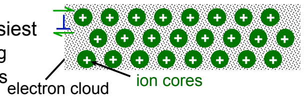
Chapter 7:
Deformation & Strengthening Mechanisms

ISSUES TO ADDRESS...

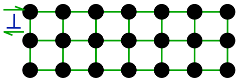
- Why are the number of dislocations present greatest in metals?
- How are strength and dislocation motion related?
- Why does heating alter strength and other properties?

Dislocations & Materials Classes

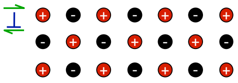
- Metals (Cu, Al):
  Dislocation motion easiest
  - non-directional bonding
  - close-packed directions for slip



- Covalent Ceramics
  (Si, diamond): Motion difficult
  - directional (angular) bonding



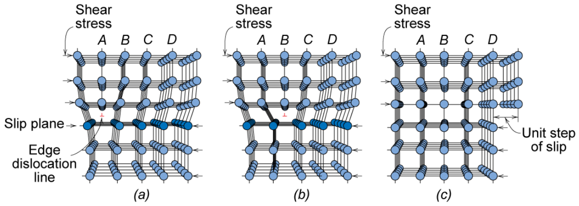
- Ionic Ceramics (NaCl):
  Motion difficult
  - need to avoid nearest neighbors of like sign (- and +)



Dislocation Motion

Dislocation motion & plastic deformation

- Metals - plastic deformation occurs by slip – an edge dislocation (extra half-plane of atoms) slides over adjacent plane half-planes of atoms.

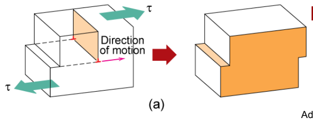


Adapted from Fig. 7.1, *Callister & Rethwisch 8e.*

- If dislocations can't move, plastic deformation doesn't occur!

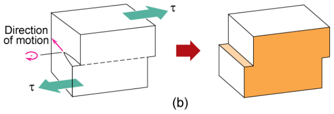
Dislocation Motion

- A dislocation moves along a slip plane in a slip direction perpendicular to the dislocation line
- The slip direction is the same as the Burgers vector direction

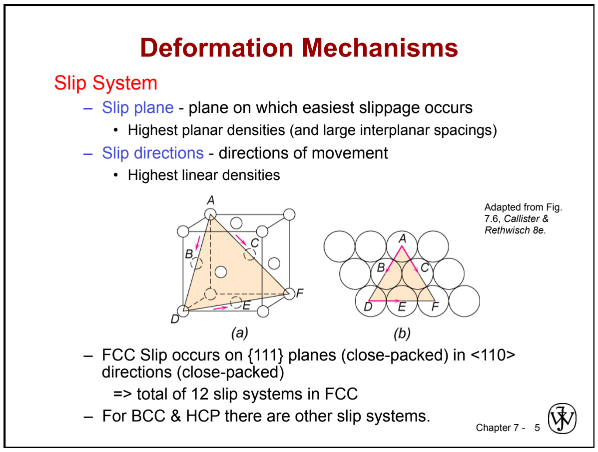


Edge dislocation

Adapted from Fig. 7.2, *Callister & Rethwisch 8e.*



Screw dislocation



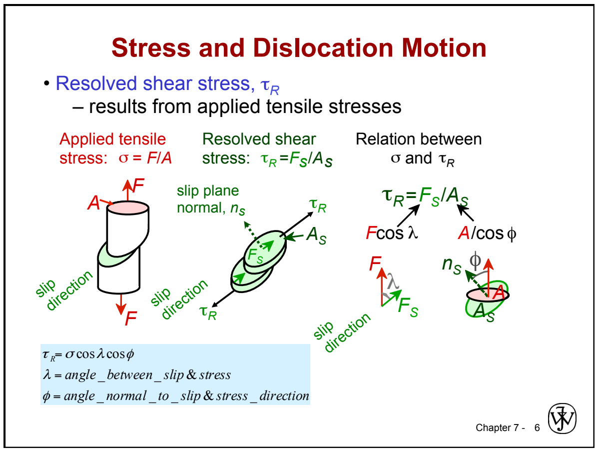
Deformation Mechanisms

Slip System

- Slip plane - plane on which easiest slippage occurs
  - Highest planar densities (and large interplanar spacings)
- Slip directions - directions of movement
  - Highest linear densities

Adapted from Fig. 7.6, *Callister & Rethwisch 8e.*

- FCC Slip occurs on {111} planes (close-packed) in <110> directions (close-packed)
  - => total of 12 slip systems in FCC
- For BCC & HCP there are other slip systems.



Stress and Dislocation Motion

- Resolved shear stress, τ_R
  - results from applied tensile stresses

Applied tensile stress: $\sigma = F/A$

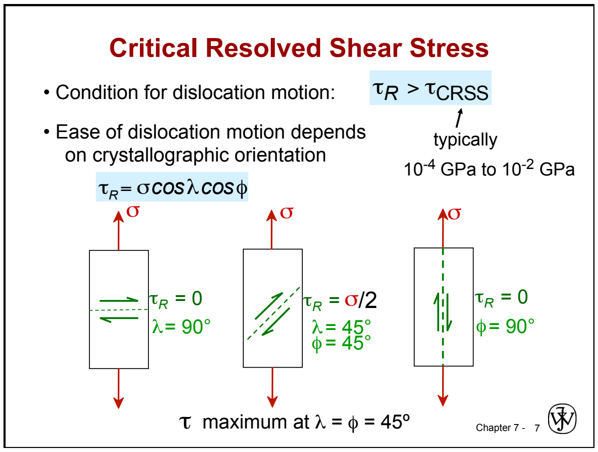
Resolved shear stress: $\tau_R = F_S/A_S$

Relation between σ and τ_R

$\tau_R = \sigma \cos\lambda \cos\phi$

$\lambda = angle\_between\_slip\,\&\,stress$

$\phi = angle\_normal\_to\_slip\,\&\,stress\_direction$



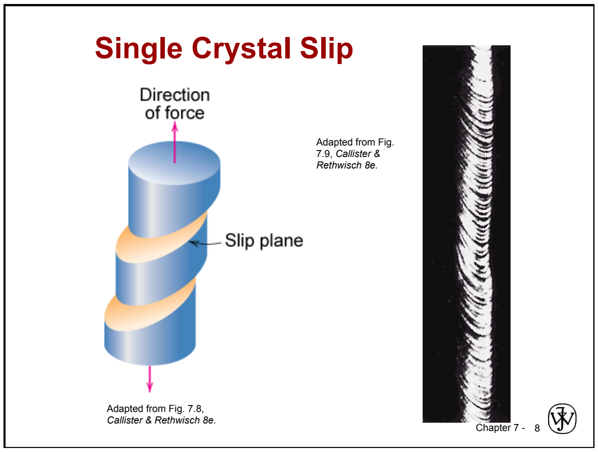
Critical Resolved Shear Stress

- Condition for dislocation motion: $\tau_R > \tau_{CRSS}$
- Ease of dislocation motion depends on crystallographic orientation

typically 10^{-4} GPa to 10^{-2} GPa

$\tau_R = \sigma \cos\lambda \cos\phi$

τ maximum at $\lambda = \phi = 45°$



Single Crystal Slip

Adapted from Fig. 7.8, *Callister & Rethwisch 8e.*

Adapted from Fig. 7.9, *Callister & Rethwisch 8e.*

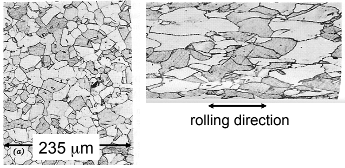
Slip Motion in Polycrystals

- Polycrystals stronger than single crystals – grain boundaries are barriers to dislocation motion.
- Slip planes & directions (λ, ϕ) change from one grain to another.
- τ_R will vary from one grain to another.
- The grain with the largest τ_R yields first.
- Other (less favorably oriented) grains yield later.

Adapted from Fig. 7.10, *Callister & Rethwisch 8e.* (Fig. 7.10 is courtesy of C. Brady, National Bureau of Standards [now the National Institute of Standards and Technology, Gaithersburg, MD].)

Anisotropy in σ_y

- Can be induced by rolling a polycrystalline metal
  - before rolling
  - after rolling

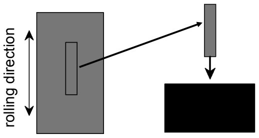


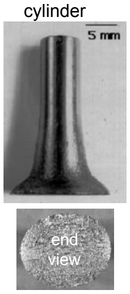
Adapted from Fig. 7.11, *Callister & Rethwisch 8e.* (Fig. 7.11 is from W.G. Moffatt, G.W. Pearsall, and J. Wulff, *The Structure and Properties of Materials*, Vol. I, *Structure*, p. 140, John Wiley and Sons, New York, 1964.)

- isotropic since grains are equiaxed & randomly oriented.
- anisotropic since rolling affects grain orientation and shape.

Anisotropy in Deformation

1. Cylinder of tantalum machined from a rolled plate:
2. Fire cylinder at a target.
3. Deformed cylinder



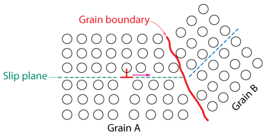


Photos courtesy of G.T. Gray III, Los Alamos National Labs. Used with permission.

- The noncircular end view shows anisotropic deformation of rolled material.

Four Strategies for Strengthening: 1: Reduce Grain Size

- Grain boundaries are barriers to slip.
- Barrier "strength" increases with Increasing angle of misorientation.
- Smaller grain size: more barriers to slip.



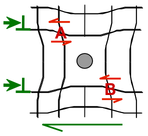
Adapted from Fig. 7.14, *Callister & Rethwisch 8e.* (Fig. 7.14 is from *A Textbook of Materials Technology*, by Van Vlack, Pearson Education, Inc., Upper Saddle River, NJ.)

- Hall-Petch Equation: $\sigma_{yield} = \sigma_o + k_y d^{-1/2}$

Four Strategies for Strengthening: 2: Form Solid Solutions

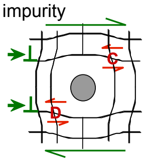
- Impurity atoms distort the lattice & generate lattice strains.
- These strains can act as barriers to dislocation motion.

- Smaller substitutional impurity



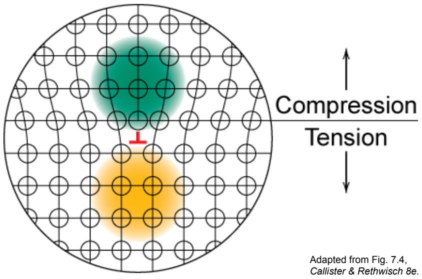
Impurity generates local stress at **A** and **B** that opposes dislocation motion to the right.

- Larger substitutional impurity



Impurity generates local stress at **C** and **D** that opposes dislocation motion to the right.

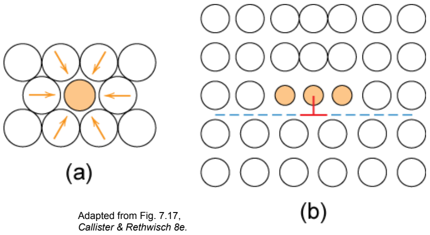
Lattice Strains Around Dislocations



Adapted from Fig. 7.4, *Callister & Rethwisch 8e.*

Strengthening by Solid Solution Alloying

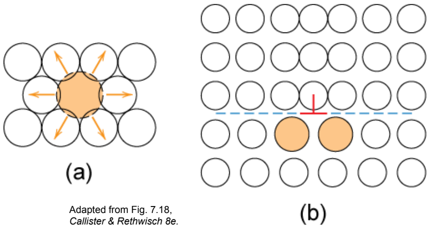
- Small impurities tend to concentrate at dislocations (regions of compressive strains) - partial cancellation of dislocation compressive strains and impurity atom tensile strains
- Reduce mobility of dislocations and increase strength



Adapted from Fig. 7.17, *Callister & Rethwisch 8e.*

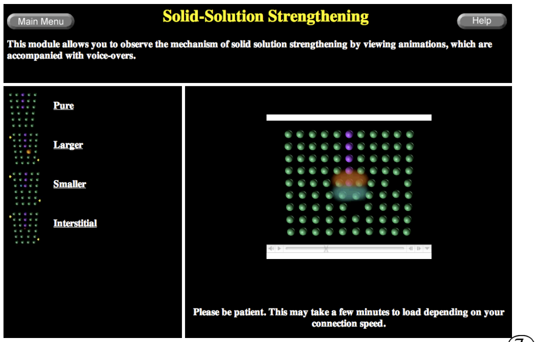
Strengthening by Solid Solution Alloying

- Large impurities tend to concentrate at dislocations (regions of tensile strains)



Adapted from Fig. 7.18, *Callister & Rethwisch 8e.*

VMSE Solid-Solution Strengthening Tutorial



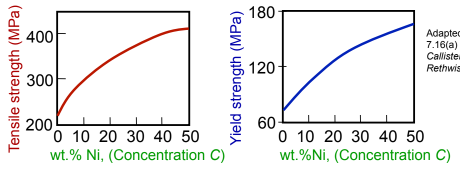
Solid-Solution Strengthening

This module allows you to observe the mechanism of solid solution strengthening by viewing animations, which are accompanied with voice-overs.

Please be patient. This may take a few minutes to load depending on your connection speed.

Ex: Solid Solution Strengthening in Copper

- Tensile strength & yield strength increase with wt% Ni.

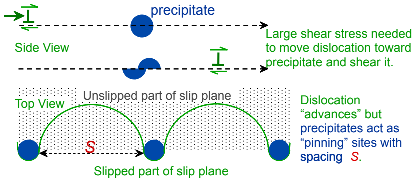


Adapted from Fig. 7.16(a) and (b), *Callister & Rethwisch 8e.*

- Empirical relation: $\sigma_y \sim C^{1/2}$
- Alloying increases σ_y and *TS*.

Four Strategies for Strengthening: 3: Precipitation Strengthening

- Hard precipitates are difficult to shear.
  Ex: Ceramics in metals (SiC in Iron or Aluminum).



Large shear stress needed to move dislocation toward precipitate and shear it.

Dislocation "advances" but precipitates act as "pinning" sites with spacing *S*.

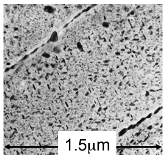
- Result: $\sigma_y \sim \dfrac{1}{S}$

Application: Precipitation Strengthening

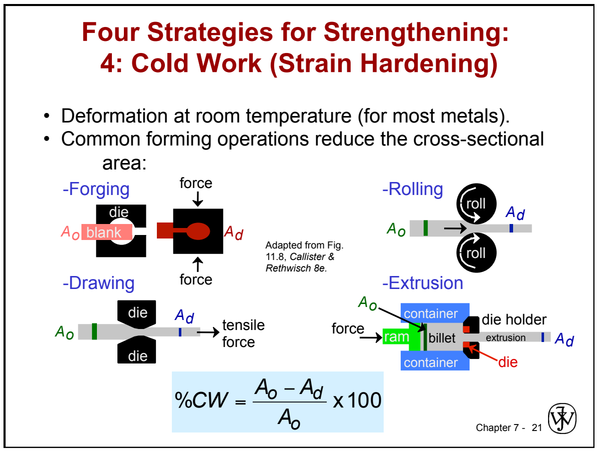
- Internal wing structure on Boeing 767

Adapted from chapter-opening photograph, Chapter 11, *Callister & Rethwisch 3e.* (courtesy of G.H. Narayanan and A.G. Miller, Boeing Commercial Airplane Company.)

- Aluminum is strengthened with precipitates formed by alloying.



Adapted from Fig. 11.26, *Callister & Rethwisch 8e.* (Fig. 11.26 is courtesy of G.H. Narayanan and A.G. Miller, Boeing Commercial Airplane Company.)

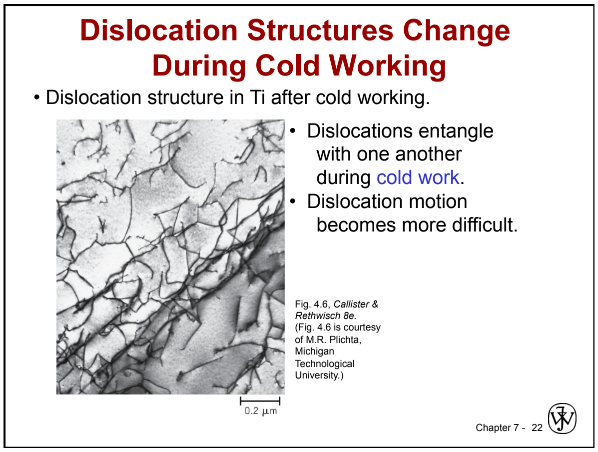


Four Strategies for Strengthening: 4: Cold Work (Strain Hardening)

- Deformation at room temperature (for most metals).
- Common forming operations reduce the cross-sectional area:

Adapted from Fig. 11.8, *Callister & Rethwisch 8e.*

$$\%CW = \frac{A_o - A_d}{A_o} \times 100$$



Dislocation Structures Change During Cold Working

- Dislocation structure in Ti after cold working.

- Dislocations entangle with one another during cold work.
- Dislocation motion becomes more difficult.

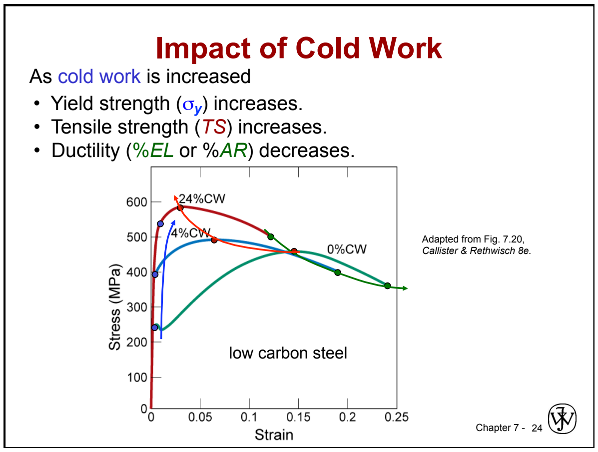
Fig. 4.6, *Callister & Rethwisch 8e.* (Fig. 4.6 is courtesy of M.R. Plichta, Michigan Technological University.)

Dislocation Density Increases During Cold Working

$$\text{Dislocation density} = \frac{\text{total dislocation length}}{\text{unit volume}}$$

- Carefully grown single crystals
  - → ca. 10^3 mm^{-2}
- Deforming sample increases density
  - → 10^9-10^{10} mm^{-2}
- Heat treatment reduces density
  - → 10^5-10^6 mm^{-2}

- Yield stress increases as ρ_d increases:

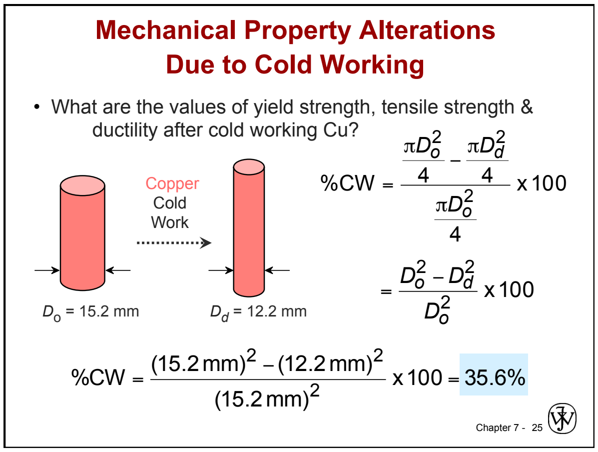


Impact of Cold Work

As cold work is increased

- Yield strength (σ_y) increases.
- Tensile strength (TS) increases.
- Ductility ($\%EL$ or $\%AR$) decreases.

Adapted from Fig. 7.20, *Callister & Rethwisch 8e.*



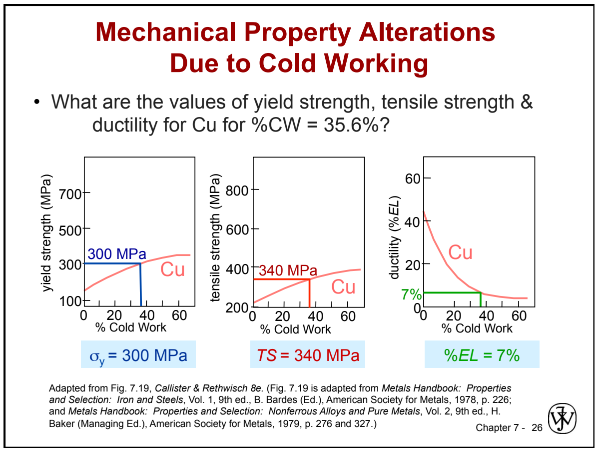
Mechanical Property Alterations Due to Cold Working

- What are the values of yield strength, tensile strength & ductility after cold working Cu?

$$\%CW = \frac{\frac{\pi D_o^2}{4} - \frac{\pi D_d^2}{4}}{\frac{\pi D_o^2}{4}} \times 100$$

$$= \frac{D_o^2 - D_d^2}{D_o^2} \times 100$$

$$\%CW = \frac{(15.2\,\text{mm})^2 - (12.2\,\text{mm})^2}{(15.2\,\text{mm})^2} \times 100 = 35.6\%$$



Mechanical Property Alterations Due to Cold Working

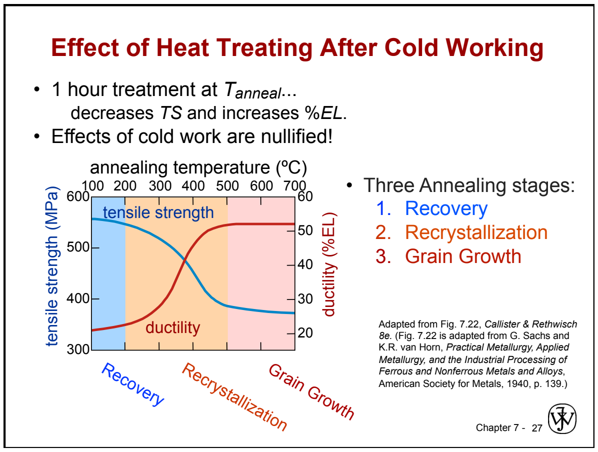
- What are the values of yield strength, tensile strength & ductility for Cu for %CW = 35.6%?

σ_y = 300 MPa

TS = 340 MPa

%*EL* = 7%

Adapted from Fig. 7.19, *Callister & Rethwisch 8e.* (Fig. 7.19 is adapted from *Metals Handbook: Properties and Selection: Iron and Steels*, Vol. 1, 9th ed., B. Bardes (Ed.), American Society for Metals, 1978, p. 226; and *Metals Handbook: Properties and Selection: Nonferrous Alloys and Pure Metals*, Vol. 2, 9th ed., H. Baker (Managing Ed.), American Society for Metals, 1979, p. 276 and 327.)

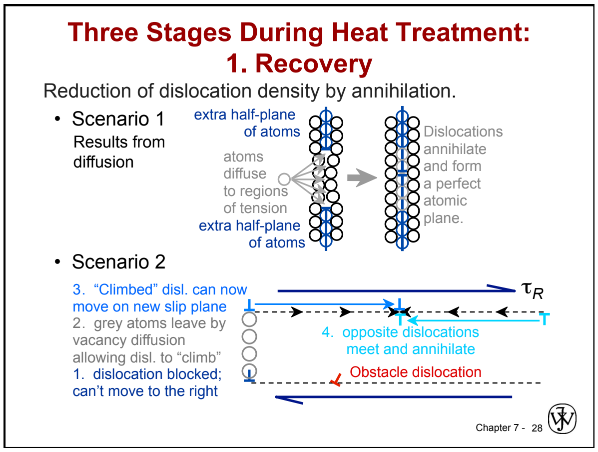


Effect of Heat Treating After Cold Working

- 1 hour treatment at T_{anneal}...
  decreases *TS* and increases %*EL*.
- Effects of cold work are nullified!

- Three Annealing stages:
  1. Recovery
  2. Recrystallization
  3. Grain Growth

Adapted from Fig. 7.22, *Callister & Rethwisch 8e.* (Fig. 7.22 is adapted from G. Sachs and K.R. van Horn, *Practical Metallurgy, Applied Metallurgy, and the Industrial Processing of Ferrous and Nonferrous Metals and Alloys*, American Society for Metals, 1940, p. 139.)

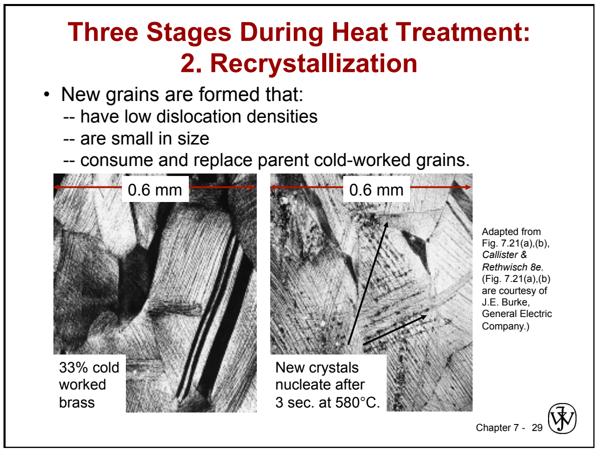


Three Stages During Heat Treatment: 1. Recovery

Reduction of dislocation density by annihilation.

- Scenario 1
  Results from diffusion

- Scenario 2



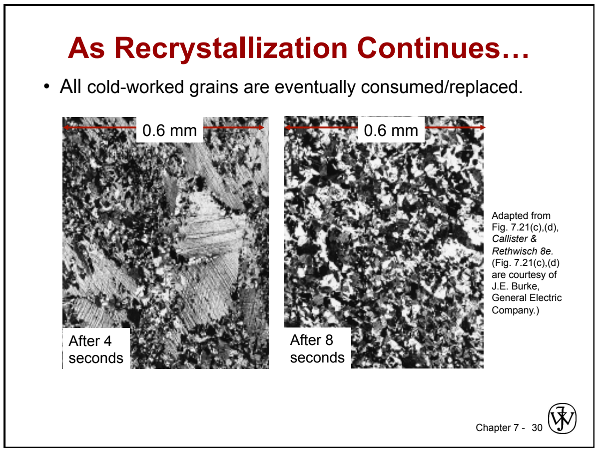
Three Stages During Heat Treatment: 2. Recrystallization

- New grains are formed that:
  - -- have low dislocation densities
  - -- are small in size
  - -- consume and replace parent cold-worked grains.

33% cold worked brass

New crystals nucleate after 3 sec. at 580°C.

Adapted from Fig. 7.21(a),(b), *Callister & Rethwisch 8e.* (Fig. 7.21(a),(b) are courtesy of J.E. Burke, General Electric Company.)



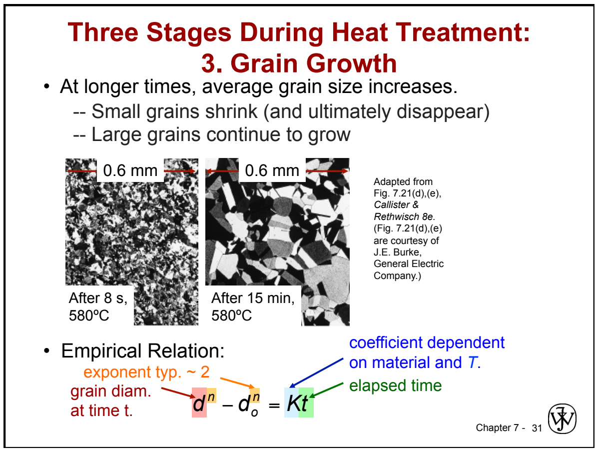
As Recrystallization Continues…

- All cold-worked grains are eventually consumed/replaced.

After 4 seconds

After 8 seconds

Adapted from Fig. 7.21(c),(d), *Callister & Rethwisch 8e.* (Fig. 7.21(c),(d) are courtesy of J.E. Burke, General Electric Company.)



Three Stages During Heat Treatment: 3. Grain Growth

- At longer times, average grain size increases.
  - -- Small grains shrink (and ultimately disappear)
  - -- Large grains continue to grow

After 8 s, 580ºC

After 15 min, 580ºC

Adapted from Fig. 7.21(d),(e), *Callister & Rethwisch 8e.* (Fig. 7.21(d),(e) are courtesy of J.E. Burke, General Electric Company.)

- Empirical Relation:

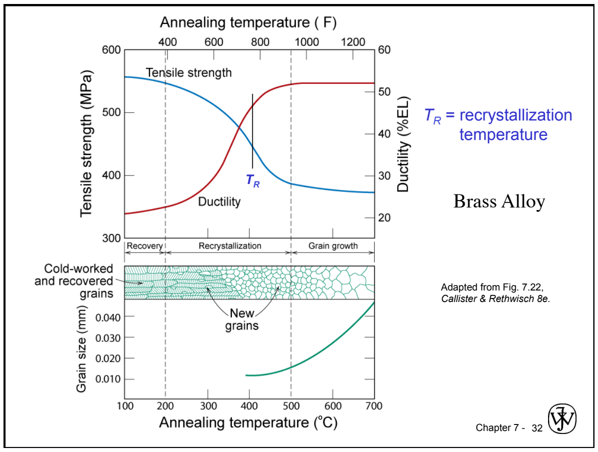
exponent typ. ~ 2

grain diam. at time t.

$$d^n - d_o^n = Kt$$

coefficient dependent on material and *T*.

elapsed time



T_R = recrystallization temperature

Brass Alloy

Adapted from Fig. 7.22, *Callister & Rethwisch 8e.*

Recrystallization Temperature

T_R = recrystallization temperature = temperature at which recrystallization just reaches completion in 1 h.

$$0.3T_m < T_R < 0.6T_m$$

For a specific metal/alloy, T_R depends on:

- %CW -- T_R decreases with increasing %CW
- Purity of metal -- T_R decreases with increasing purity

Recrystallization & Melting

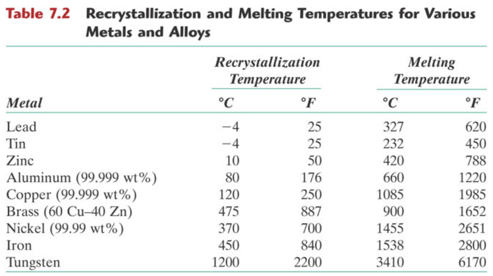


Table 7.2 **Recrystallization and Melting Temperatures for Various Metals and Alloys**

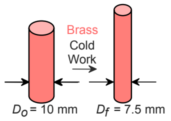
	Recrystallization Temperature		*Melting Temperature*	
Metal	*°C*	*°F*	*°C*	*°F*
Lead	−4	25	327	620
Tin	−4	25	232	450
Zinc	10	50	420	788
Aluminum (99.999 wt%)	80	176	660	1220
Copper (99.999 wt%)	120	250	1085	1985
Brass (60 Cu–40 Zn)	475	887	900	1652
Nickel (99.99 wt%)	370	700	1455	2651
Iron	450	840	1538	2800
Tungsten	1200	2200	3410	6170

Diameter Reduction Procedure - Problem

A cylindrical rod of brass originally 10 mm (0.39 in) in diameter is to be cold worked by drawing. The circular cross section will be maintained during deformation. A cold-worked tensile strength in excess of 380 MPa (55,000 psi) and a ductility of at least 15 %*EL* are desired. Furthermore, the final diameter must be 7.5 mm (0.30 in). Explain how this may be accomplished.

Diameter Reduction Procedure - Solution

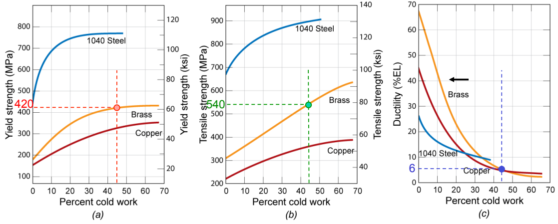
What are the consequences of directly drawing to the final diameter?



$$\%CW = \left(\frac{A_o - A_f}{A_o}\right) x\,100 = \left(1 - \frac{A_f}{A_o}\right) x\,100$$

$$= \left(1 - \frac{\pi D_f^2/4}{\pi D_o^2/4}\right) x\,100 = \left(1 - \left(\frac{7.5}{10}\right)^2\right) x\,100 = 43.8\%$$

Diamater Reduction Procedure – Solution (Cont.)

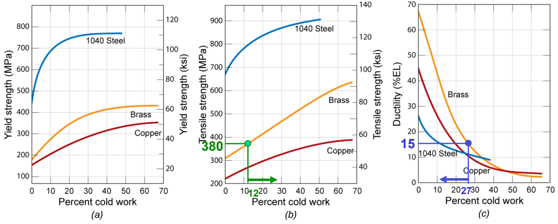


(a) (b) (c)

Adapted from Fig. 7.19, *Callister & Rethwisch 8e.*

- For %CW = 43.8%
  - σ_y = 420 MPa
  - *TS* = 540 MPa > 380 MPa
  - %*EL* = 6 < 15
- This doesn't satisfy criteria… what other options are possible?

Diameter Reduction Procedure – Solution (cont.)



(a) (b) (c)

Adapted from Fig. 7.19, *Callister & Rethwisch 8e.*

For *TS* > 380 MPa → > 12 %CW

For %*EL* > 15 → < 27 %CW

∴ our working range is limited to 12 < %CW < 27

Diameter Reduction Procedure – Solution (cont.)

Cold work, then anneal, then cold work again

- For objective we need a cold work of 12 < %CW < 27
  - We'll use 20 %CW
- Diameter after first cold work stage (but before 2nd cold work stage) is calculated as follows:

$$\%CW = \left(1 - \frac{D_{f2}{}^2}{D_{02}{}^2}\right) x\,100 \;\Rightarrow\; 1 - \frac{D_{f2}{}^2}{D_{02}{}^2} = \frac{\%CW}{100}$$

$$\frac{D_{f2}}{D_{02}} = \left(1 - \frac{\%CW}{100}\right)^{0.5} \;\Rightarrow\; D_{02} = \frac{D_{f2}}{\left(1 - \frac{\%CW}{100}\right)^{0.5}}$$

$$\text{Intermediate diameter} = D_{f1} = D_{02} = 7.5\,\text{mm} \Big/ \left(1 - \frac{20}{100}\right)^{0.5} = \boxed{8.39\,\text{mm}}$$

Diameter Reduction Procedure – Summary

Stage 1: Cold work – reduce diameter from 10 mm to 8.39 mm

$$\%CW_1 = \left(1 - \left(\frac{8.39\,\text{mm}}{10\,\text{mm}}\right)^2\right) x\,100 = 29.6$$

Stage 2: Heat treat (allow recrystallization)

Stage 3: Cold work – reduce diameter from 8.39 mm to 7.5 mm

$$\%CW_2 = \left(1 - \left(\frac{7.5}{8.49}\right)^2\right) x\,100 = 20 \;\overset{\text{Fig 7.19}}{\Rightarrow}\; \boxed{\begin{aligned}\sigma_y &= 340\,\text{MPa}\\ TS &= 400\,\text{MPa}\\ \%EL &= 24\end{aligned}}$$

Therefore, all criteria satisfied

Cold Working vs. Hot Working

- Hot working → deformation above T_R
- Cold working → deformation below T_R

Grain Size Influences Properties

- Metals having small grains – relatively strong and tough at low temperatures
- Metals having large grains – good creep resistance at relatively high temperatures

Summary

- Dislocations are observed primarily in metals and alloys.
- Strength is increased by making dislocation motion difficult.
- Strength of metals may be increased by:
  - -- decreasing grain size
  - -- solid solution strengthening
  - -- precipitate hardening
  - -- cold working
- A cold-worked metal that is heat treated may experience recovery, recrystallization, and grain growth – its properties will be altered.

ASSIGNMENT/DUE DATE

Reading: Chapters 7 & 8/2-28-12

Problems: 7.5, 7.22, 7.27, 7.D7/3-1-12