SAND2011-7881C

On Sintering Stress in Complex Powder Compacts

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Albuquerque, NM

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MS&T 2011

Columbus, OH

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Objectives

- Develop a meso-scale model to simulate microstructural evolution during solid-state sintering
  - Understand microstructural evolution details
  - Obtain engineering sintering quantities
    - Sintering stress
    - Bulk and shear viscosities

- End goal: simulate constrained sintering with the accompanying shape distortion
  - Variations in density
  - Multi-layered materials
  - Functionally graded materials
  - Powder packing defects

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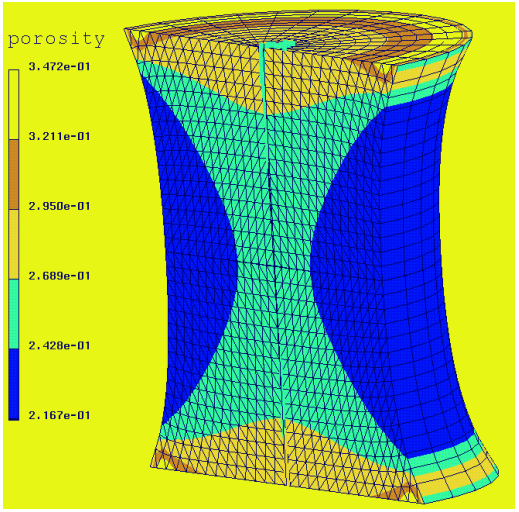

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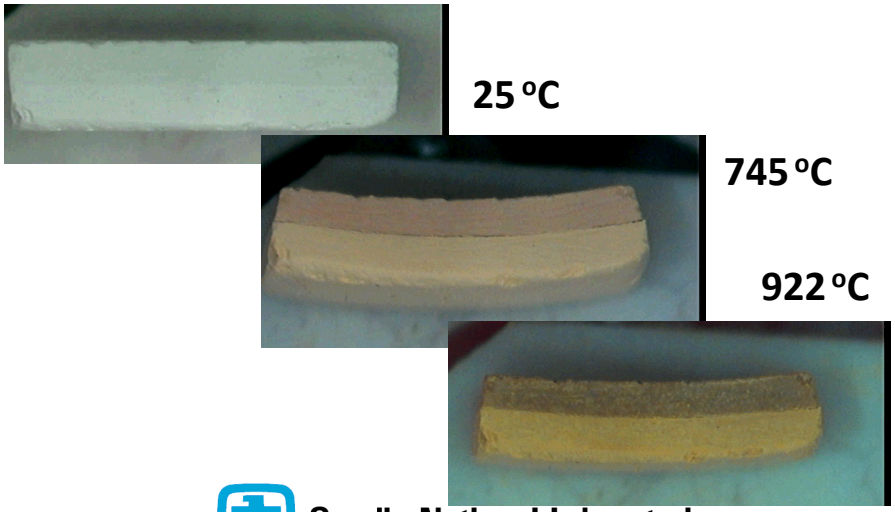


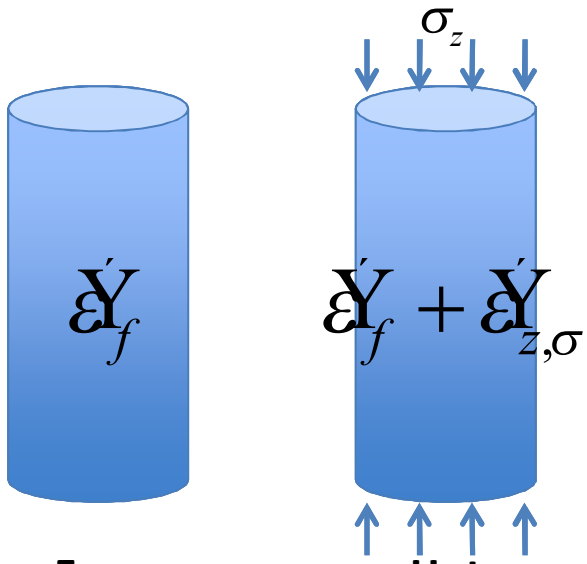
T. Garino, SNL

Experimental Measurement of Sintering Stress

- The usual method for determining sintering stress is loading dilatometry

$$\dot{\varepsilon}_f = \frac{P_L}{3K}$$

$$\dot{\varepsilon}_z = \dot{\varepsilon}_f + \frac{\sigma_z}{3(1-2\upsilon_p)}$$



- Assumes microstructural evolution during hot forging & free sintering are the same
- Zuo et al. showed microstructural evolution is not the same for these conditions

Zuo, Aulbach & Rodel, Acta Met, 2003

Microstructural Evolution During Simple Solid-State Sintering

Mass transport described by

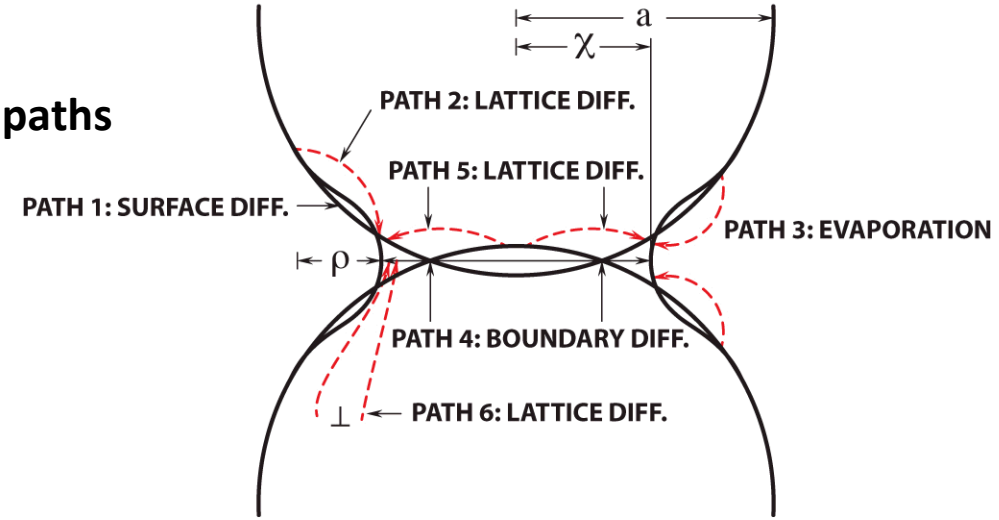
Classic Ashby model with the 6 paths

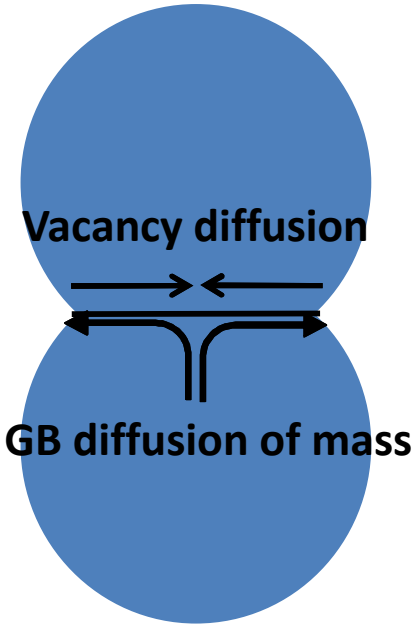
In this work:

grain boundary diffusion

surface diffusion

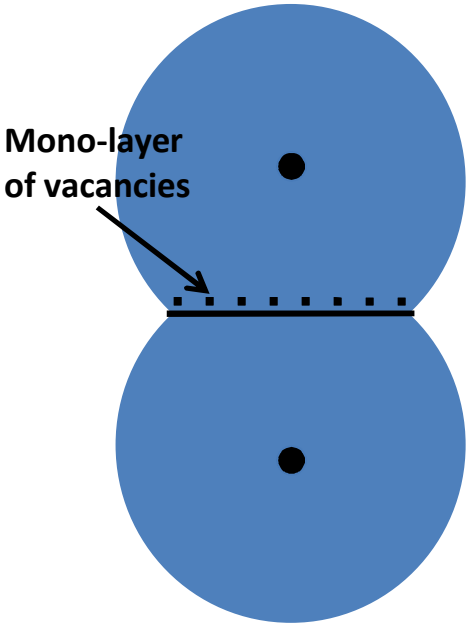
are active.





- **Mass diffuses the along the grain boundary to fill the pore**
- **Vacancies generated at the pore surface**
- **Vacancies diffuse from the pore to the grain boundary**
- **Vacancies are annihilated at the grain boundaries**

Densification in Stereological Model of Sintering*



Densification

- Vacancies diffuse along the grain boundary
- They paint the grain boundary forming a mono-layer
- The entire monolayer is annihilated
- The centers of mass of the particles move closer
- The neck grows
- The pore shrinks

Densification Rate

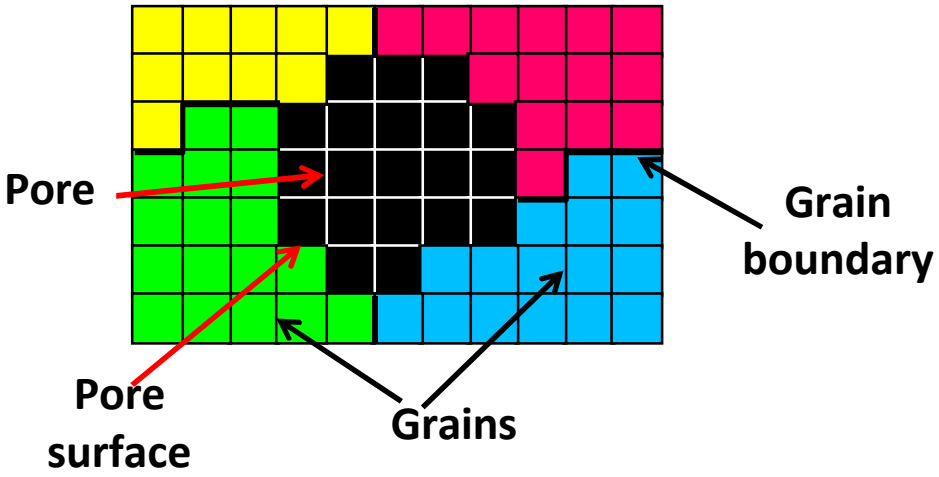
- Rate of vacancy annihilations $\dot{n}_A = \dot{Y} = \dfrac{\int (-D_b \nabla C)\delta dL}{A_b}$

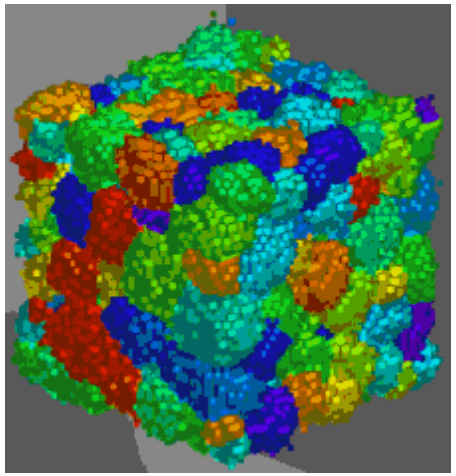
- As the neck area grows, the time between the annihilation events increases
- $\tau \propto A_b$

*R.T DeHoff, Sci. of Sintering, 1989

Potts kMC Model

- **Microstructure is represented by digitizing on a cubic lattice:**



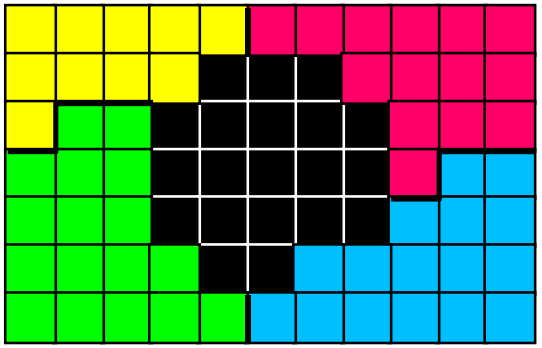


- **Each voxel is a unit of matter**

Potts kMC Model
Equation of State

- **Driving force for sintering is the reduction in total interfacial energy**

$$E = \frac{1}{2}\sum_{i=1}^{N}\sum_{j=1}^{26} J_{ij}\left(1-\delta\left(q_i,q_j\right)\right)$$



- **Dihedral angle can be changed by adjusting J_{ij}**

Potts kMC Model
Vacancy Generation

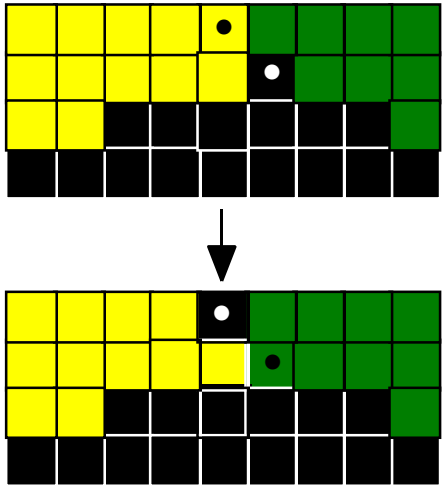
- Vacancies are generated by the exchange mechanisms as shown.
- There is an equilibrium concentration of vacancies

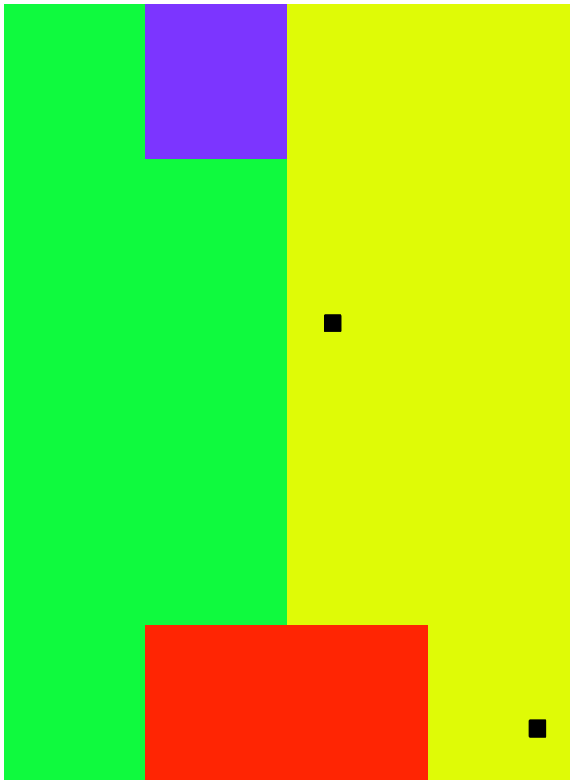
$$P = \exp\left(\frac{-\Delta E}{k_B T}\right) \quad \Delta E > 0$$

- Concentration of vacancies is proportional to the surface curvature

$$C_v \propto \frac{\gamma}{r}$$

Exchange sites

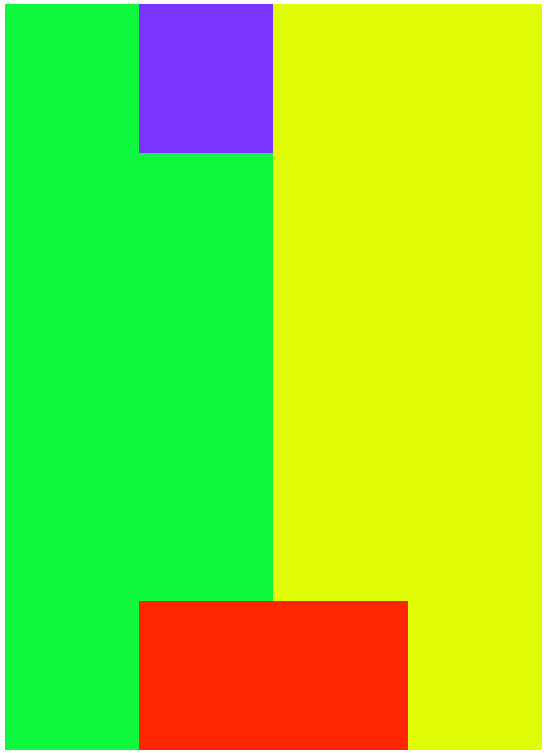




Potts kMC Model
Vacancy Diffusion and Annihilation

- Stereological model
  - Paint a layer of vacancies on the neck and annihilate them.
  - Centroids of grains move closer to give densification.

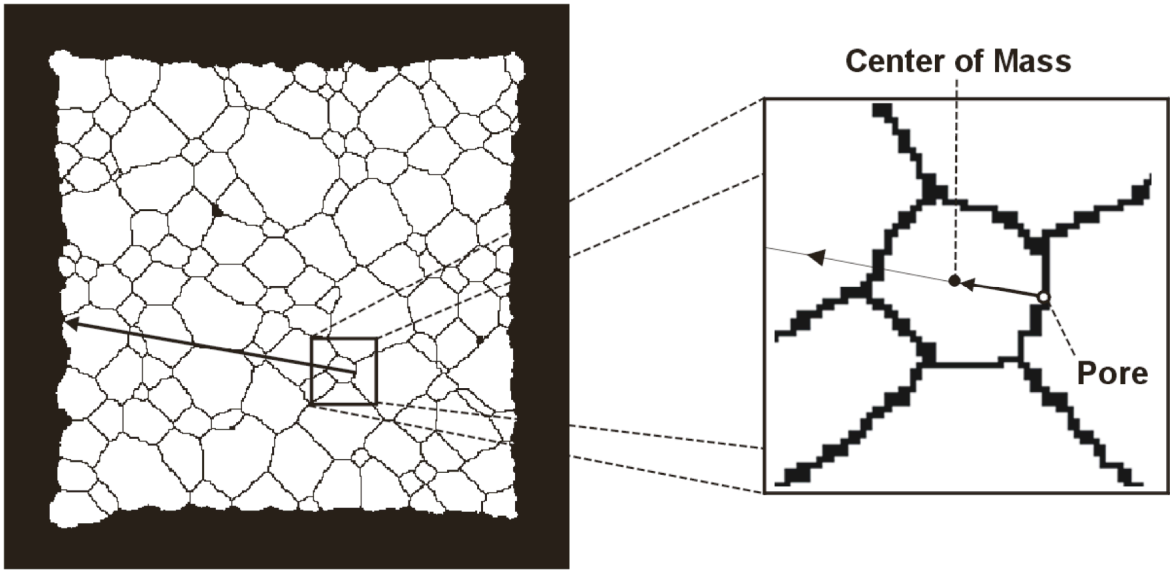
- Potts model
  - Annihilation mono-layer is not possible.
  - Annihilate one vacancy with equal probability of being anywhere in the neck.
  - Annihilation frequency is $\tau \, \mathrm{H} \, A_b$.
  - Annihilation is simulated by collapsing a column of sites.
  - Centroid of grains approach each other.
  - Powder compact densifies.



Potts kMC Model
Simulation of Annihilation

Annihilation of a vacancy on a grain boundary

- **Draw a line from the vacancy through the COM to the external surface of the powder compact**
- **Collapse all the sites along the line by one pixel to fill the vacancy**



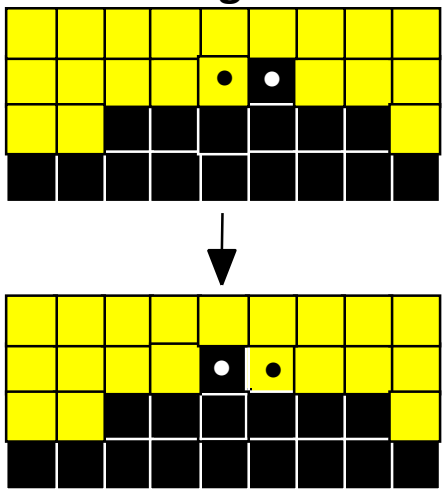
Potts kMC Model
Pore Surface Diffusion

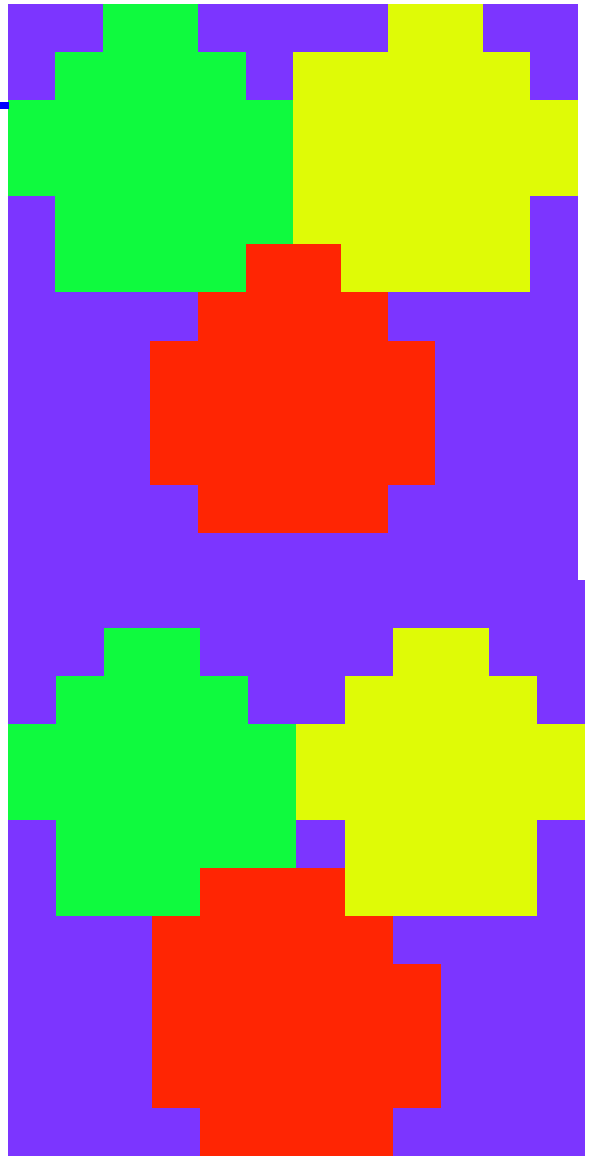
- Pore sites and grain sites at pore surface exchange places to simulate surface diffusion
- Minimize surface energy by Metropolis algorithm
- Calculate ΔE
- Probability of exchange is

$$P = 1 \qquad \Delta E \leq 0$$

$$P = \exp\left(\frac{-\Delta E}{k_B T}\right) \qquad \Delta E > 0$$

Exchange sites





Potts kMC Model
Grain Growth

Coarsening of grains during sintering

- **Is a significant contributor**
- **Affects densification and distortions**

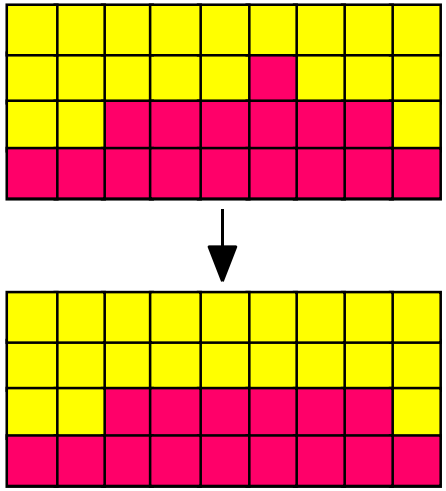
Curvature-driven grain growth is simulated by grain boundary motion

- **Grain sites can change from one grain to another**
- **Calculate ΔE** $E = \frac{1}{2}\sum_{i=1}^{N}\sum_{j=1}^{26} J_{ij}\left(1-\delta\left(q_i,q_j\right)\right)$
- **Probability of change**

$$P = 1 \qquad \Delta E \le 0$$

$$P = \exp\left(\frac{-\Delta E}{k_B T}\right) \quad \Delta E > 0$$

grain growth
change pixel color



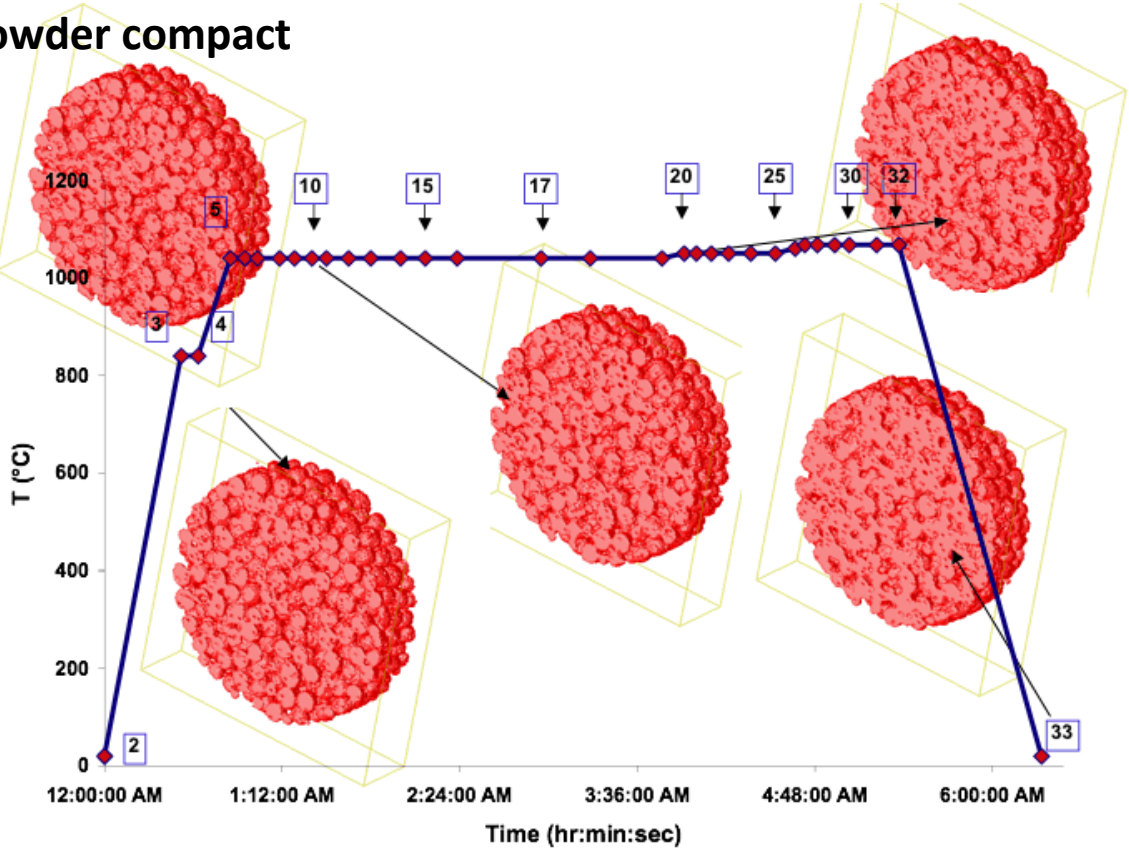
Application and Validation of Potts kMC Sintering Model

Potts kMC Sintering model was tested by simulating

- **Many simple geometries with analytic results.**

Comparing to sintering Cu-powder compact

- **Imaged with high-energy X-rays in synchrotron**
- **Cu-particles 30 – 50 μm**
- **Shows the mass and pore distribution in-situ**

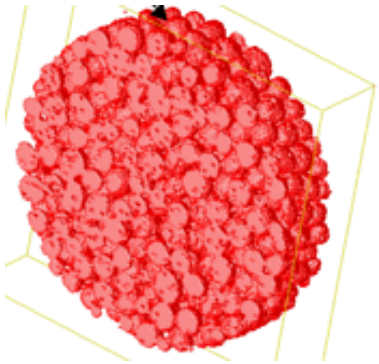


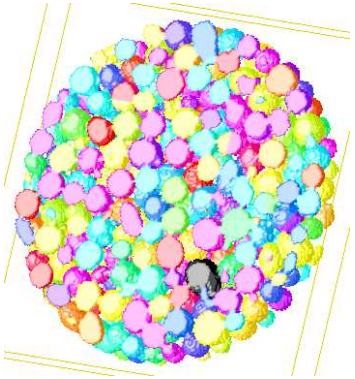
D. Bouvard

Validation by Comparing to Cu-Compact Sintering Potts kMC Sintering Model

Grain structure extrapolated into the initial 3D image obtained from the synchrotron

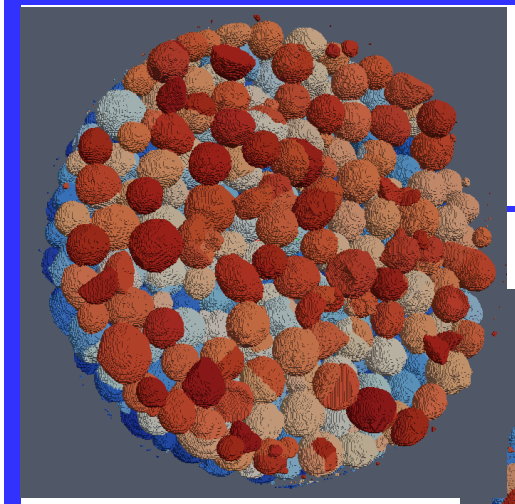
- **Using the Potts grain growth algorithm**



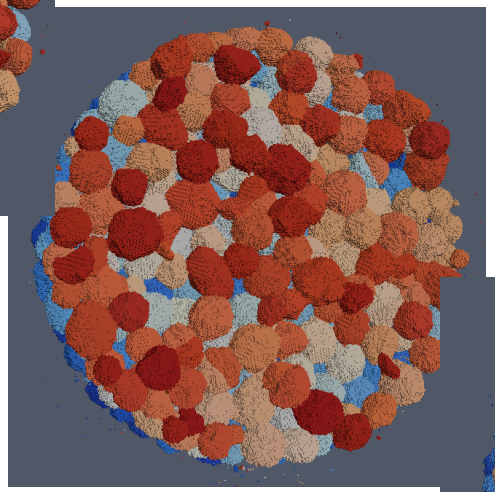


- **Microstructural evolution during sintering from this image was compared to later experimentally obtained images.**

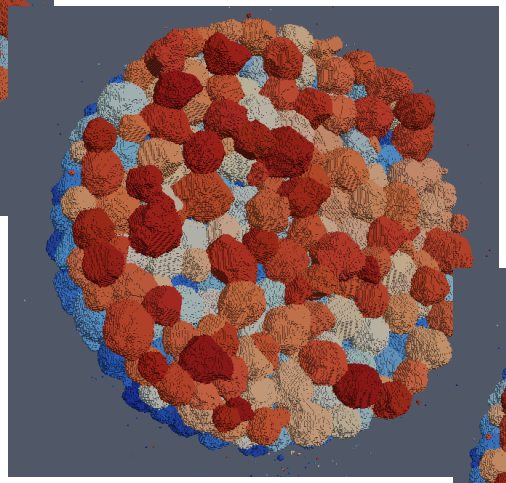
Potts kMC Model
Simulation of Cu-Particles Compact



$\rho = 72\%$

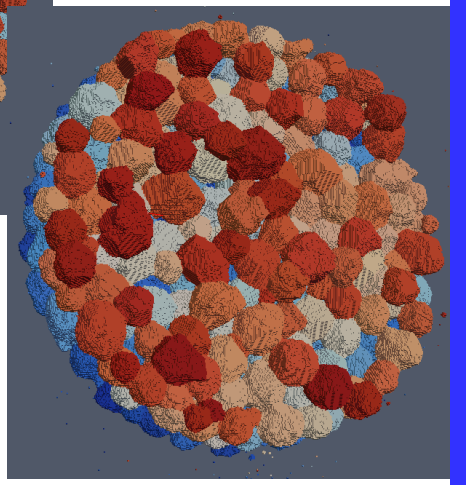


$\rho = 82\%$

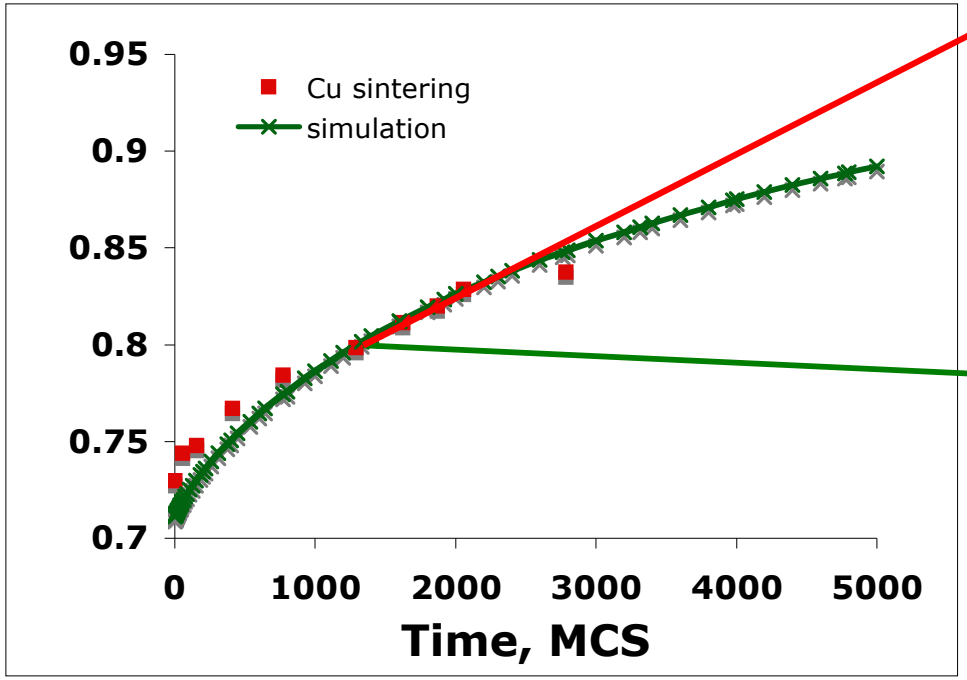


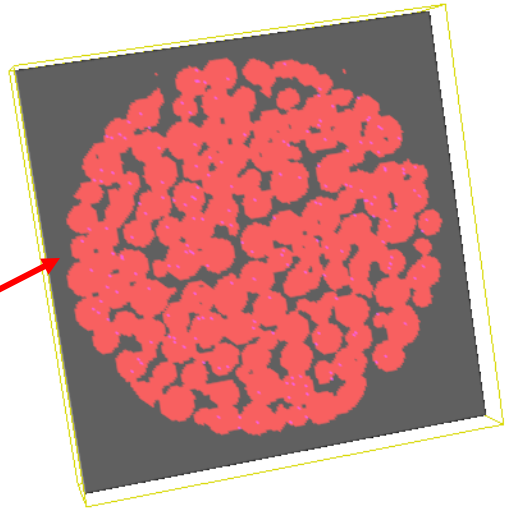
$\rho = 85\%$

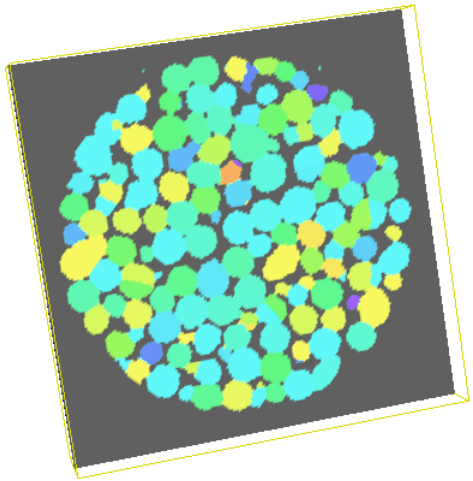
$\rho = 87\%$



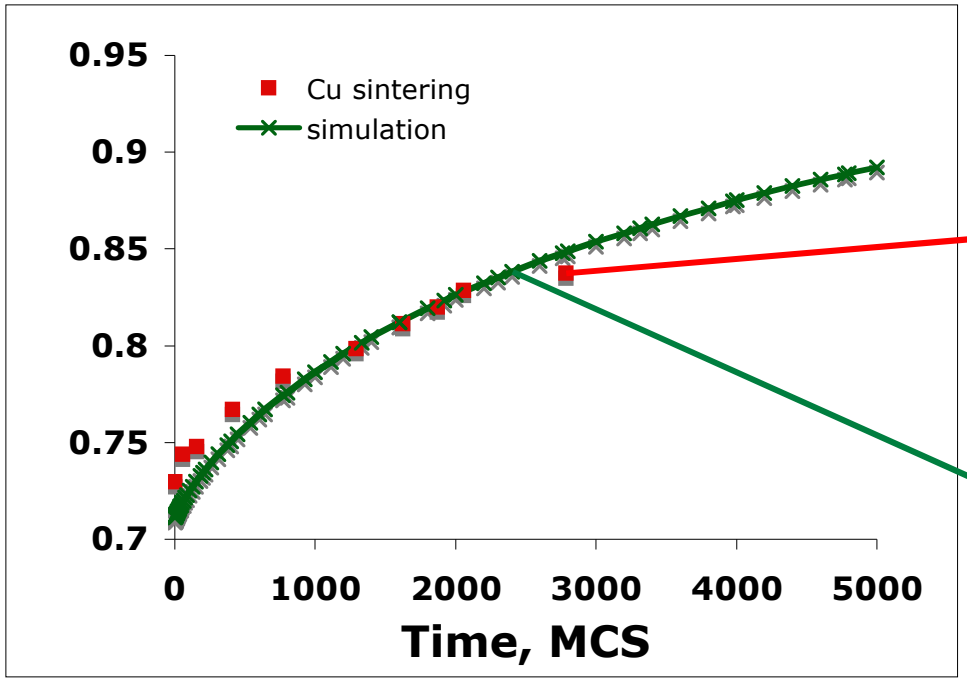
Comparison of Potts Simulation and Cu-Experiments Microstructure & Densification

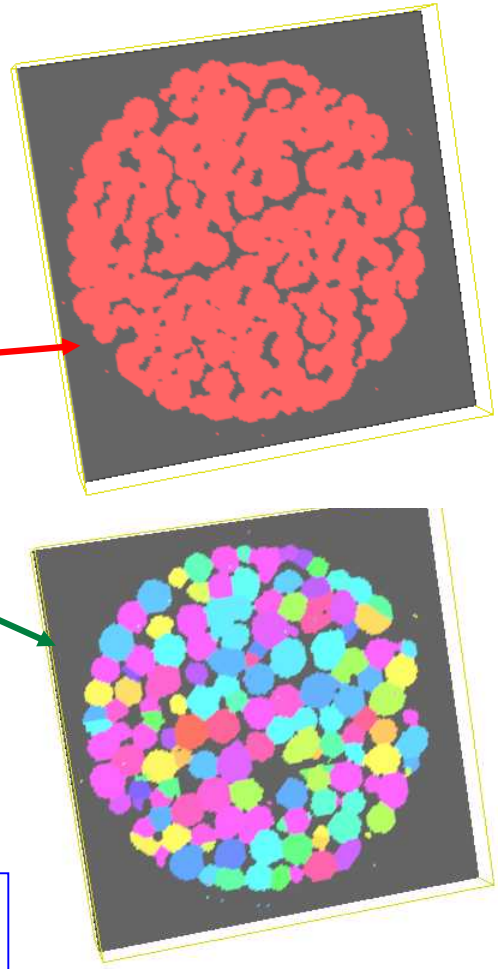






Comparison of Densification Microstructure & Densification

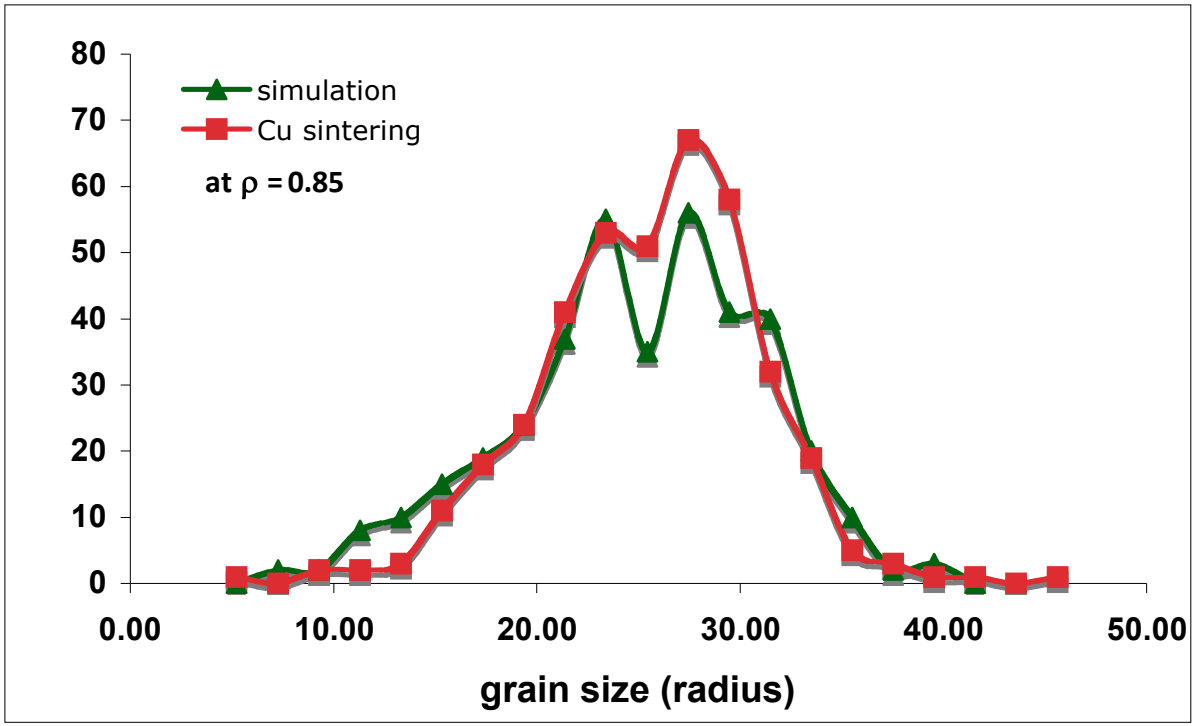


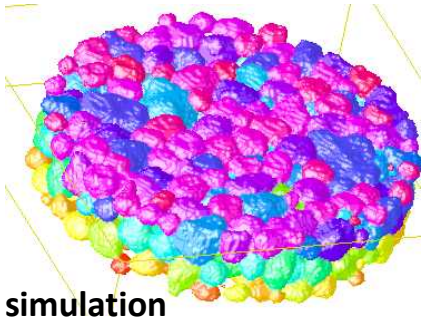


Very good agreement between the sintering simulation and Cu-sintering experiments.

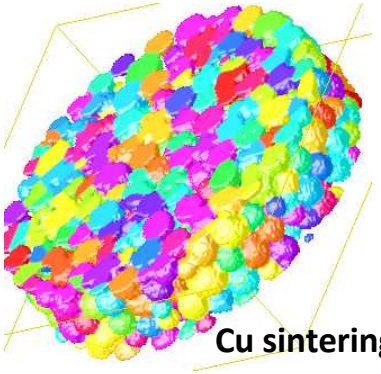
Comparison of Grain Size Distributions

- The overall GSD's have very similar sizes and distribution shape.
- There are 15 (out of 380) more grains in Cu sintering compacts because grains in the simulation are truncated at the edges.





simulation



Cu sintering

The GSD from simulated sintering is very similar to the 3D image of Cu sintering. Differences are due primarily to edge effects.

Sintering Stress

- **Driving force for sintering, ΔG, is the total change in free energy during sintering**
  - **Potts kMC model simulates the entire microstructural evolution**
  - **In response to grain boundary energy γ_{gb} and pore surface energy γ_s contributions**

$$E = A_{gb}\gamma_{gb} + A_s\gamma_s$$

- **Sintering stress, P_L, is the inherent sintering stress due to capillarity for densification.**

- **Energy Method**

$$P_L = \frac{E_s(V_o + \Delta V) - E_s(V_o)}{\Delta V} = \frac{\partial E_s}{\partial V}$$

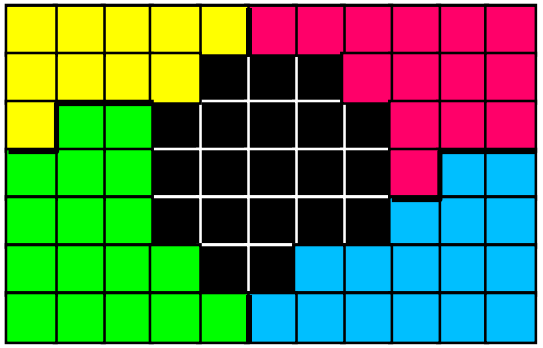
- **Curvature Method**

$$P_L = \gamma_s \overline{H} = \gamma_s \frac{\frac{1}{2}\iint_S \left(\frac{1}{r_1} + \frac{1}{r_2}\right) dS}{\iint_S dS}$$

Sintering Stress
Measuring from Simulations

Energy Method

$$E = \frac{1}{2}\sum_{i=1}^{P}\sum_{j=1}^{26} J_S\left(1-\delta\left(q_i,q_j\right)\right)$$ **For all pore sites q_i**

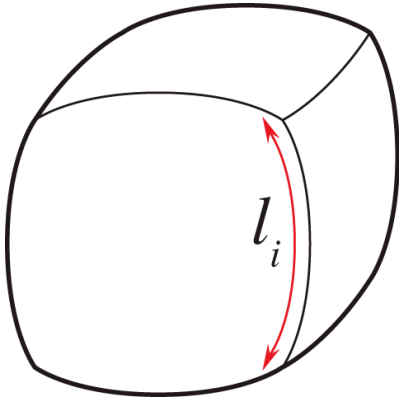


Curvature Method

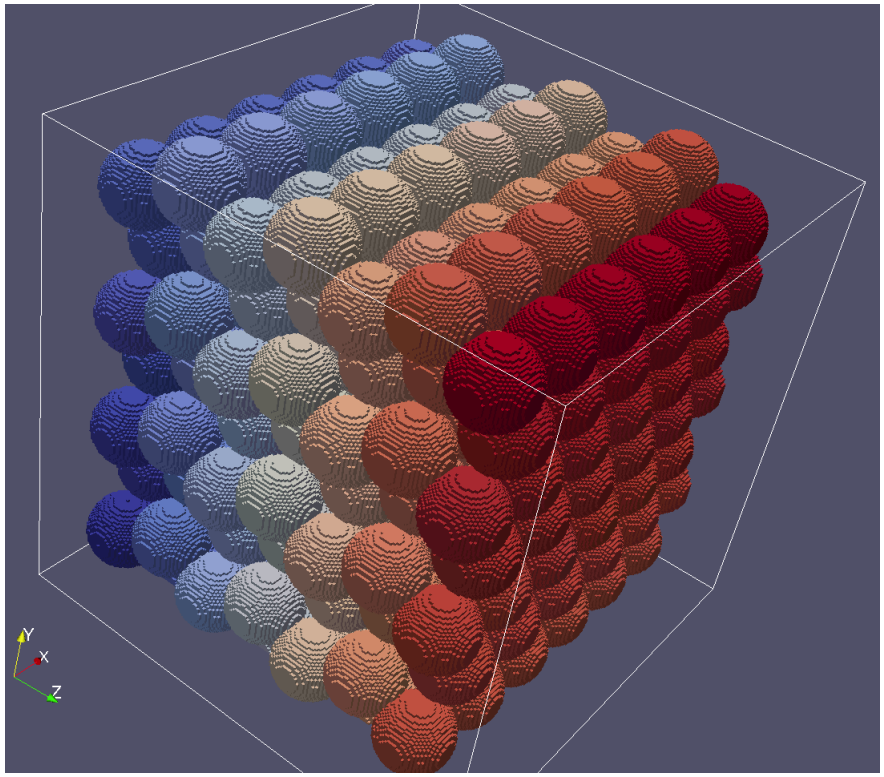
- **For a polyhedron**
  - **Integral mean curvature**

$$M_v = \underbrace{\iint_S \frac{1}{2}\left(\frac{1}{r_1}+\frac{1}{r_2}\right)dS}_{\text{Faces = 0}} + \underbrace{\frac{1}{2\pi}\sum_{e=1}^{E} l_e\beta_e}_{\text{Edges}}$$

  - **Digitized microstructure**

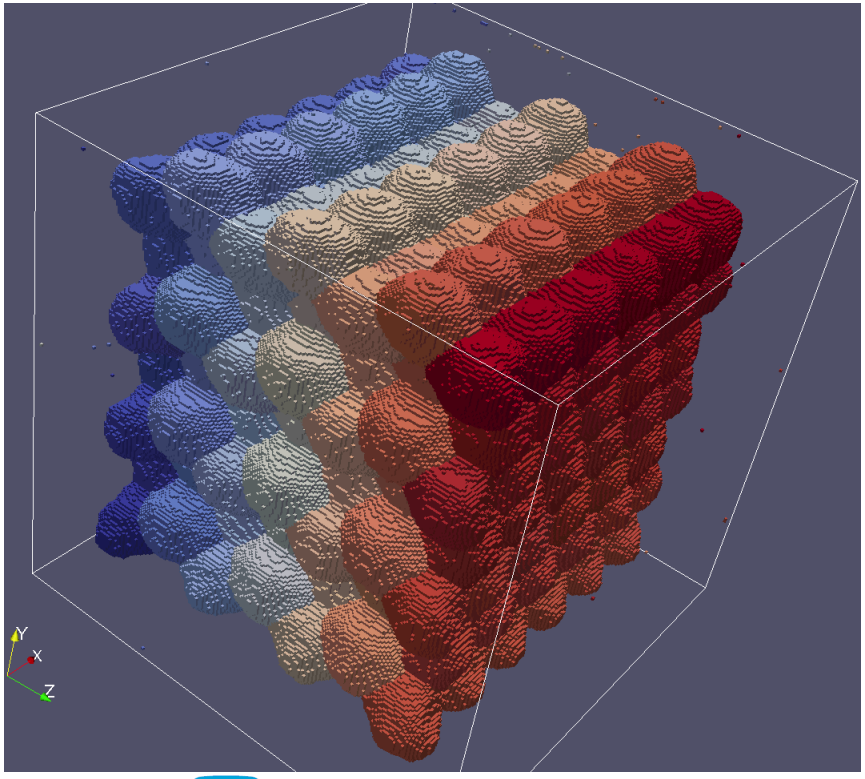


Potts kMC Model
Simulation of Close-Packed Spheres Sintering



Density = 72% at t = 0 MCS

Density = 100% at t = 60,000 MCS



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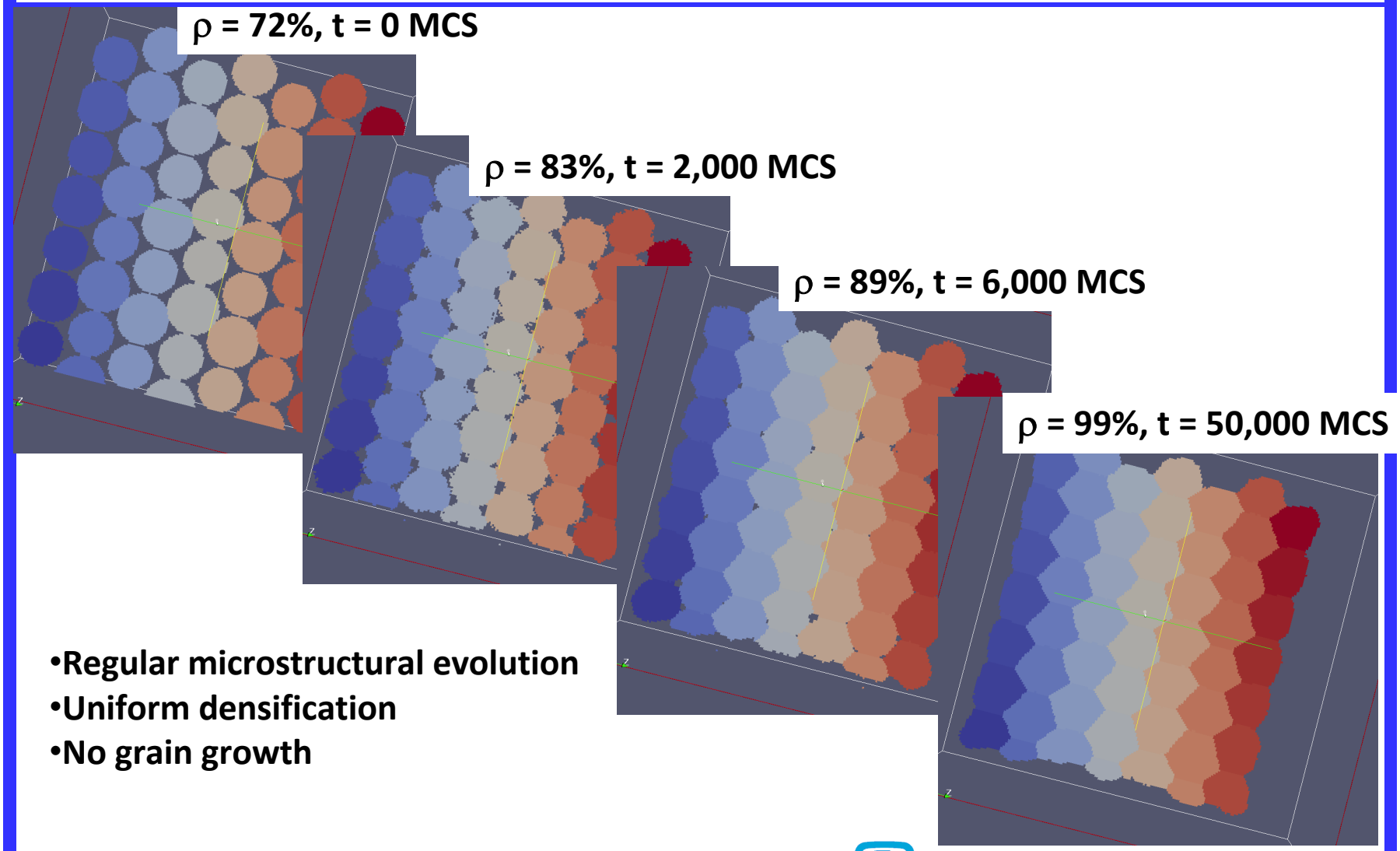

- Regular microstructural evolution
- Uniform densification
- No grain growth

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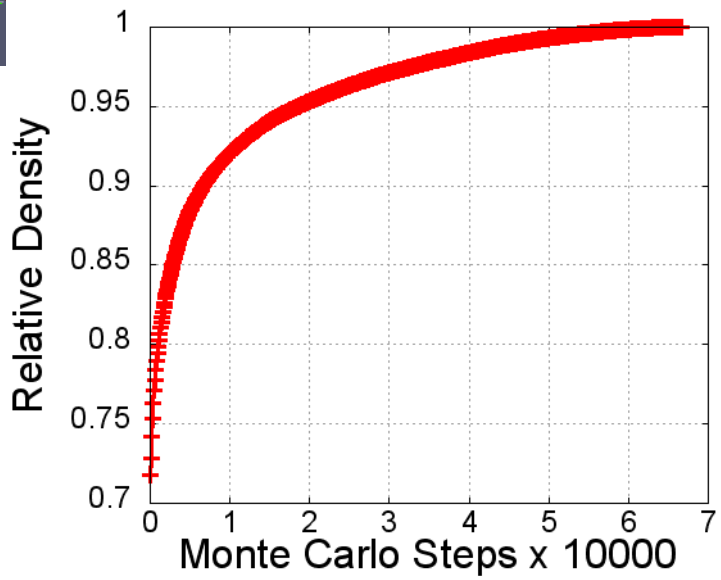
Potts kMC Model
Simulation of Close-Packed Spheres Sintering

ρ = 72%, t = 0 MCS

ρ = 83%, t = 2,000 MCS

ρ = 89%, t = 6,000 MCS

ρ = 99%, t = 50,000 MCS



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Potts kMC Model
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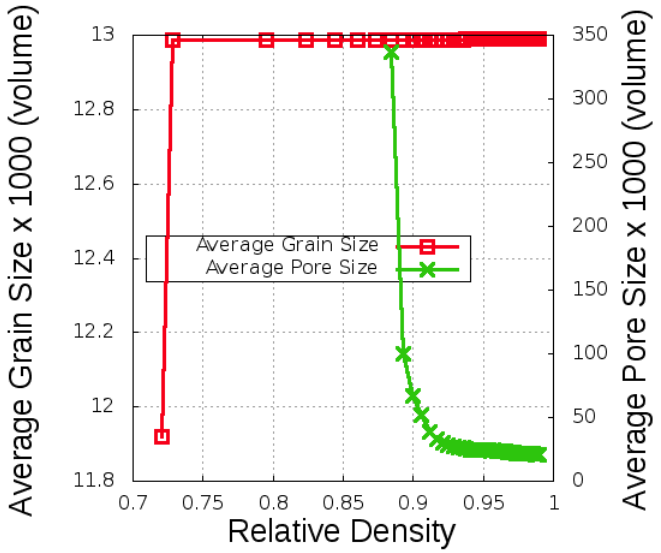
ρ = 89%, t = 6,000 MCS

ρ = 99%, t = 50,000 MCS



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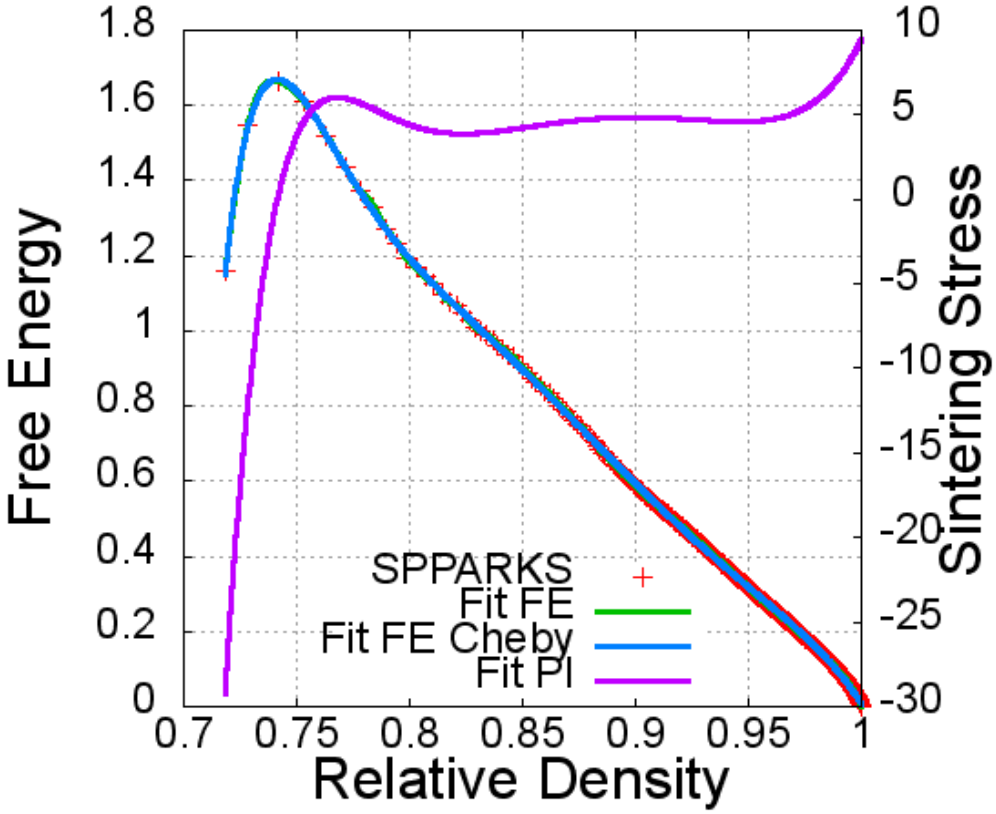
Sintering Stress, Energy Method
Simulation of Close-Packed Spheres Sintering

- Energy method $P_L = \frac{\partial E_s}{\partial V}$
- Data from simulations is $E_s(\rho)$
- Fit $E_s(\rho)$ with splines, results in noisy P_L
- Fit $E_s(\rho)$ with Chebyshev poly
- Resulting P_L

- P_L is initially negative due to initial pore curvature.
- Becomes ~constant and then increases as pores become isolated and small.



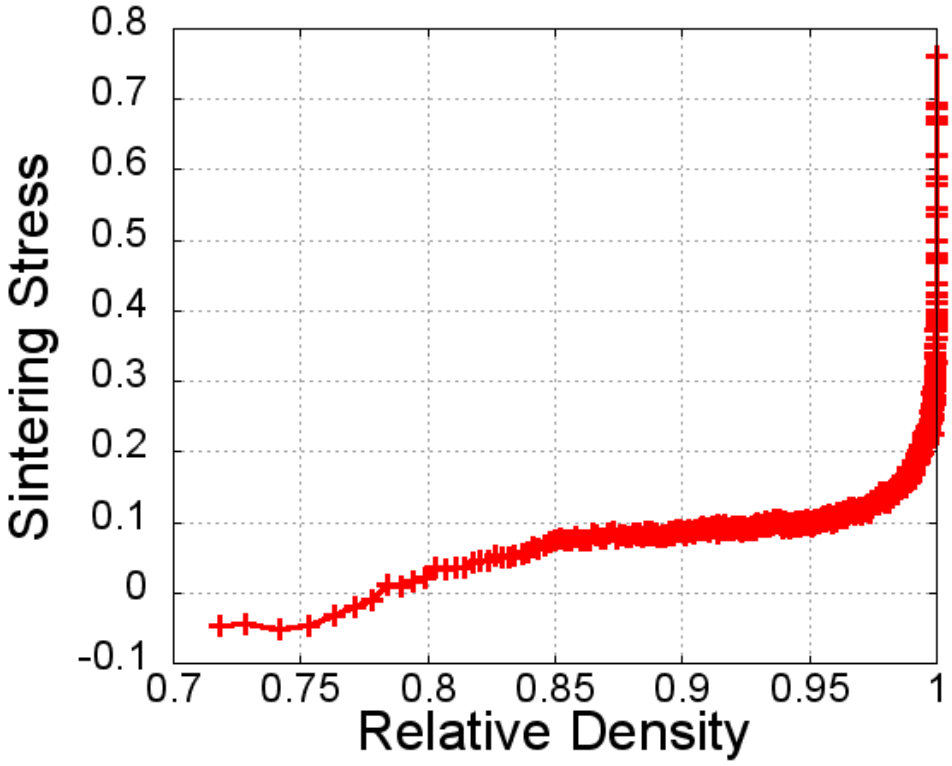
While overall trend is accurate, P_L is sensitive to the fitting technique used with the energy method

Sintering Stress, Curvature Method
Simulation of Close-Packed Spheres Sintering

- **Curvature method** $P_L = \gamma_s \overline{H} = \gamma_s \frac{M_v}{S_v}$

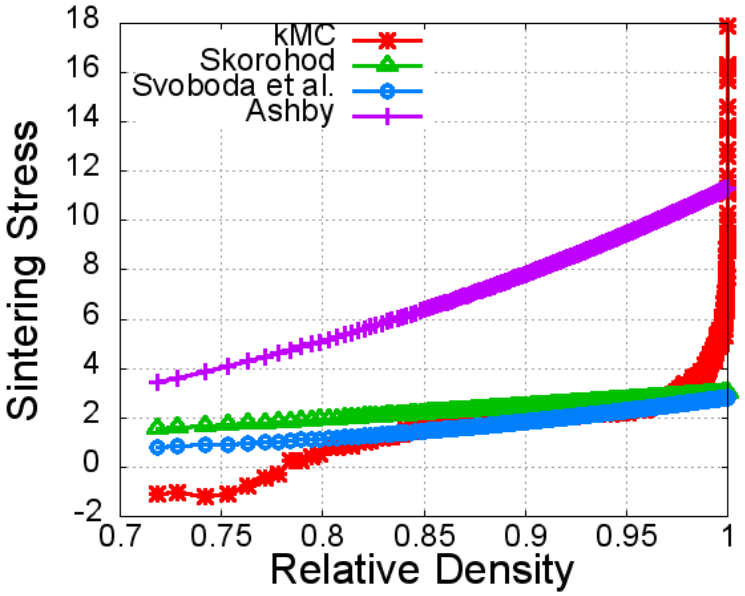
- **Directly measure from the simulated microstructures**
- **Is an instantaneous measure and does not depend on the microstructural evolution path**

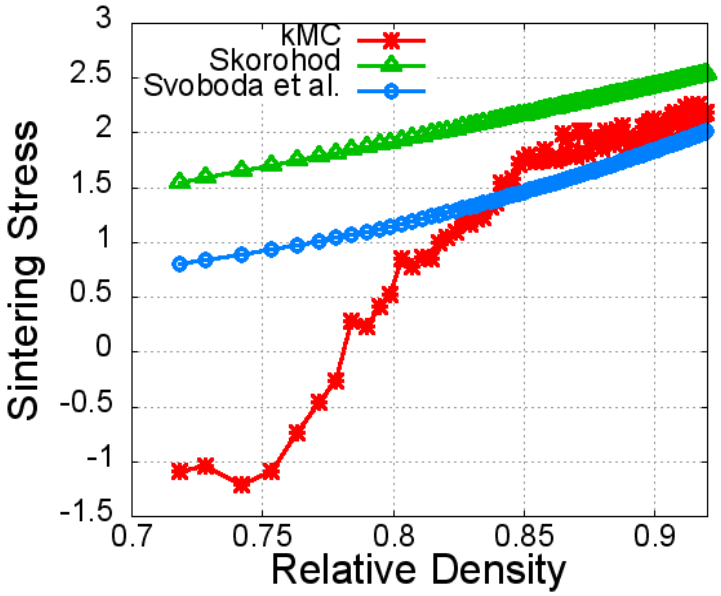
- P_L **initially negative**
- P_L **increase with increasing pore curvature.**



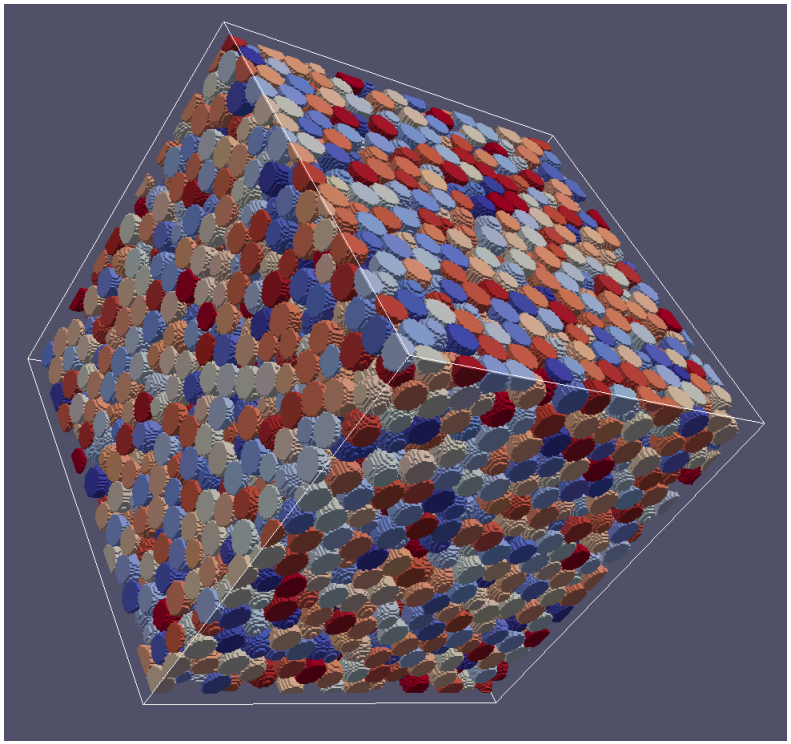
Curvature method will be used for the remainder of this work

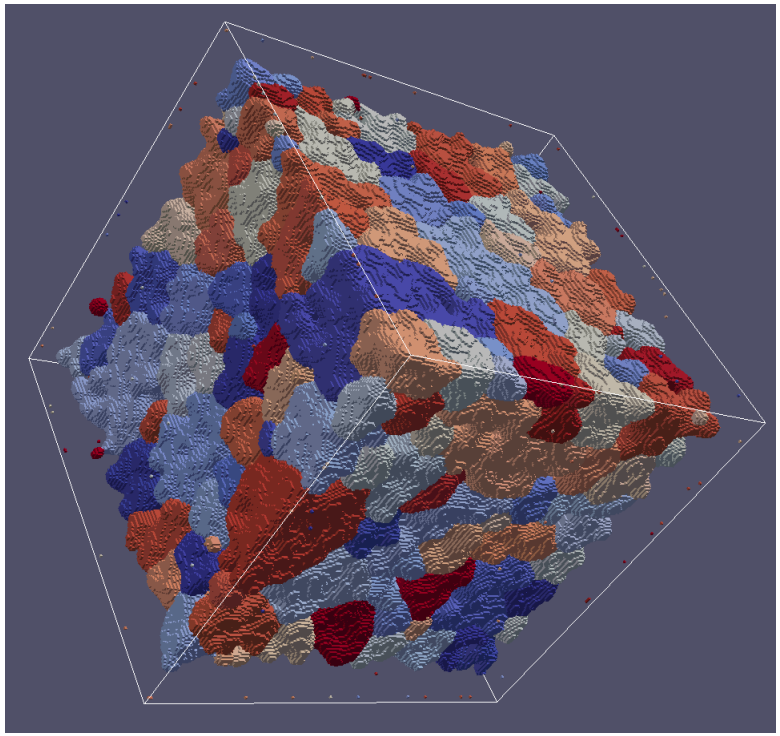
Sintering Stress, Comparison to Analytic models
Simulation of Close-Packed Spheres Sintering



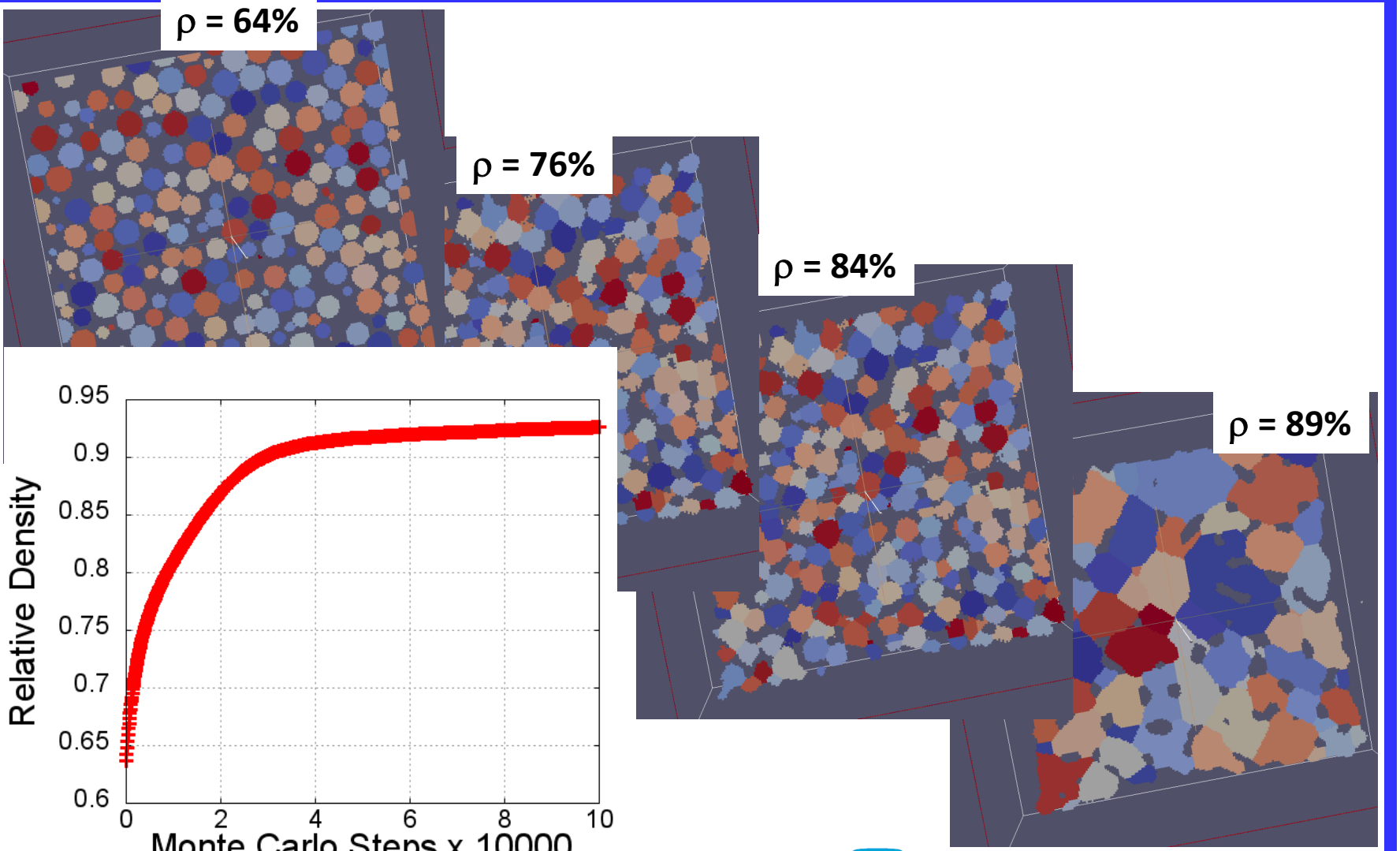


Potts kMC Model
Simulation of Randomly-Packed Mono-Sized Spheres Sintering





Potts kMC Model
Simulation of Randomly-Packed Mono-Sized Spheres Sintering



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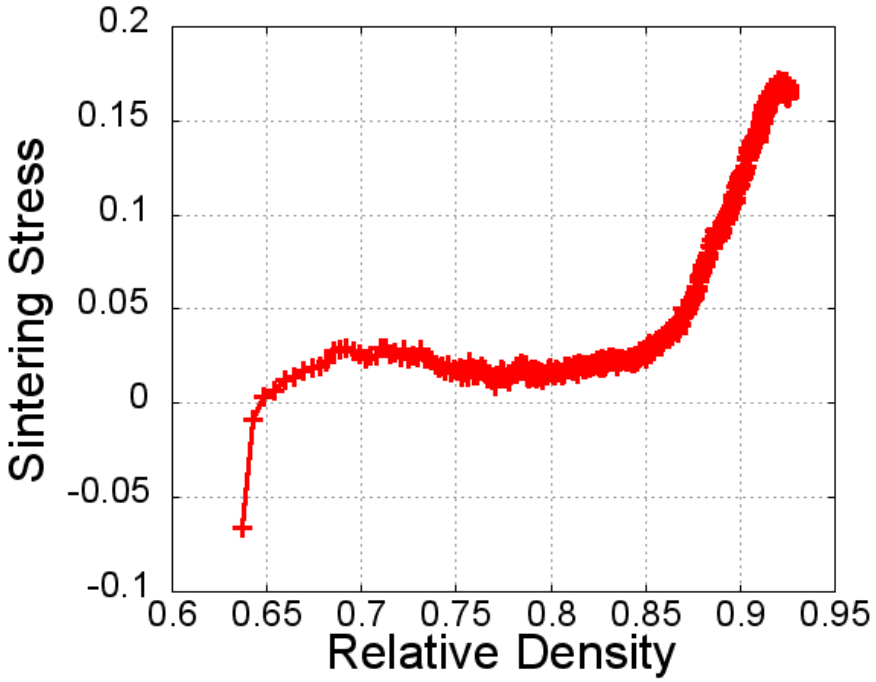
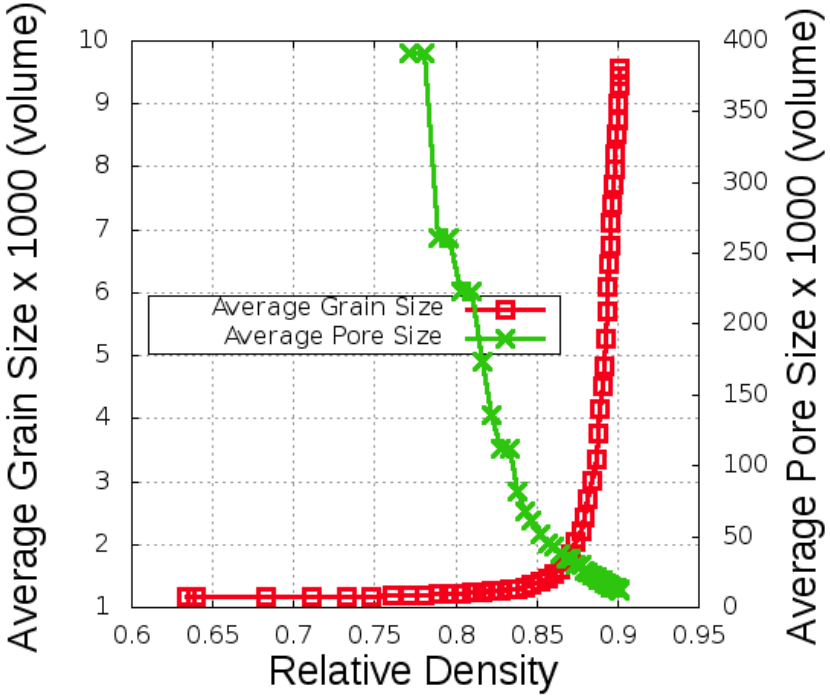
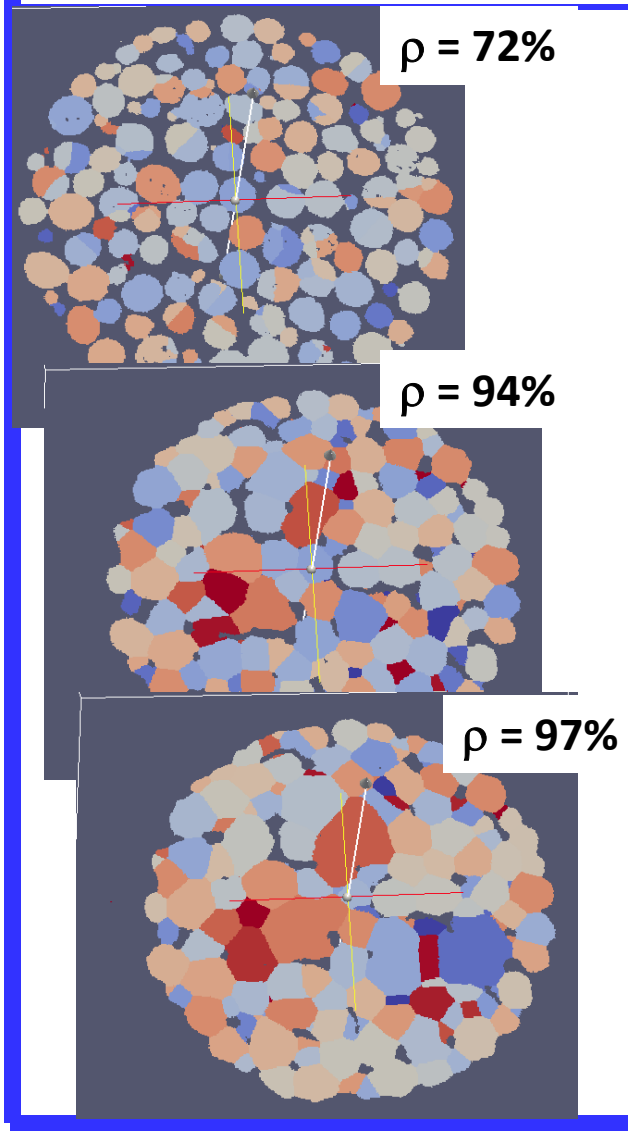
Sintering Stress
Simulation of Randomly-Packed Mono-Sized Spheres Sintering

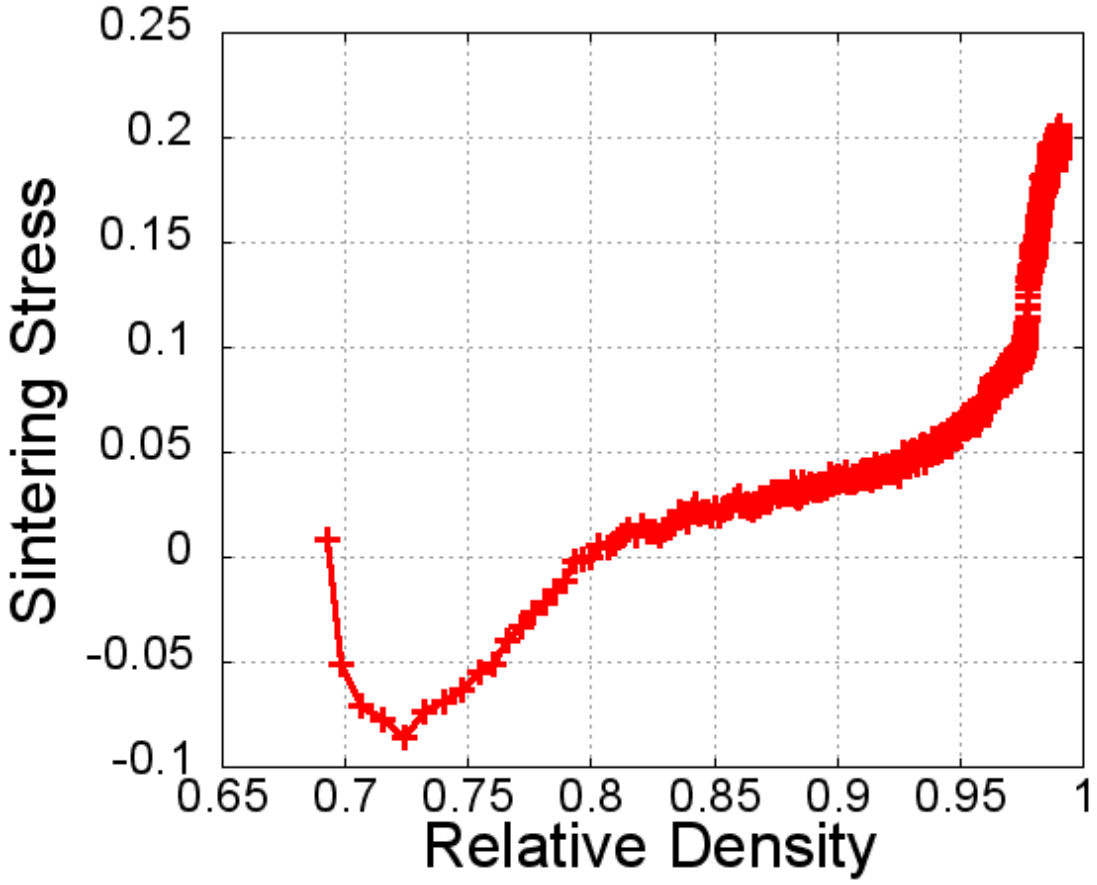




As grains grow and pore curvature decreases at density ~90%, sintering stress also decreases.

Sintering Stress
Simulation of Cu-Particle Compact Sintering

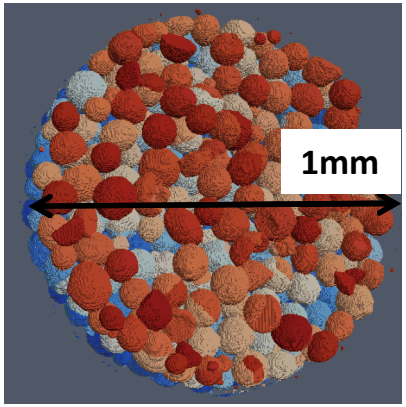




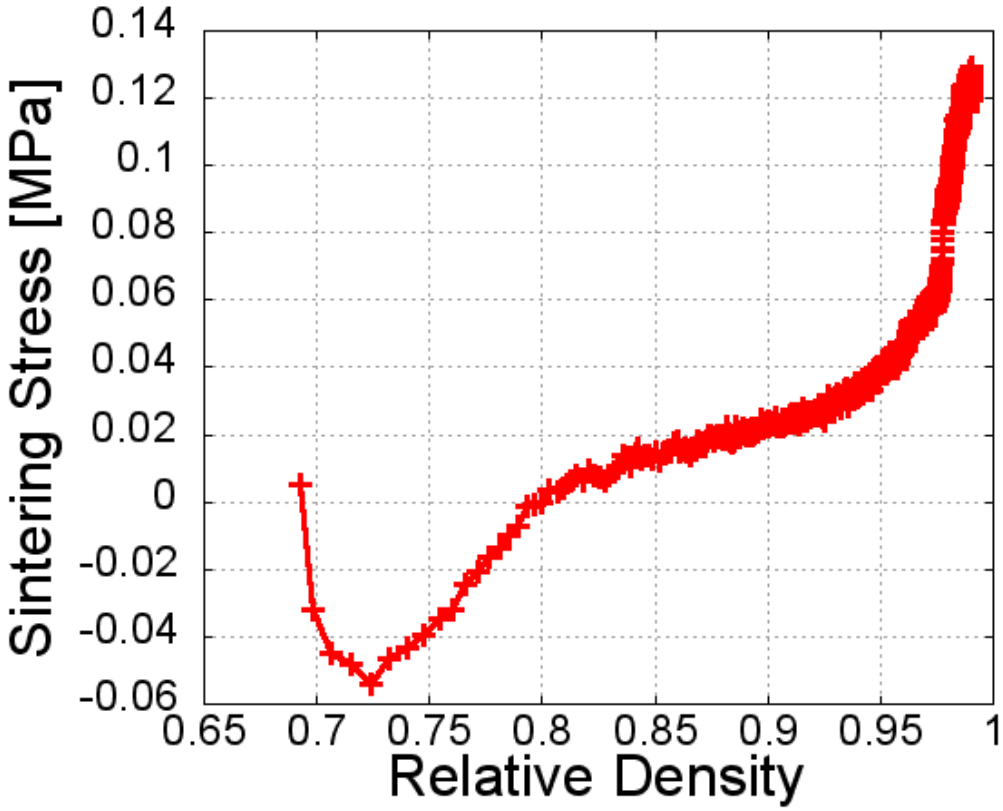
Sintering Stress
Simulation of Cu-Particle Compact Sintering

Obtaining P_L with units for real systems

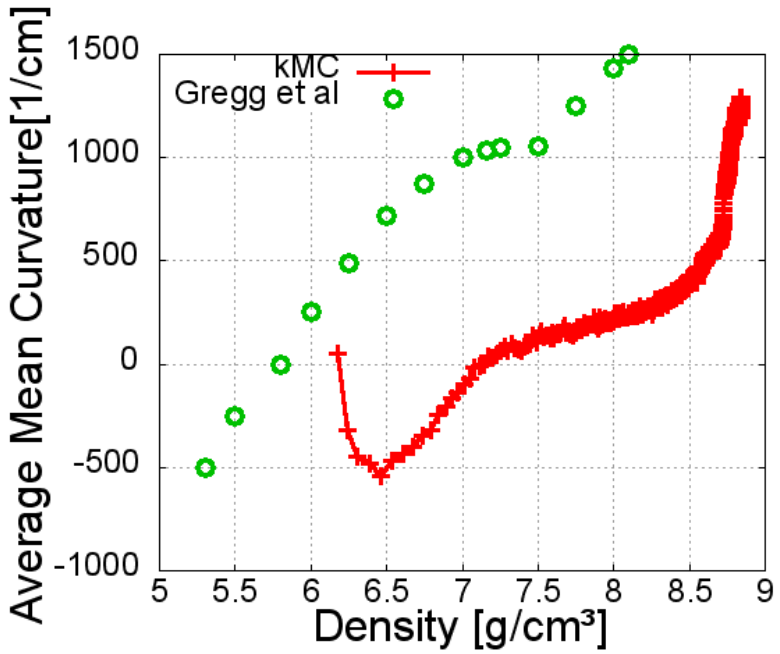
- units of spatial dimension



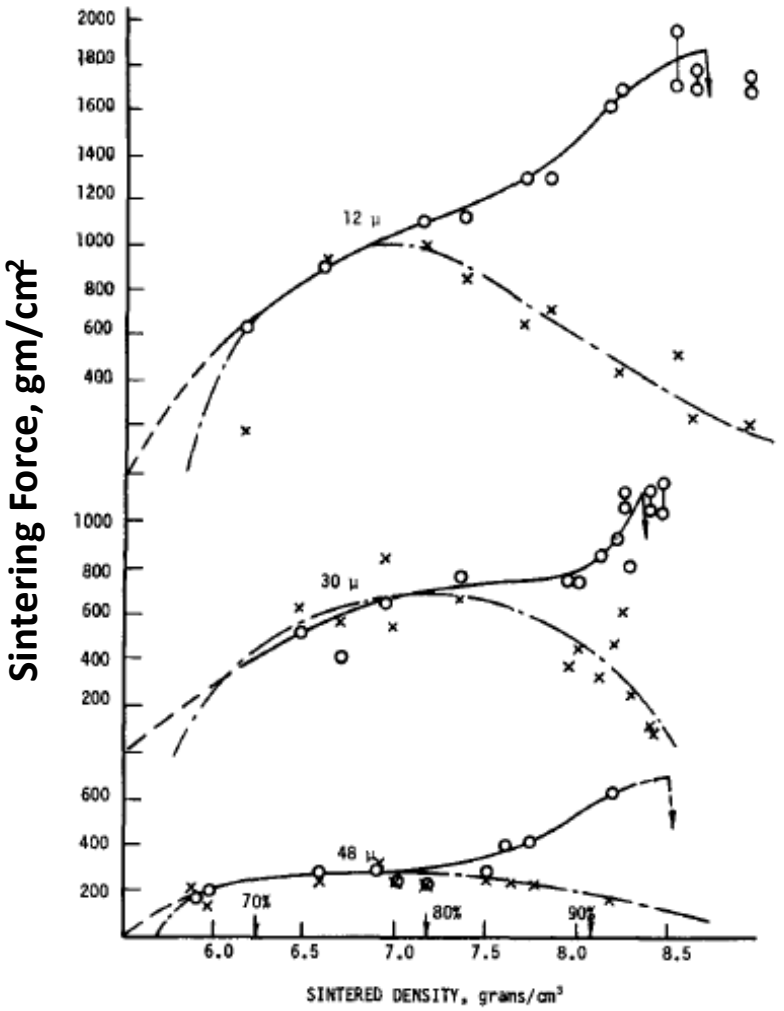
- Assume γ_s = 1 J/m^2 at 1050 ^{o}C

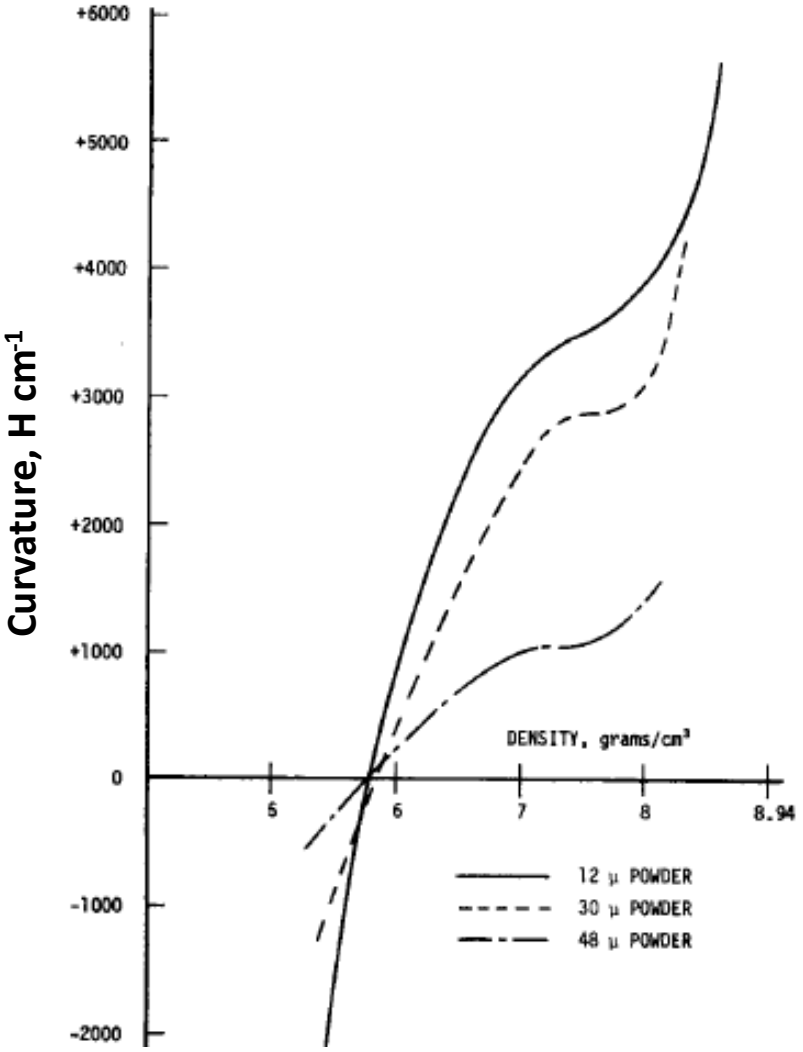


Sintering Stress, Comparison to Experiment
Simulation of Cu-Particle Compact Sintering



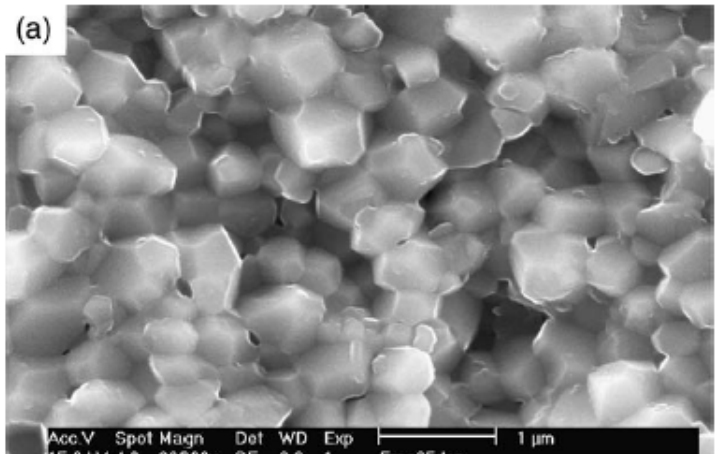
Experimental Measurement of Sintering Stress
Cu-Powder Compact Sintering

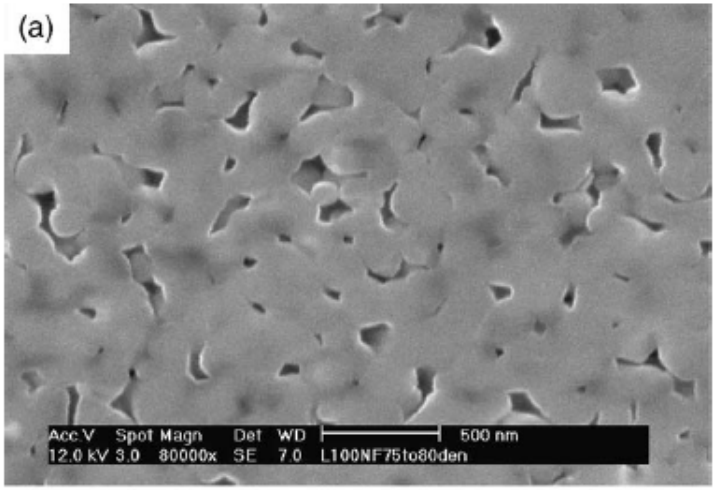


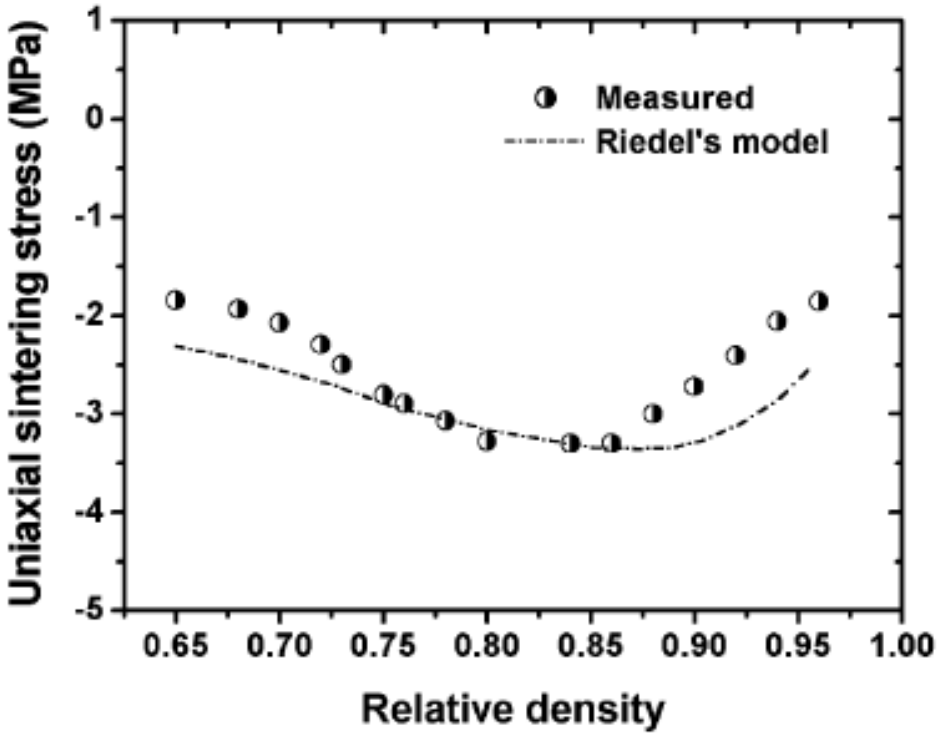


Gregg & Rhines, Met Trans., 1973

Experimental Measurement of Sintering Stress
150 nm Al_2O_3-Powder Compact Sintering

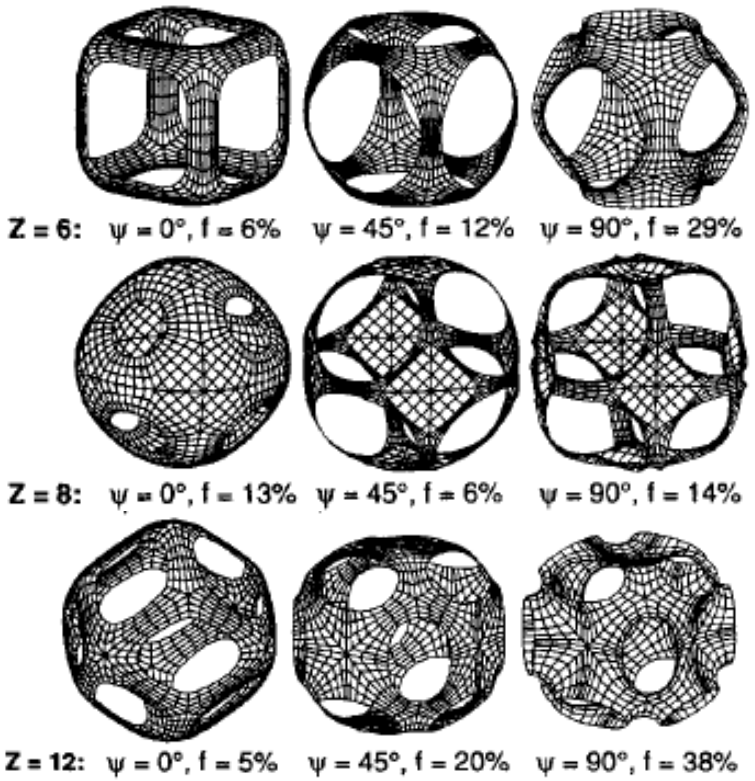


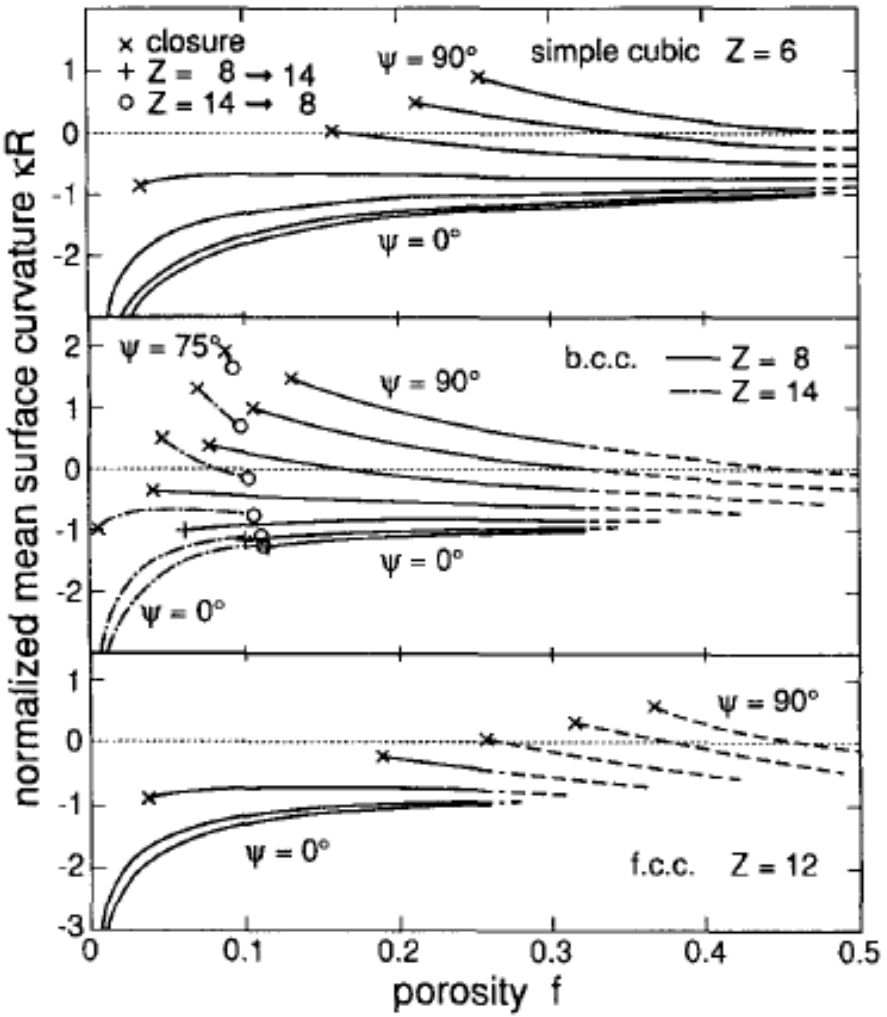




Zuo, Aulbach & Rodel, Acta Met, 2003
Svoboda, Riedel & Zipse, Acta Metall 1994

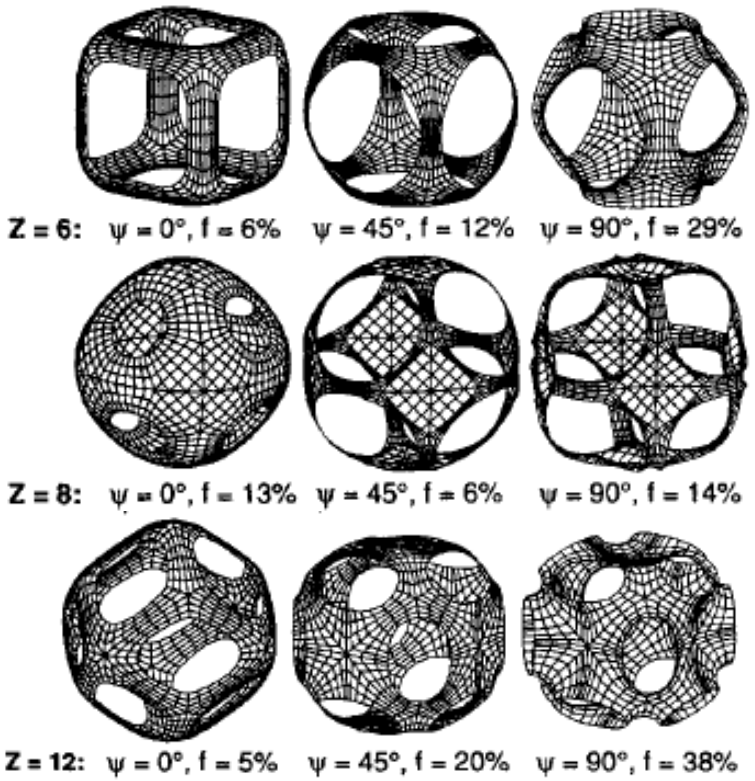
Analytic Calculation of Pore Surface Curvature
Cellular Powder Compact Sintering

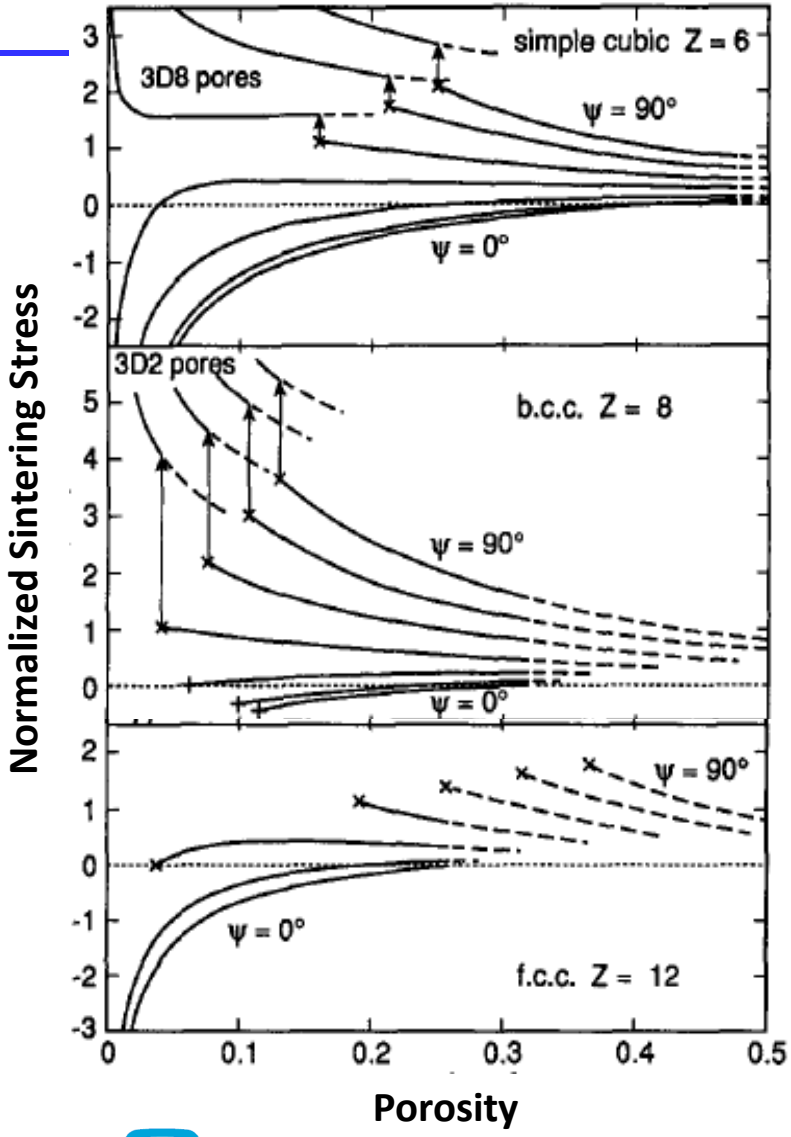




Svoboda, Riedel & Zipse, Acta Metall 1994

Analytic Calculation of Sintering Stress
Cellular Powder Compact





Svoboda, Riedel & Zipse, Acta Metall 1994

Sintering Stress
In Heterogeneous Powder Compacts

- A combination of inherent sintering stress and far-field stresses will lead to unique microstructural evolution.

- We are developing models to generate detailed microstructural evolution
  - Direct coupling between FEM – Potts. The distortions introduced in the coupling are of the same magnitude as shrinkage
  - Material Point Method. Enjoying some success, but development of coupling between microstructure and mechanics is demanding
  - Potts – DEM coupling. Just beginning. Early stages of sintering are possible, later stages remain challenging

- Actively seeking collaborations to bring other methods to develop these models.

Summary and Conclusions

- A model that is capable of simulating simple, solid-state sintering has been presented.
  - True meso-scale with hundred or thousands of particles
  - Arbitrarily complex powder particles of different geometries
- It can incorporate all the mechanisms necessary for simulation of microstructural evolution during sintering
  - Generation, diffusion and annihilations of vacancies
  - Surface diffusion at pore surface
  - Curvature-driven grain growth
- Has sufficient detail to characterize detailed topological features and their influence kinetics
- Can be extended to include more mechanisms and vary thermodynamics and kinetic characteristics.

Potts kMC Model
Available as open source code in October 2011

SPPARKS is a Monte Carlo simulation code

- with kinetic Monte Carlo (kMC), rejection MC and Metropolis MC
- 2- or 3D simulations
- on- and off-lattice, with several lattice choices
- serial and parallel, supports MPI
- C++
- open source, download from
  http://www.cs.sandia.gov/~sjplimp/spparks.html
- designed to modify and extend to many materials processes

SPPARKS has been adapted to 3D simulate sintering

- the serial algorithm was parallelized
- can run much larger simulations in more detail

SPPARKS Developer: Steve Plimpton, SNL

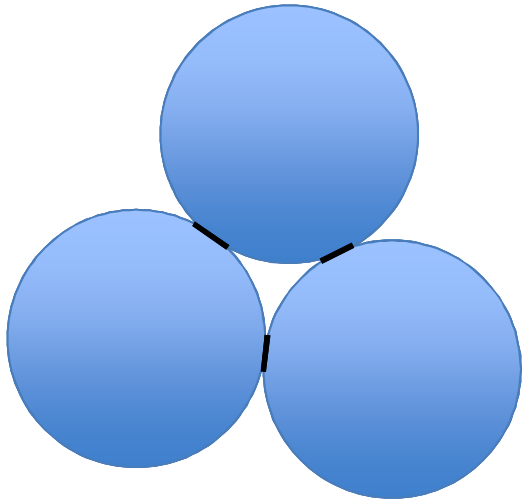
Sintering/SPPARKS Developer: Cristina Garcia C., SNL / SDSU

Surface Diffusion at Pore Surfaces in Stereological Model of Sintering*

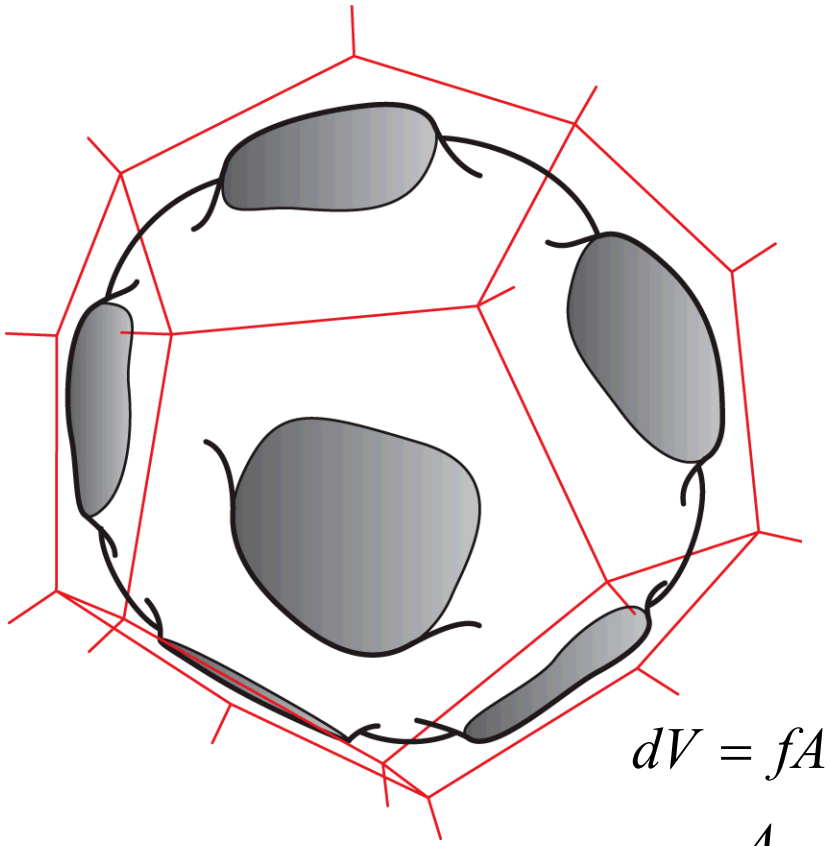
- Pores continually reshape themselves to lower their surface free energy
- Material is transported from areas of high curvature to lower curvature

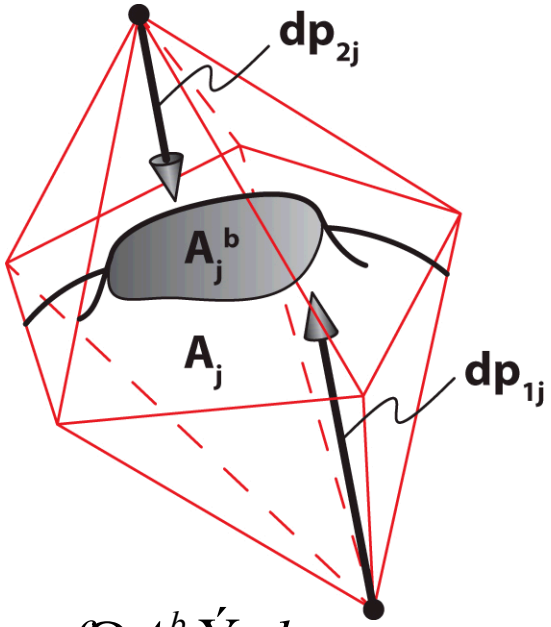
- Velocity of pore surface

$$v_s = -\Omega\delta\nabla \bullet J_s$$



Bi-Crystal View
Stereological Model of Sintering*





$$dV = fA_j^b dp_j = -f\Omega A_j^b \dot{N}_{Aj} dt$$

$$f = \frac{A_j}{A_j^b}$$