

STRUCTURE, PROPERTIES OF ECAP DEFORMED Cu AND Ni-Ti SHAPE MEMORY ALLOYS

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ABSTRACT

This paper was aimed at verification of functionality of the ECAP technology at extrusion of the copper and Ni-Ti alloys. Cross-section of original samples was 8 x 8 mm and their length was 32 mm. The samples of Cu were extruded at room temperature. For the samples of Ni-Ti alloys was used the two-stage pressing, when the samples were extruded at temperature of approx. $T_1 = 520\text{ }^{\circ}\text{C}$ and $T_2 = 420\text{ }^{\circ}\text{C}$. In order to increase the concentration of deformation in volume of the sample, the samples were turned around their longitudinal axis by 90 ° after individual passes and they were extruded again. Deformation forces were measured during extrusion, resistance to deformation was calculated and deformation speed was approximately determined. Analysis of structure was made by using of light microscopy.

Keywords : ECAP technology, Cu and Ni-Ti alloy, structure, mechanical properties

1. INTRODUCTION

The extrusion by ECAP method enables obtaining a fine-grain structure in larger volumes. Products made by this technique are characterised by high strength properties (Fig.1), and they can be potentially used at subsequent super-plastic forming. Magnitude of deformation, development of structure and resulting mechanical properties achieved by this technique depend notably on: homologous temperature T_h , size of grain d_z , deformation speed $\dot{\epsilon}$, homologous tension in die (σ/E), density of structural failures, on purity, etc. The obtaining required final structure depends primarily on geometry of tool, number of passes through die, obtained magnitude and speed of deformation, temperature, etc.

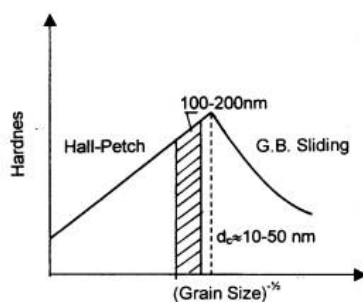


Figure 1. Predicted dependence of strength on grain size [1]

2. DEVELOPMENT OF STRUCTURE

Influence of magnitude of plastic deformation on properties of metallic materials is connected with increasing internal energy. Internal energy increases right to the limit value, which depends on manner of deformation, purity, grain size, temperature, etc. As a result of non-homogeneity of deformation at ECAP technique the internal energy gain differs at different places of formed alloy [2]. For example the value of internal energy is different in slip planes, at boundaries and inside cells. It is possible to observe higher internal energy also in proximity of precipitates, segregates and solid structural phases. For usual techniques, pure metals, medium magnitude of deformation and temperatures the value of stored energy is said to be approx. around 10 J.mol^{-1} [3].

3. EXPERIMENTAL MATERIALS AND PROCEDURES

The experiment was divided into three parts. In the first part of experiment the copper was pressed in the second part Ni-Ti alloy was extruded. The chemical composition of Cu and Ni-Ti alloys is demonstrated in the Table 1. Cross-section of original samples of Cu and Ni-Ti alloys was $8 \times 8 \text{ mm}$ and their length was 32 mm . The samples of Cu were extruded at room temperature. For the samples of Ni-Ti alloy was used the two-stage pressing, when the samples were extruded at temperature of approx. $T_1 = 325 \text{ }^\circ\text{C}$ and $T_2 = 220 \text{ }^\circ\text{C}$. In order to increase the concentration of deformation in volume of the sample, the samples were turned around their longitudinal axis by 90° after individual passes and they were extruded again.

Table 1. Chemical composition of Cu and Ni-Ti alloys

Alloys	Chemical composition, %							
	Cu	Ni	Ti	Fe	Pb	P	As	O
Cu	99.5	-	-	-	0.05	0.04	0.04	0.02
Ni-Ti	-	50.00	49.00	1.00	-	-	-	-

The experiments were aimed at determination of extrusion force, pressure necessary in individual stages of extrusion, change of strength properties in dependence on number of extrusions and change of structure.

In the first part of the experiment we used for extrusion the copper. Original samples were processed by cold forming and they were afterwards annealed at temperature of $870 \text{ }^\circ\text{C}/3\text{h}$. Initial shape of the samples and shapes of samples after individual stages of extrusion are shown in Fig 2.



Figure 2. Copper samples after individual passes with using the ECAP technology

The samples were extruded at temperature of approx. $20 \text{ }^\circ\text{C}$. The samples are ordered from the left to the right according to number of passes. We measured at extrusion the deformation forces and we have also calculated the pressure needed for extrusion [4]. We approximately determined the strain rate, which was approx. $2,3 \cdot 10^{-2} \text{ s}^{-1}$. The structure analysis was made by optical microscopy. Structure of original samples and that of samples after individual stages of extrusion is shown on Fig. 3.

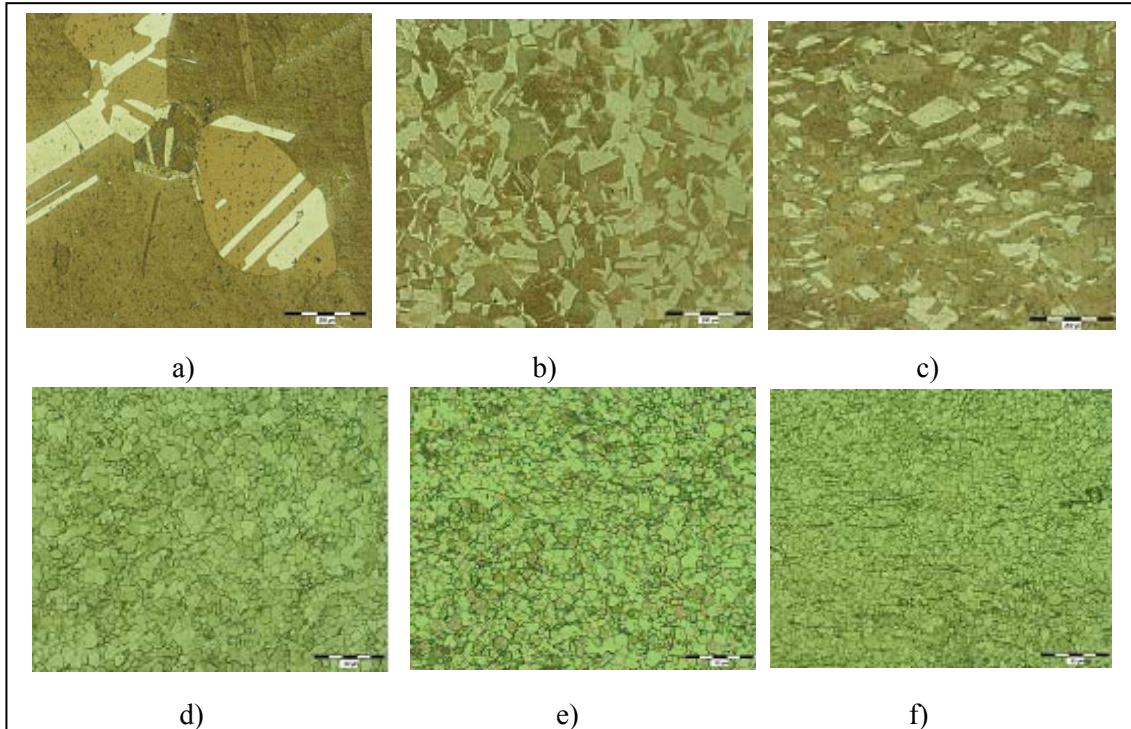


Figure 3. Development of structure (in longitudinal direction) at extrusion of copper: a – initial structure , b – structure after the 2st extrusion, c – structure after the 3nd extrusion, d) structure after the 4th extrusion, e) structure after 6th extrusion, f) structure after 9nd extrusion

In the second part of the experiment Ni-Ti alloy was pressed. Before pressing the samples were annealed for ECAP. The temperature of annealing was 850 °C and the idle period of the anneal temperature was 30 min. After annealing the metalographical examination of structure was made (Fig. 4), the tensile test on the miniaturized samples and the hardness HV. The fortness of samples after annealing was moving about 308,7 MPa and the hardness from 100 till 104 HV [5]. The structure of Ni-Ti after annealing is more ferrite material with very little grains. The average size of seed is moving about 30 µm.

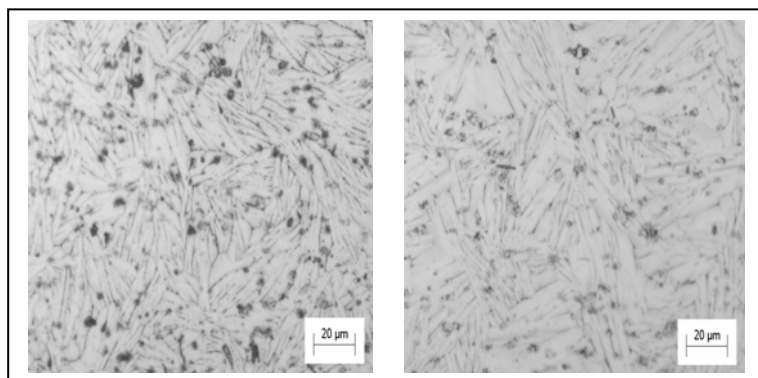


Figure 4. Structure of Ni-Ti alloy after annealing: a) in longitudinal direction and b) in transverse direction

There were used the two-stage pressing, the samples were extruded at temperature of approx. $T_1 = 520\text{ }^{\circ}\text{C}$ and $T_2 = 420\text{ }^{\circ}\text{C}$. Structure analysis was made by optical microscopy. Structure of original samples and that of samples after individual stages of extrusion is shown in Fig 5.

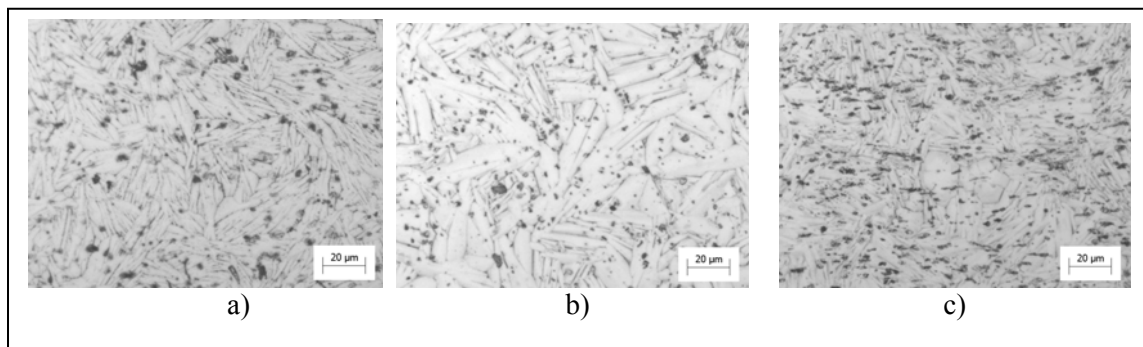


Figure 5. Development of structure at extrusion of Ni-Ti alloy:
 a) initial structure, b – structure after the 1th extrusion and c) structure after the 3th extrusion

4. EXPERIMENTAL RESULTS

For copper: After individual passes there it occurred an accumulation of deformation strengthening, e.g. at extrusion with radius of rounding of inside cants ($R = 0,5$) the extrusion pressure at the beginning varied around $\tau_1 = 510$ MPa. At the second extrusion it increased to $\tau_2 = 615$ MPa, and at the third extrusion it increased to $\tau_3 = 745$ MPa [6].

For Ni-Ti alloy: During pressing the press power was moving due to depending on degree of fulling the die channel. For the 1th sample was $F_{\max} = 90$ kN, for the 2nd sample was $F_{\max} = 95$ kN and for the 3th sample was $F_{\max} = 125$ kN. The press on ejecting punch subject to these powers: 1435 MPa, 1485 MPa and 1920 MPa. The press power was going up with growing deformation (the hardening sample). The stability properties are going up with size of deformation ($e = 3,54$) and during four passes raise double [7]. The tensibility is going down. It is caused by recovery processes which were not passed. The tensibility is going up due to softer seen.

5. CONCLUSION

The experiments were made on poly-crystalline copper and on Ni-Ti alloy have confirmed that the ECAP method is efficient tool for refining of grain. Microstructure depends on experimental conditions, particularly on number of passes and on rotation of the sample between individual passes. The angle between horizontal and vertical part of extrusive channel was for this experiment around 90° for Cu and for Ni-Ti around 105° . Radii of rounding of working parts of extrusive channel must correspond to conditions for laminar flow of metal.

6. ACKNOWLEDGEMENTS

The works were realised under support of the Czech Ministry of Education project VS MSM 619 891 0013

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