ICME for Rapid Qualification of AM End-use Parts

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VEXTEC

DMC 2018
December 3-6, 2018
Nashville, TN

VEXTEC Introduction




- **Headquarters:** **Located in Nashville, TN**
- **VPS-MICRO® Software:** **Predicting fatigue durability and risk of products and systems**
- **Value Proposition**: **Supplement physical testing for increased confidence in rapid part qualification**

VPS-MICRO is:

- ***Validated by government programs***
- ***Utilized globally by commercial industries***
- ***Backed by 7 US Patents***

Acknowledgements

- **Kishan Goel and Madan Kittur (NAVAIR)**

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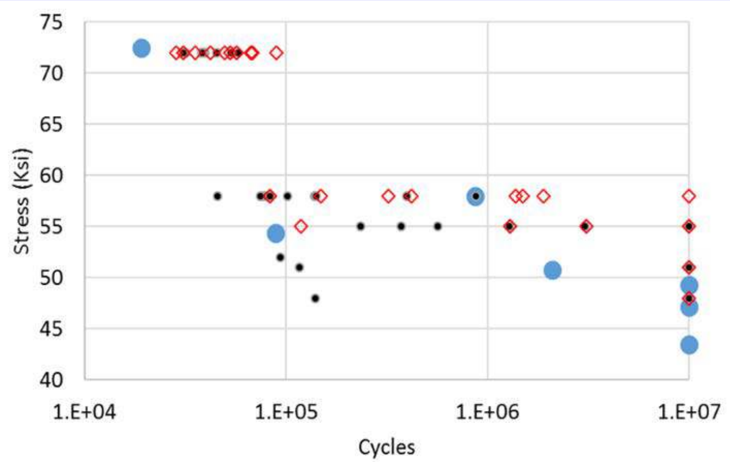
Objectives

<u>Use Integrated Computational Materials Engineering (ICME) to aid in the certification of AM products</u>

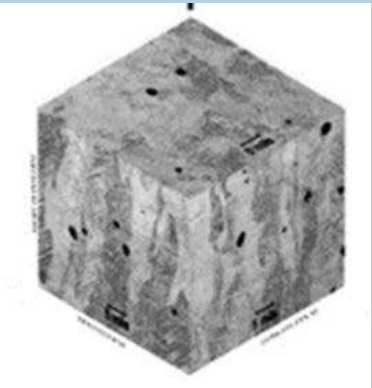
- **Link local properties to overall component durability**
- **Quantify effects of microstructure variations on mechanical performance of AM-built parts**
- **Extend modeling of conventionally-processed materials to predict performance of AM-processed materials**

AM Presents New Opportunities

- Conventional design based on a static materials library
  - Design is separated from material development
- <u>AM allows integration of product design and material properties</u>



Required Durability →

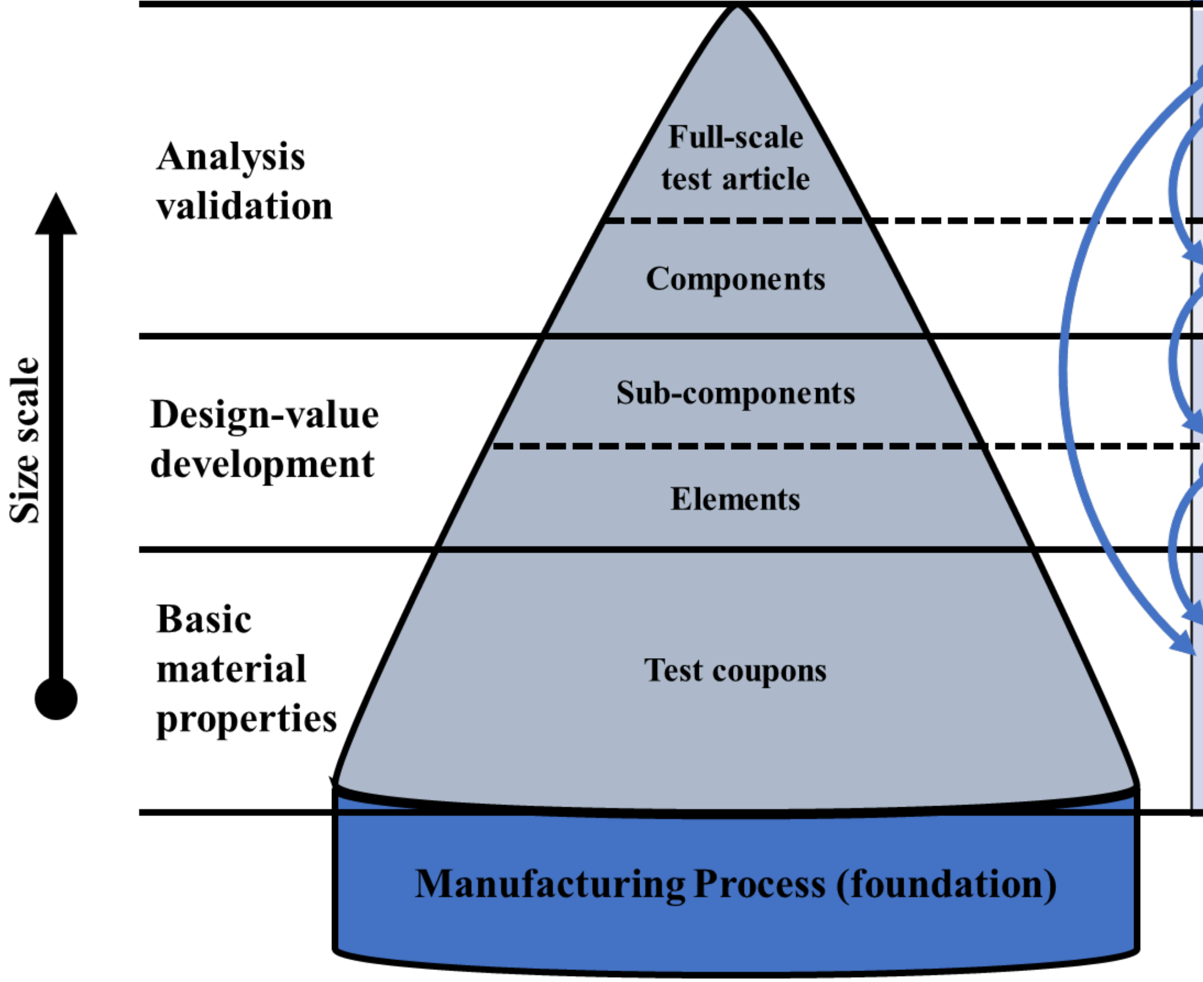


Allowable Microstructure →

Range of Processing Parameters

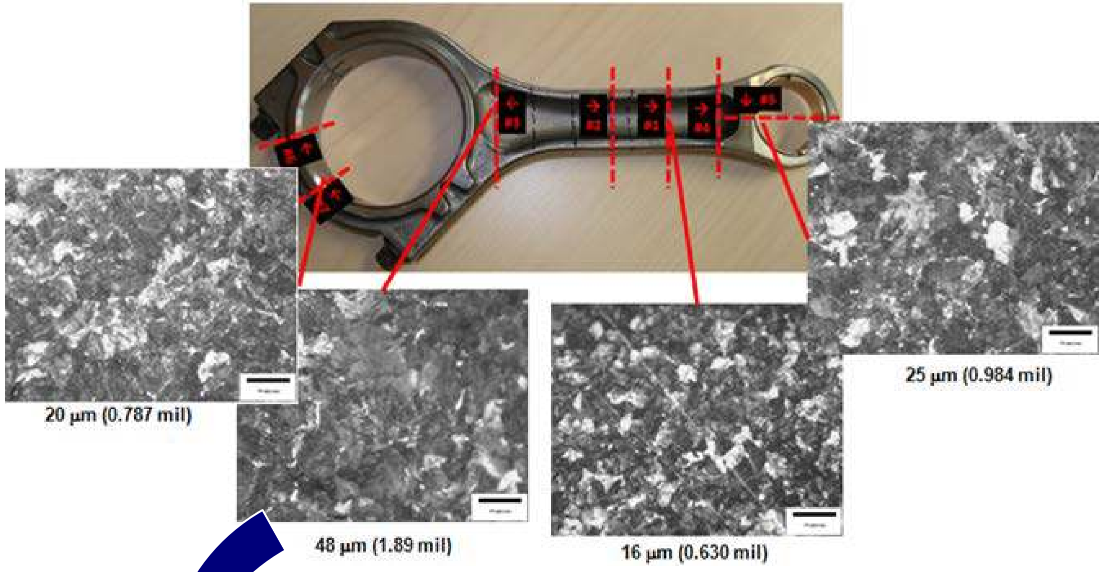
Product Certification Costs

Building Block Test Structure Required for Certification
(adapted from DARPA/DSO "Open Manufacturing Review", 2016)

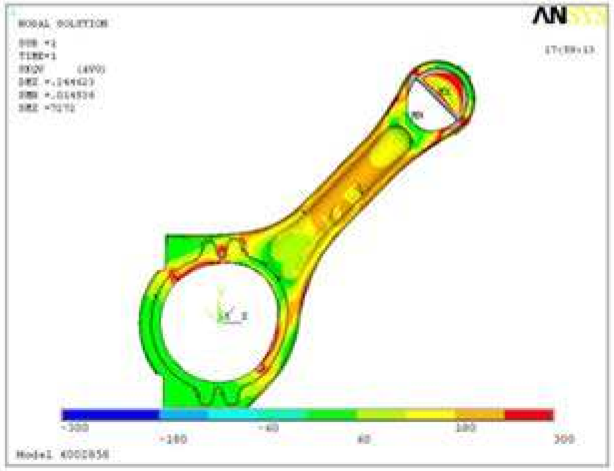


Specimen Count	Cost ($M)	Time (Years)
2-3	100-125	4
10-30	10-20	3
25-50	10-35	3
2000-5000	10-35	3
5000-100,000	8-15	2

Application of ICME



Map microstructure from part to FEA



VPS-MICRO® – computational micro*structural* fatigue software

- **Each element in a FE model can have a different distribution of microstructural properties**
- **Virtual fatigue analysis simulation grain → element → component**
  - **System reliability**
- **Proven technology on forgings, castings, weldments (2 decades)**
- **Now being validated on AM parts**

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Durability Certification in Fatigue

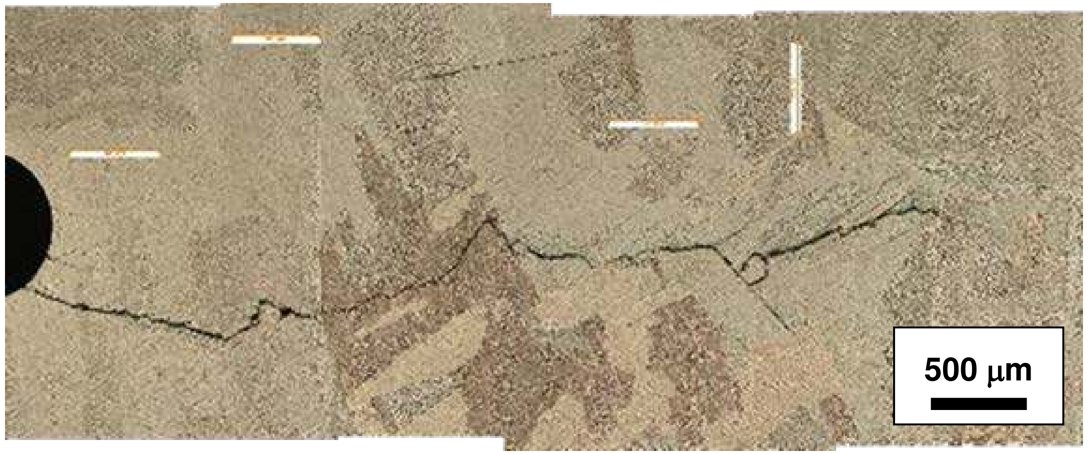
NAVAIR-funded program to develop ICME-based certification of electron beam melted (EBM) Ti-6Al-4V alloy

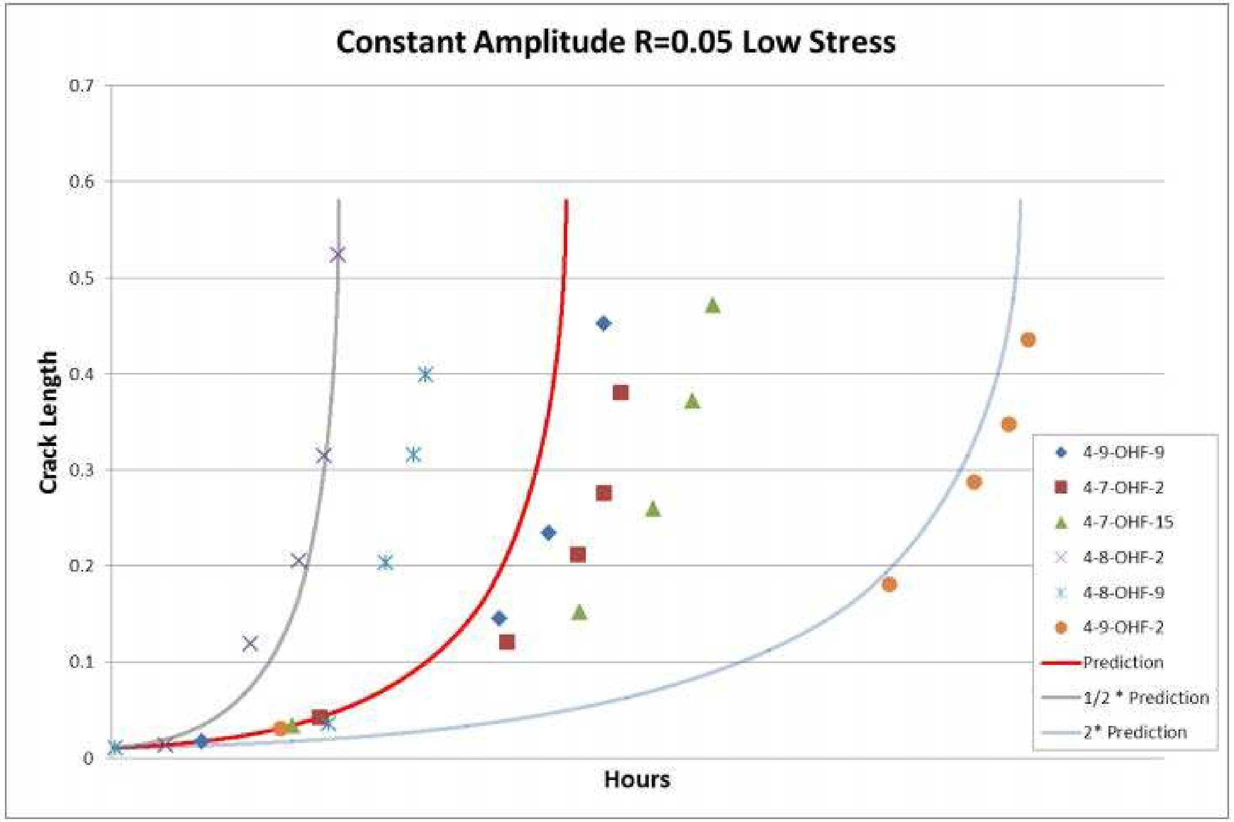
- Certification for cyclic load resistance is expensive
  - Long duration of each test
  - Large scatter in results requires many tests to achieve confidence
- VEXTEC used knowledge about forged / β-annealed Ti-6-4 to develop a certification model for AM Ti-6-4, and compared to physical test data[1]
  - Explicitly modeled differences in microstructure, defects, and damage mechanisms

[1]Gong, Haijun, "Generation and detection of defects in metallic parts fabricated by selective laser melting and electron beam melting and their effects on mechanical properties." (2013). Electronic Theses and Dissertations. Paper 515.

Fatigue Behavior of Forged / β-Annealed Ti-6-4

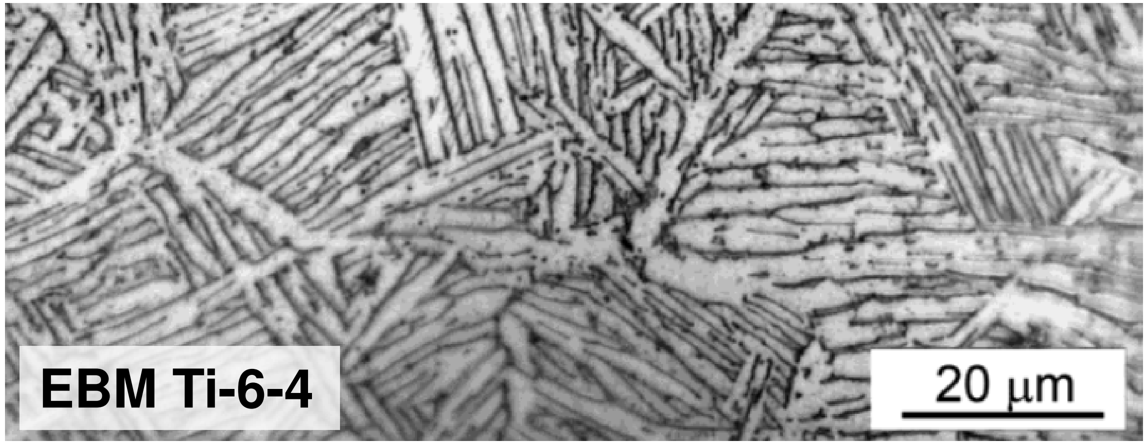
- Majority of life spent in crack growth when damage initiates at a large defect
- Large variation in crack growth
  - Limited slip systems in basket-weave titanium alloys
  - Coarse microstructure





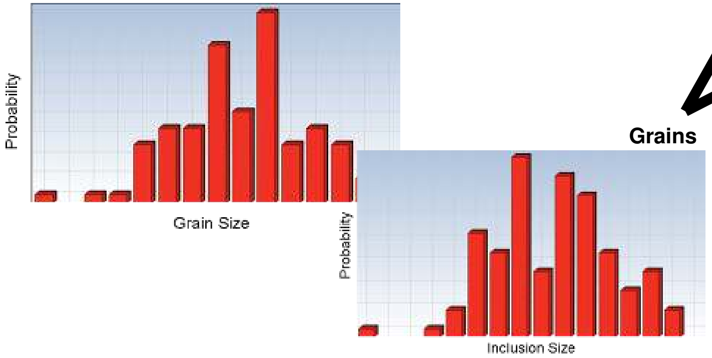
Park, Ji, et al. "Titanium 6Al-4V Durability Method Development and Test Verification Results" (2014). Presented at the Aircraft Structural Integrity Program (ASIP) annual conference.

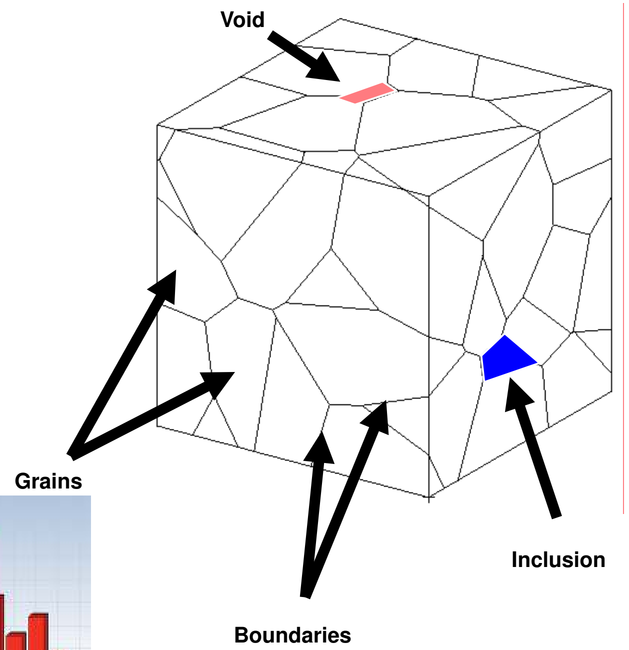
Microstructural Comparison (Forged vs. EBM)



Microstructural Volume Element

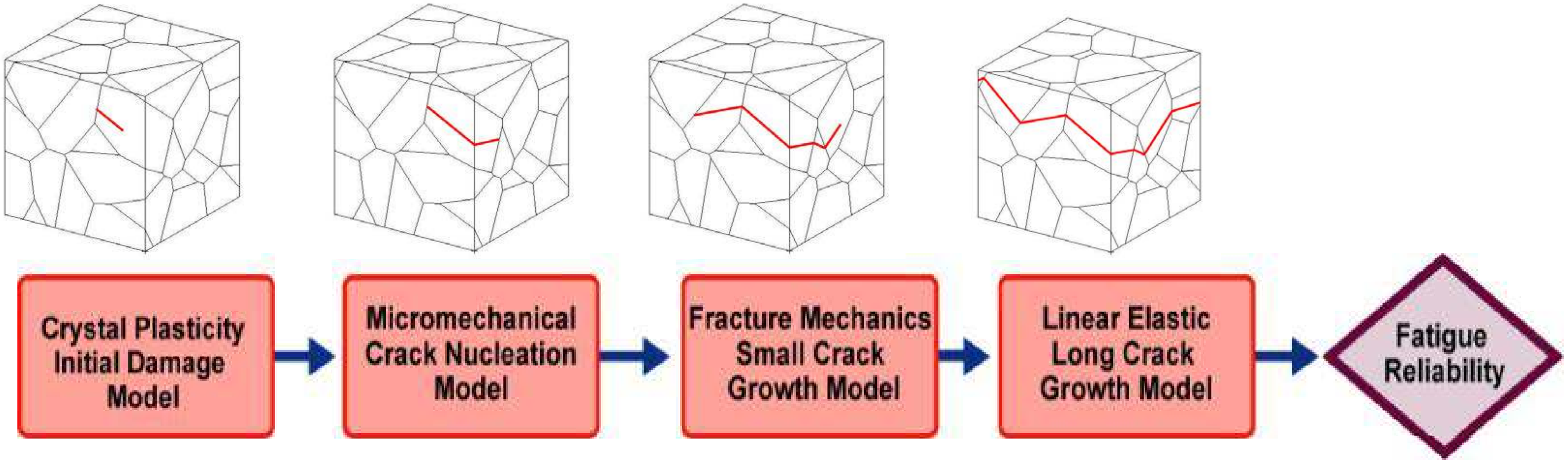
- Microscale matrix material model
- Voids and NMIs





- **EBM Ti-6-4 has similar morphology, but a smaller grain size**
- **Used model previously-calibrated to forged Ti-6-4, to predict EBM Ti-6-4**

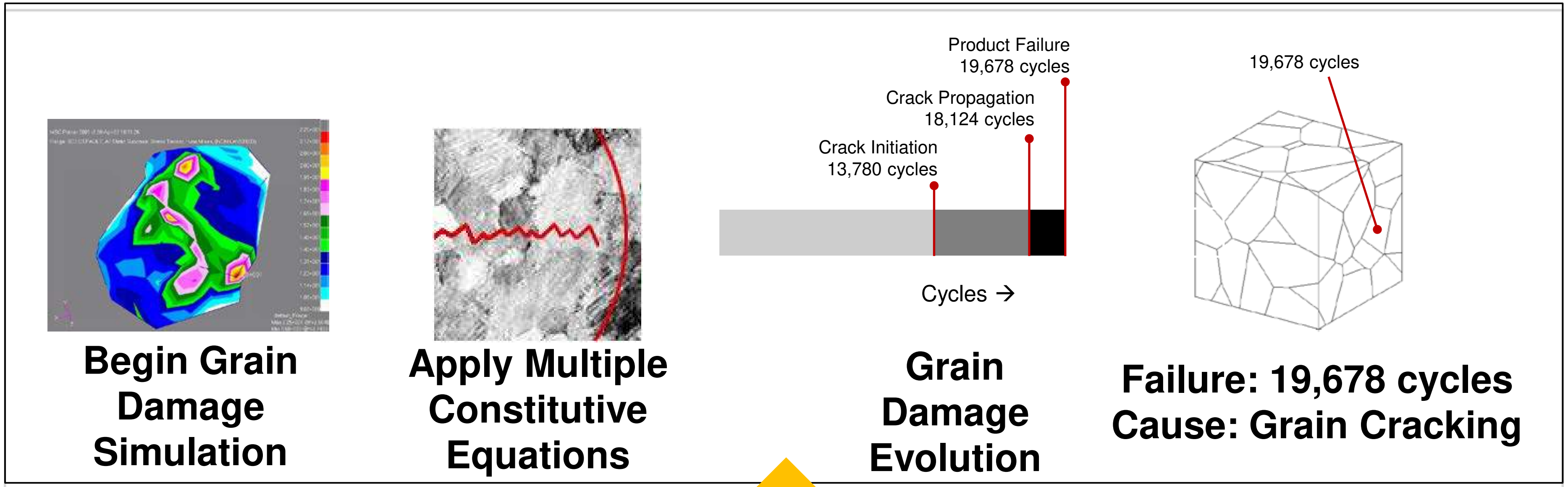
ICME Models for Damage Evolution

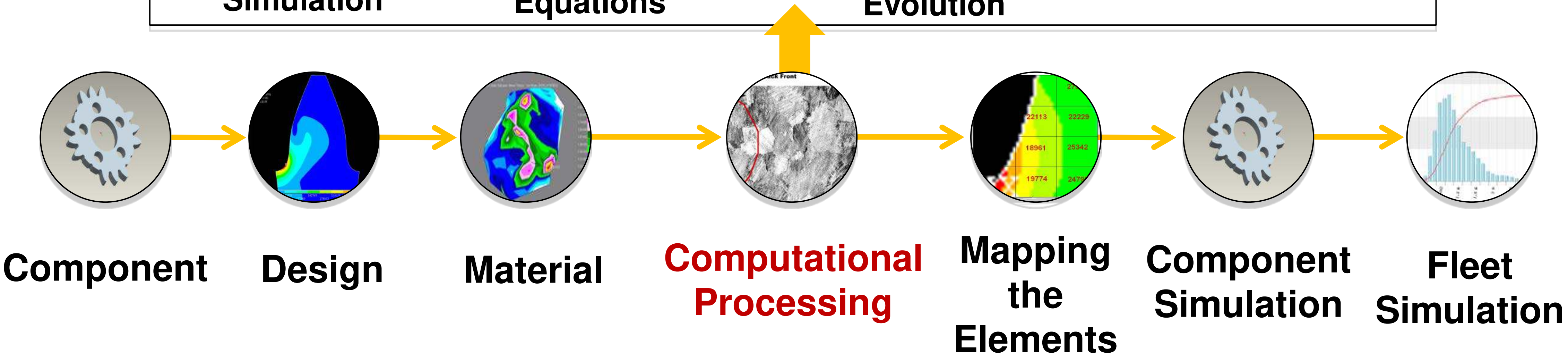


Software uses proven equations for each damage stage

- **Material property values and damage mechanisms from testing**
- **Stage transition rules from experimental observations**

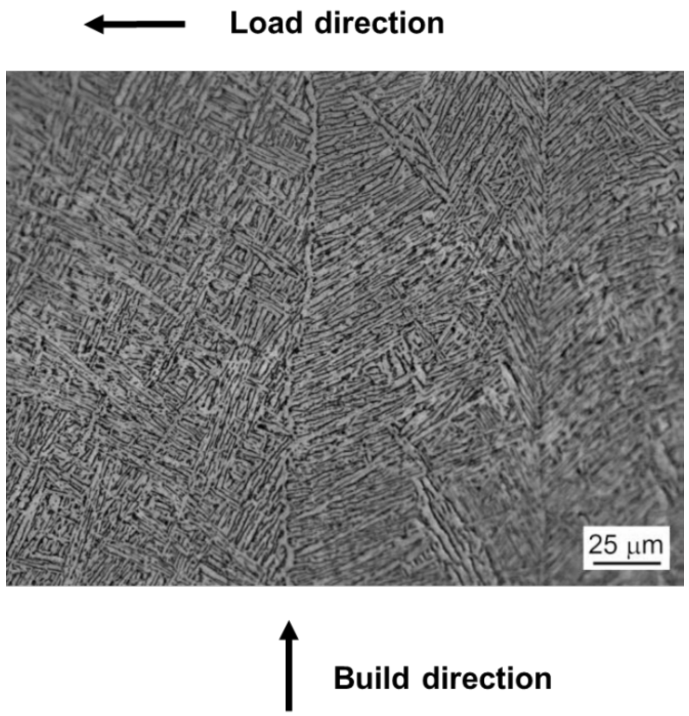
ICME Computational Process Flow



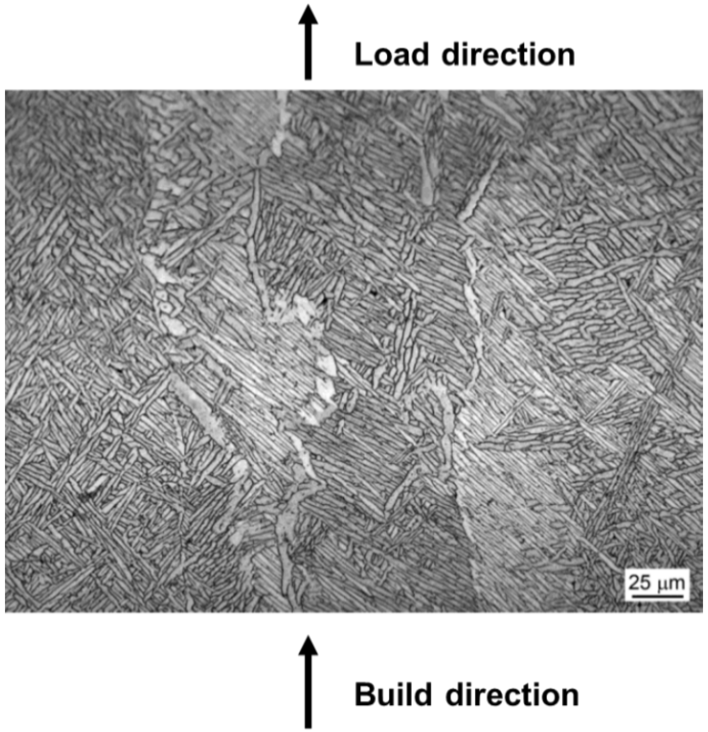


Evaluation of Fatigue and Fracture Mechanism

Horizontal Specimens



Vertical Specimens



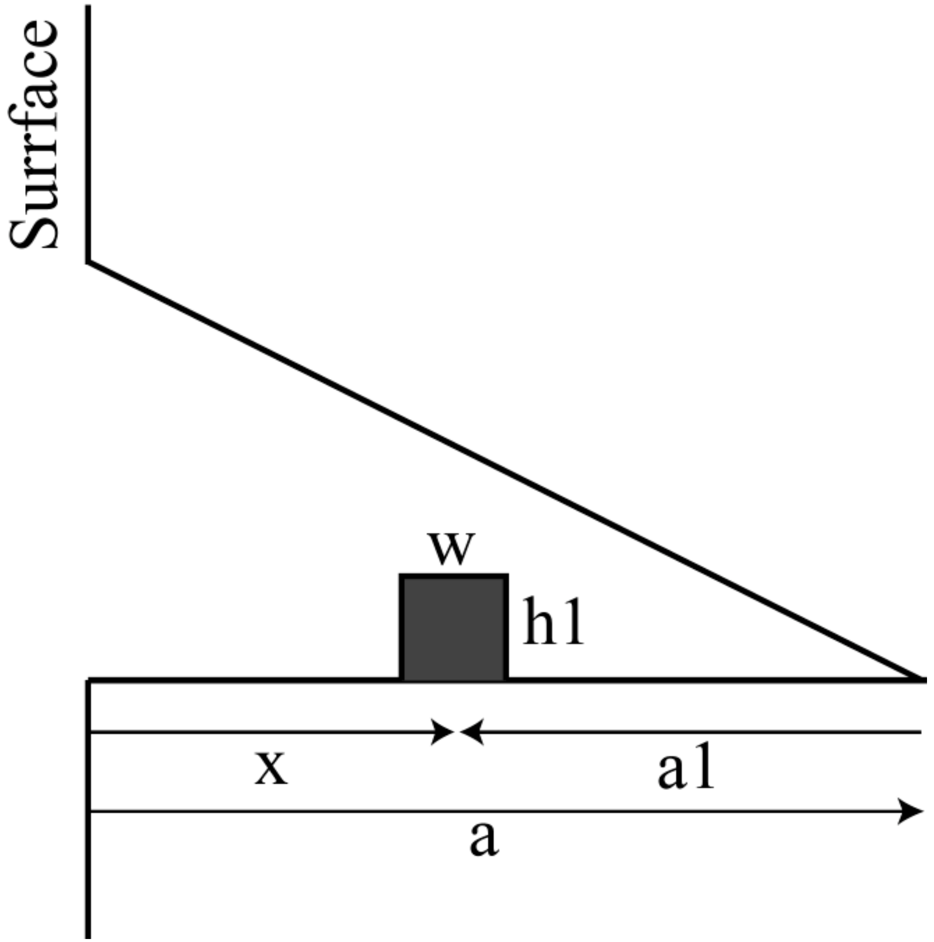
- **Slightly higher tensile strength due to absence of build defects**
- **Smooth fatigue fracture surface**

- **Slightly lower tensile strength due to build defects**
- **Rough fatigue fracture surface**

Gong (2103)

Modeling Rough Fatigue Fracture Surface

- **Difference between physically small crack and long cracks**
  - Plastic deformation of the wake
  - Wake roughness caused by crystallographic crack growth
  - Shielding caused by crack branching
  - Wake roughness caused by oxidation products
- **Wake roughness caused by crystallographic crack growth is the driver in β annealed Ti**



Crack with asperity of height h1 and width w.

Material Property Inputs

		Conventional		AM (Horizontal)	
Description	Distribution	Mean Value	COV	Mean Value	COV
CTOD Law Coefficient	Deterministic	0.1	N/A	0.1	N/A
Slip length	Lognormal	0.025 in.	0.3	0.0034 in	.3
Bulk shear modulus	Deterministic	3610 ksi	N/A	3610 ksi	N/A
Frictional strength	Weibull	113 ksi	0.3	83 ksi	0.3
Grain boundary SIF	Deterministic	2.5 ksi√in.	N/A	3.0 ksi√in.	N/A
Paris Law Coefficient	Lognormal	6.58E-11	0.45	6.58E-11	0.45
Paris law exponent	Deterministic	3.96	N/A	3.96	N/A
Specific fracture energy	Deterministic	7500lbs/in	N/A	7700lbs/in	N/A
Micro-stress	Normal	Applied stress	0.15	Applied stress	0.15
Poisson's ratio	Deterministic	0.3	N/A	0.3	N/A
Defect size	Lognormal	None	N/A	None	N/A
Asperity	Lognormal	0.01, .1, 1, 1	N/A	None	N/A

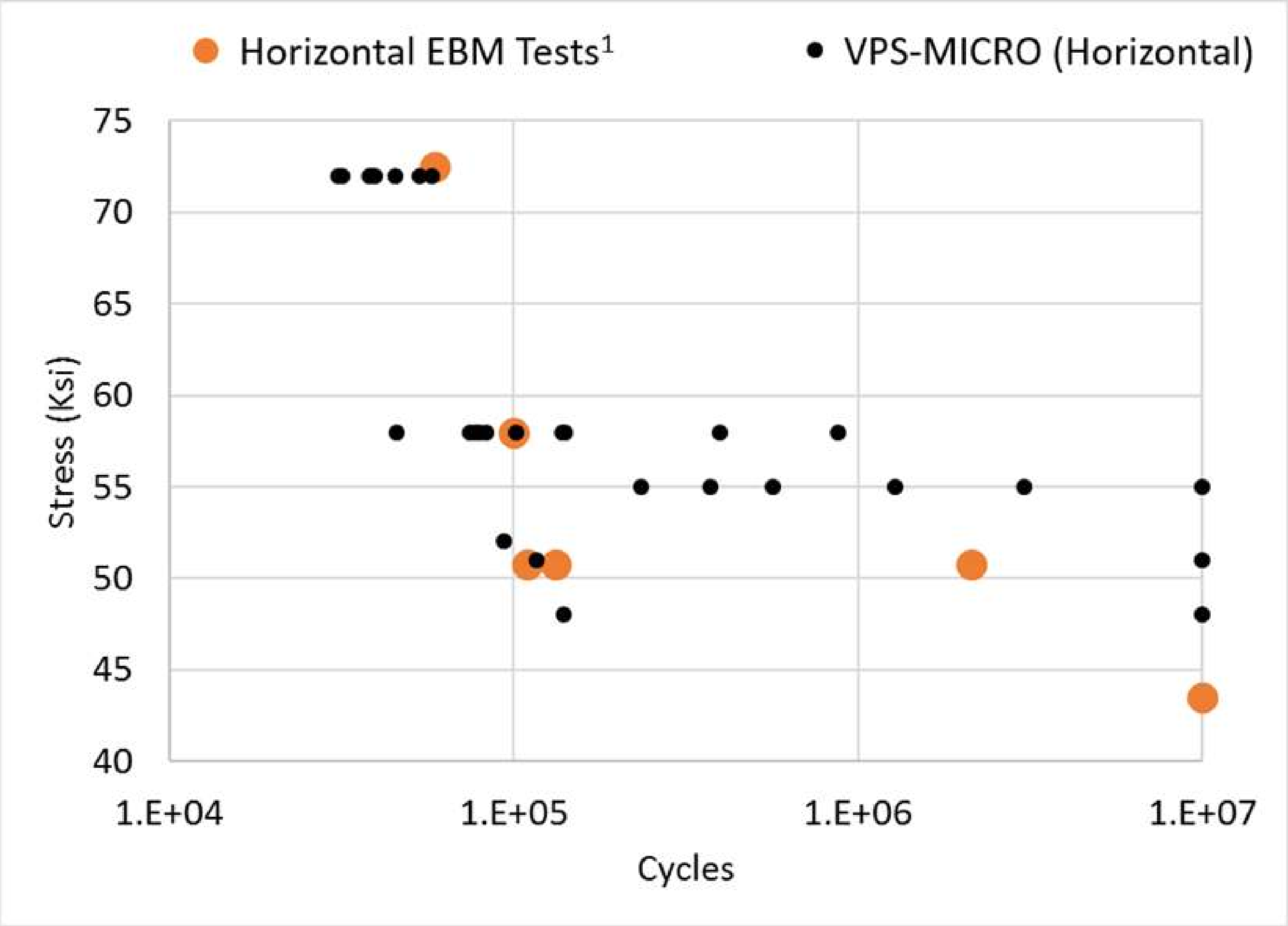
Material Property Inputs

Parameter	Nature and Description of Parameter	Typical Source of Data
Grain Boundary Strength	Deterministic; the minimum strength a nucleated crack must have to propagate.	Threshold crack growth per ASTM E647 (slow rate; high R-ratio).
Small Crack Coefficient	Deterministic; the multiplicative coefficient to small crack growth.	Used in this process as a calibration parameter.
Specific Fracture Energy	Deterministic; the energy barrier for crack nucleation.	Proportional to the area under the stress/strain curve per ASTM E8.
Grain Size	Probabilistic; the size of the microstructure participating in damage.	Metallography (preparation per ASTM E3); measure per ASTM E1382 (or equivalent).
Frictional Strength	Probabilistic; the micro-yield strength of a grain to resist dislocation motion.	Proportional to monotonic yield strength per ASTM E8; cyclic yield strength per ASTM E606 (for parameter refinement).
Long Crack Growth Parameters	Exponent 'n' (deterministic) and coefficient 'C' (probabilistic) of Paris Equation: $da/dN = C\Delta K^n$.	Long crack growth regime per ASTM E647.
Defect Size / Population	Probabilistic; size and area density of the defects participating in the damage.	Metallography (preparation per ASTM E3); measure per ASTM E1245 (or equivalent).

Model Predictions for Horizontal Specimens

Used software with model for conventional Ti-6-4 updated with measured material properties from experimental tests

- **10 specimens simulated at each stress level (all complete < 1 hr.)**
- **Results show good comparison between actual and predicted fatigue lives**



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Material Property Comparison (Forged vs. EBM)

†Additional model parameters (not listed) were unchanged between forged & EBM conditions

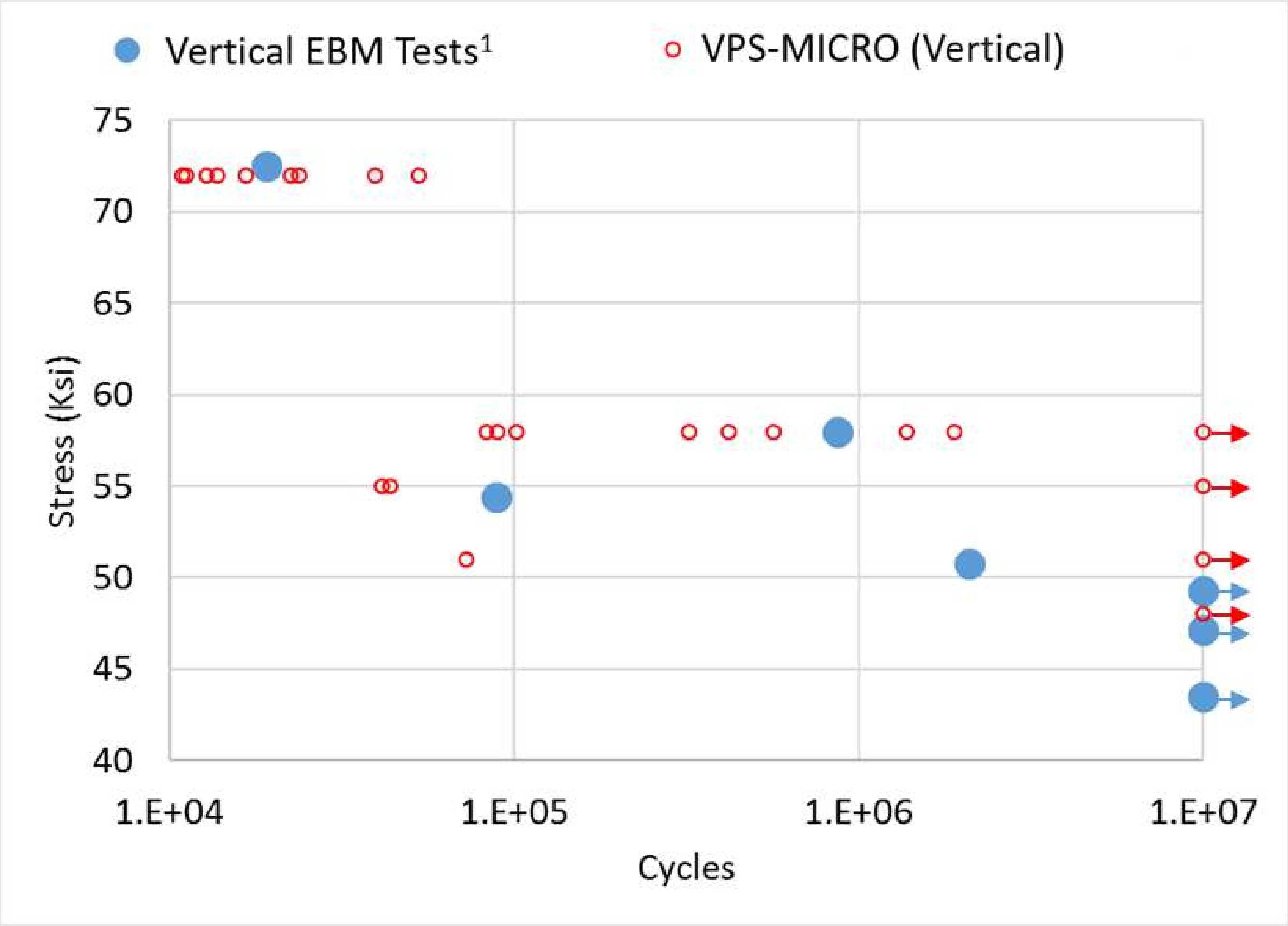
	Material Properties Influenced by Manufacturing Technique†		Ti-6Al-4V Forged + β-Annealed		Ti-6Al-4V EBM (Horizontal)		Ti-6Al-4V EBM (Vertical)	
	Description	Distribution	Mean Value	COV	Mean Value	COV	Mean Value	COV
Probabilistic	Grain size	Lognormal	0.025 in	0.3	0.0034 in	0.3	0.0034 in	0.3
Probabilistic	Frictional strength	Weibull	113 ksi	0.3	83 ksi	0.3	83 ksi	0.3
	Grain boundary SIF	Deterministic	2.5 ksi√in	N/A	3.0 ksi√in	N/A	3.0 ksi√in	N/A
	Specific fracture energy	Deterministic	7500 lbs/in	N/A	7700 lbs/in	N/A	7700 lbs/in	N/A
Probabilistic	Defect size (population density)	Lognormal	None	N/A	None	N/A	0.004 (200/in^2)	0.3
	Asperity	Deterministic	0.01,0.1,1,1	N/A	None	N/A	0.01,0.5,1,1	N/A

Model Predictions for Specimens w/ both Defects and Asperities i.e., Vertical Specimens

Experimentally observed mechanistic differences between Horizontal and Vertical specimens

- **Defects are active damage sources in Vertical specimens**
- **Tortuous fracture surfaces of Vertical specimens (asperities)**

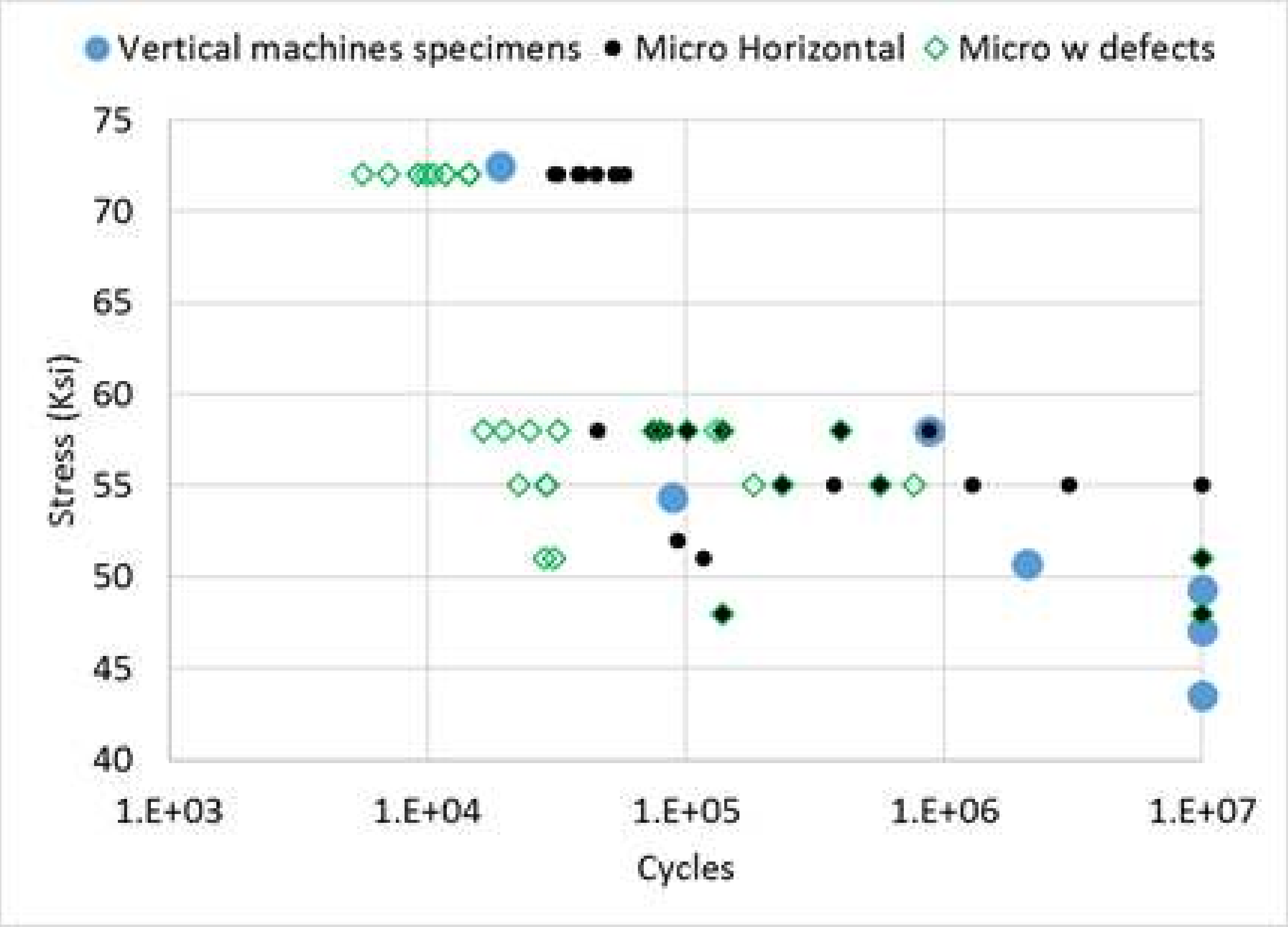
- **10 specimens simulated at each stress level (all complete < 1 hr.)**
- **Good comparison between actual and predicted fatigue lives**



Model Predictions for Specimens w/ only Defects

Used software with model for Horizontal specimens updated with *only* the defects measured from Vertical specimen fracture surfaces

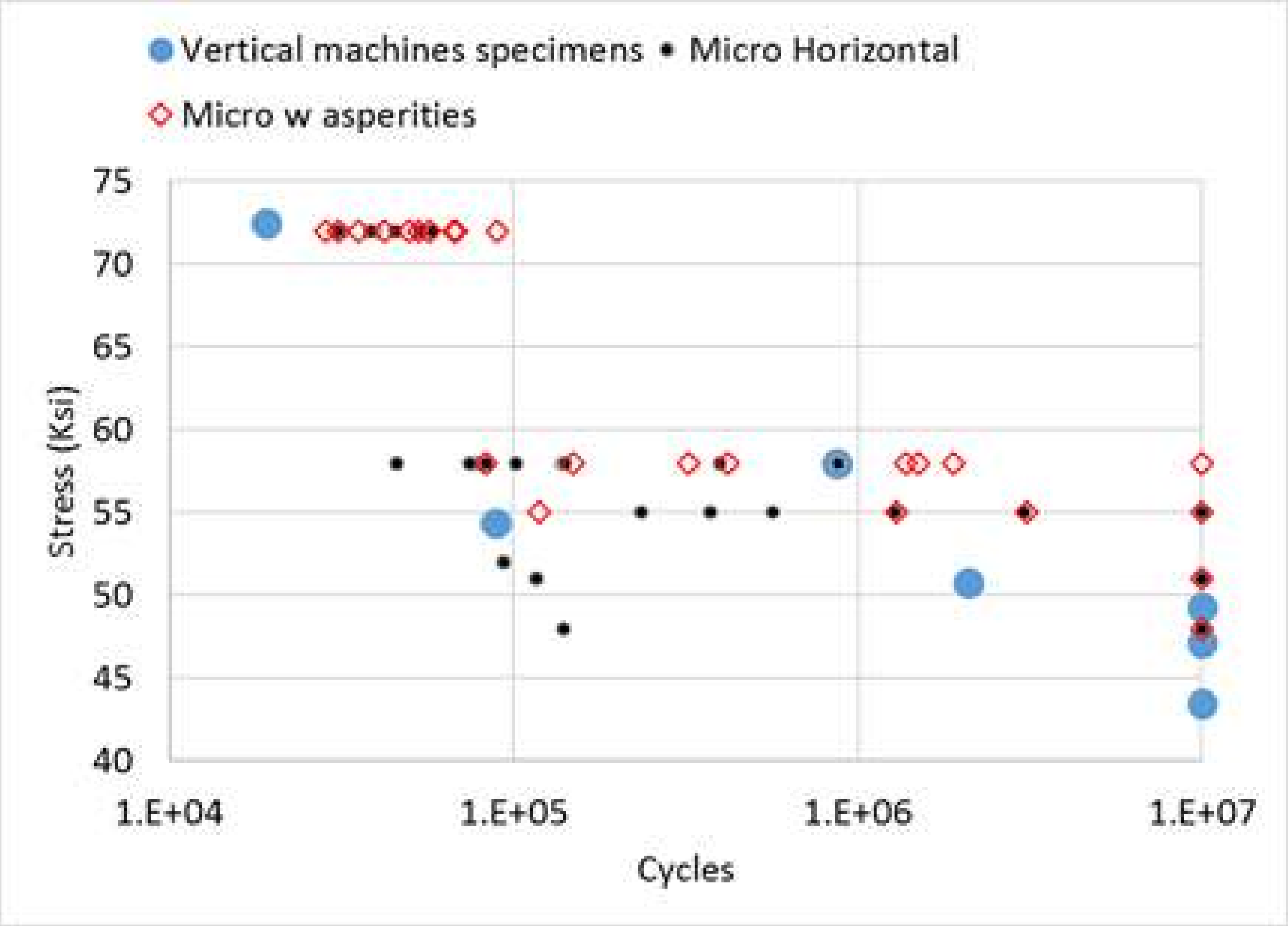
- **Defects are active damage sources in Vertical specimens**
- **10 specimens simulated at each stress level (all complete < 1 hr.)**
- **Simulation under predicts the Vertical specimen lifetimes**



Model Predictions for Specimens w/ only Asperities

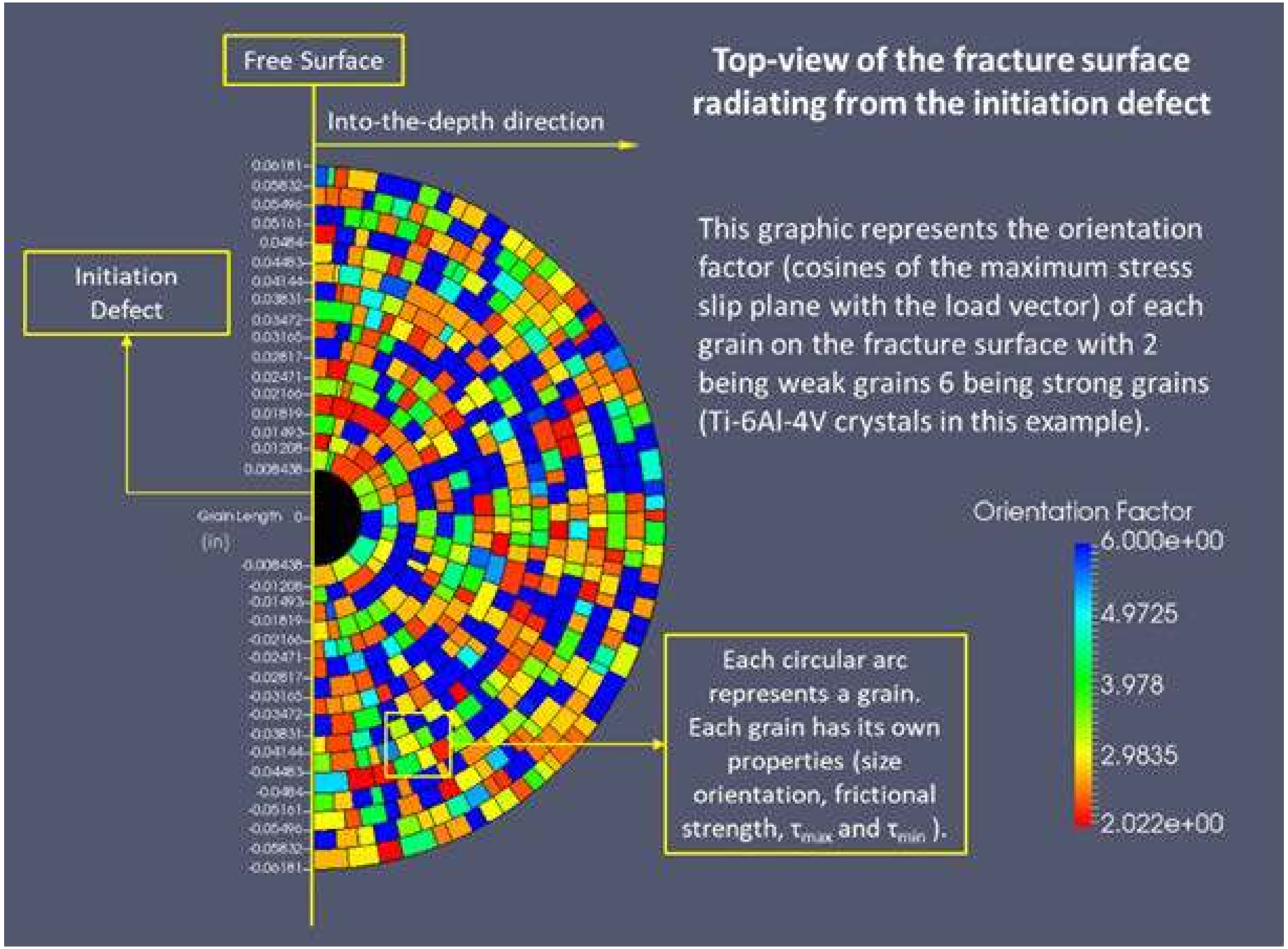
Used software with model for Horizontal specimens updated with *only* the asperities observes on Vertical specimen fracture surfaces

- **Tortuous fracture surfaces of Vertical specimens (asperities)**
- **10 specimens simulated at each stress level (all complete < 1 hr.)**
- **Simulation over predicts the Vertical specimen lifetimes**



Simulated Crack Growth Rate

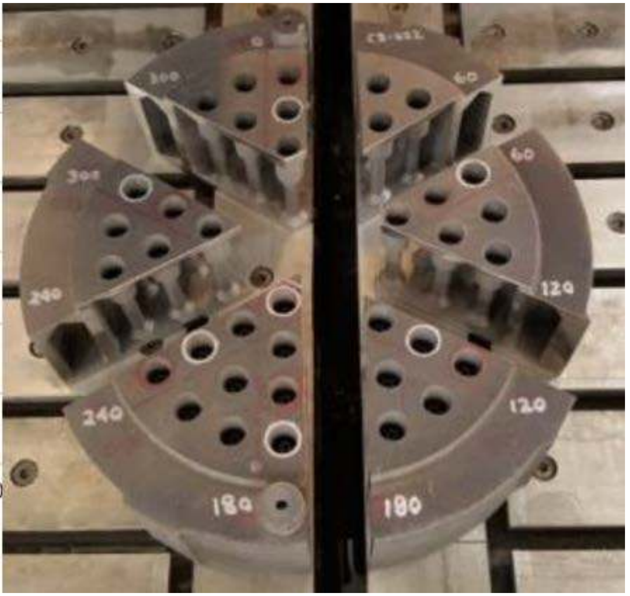
Simulated Fracture Surface

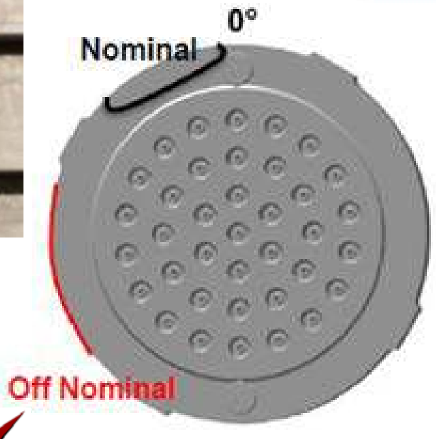


Burst Test Prediction of AM Nickel Nozzles

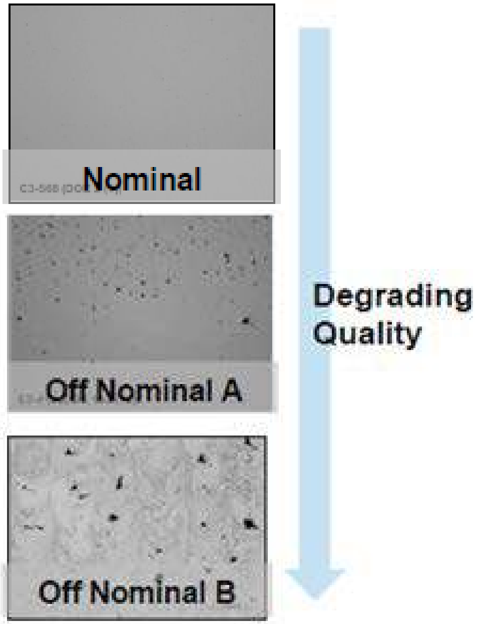
Nickel Nozzle

- SLM Mondaloy



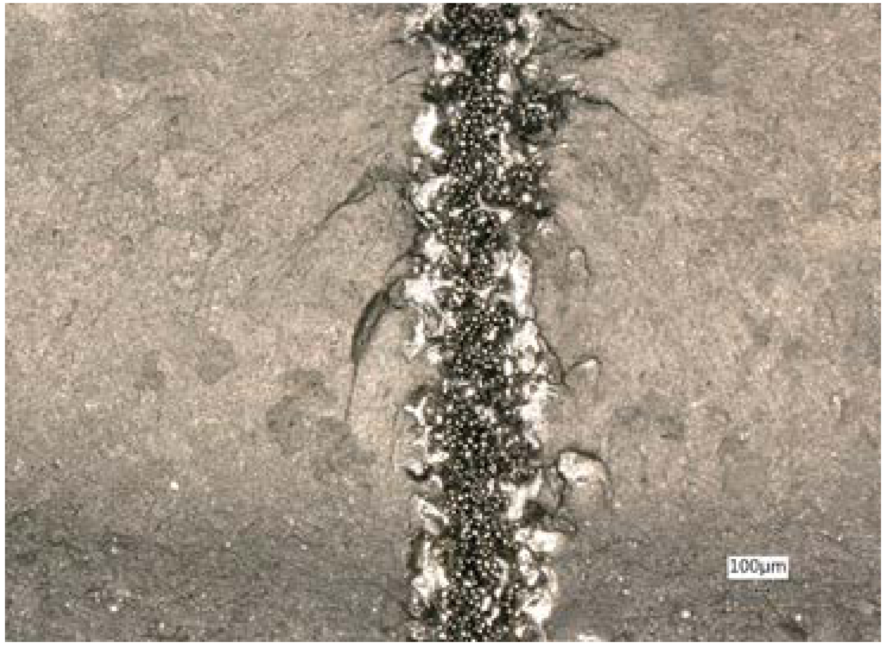


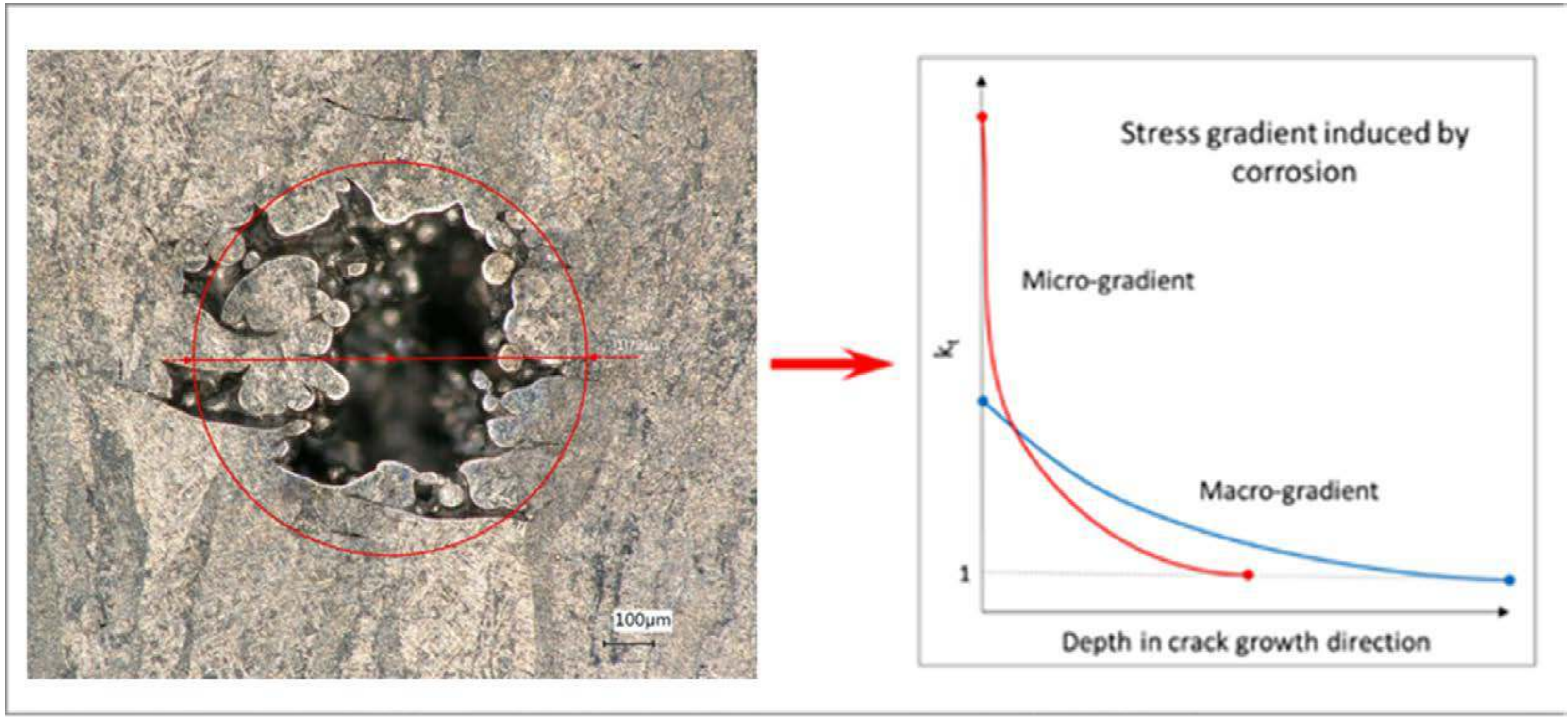
Unit	Identifier	Operating Pressure	Proof Pressure	Vextec Calculated Burst	Actual Burst
Nominal	C3-11/28/16	6.5 KSI	7.8 KSI	>13 KSI	15.022KSI
Off-Nominal A	C3-11/14/16	6.5 KSI	7.8 KSI	11-13 KSI	12.218 KSI
Off-Nominal B2	C3-120816	6.5 KSI	7.8 KSI	11-12 KSI	In Process
Off-Nominal B3	C3-011217	6.5 KSI	7.8 KSI	11-12 KSI	10.555 KSI



Software accurately predicted burst test location & pressure for different AM process settings

Next Steps: Model Surface Roughness effect on Fatigue





Conclusions

- ICME was used to link microstructure-to-performance
- Microstructural effects due to changes in AM processing characteristics were identified
- A probabilistic ICME fatigue model previously calibrated to conventionally processed Ti-6Al-4V was extended to predict fatigue of AM/EBM Ti-6Al-4V
- ICME software can decrease the time and resources needed to certify metal AM structural components exposed to fatigue.

THANK YOU

We welcome you to Booth #151 for a software demo