<table>
<thead>
<tr>
<th>Title</th>
<th>High Temperature Strength and Oxidation Resistance of Newly Developed SiC Fibers (Mechanics, Strength &amp; Structure Design)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Author(s)</td>
<td>Serizawa, Hisashi; Lewinsonh, Charles A.; Youngblood, Gerald E.; Jones, Russ H.; Johnston, Daniel E.; Kohyama, Akira</td>
</tr>
<tr>
<td>Citation</td>
<td>Transactions of JWRI. 27(1) P.57-P.60</td>
</tr>
<tr>
<td>Issue Date</td>
<td>1998-07</td>
</tr>
<tr>
<td>Text Version</td>
<td>publisher</td>
</tr>
<tr>
<td>URL</td>
<td><a href="http://hdl.handle.net/11094/3922">http://hdl.handle.net/11094/3922</a></td>
</tr>
<tr>
<td>DOI</td>
<td></td>
</tr>
<tr>
<td>rights</td>
<td>本文データはCiNiiから複製したものである</td>
</tr>
</tbody>
</table>
High Temperature Strength and Oxidation Resistance of Newly Developed SiC Fibers


Abstract

As a result of R & D efforts for silicon carbide (SiC) fibers, near-stoichiometric and highly crystalline SiC fiber (Hi-Nicalon type S) has been developed. In this research, to estimate the potential capability of Hi-Nicalon type S for reinforcement of ceramic matrix composites, fiber tensile tests at high temperature and fiber oxidation tests at 1373 K were carried out. Hi-Nicalon fibers were also tested to compare with Hi-Nicalon type S. From the results of research for effects of gauge length on fiber strength, the strength-gauge length relationship of Hi-Nicalon type S was found to follow the weakest-link rule. The results of tensile tests at high temperature indicated that the strength of Hi-Nicalon type S slightly increased with increasing test temperature. Finally, from the SEM observation results of oxidized fibers, the oxidation behavior of Hi-Nicalon type S was found to fit the Deal/Grove linear-parabolic model.

KEY WORDS: (SiC Fibers) (Ceramic Matrix Composites) (Ceramics) (High Temperature) (Oxidation) (Tensile Strength) (Composites)

1. Introduction

SiC-based fibers which have high tensile strength, high elastic modulus and good thermal stability are one of the most promising candidates for the reinforcement of ceramic matrix composites (CMCs). Many types of SiC-based fibers have been produced industrially for example Nicalon of Nippon Carbon Co., Ltd. and Tyranno Lox-M of UBE Co., Ltd.. At high temperature, however, microstructural changes in those SiC-based fibers occur because of surplus oxygen in the fibers, thus degrading the properties of CMCs. Therefore the SiC-based fibers with a low oxygen content have been developed: Hi-Nicalon of Nippon Carbon Co., Ltd. and Tyranno Lox-E of UBE Co., Ltd.. Recently, based on research on the effect of C/Si on thermomechanical properties of fibers, the near-stoichiometric and highly crystalline SiC fiber, which was named Hi-Nicalon type S, has been developed by Nippon Carbon Co., Ltd. according to ASTM standards in USA or JIS standards in Japan where the gauge length is 1 inch or 25 mm, respectively. So the effects of gauge length on the fiber strength was examined. In addition, since fiber oxidation can seriously degrade the mechanical behavior of CMCs, oxidation studies were carried out.

2. Experimental

Materials used for the fiber tensile tests were Hi-Nicalon type S and Hi-Nicalon. Characteristic properties of these fibers, as reported by the manufacturer, are shown in Table 1 where the tensile strength at room temperature (R.T.) was measured with 25 mm gauge length according to JIS standards (JIS R 7601) by Nippon Carbon Co., Ltd.. In this study a 190 mm gauge

<table>
<thead>
<tr>
<th>Table 1</th>
<th>Characteristic properties of fibers used.</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Hi-Nicalon type S</td>
</tr>
<tr>
<td></td>
<td>Hi-Nicalon</td>
</tr>
<tr>
<td>Diameter</td>
<td>12 µm</td>
</tr>
<tr>
<td>Density</td>
<td>3.20 Mg/m³</td>
</tr>
<tr>
<td>Tensile Strength</td>
<td>2.45 GPa</td>
</tr>
<tr>
<td>Tensile Modulus</td>
<td>390 GPa</td>
</tr>
<tr>
<td>Oxygen</td>
<td>0.8 wt%</td>
</tr>
</tbody>
</table>

*** Professor, Kyoto University

Transactions of JWRI is published by Joining and Welding Research Institute of Osaka University, Ibaraki, Osaka 567-0047, Japan.

† Received on June 1, 1998
* Research Associate
** Pacific Northwest National Laboratory
*** Undergraduate Student, University of Washington

**** Professor, Kyoto University
length was used to ensure that the ends of the fibers, where the load was applied, were cool during high-
temperature testing. The fiber tensile tests were carried
out with a Micropull Tensile Test Machine (Micropull
Science) with a constant crosshead rate of 5.5 μm/s. Hi-
Nicalon type S were tested at R.T., 1373 K and 1673 K,
in air. Hi-Nicalon fibers were tested at R.T. and 1373 K,
in air. In addition, Hi-Nicalon fibers that were annealed
at 1373 K in argon for 2 hours and fibers that were
oxidized at 1373 K in air for 2 hours also were examined.
To study the oxidation behavior of Hi-Nicalon type S
fibers, fibers were oxidized at 1373 K for 10, 50, 100
and 210 hours, in air. The oxide layer thickness of fibers
was measured directly with SEM observations.

3. Results and Discussion
3.1 Effect of gauge length

The strength (σ) distribution of brittle fibers like SiC, glass or carbon fibers usually follows a classical
Weibull distribution described by the following Eq. (1),

\[ P(\sigma) = 1 - F(\sigma) = \exp \left[ -\left( \frac{\sigma}{\sigma_0} \right)^m \right] \]  (1)

where \( P(\sigma) \), \( F(\sigma) \), \( m \) and \( \sigma_0 \) are probability of
survival, probability of failure, shape parameter (Weibull
modulus) and scale parameter (sigma zero), respectively.
The results of fiber tensile tests of Hi-Nicalon type S
with 190 mm gauge length at R.T. are shown in Fig. 1.
The strength of the fiber was 1.33 GPa according to the
classical Weibull distribution. The fiber diameter, 12.7
μm, was determined from SEM measurements of Hi-
Nicalon type S fibers.

Eq. (1) does not explicitly include the effects of
gauge length. To predict the strength at a different gauge
length, the results were analyzed by using the following
modified Eq. (2), which was suggested by Watson and
Smith\(^6\) and Gutans and Tamuzs\(^5\),

\[ P(\sigma) = 1 - F(\sigma) = \exp \left[ -\left( \frac{l_0}{l_0} \right)^\alpha \cdot \left( \frac{\sigma}{\sigma_0} \right)^m \right] \]  (2)

where \( l \) and \( l_0 \) are the different gauge lengths (\( l \geq l_0 \)),

and \( \alpha \) is a parameter between 0 and 1. Phoenix et al.\(^{\text{10}}\)
suggested that \( \alpha = 0.60 \) for Kevlar 49 fibers, and
Watson and Smith\(^6\) obtained \( \alpha = 0.90 \) for carbon fibers.
In the case of fibers that obey the weakest-link rule, \( \alpha \)
becomes 1.0 and Wu and Netravali\(^{\text{10}}\) reported that \( \alpha =
1.0 \) for single Nicalon fibers. In contrast, recent data for
ultra high-strength polyethylene fibers yield \( \alpha \) near
zero\(^{\text{12}}\). To compare with Nippon Carbon's results shown
in Table 1, 190 and 25 mm were used for \( l \) and \( l_0 \),
respectively, and \( \alpha \) was assumed to be 1.0. Then, from

Fig. 1  Results of fiber tensile tests of Hi-Nicalon type S with 190 mm gauge length at R.T..

the analysis of the fiber tensile tests according to Eq. (2),
the strength of Hi-Nicalon type S with 25 mm gauge
length was calculated to be 2.09 GPa. If the fiber
diameter was assumed to be 12.0 μm according to Table
1 as reported by the manufacturer, the strength of Hi-
Nicalon type S with 25 mm gauge length was calculated
to be 2.35 GPa, which is in agreement with Nippon Carbon's results considering that the typical value for
the standard deviation is 0.36 GPa and the Weibull modulus
is relatively low. Since the standard deviation of the fiber
diameter was 0.78 μm and the accuracy of SEM
observation was considered to be 10%, the strength-
gauge length relationship of Hi-Nicalon type S was
found to follow the weakest-link rule.

3.2 Fiber tensile tests at high temperature

The results of fiber tensile tests at R.T. and high
temperature are shown in Table 2. The diameters of
fibers were decided from SEM observations of the tested
fibers. The strength of fibers was calculated from the
classical Weibull distribution analysis where at least 30
fibers were tested. The diameter of fibers did not change
after heat treatment, annealing in argon for 2 hours or
oxidation in air for 2 hours.

The effect of test temperature on the tensile strength
values of the fibers are shown in Fig. 2. In the case of
Hi-Nicalon, the strength of the fibers scarcely changed
with increasing test temperature. After fibers were
annealed or oxidized, the strength decreased
significantly although the diameter did not change. This
decrease in strength is probably due to microstructural
development in the fiber, such as grain growth. Takeda et
Table 2  Results of fiber tensile tests at R.T. and high temperature.

<table>
<thead>
<tr>
<th>Test Temperature</th>
<th>Hi-Nicalon type S</th>
<th>Hi-Nicalon</th>
<th>Hi-Nicalon annealed</th>
<th>Hi-Nicalon oxidized</th>
</tr>
</thead>
<tbody>
<tr>
<td>R.T.</td>
<td>1373 K</td>
<td>1673 K</td>
<td>1373 K</td>
<td>1373 K</td>
</tr>
<tr>
<td>Weibull Modulus, m</td>
<td>4.49</td>
<td>4.06</td>
<td>6.11</td>
<td>5.06</td>
</tr>
<tr>
<td>Tensile Strength, σ₀</td>
<td>1.33 GPa</td>
<td>1.60 GPa</td>
<td>1.74 GPa</td>
<td>2.88 GPa</td>
</tr>
<tr>
<td>Standard Deviation</td>
<td>0.32 GPa</td>
<td>0.39 GPa</td>
<td>0.28 GPa</td>
<td>0.60 GPa</td>
</tr>
<tr>
<td>Diameter of Fibers</td>
<td>12.7 μm</td>
<td>12.7 μm</td>
<td>12.7 μm</td>
<td>12.6 μm</td>
</tr>
<tr>
<td>Number of Specimens</td>
<td>31</td>
<td>30</td>
<td>32</td>
<td>34</td>
</tr>
</tbody>
</table>

![Diagram](image)

**Fig. 2**  Effects of test temperature on tensile strength of fiber.

![Diagram](image)

**Fig. 3**  Effects of oxidation time on oxide layer thickness.

al. has also reported a decreasing strength with increasing temperature for Hi-Nicalon fibers annealed in argon. It is also possible that these results are due to damage to the fiber surfaces caused by removal of the protective sizing and additional handling steps. On the other hand, for Hi-Nicalon type S, the strength increased slightly with increasing test temperature up to 1673 K. One possible explanation for this apparent increase in strength is the formation of a thin layer of oxide that blunts, or heals, pre-existing flaws in the fibers. In addition, thermal expansion may close some of the pre-existing flaws on the fiber surface. Since Takeda et al. has measured a decrease in the strength of Hi-Nicalon type S with increasing heat-treatment temperature, it is likely that simultaneous changes in the fiber microstructure occur during high temperature testing. Since the initial grain size of the Hi-Nicalon type S is larger than that of the Hi-Nicalon fibers, if grain growth occurred in both fibers at a similar rate (i.e., controlled by the same diffusional process) then the strength of the Hi-Nicalon type S fibers would decrease more slowly than the Hi-Nicalon fibers. If the decrease in strength occurred at a slow enough rate then another process, such as flaw healing due to the growth of a surface oxide, may be capable of mitigating the strength loss temporarily.

3.3 Oxidation tests

The effects of oxidation time on oxide layer thickness of Hi-Nicalon type S are shown in Fig. 3. The thickness was measured from SEM observation of the cross section of the fibers normal to their axis. The thickness gradually increased with increasing oxidation time. In the case of 210 hours oxidation, which is indicated by an open circle in Fig.3, the thickness was not clearly observed by SEM because not only the edges of fibers but also the surface of fibers were oxidized. So this result might be smaller than the true thickness.

To analyze the oxidation results the Deal/Grove linear-parabolic model, which describes the growth of silica (SiO₂) on silicon, was applied. This model describes the oxidation of silicon using a mixed-control model, in which the diffusion of oxygen through the oxide layer and the chemical reaction at the Si/SiO₂ interface act in series. These two processes are coupled by the concentration of the diffusing species at the interface. The Deal/Grove model predicts that, for thin oxide layers, the chemical reaction at the Si/SiO₂ interface is rate controlling. As the oxide thickens, the growth rate is limited by the coupled control between the interfacial reaction and the diffusion of oxygen through the SiO₂. Finally, for thick oxides, the growth rate is diffusion controlled. For fast gaseous diffusion, their model is,
Table 3 Rate constants for Deal/Grove model\textsuperscript{15}.

<table>
<thead>
<tr>
<th>Material</th>
<th>B (nm\textsuperscript{3}/min)</th>
<th>B/A (nm\textsuperscript{3}/min)</th>
<th>(\tau)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Single-crystal SiC (0001)</td>
<td>239.10</td>
<td>0.1678</td>
<td>4.573</td>
</tr>
<tr>
<td>Single-crystal SiC (0001)</td>
<td>11.15</td>
<td>0.0199</td>
<td>86.85</td>
</tr>
<tr>
<td>CVD SiC (111)</td>
<td>225.50</td>
<td>0.1841</td>
<td>0</td>
</tr>
<tr>
<td>CVD SiC (111)</td>
<td>12.98</td>
<td>2.807</td>
<td>0</td>
</tr>
<tr>
<td>Hi-Nicalon type S</td>
<td>71.4</td>
<td>0.266</td>
<td>22.1</td>
</tr>
</tbody>
</table>

\[ x^3 + A \cdot x = B \cdot (t + \tau) \]

where \(x\) and \(\tau\) are oxide thickness and time, respectively. The time constant \(t\) allows the origin \((x = 0)\) of the model to adjust to allow for an initial oxide layer or regime not described by the model. \(B\) is the parabolic rate constant. \(B/A\) is the linear rate constant.

The oxidation behavior of silicon and SiC has been well described by the Deal/Grove model\textsuperscript{16}. Ramberg et al.\textsuperscript{15} examined the oxidation behavior of single-crystal SiC (\(\alpha\)-SiC) and CVD-SiC (\(\beta\)-SiC), and reported the results of these rate constants as shown in Table 3. In this research, the Deal/Grove model was applied to the oxidation results for 0, 10, 50 and 100 hours. The results fitted this model very well, and the parabolic constant, \(B\), was calculated to be 71.4 nm\textsuperscript{3}/min. This value is within the range reported by Ramberg et al.\textsuperscript{15}. Thus the oxidation behavior of Hi-Nicalon type S was found to fit the Deal/Grove model.

4. Conclusions

To estimate the potential capability of newly developed advanced SiC fibers (Hi-Nicalon type S) for reinforcement of ceramic matrix composites, fiber tensile tests at high temperature with 190 mm gauge length and fiber oxidation tests at 1373 K were carried out. The conclusions can be summarized as follows.

(1) The relationship between the strength of Hi-Nicalon type S at room temperature and the gauge length was found to follow the weakest-link rule, described by the Weibull distribution.

(2) The strength of Hi-Nicalon type S slightly increased with increasing test temperature up to 1673 K. On the other hand, the strength of Hi-Nicalon scarcely changed and decreased after annealing in argon for 2 hours or oxidation in air for 2 hours at 1373 K.

(3) The oxidation behavior of Hi-Nicalon type S was found to fit the Deal/Grove linear-parabolic model.

Acknowledgments

The authors would like to express their sincere appreciation to Dr. Y. Imai and Mr. M. Takeda (Nippon Carbon Co., Ltd.) for providing the materials. This work was maintained by National Institute for Fusion Science under Japan-USA Program of Irradiation Test for Fusion Research. This work was also supported by Basic Energy Science under U.S. Department of Energy (DOE) contract DE-AC06-76RLO 1830 with Pacific Northwest National Laboratory, which is operated for DOE by Battelle.

References