Neutrons with Matter *228*
14.1.3 Geometries *230*
14.1.4 Resolution Functions *232*
14.1.5 Image Degradation *235*
14.1.6 Other Imaging Techniques *236*
14.1.6.1 Energy Dispersive Radiography *236*
14.1.6.2 Real-Time Radiography *238*
14.1.6.3 Phase Contrast Radiography *239*
14.2 Tomography *240*
14.2.1 Mathematical Introduction *240*
14.2.2 Slice Theorem, Shannon Theorem *241*
14.2.3 Image Reconstruction *243*
14.3 New Developments in Neutron Tomography *244*
14.3.1 Refraction *246*
14.3.2 Ultra-Small Angle Neutron Tomography *247*
14.3.3 Radiography and Tomography with Polarized Neutrons *249*
References *250*

15 Neutron and Synchrotron-Radiation-Based Imaging for Applications in Materials Science – From Macro- to Nanotomography *253*
Felix Beckmann
15.1 Introduction *253*
15.1.1 Attenuation-Contrast Projections *253*
15.1.2 Phase-Contrast Projections *254*
15.1.3 Phase-Enhanced Projections *255*
15.1.4 Direct Phase-Contrast Projections *255*
15.1.5 Indirect Phase-Contrast Projections *255*
15.2 Parallel-Beam Tomography *256*
15.2.1 Measurement and Reconstruction *256*
15.2.2 Density Resolution and Detector Quality *258*
15.2.3 Data Evaluation and Visualization *258*
15.3 Macrotomography Using Neutrons *258*
15.3.1 Experimental Setup *258*
15.3.2 Measurements and Results *260*

15.4 Microtomography Using Synchrotron Radiation *264*
15.4.1 Beamline Optics *265*
15.4.2 Experimental Setup *267*
15.5 Summary and Outlook *271*
References *271*

16 μ-Tomography of Engineering Materials *275*
Astrid Haibel and Julia Herzen
16.1 Introduction *275*
16.2 Advantage of Synchrotron Tomography *275*
16.3 Applications and 3D Image Analysis *276*
16.3.1 Discharging Processes in Alkaline Cells *276*
16.3.2 Microstructural Investigations of Nb_3Sn Multi-filamentary Superconductor Wires *278*
16.3.3 Influence of the Foaming Agent on Metallic Foam Structures *280*
16.3.4 *Ex vivo* Grating-Based Phase Contrast Imaging of Human Carotid Arteries *281*
16.4 Image Artifacts *282*
16.4.1 Ring Artifacts *282*
16.4.2 Image Noise *284*
16.4.3 Edge Artifacts *284*
16.4.4 Motion Artifacts *285*
16.4.5 Centering Errors of the Rotation Axis *286*
16.5 Summary *286*
References *286*

Part III New and Emerging Methods *291*

17 3D X-ray Diffraction Microscope *293*
Henning F. Poulsen, Wolfgang Ludwig, and Søren Schmidt
17.1 Basic Setup and Strategy *294*
17.1.1 The 3DXRD Microscope *296*
17.2 Indexing and Characterization of Average Properties of Each Grain *296*
17.2.1 Application I: Nucleation and Growth Studies *297*
17.2.2 Application II: Plastic Deformation *298*
17.2.3 Application III: Studies of Subgrains and Nanocrystalline Materials *299*
17.3 Mapping of Grains and Orientations *300*
17.3.1 Mode III: Mapping Grains in Undeformed Specimens *300*
17.3.2 Mode IV: Mapping Orientations in Deformed Specimens *301*
17.3.3 Application I: Recrystallization *302*
17.3.4 Application II: Grain Growth *303*
17.4 Combining 3DXRD and Tomography *304*
17.4.1 Grain Mapping by Tomography *304*
17.5 Outlook *305*
References *306*

18 3D Micron-Resolution Laue Diffraction *309*
Gene E. Ice
18.1 Introduction *309*
18.2 The Need for *Polychromatic* Microdiffraction *309*
18.3 Theoretical Basis for Advanced Polychromatic Microdiffraction *311*
18.3.1 Modified Ewald's Sphere Description of Laue Diffraction *311*
18.3.2 Qualitative Information: Phase, Texture, Elastic Strain, Dislocation Density *312*
18.3.2.1 Phase *312*
18.3.2.2 Texture *312*
18.3.2.3 Dislocation Tensor *313*
18.3.2.4 Elastic Strain Tensor *313*
18.4 Technical Developments for an Automated 3D Probe *313*
18.4.1 Source *313*
18.4.2 Microbeam Monochromator *315*
18.4.3 Nondispersive Focusing Optics *316*
18.4.4 Area Detector *317*
18.4.5 Differential Aperture *317*
18.4.6 Software *317*
18.5 Research Examples *318*
18.5.1 3D Grain Boundary Networks *319*
18.5.2 Deformation Behavior and Grain Boundaries *319*
18.5.3 Deformation in Single Crystals *321*
18.5.4 Grain Growth on Surfaces and in Three Dimensions *321*
18.5.5 Anomalous Grain Growth *321*
18.6 Future Prospects and Opportunities *324*
Acknowledgment *324*
References *325*

Part IV Applications *327*

19 The Use of Neutron and Synchrotron Research for Aerospace and Automotive Materials and Components *329*
Wolfgang Kaysser, Jörg Eßlinger, Volker Abetz, Norbert Huber, Karl U. Kainer, Thomas Klassen, Florian Pyczak, Andreas Schreyer, and Peter Staron
19.1 Introduction *329*
19.2 Commercial Passenger Aircraft *331*
19.2.1 Reduction of Airframe Weight of Commercial Passenger Aircrafts *332*
19.2.1.1 Welding Commercial Passenger Aircraft Frames: Reactions, Microstructure Development, and Mechanical Properties *332*
19.2.1.2 Welding Commercial Passenger Aircraft: Residual Stresses and Stress Modification *333*
19.2.1.3 Welding of Commercial Passenger Aircraft: Fatigue Crack Growth *335*

19.2.1.4 Weight Reduction of Aircraft by Polymers and Polymer Matrix-Based Composites *335*
19.2.2 Aero-Engines *337*
19.2.2.1 Metallic Materials to Improve the Thrust-to-Weight Ratio of Jet Aero-Engines *338*
19.2.2.2 Thermal Barrier Coatings to Enhance the Thrust-to-Weight Increase of the Aero-Engine *340*
19.3 The Light-Duty Automotive Vehicle *341*
19.3.1 The Optimized Light-Duty Car Body *343*
19.3.1.1 Lightweight Metallic Materials for Lightweight Car Bodies *343*
19.3.1.2 Optimized Joining Processes for Automotive Applications *345*
19.3.2 The Automotive Power Train and the Propulsion System of Light-Duty Cars *346*
19.3.2.1 Residual Stresses in Components *347*
19.3.2.2 Wear and Lubrication *348*
19.3.2.3 Polymeric Membranes for Fuel Cells (PEMFCs) *349*
19.3.2.4 Nanocrystalline Metal Hydrides for Hydrogen Storage *350*
19.4 Other Transport Systems *352*
References *353*

20 *In situ* Experiments with Synchrotron High-Energy X-rays and Neutrons *365*
Peter Staron, Torben Fischer, Thomas Lippmann, Andreas Stark, Shahrokh Daneshpour, Dirk Schnubel, Eckart Uhlmann, Robert Gerstenberger, Bettina Camin, Walter Reimers, Elisabeth Eidenberger-Schober, Helmut Clemens, Norbert Huber, and Andreas Schreyer
20.1 Introduction *365*
20.2 *In situ* Dilatometry *366*
20.2.1 Motivation *366*
20.2.2 FlexiTherm *366*
20.2.3 Results *367*
20.3 *In situ* Study on Single Overload of Fatigue-Cracked Specimens *368*
20.3.1 Motivation *368*
20.3.2 Experimental *369*
20.3.3 Results *369*
20.4 *In situ* Cutting Experiment *370*
20.4.1 Motivation *370*
20.4.2 Experiment *371*
20.4.3 Results *371*
20.5 *In situ* Study of Precipitation Kinetics Using Neutrons *372*
20.5.1 Motivation *372*
20.5.2 Experimental Details *372*
20.5.3 Results *373*
20.6 Conclusions *373*
References *374*

21 Application of Photons and Neutrons for the Characterization and Development of Advanced Steels *377*
Elisabeth Eidenberger-Schober, Ronald Schnitzer, Gerald A. Zickler, Michael Eidenberger-Schober, Michael Bischof, Peter Staron, Harald Leitner, Andreas Schreyer, and Helmut Clemens
21.1 Introduction *377*
21.2 Characterization Using Synchrotron Radiation *378*
21.2.1 *Ex situ* and *In situ* High-Energy X-ray Diffraction (HE-XRD) during Heating *378*
21.2.2 Small-Angle X-ray Scattering (SAXS) *380*
21.2.3 *In situ* High-Energy X-ray Diffraction under Tensile Loading *381*
21.3 Characterization Using Small-Angle Neutron Scattering (SANS) *382*
21.3.1 Use of SANS to Study Precipitates in Steels *382*
21.3.1.1 Analysis of Secondary Hardening Carbides *382*
21.3.1.2 Analysis of Intermetallic Precipitates *383*
21.3.2 *In situ* SANS during Continuous and Isothermal Aging *386*
21.3.3 SANS with Variable Magnetic Field *388*
21.4 Conclusions *388*
References *390*

22 The Contribution of High-Energy X-rays and Neutrons to Characterization and Development of Intermetallic Titanium Aluminides *395*
Thomas Schmoelzer, Klaus-Dieter Liss, Peter Staron, Andreas Stark, Emanuel Schwaighofer, Thomas Lippmann, Helmut Clemens, and Svea Mayer
22.1 Introduction *395*
22.2 High-Energy X-rays and Neutrons *396*
22.3 *In situ* Investigation of Phase Evolution *398*
22.3.1 General Aspects *398*
22.3.2 Phase Evolution in β/γ-Alloys *399*
22.3.3 Formation and Identification of a Transition Phase *401*
22.3.4 Formation of Lamellar Microstructure *405*
22.4 Atomic Order and Disorder in TiAl Alloys *409*
22.5 Recovery and Recrystallization during Deformation of TiAl *412*
22.5.1 General Aspects *412*
22.5.2 Analysis of Diffraction Data *414*
22.5.3 Hot Deformation of a Multi-phase Alloy *415*
22.6 Lattice Parameter and Thermal Expansion *418*
22.7 Conclusions *419*
References *420*

23 *In situ* μLaue: Instrumental Setup for the Deformation of Micron Sized Samples *425*
Christoph Kirchlechner, Jozef Keckes, Jean S. Micha, and Gerhard Dehm
23.1 Introduction *425*
23.1.1 μLaue Diffraction, a Short Introduction *426*
23.2 Experimental Instrumentation *427*

23.2.1 The Straining Device *427*
23.2.2 The Synchrotron Beamline *428*
23.2.3 The Experiment *429*
23.2.4 Data Analysis *430*
23.2.5 Example: *In situ* Deformation of a Copper Pillar *430*
23.3 Discussion *433*
23.3.1 Deformation Behavior of the Pillar *433*
23.3.2 Tails of the Primary Beam *433*
23.3.3 Sample Movements during Deformation *435*
23.3.4 Streaking of Laue Patterns *435*
23.4 Conclusion *436*
Acknowledgments *436*
References *436*

24 Residual Stresses in Thin Films and Coated Tools: Challenges and Strategies for Their Nondestructive Analysis by X-ray Diffraction Methods *439*
Manuela Klaus and Christoph Genzel
24.1 Introduction *439*
24.2 Compilation of Approaches to Meet the Challenges in Thin Film X-ray Stress Analysis (XSA) *441*
24.2.1 Stress Analysis under Grazing and Glancing Diffraction Conditions *441*
24.2.2 Separation of Residual Stress and Composition Gradients *444*
24.3 Final Remarks and Recommendations *447*
References *448*

Index *451*