

Contents

Preface XIII
Figures–Tables Acknowledgement List XV

1	Introduction	1
	References	3
2	Constitution	5
2.1	The Binary Ti–Al Phase Diagram	5
2.2	Ternary and Multicomponent Alloy Systems	11
	References	20
3	Thermophysical Constants	25
3.1	Elastic and Thermal Properties	25
3.2	Point Defects	27
3.3	Diffusion	29
	References	30
4	Phase Transformations and Microstructures	33
4.1	Microstructure Formation on Solidification	33
4.2	Solid-State Transformations	49
4.2.1	$\beta \rightarrow \alpha$ Transformation	50
4.2.2	Formation of $(\alpha_2 + \gamma)$ Lamellae Colonies	52
4.2.3	Feathery Structures and Widmannstätten Colonies	60
4.2.4	Massive Transformation	63
	References	64
5	Deformation Behavior of Single-Phase Alloys	71
5.1	Single-Phase $\gamma(\text{TiAl})$ Alloys	71
5.1.1	Slip Systems and Deformation Kinematics	71
5.1.2	Planar Faults	75
5.1.3	Planar Dislocation Dissociations in $\gamma(\text{TiAl})$	81
5.1.4	Nonplanar Dissociations and Dislocation Locking	85

5.1.5	Mechanical Twinning in γ (TiAl)	89
5.1.6	Effects of Orientation and Temperature on Deformation of γ Phase	95
5.2	Deformation Behavior of Single-Phase α_2 (Ti ₃ Al) Alloys	106
5.2.1	Slip Systems and Deformation Kinematics	106
5.2.2	Effects of Orientation and Temperature on Deformation of α , Phase	112
5.3	β /B2 Phase Alloys	114
	References	118
6	Deformation Behavior of Two-Phase α_2(Ti₃Al) + γ(TiAl) Alloys	125
6.1	Lamellar Microstructures	125
6.1.1	Interface Structures in Lamellar TiAl Alloys	125
6.1.2	Energetic Aspects of Lamellar Interfaces	136
6.1.3	Coherent and Semicohesive Interfaces	139
6.1.4	Coherency Stresses	149
6.1.5	Plastic Anisotropy	156
6.1.6	Micromechanical Modeling	161
6.2	Deformation Mechanisms, Contrasting Single-Phase and Two-Phase Alloys	164
6.2.1	Methodical Aspects of TEM Characterization	164
6.2.2	Deformation of (α_2 + γ) Alloys at Room Temperature	165
6.2.3	Independent Slip Systems	169
6.2.4	High-Temperature Deformation of (α_2 + γ) Alloys	171
6.2.5	Slip Transfer through Lamellae	173
6.3	Generation of Dislocations and Mechanical Twins	178
6.3.1	Dislocation Source Operation in γ (TiAl)	178
6.3.2	Interface-Related Dislocation Generation	184
6.3.3	Twin Nucleation and Growth	186
6.3.4	Twin Intersections	197
6.3.5	Acoustic Emissions	204
6.3.6	Thermal Stability of Twin Structures	206
6.4	Glide Resistance and Dislocation Mobility	207
6.4.1	Thermally Activated Deformation	207
6.4.2	Glide Resistance at the Beginning of Deformation	217
6.4.3	Static and Dynamic Strain Aging of TiAl Alloys	222
6.4.4	Diffusion-Assisted Dislocation Climb, Recovery, and Recrystallization	232
6.5	Thermal and Athermal Stresses	234
	References	240
7	Strengthening Mechanisms	249
7.1	Grain Refinement	249
7.2	Work Hardening	254
7.2.1	Work-Hardening Phenomena	255

7.2.2	Athermal Contributions to Work Hardening	257
7.2.3	Jog Dragging and Debris Hardening	259
7.2.4	Thermal Stability of Deformation Structures	262
7.2.5	High-Temperature Flow Behavior	268
7.2.6	High Strain-Rate Deformation	272
7.3	Solution Hardening	273
7.3.1	Elemental Size Misfit of Solute Atoms with the TiAl Matrix	273
7.3.2	Survey of Observations	276
7.3.3	Effect of Solute Niobium	277
7.4	Precipitation Hardening	282
7.4.1	Carbide Precipitation in TiAl Alloys	282
7.4.2	Hardening by Carbides	284
7.4.3	Hardening by Borides, Nitrides, Oxides, and Silicides	289
7.5	Optimized Nb-Bearing Alloys	292
	References	295
8	Deformation Behavior of Alloys with a Modulated Microstructure	301
8.1	Modulated Microstructures	301
8.2	Misfitting Interfaces	306
8.3	Mechanical Properties	310
	References	311
9	Creep	313
9.1	Design Margins and Failure Mechanisms	313
9.2	General Creep Behavior	314
9.3	The Steady-State or Minimum Creep Rate	316
9.3.1	Single-Phase γ (TiAl) Alloys	317
9.3.2	Two-Phase α_2 (Ti ₃ Al) + γ (TiAl) Alloys	319
9.3.3	Experimental Observation of Creep Structures	320
9.4	Effect of Microstructure	322
9.5	Primary Creep	325
9.6	Creep-Induced Degradation of Lamellar Structures	329
9.7	Precipitation Effects Associated with the $\alpha_2 \rightarrow \gamma$ Phase Transformation	339
9.8	Tertiary Creep	340
9.9	Optimized Alloys, Effect of Alloy Composition and Processing	341
9.10	Creep Properties of Alloys with a Modulated Microstructure	346
9.10.1	Effect of Stress and Temperature	346
9.10.2	Damage Mechanisms	347
	References	352
10	Fracture Behavior	357
10.1	Length Scales in the Fracture of TiAl Alloys	357
10.2	Cleavage Fracture	360

10.3	Crack-Tip Plasticity	362
10.3.1	Plastic Zone	362
10.3.2	Interaction of Cracks with Interfaces	365
10.3.3	Crack–Dislocation Interactions	367
10.3.4	Role of Twinning	369
10.4	Fracture Toughness, Strength, and Ductility	373
10.4.1	Methodical Aspects	373
10.4.2	Effects of Microstructure and Texture	376
10.4.3	Effect of Temperature and Loading Rate	383
10.4.4	Effect of Predeformation	387
10.5	Fracture Behavior of Modulated Alloys	388
10.6	Requirements for Ductility and Toughness	391
10.7	Assessment of Property Variability	393
10.7.1	Statistical Assessment	393
10.7.2	Variability in Strength and Ductility of TiAl	394
10.7.3	Fracture Toughness Variability of TiAl	396
	References	398
11	Fatigue	403
11.1	Definitions	403
11.2	The Stress–Life (S–N) Behavior	405
11.3	HCF	407
11.3.1	Fatigue Crack Growth	407
11.3.2	Crack-Closure Effects	409
11.3.3	Fatigue at the Threshold Stress Intensity	411
11.4	Effects of Temperature and Environment on the Cyclic Crack-Growth Resistance	413
11.5	LCF	418
11.5.1	General Considerations	418
11.5.2	Cyclic-Stress Response	419
11.5.3	Cyclic Plasticity	422
11.5.4	Stress-Induced Phase Transformation and Dynamic Recrystallization	426
11.6	Thermomechanical Fatigue and Creep Relaxation	428
	References	429
12	Oxidation Behavior and Related Issues	433
12.1	Kinetics and Thermodynamics	433
12.2	General Aspects Concerning Oxidation	437
12.2.1	Effect of Composition	437
12.2.2	Mechanical Aspects of Oxide Growth	439
12.2.3	Effect of Oxygen and Nitrogen	441
12.2.4	Effect of Other Environmental Factors	443
12.2.5	Subsurface Zone, the Z-Phase, and Silver Additions	446
12.2.6	Effect of Surface Finish	447

12.2.7	Ion Implantation	448
12.2.8	Influence of Halogens on Oxidation	450
12.2.9	Embrittlement after High-Temperature Exposure	450
12.2.10	Coatings/Oxidation-Resistant Alloys	456
12.3	Summary	458
	References	459
13	Alloy Design	465
13.1	Effect of Aluminum Content	465
13.2	Important Alloying Elements—General Remarks	467
13.2.1	Cr, Mn, and V	468
13.2.2	Nb, W, Mo, and Ta	469
13.2.3	B, C, and Si	469
13.3	Specific Alloy Systems	471
13.3.1	Conventional Alloys	472
13.3.2	High Niobium-Containing Alloys	472
13.3.3	β -Solidifying Alloys	473
13.3.4	Massively Transformed Alloys	474
13.4	Summary	476
	References	477
14	Ingot Production and Component Casting	479
14.1	Ingot Production	479
14.1.1	Vacuum Arc Melting (VAR)	480
14.1.2	Plasma-Arc Melting (PAM)	483
14.1.3	Induction Skull Melting (ISM)	489
14.1.4	General Comments	492
14.2	Casting	495
14.2.1	Investment Casting	497
14.2.2	Gravity Metal Mold Casting (GMM)	503
14.2.3	Centrifugal Casting	506
14.2.4	Countergravity Low-Pressure Casting	513
14.2.5	Directional Casting	514
14.3	Summary	515
	References	515
15	Powder Metallurgy	521
15.1	Prealloyed Powder Technology	522
15.1.1	Gas Atomization	522
15.1.1.1	Plasma Inert-Gas Atomization (PIGA) at GKSS	524
15.1.1.2	Titanium Gas-Atomizer Process (TGA)	526
15.1.1.3	Electrode Induction Melting Gas Atomization (EIGA)	527
15.1.2	Rotating-Electrode Processes	529
15.1.3	Rotating-Disc Atomization	531
15.1.4	General Aspects of Atomization	532

15.1.5	Postatomization Processing	542
15.1.5.1	Hot Isostatic Pressing (HIPing), Hot Working, and Properties	543
15.1.5.2	Laser-Based Rapid-Prototyping Techniques	547
15.1.5.3	Metal Injection Molding (MIM)	549
15.1.5.4	Spray Forming	551
15.1.5.5	Sheet/Foil Production through (i) HIP of Cast Tapes and (ii) Liquid-Phase Sintering	556
15.1.5.6	Spark Sintering	557
15.1.6	Summary	558
15.2	Elemental-Powder Technology	559
15.2.1	Reactive Sintering	559
15.2.1.1	Mechanical Properties of Reactive Sintered Material	563
15.2.1.2	Manufacture of Reactively Sintered Components/Parts	564
15.2.2	Summary	564
15.3	Mechanical Alloying	565
	References	566

16 Wrought Processing 573

16.1	Flow Behavior under Hot-Working Conditions	574
16.1.1	Flow Curves	574
16.1.2	Constitutive Analysis of the Flow Behavior	578
16.2	Conversion of Microstructure	585
16.2.1	Recrystallization of Single-Phase Alloys	585
16.2.2	Multiphase Alloys and Alloying Effects	587
16.2.3	Influence of Lamellar Interfaces	595
16.2.4	Microstructural Evolution during Hot Working above the Eutectoid Temperature	603
16.2.5	Technological Aspects	605
16.3	Workability and Primary Processing	607
16.3.1	Workability	607
16.3.2	Ingot Breakdown	617
16.4	Texture Evolution	642
16.5	Secondary Processing	658
16.5.1	Component Manufacture through Wrought Processing	658
16.5.2	Rolling – Sheet Production and Selected Mechanical Properties	662
16.5.2.1	Pack Rolling	663
16.5.2.2	Rolling Defects	666
16.5.2.3	Industrial Production of Sheet	667
16.5.2.4	Mechanical Properties of Sheet	668
16.5.2.5	Superplastic Behavior	669
16.5.3	Novel Techniques	671
16.5.3.1	Manufacture of Large “Defect-Free” Components	671
	References	673

17	Joining	683
17.1	Diffusion Bonding	683
17.1.1	Alloy Compositions and Microstructures	684
17.1.2	Microasperity Deformation	685
17.1.3	Diffusion Bonding; Experimental Setup	687
17.1.4	Metallographic Characterization of the Bonding Zone	687
17.1.5	Effect of Alloy Composition	696
17.1.6	Influence of Bonding Time and Stress	698
17.1.7	Mechanical Characterization of the Bonds	700
17.2	Brazing and Other Joining Technologies	702
17.2.1	Brazing and Transient Liquid-Phase Joining	702
17.2.2	Other Techniques	704
	References	704
18	Surface Hardening	707
18.1	Shot Peening and Roller Burnishing	707
18.2	Residual Stresses, Microhardness, and Surface Roughness	708
18.3	Surface Deformation Due to Shot Peening	712
18.4	Phase Transformation, Recrystallization, and Amorphization	716
18.5	Effect of Shot Peening on Fatigue Strength	721
18.6	Thermal Stability of the Surface Hardening	724
	References	726
19	Applications, Component Assessment, and Outlook	729
19.1	Aerospace	729
19.1.1	Aircraft-Engine Applications	729
19.1.2	Exotic Aerospace Applications	731
19.2	Automotive	732
19.3	Outlook	736
	References	737
	Subject Index	739

