

Contents

PART I. INTRODUCTORY CHAPTERS ON DEFORMATION AND FAILURE UNDER CREEP CONDITIONS

1	SUMMARY OF THE DEFORMATION BEHAVIOR UNDER CREEP CONDITIONS	3
1.1	The Creep Curve	3
1.2	A Few Facts on the Micromechanisms Underlying the Creep Curve	4
1.3	Diffusion Creep	6
1.4	Inhibition of Diffusion Creep	7
1.5	Grain Boundary Sliding	8
1.5.1	The infinite grain boundary (an intrinsic sliding model)	8
1.5.2	Grain boundary sliding in polycrystals (extrinsic models)	10
1.6	Deformation-Mechanism Maps	11
2	INTRODUCTION TO CREEP FRACTURE AND OTHER FRACTURE MODES	14
2.1	The Nature of Creep Damage	14
2.2	Fracture-Mechanism Maps	15
2.2.1	Cleavage and brittle intergranular fracture	16
2.2.2	Ductile transgranular fracture by plastic hole growth	18
2.2.3	Necking and superplasticity	18
2.2.4	Intergranular creep fracture	21
2.2.5	Rupture by dynamic recrystallization	21
2.2.6	Fracture at very high temperature	22
2.3	Empirical Formulas for the Rupture Time in the Creep Regime	23
2.3.1	The Monkman-Grant rule	23
2.3.2	The Sherby-Dorn parameter	23
2.3.3	The Larson-Miller parameter	24
2.3.4	The Kachanov equations	24
2.3.5	The θ -projection concept	26
3	THE CONTINUUM-MECHANICAL EQUATIONS	27
3.1	The Equations for Equilibrium and Compatibility	27
3.2	The Material Law	28
3.3	The Equations for Antiplane Shear, Plane Stress and Plane Strain	29
3.4	General Features of the Continuum-Mechanical Fields	33
3.4.1	The elastic-viscous analogy (Hoff, 1954)	33
3.4.2	Scaling properties for power-law materials (Ilyushin, 1946)	33
3.4.3	Path-independent integrals: J and C^*	34
3.4.4	The HRR crack-tip fields in power-law materials	36
3.5	Numerical Techniques in Solid Mechanics	39
4	STRESS-DIRECTED DIFFUSION AND SURFACE DIFFUSION	40
4.1	The Role of Vacancy Sources in Stress-Directed Diffusion	40
4.2	Stress-Directed Diffusion Along Grain Boundaries	41
4.3	Stress-Directed Diffusion Through the Grains	43
4.4	Surface Diffusion	45
4.5	Grain-Boundary Diffusion Combined with Power-Law Creep	46

Part II. CREEP CAVITIES

5	INTRODUCTION TO PART II	51
5.1	Experimental Techniques	52
5.2	Materials which Exhibit Intergranular Cavitation	53
5.3	Diffusion as the General Cause for Intergranular Cavitation	55
5.4	The Role of Grain Boundary Sliding	56
5.4.1	Experiments on bicrystals	56
5.4.2	The orientation of cavitating boundaries in polycrystals	56
5.5	Cavity Nucleation Sites	57
5.5.1	Slip bands	57
5.5.2	Grain-boundary ledges	57
5.5.3	Triple grain junctions	59
5.5.4	Grain boundary particles	59
5.6	Wedge Cracks	61
5.7	Some Observations on the Kinetics of Cavity Nucleation	62
5.7.1	The observed nucleation kinetics	62
5.7.2	Is there a critical stress for cavity nucleation?	65
5.8	Pre-Existing Cavities	66
6	NUCLEATION OF CREEP CAVITIES / BASIC THEORIES	67
6.1	Cavity Nucleation by the Rupturing of Atomic Bonds	67
6.2	Cavity Nucleation by Vacancy Condensation	69
6.2.1	Historical remarks and related subject areas	69
6.2.2	Cavity shapes	70
6.2.3	The free energy of a cavity	72
6.2.4	The nucleation rate according to Raj and Ashby	75
6.2.5	The Fokker-Planck equation	77
6.2.6	The steady-state nucleation rate and the nucleation stress	78
6.2.7	Transient solutions of the Fokker-Planck equation and incubation times	80
6.3	Discussion of Cavity Nucleation Theories	82
6.3.1	A theoretical remark	83
6.3.2	On possible causes for the discrepancy between theoretical and experimental nucleation stresses	83
6.3.3	The problem of continuous cavity nucleation	84
7	CAVITY NUCLEATION BY STRESS CONCENTRATIONS DURING CREEP	85
7.1	An Isolated Sliding Grain Boundary Facet (Shear-Crack Model)	86
7.1.1	Elastic analysis of a sliding facet	86
7.1.2	A sliding boundary facet (shear crack) in creeping material	89
7.1.3	Relaxation of elastic stress concentrations at a shear crack by power-law creep	90
7.1.4	The time to build up elastic stress concentrations	91
7.2	The Triple Grain Junction in Polycrystals	92
7.2.1	The triple junction in elastic material	93
7.2.2	The triple junction in power-law creeping material	94
7.2.3	Stresses during Coble creep (rigid grains)	96
7.2.4	A combination of power-law creep and grain-boundary diffusion	98
7.2.5	Relaxation of elastic stress concentrations at triple junctions by creep	99
7.2.6	Relaxation of elastic stress concentrations at triple points by diffusion	99

7.3	Stress Concentrations at Particles on Sliding Grain Boundaries	102
7.3.1	Elastic stress concentrations at two-dimensional particles	102
7.3.2	Elastic stress concentrations at three-dimensional particles	103
7.3.3	Stresses at two-dimensional particles during power-law creep	105
7.3.4	Stresses at three-dimensional particles during power-law creep	107
7.3.5	Diffusion and creep around particles during power-law creep of the grains	108
7.3.6	Stresses at particles during (free and inhibited) Coble creep	110
7.3.7	Relaxation of elastic stress concentrations at particles by creep	112
7.3.8	Relaxation of elastic stress concentrations at particles by diffusion	113
7.4	Stresses at Grain-Boundary Ledges	114
7.5	Summary of Stress Concentrations	115
8	THE ROLE OF IMPURITY SEGREGATION IN CAVITY NUCLEATION	116
8.1	Qualitative Observations	116
8.1.1	Grain-boundary brittleness at room temperature (temper embrittlement)	116
8.1.2	Embrittlement by impurity segregation under creep conditions	117
8.1.3	Stress relief cracking or reheat cracking	119
8.2	Theories Related to Segregation and Cohesion	121
8.2.1	Segregation equilibria	121
8.2.2	Segregation kinetics	123
8.2.3	Calculation of interface energies from adsorption data	124
8.2.4	The relevance of segregation for decohesion	127
8.2.5	The effect of segregation on cavity nucleation by vacancy condensation	129
9	CAVITY NUCLEATION ASSISTED BY INTERNAL GAS PRESSURE	131
9.1	Oxygen Attack and Related Phenomena	131
9.1.1	The equilibrium carbon-dioxide pressure in nickel	132
9.1.2	Carbon-oxides in nickel-chromium alloys	135
9.2	Hydrogen Attack	136
9.3	Helium Embrittlement	138
9.4	Kinetic Aspects	139
10	INTERNAL STRESSES DUE TO THE PRECIPITATION OF SOLID PHASES AND THERMAL EXPANSION	140
10.1	The Flux of Carbon to the Carbide	140
10.2	Elastic Accommodation	142
10.3	Accommodation by Power-Law Creep	144
10.4	Accommodation by Grain Boundary Diffusion	145
10.5	Decohesion of Particles by Thermal Expansion	146
10.6	Grain-Boundary Decohesion by Thermal-Expansion Anisotropy	147
11	DIFFUSIVE CAVITY GROWTH	148
11.1	Diffusional Growth of Lens-Shaped (Equilibrium) Cavities	149
11.1.1	The stress distribution between the cavities the cavity growth rate	150

11.1.2	Rupture times by diffusive cavity growth neglecting nucleation	154
11.1.3	The effect of the sintering stress on the rupture time	155
11.1.4	Removal of cavities by compressive loads or by surface tension forces	156
11.1.5	The effect of impurity segregation on diffusive cavity growth	158
11.1.6	The effect of gas pressure on the diffusive cavity growth rate	159
11.2	Diffusional Growth of Non-Equilibrium Cavities	160
11.2.1	The procedure to solve the coupled problem of surface diffusion and grain boundary diffusion	161
11.2.2	Re-formulation of the surface diffusion problem	161
11.2.3	A steady-state solution of the surface diffusion problem in the crack-like limit	163
11.2.4	Similarity solutions for the surface diffusion problem	164
11.2.5	The relation between growth rate and stress in the crack-like limit	165
11.2.6	Rupture times for non-equilibrium growth	167
11.2.7	Experiments on copper and silver containing water vapor bubbles	169
11.2.8	Void-shape instability/finger-like cavity growth	170
12	CONSTRAINED DIFFUSIVE CAVITATION OF GRAIN BOUNDARIES	172
12.1	Cavity Growth Rates for Constrained Cavitation of an Isolated Facet	173
12.1.1	A tensile-crack model for the calculation of constrained growth rates	173
12.1.2	Comparison with measured cavity growth rates	175
12.1.3	Additional remarks on constrained cavity growth rates	179
12.2	The Time to Cavity Coalescence on an Isolated Boundary Facet	181
12.3	On the Irrelevance of Constrained Cavity Growth for Rupture Lifetimes	181
12.4	Comparison of Calculated Times to Cavity Coalescence on Isolated Facets with Measured Rupture Lifetimes of Pre-Cavitated Materials	182
12.4.1	Rupture lifetime of prestrained Nimonic 80A	182
12.4.2	Rupture lifetime of prestrained Inconel alloy X-750	183
12.4.3	Rupture time of α -brass with implanted water vapor bubbles	184
12.5	Constitutive Behavior of Creeping Materials Containing Widely Spaced Cavitating Grain Boundary Facets	185
12.5.1	The constrained limit (Hutchinson's model)	185
12.5.2	The unconstrained limit	186
12.5.3	The effect of cavitation on diffusion creep	187
12.6	Interaction Between Closely Spaced Cavitating Boundary Facets	188
12.6.1	Self-consistent models for constrained cavitation	188
12.6.2	The penny-shaped crack in a finite cylinder	190
12.6.3	Interactions between closely spaced facets in the presence of grain boundary sliding	191
12.7	Time to Rupture for Interacting Facets	193
12.7.1	Failure by large strains	193
12.7.2	Rupture lifetimes for continuous nucleation of cavitating facets	194
12.7.3	The combined effect of necking and continuous nucleation	196
12.8	Conclusions on Constrained Cavitation	197

13	INHIBITED CAVITY GROWTH	198
13.1	Inhibited Cavity Growth Rates	198
13.2	Time to Cavity Coalescence and Time to Rupture for Inhibited Growth	200
14	CAVITY GROWTH BY CREEP FLOW OF THE GRAINS OR BY GRAIN BOUNDARY SLIDING	201
14.1	Hole Growth by Creep Flow of the Grains	201
14.1.1	The growth of isolated holes in linearly viscous materials	202
14.1.2	An isolated circular-cylindrical void in nonlinear viscous material	204
14.1.3	Spherical voids in nonlinear material under axisymmetric loading. Comparison with penny-shaped cracks	206
14.1.4	Strain to failure neglecting void interaction effects	209
14.1.5	Void interaction effects	210
14.2	Cavity Growth by Grain Boundary Sliding	212
15	CREEP-ENHANCED DIFFUSIVE CAVITY GROWTH AND ELASTIC ACCOMMODATION	215
15.1	Cavity Growth by a Coupling of Diffusion and Power-Law Creep	215
15.1.1	Models for the interactive growth mechanism	215
15.1.2	Comparison with experiments	218
15.2	Diffusive Cavity Growth with Elastic Accommodation	220
15.2.1	Elasticity effects in the growth of equilibrium-shaped cavities	220
15.2.2	Crack-like cavity growth with elastic accommodation	221
16	THE CAVITY SIZE DISTRIBUTION FUNCTION FOR CONTINUOUS CAVITY NUCLEATION. RUPTURE LIFETIMES AND DENSITY CHANGES	225
16.1	The Cavity Size Distribution Function	225
16.2	The Cavitated Area Fraction and the Rupture Lifetime	227
16.2.1	Lifetimes for diffusive cavity growth and continuous nucleation	228
16.2.2	Crack-like diffusive growth and continuous nucleation	231
16.2.3	Constrained diffusive growth and continuous nucleation	231
16.2.4	Inhibited cavity growth and continuous nucleation	233
16.2.5	Plastic hole growth and continuous nucleation	233
16.3	Comparison of Calculated Rupture Times with Experiments Involving Continuous Nucleation	234
16.3.1	Rupture lifetimes of ferritic steels	234
16.3.2	Lifetimes of austenitic steels	237
16.3.3	Rupture lifetimes of astroloy	239
16.4	Density Changes During Cavitation	240
17	SUMMARY OF RESULTS ON CAVITY NUCLEATION AND GROWTH	242
17.1	Nucleation	242
17.2	Cavity Growth Rates and Rupture Lifetimes for Instantaneous Nucleation	243
17.3	Rupture Lifetimes for Continuous Nucleation	246

18	GRAIN BOUNDARY CAVITATION UNDER CREEP-FATIGUE CONDITIONS	247
18.1	Micromechanisms of Creep-Fatigue Failure	247
18.2	Theories of Cavitation Failure for Slow-Fast Fatigue Loading	248
18.2.1	Cycles to failure for unconstrained diffusive cavity growth	249
18.2.2	Cycles to failure for plastic hole growth	251
18.2.3	Cycles to failure for unconstrained growth	252
18.2.4	Summary of fatigue lifetimes for different cavity growth mechanisms	253
18.3	Comparison with Results of Slow-Fast Tests	254
18.3.1	Low-cycle fatigue tests on Al-5%Mg	254
18.3.2	Low-cycle fatigue tests on nickel	255
18.3.3	Low-cycle fatigue tests on copper	256
18.3.4	Low-cycle fatigue tests on austenitic steel	257
18.4	Why Do Cavities Grow under Balanced Cyclic Loading?	258
18.5	Discussion	259

PART III. CREEP CRACK GROWTH AND CREEP-FATIGUE CRACK GROWTH

19	INTRODUCTION TO PART III	263
19.1	The Relevance of Cracks	263
19.2	The First Aspect: Deformation Fields in Cracked Bodies	264
19.3	The Second Aspect: Micromechanisms	265
19.3.1	Grain boundary cavitation ahead of the crack tip	265
19.3.2	Corrosive processes at the crack tip	266
20	NONLINEAR VISCOUS MATERIALS AND THE USE OF C*	267
20.1	Definition of the C*-Integral	267
20.2	Stress Fields and the C*-Integral in Power-Law Viscous Materials	268
20.2.1	The C*-integral in power-law viscous materials	269
20.2.2	Crack-tip fields in power-law viscous materials	271
21	C*-CONTROLLED CREEP CRACK GROWTH BY GRAIN-BOUNDARY CAVITATION	272
21.1	Creep Crack Growth Based on a Local Critical-Strain Criterion	273
21.2	Strain-Controlled Cavity Growth and Stress-Controlled Nucleation	277
21.3	Diffusive Growth of a Constant Number of Cavities	279
21.4	Diffusive Cavity Growth and Stress-Controlled Nucleation	280
21.5	Comparison with Experiments	281
21.5.1	Tests on a 1Cr-1/2Mo steel	281
21.5.2	Comparison of the data with models	283
21.5.3	Conclusions	285
22	SPECIMEN SIZE REQUIREMENTS FOR C*-TESTING CAUSED BY CRACK-TIP BLUNTING AND BY 3-D EFFECTS	286
22.1	Limitations to C* Set by Blunting	286
22.2	The Third Dimension in Fracture Mechanics and its Practical Consequences	288
22.2.1	The C*-integral in three dimensions	289

22.2.2	Crack-tip fields in specimens of finite thickness	290
22.2.3	The singularity at the intersection of the crack front with the surface	290
22.2.4	Ranges of validity of singular fields in parallel-sided specimens with straight crack fronts	292
22.2.5	Conditions for plane strain near the crack tip	293
22.2.6	Thumbnail-shaped crack fronts	295
22.2.7	Shear lips	296
22.2.8	Crack-tip fields in side-grooved specimens	297
22.2.9	The compliance and C^* in parallel-sided and side-grooved specimens	298
23	ELASTIC/NONLINEAR VISCOUS MATERIALS. APPLICABILITY OF K_I AND OF C^*	301
23.1	Stationary Crack under Step Loading	301
23.1.1	Similarity solutions in the small-scale creep, or short-time, limit	302
23.1.2	The crack-tip field in the short-time limit	304
23.1.3	The complete stress field in the short-time limit	305
23.1.4	The creep zone	306
23.1.5	A characteristic transition time	308
23.1.6	Interpolation formulas for the transient regime	309
23.1.7	Possible generalizations and related work	311
23.2	Stress Fields at Growing Cracks in Elastic/Nonlinear Viscous Material	312
23.2.1	Derivation of the singularity at growing cracks for Mode III	312
23.2.2	The growing crack singularity: results for Mode I	314
23.2.3	Fields for steady-state crack growth under small-scale creep conditions	315
23.2.4	Steady-state crack growth during extensive creep of the whole specimen	316
23.2.5	The evolution of the asymptotic field under non-steady-state conditions	317
23.3	Crack Growth in Elastic/Nonlinear Viscous Material Subject to a Critical-Strain Criterion	319
23.3.1	Analysis of the case $r_{HR} < x_0$ and $a-a_0 < r_{cr}$	319
23.3.2	Crack growth subject to a critical-strain criterion for small-scale creep	321
23.4	Application to Experiments	324
23.4.1	The appropriate load parameter	324
23.4.2	A 1Cr-1/2Mo steel	324
23.4.3	Nimonic 80A	325
24	INSTANTANEOUS PLASTICITY	327
24.1	Deformation Fields in Elastic/Plastic Material	328
24.2	Growth of a Creep Zone in an Initially Fully-Plastic Body	329
24.3	The Special Case $N = 1/n$	330
24.4	An Experimental Example for J-Controlled Creep Crack Growth	331
25	PRIMARY-CREEP EFFECTS	332
25.1	Strain-Hardening Model for Primary Creep	332
25.1.1	Primary creep of the whole specimen	333
25.1.2	Growth of a primary-creep zone in an elastic field	334

25.1.3	Growth of a secondary-creep zone in a primary-creep field	335
25.1.4	Summary and introduction of a load parameter map	336
25.2	Hardening/Recovery Model for Primary Creep	338
25.2.1	The constitutive equations	338
25.2.2	Solutions for crack geometries	340
25.2.3	Elasticity effects and load parameter map	341
25.3	Analysis of an Experiment in the Transition Range Between J , C_h^* and C^*	342
26	DIFFUSION CREEP	346
26.1	Constitutive Law	346
26.2	The Effect of Diffusion Creep on the Deformation Fields in Cracked Bodies	346
26.3	Crack Growth Rates Assuming a Critical-Strain Criterion	348
27	A DAMAGE MECHANICS APPROACH TO CREEP CRACK GROWTH	349
27.1	Introduction	349
27.1.1	The constitutive model	349
27.1.2	The relation between fracture mechanics and damage mechanics	350
27.2	Small-Scale Damage in Extensively Creeping Specimens	352
27.2.1	Similarity solutions	352
27.2.2	Crack growth rates	352
27.2.3	Approximate and numerical methods in small-scale damage	353
27.2.4	The process zone	354
27.3	The Range of Validity of the Small-Scale Damage Approximation in Extensively Creeping Specimens	355
27.4	The Evolution of Damage and Crack Growth for Small-Scale Creep	356
27.4.1	Crack grows faster than creep zone	357
27.4.2	Creep zone grows faster than process zone	358
27.5	Primary-Creep Effects	359
27.5.1	Small-scale damage in a specimen which creeps in the primary stage	359
27.5.2	The transient from elasticity over primary to secondary creep	359
27.6	The Evolution of the Crack Length and the Lifetime	359
27.7	Discussion	362
28	CREEP-FATIGUE CRACK GROWTH	364
28.1	Micromechanisms of Fatigue Crack Growth	365
28.1.1	The alternating slip model (also called the crack-tip blunting model)	365
28.1.2	Fatigue crack growth by grain boundary cavitation	367
28.1.3	Corrosive effects in creep-fatigue crack growth	368
28.2	Fatigue Cracks in Viscous Materials	370
28.2.1	Growth rates by the alternating slip mechanism	370
28.2.2	Growth by cavitation in viscous materials	370
28.3	Fatigue Cracks in Elastic-Plastic Materials	371
28.3.1	Elastic-plastic deformation fields	372
28.3.2	The cyclic J -integral, Z	372
28.3.3	Z -controlled crack growth rates by alternating slip	372
28.4	Fatigue Cracks in Elastic/Nonlinear Viscous Materials	373
28.4.1	Stress fields in elastic/nonlinear viscous material after a load step	373

28.4.2	Gradual load variations in elastic/nonlinear viscous material	374
28.4.3	Stress fields for rapid cyclic loading	376
28.4.4	Crack growth rates by the alternating slip mechanism	377
28.4.5	Fatigue crack growth by cavitation ahead of the crack	378
28.5	The Combined Effects of Elastic, Plastic and Creep Deformation on Fatigue Crack Growth Rates	379
28.5.1	An approximate general expression for the crack growth rate by alternating slip	379
28.5.2	Creep-fatigue crack growth rates in fracture mechanics specimens	380
28.5.3	Fatigue lifetimes of initially smooth specimens by microcrack growth	381
28.6	Discussion	384
28.7	Summary	385

APPENDICES

APPENDIX A: MATERIAL PARAMETERS	389
APPENDIX B: ELASTIC STRESS FIELDS AT NOTCHES, CRACKS AND GRAIN BOUNDARY TRIPLE POINTS	391
B.1 Stress Fields at Sharp Notches and Cracks	392
B.1.1 The eigenvalue equation for sharp notches	392
B.1.2 Crack-tip fields	393
B.2 The Stress Singularity at a Triple Junction of Sliding Grain Boundaries	395
APPENDIX C: CALCULATION OF C* FOR TEST SPECIMEN CONFIGURATIONS	396
REFERENCES	401
INDEX	417