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High Temperature Ceramic Microstructure and Interface Evolution during Exposure to Particulate Laden Combustion Flows in Gas Turbine Engines

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Overview

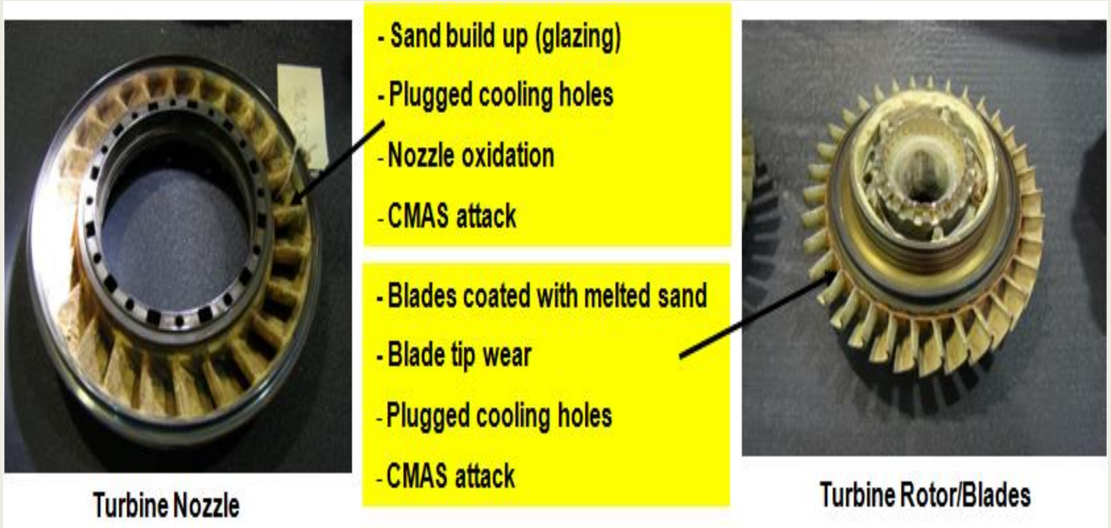
- Introduction
  - The sand – CMAS problem
  - Protective Ceramic Coatings
- Ongoing Experimental Efforts
  - TBCs tested in full scale engine tests
  - EBC burner rig testing and characterization
  - CMAS characterization and evolution
  - Model bulk YSZ systems under CMAS attack
- Future Work
  - Advanced Interfacial Studies
  - Computational Studies
- Summary

OBJECTIVE

To innovate sandphobic coating and surface modification for high temperature turbine blades to resist sand glaze build-up and related Calcia-Magnesia-Alumina-Silicate (CMAS) attack on Thermal/Environmental Barrier Coatings (T/EBCs)

Sand – CMAS Problem

Field returned engine hardware from SWA



Typical build-up on vane

Typical build-up on blade

Typical rotorcraft gas turbine engine nozzle and rotor blades with sand-induced damages

- **Hot section sand glazing / chemical attack is influenced by following parameters:**
  - Particle size and material composition of particle
  - Material properties of airfoil thermal barrier coating systems
  - Fluid flow dynamics and temperature

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Problem Statement

ARL

- Various empirical methods in research/development to mitigate CMAS damage
- Lacking → quantitative physico-chemical model of the reactions
- This is a complex problem:
    - Impact + adherence
    - Infiltration
    - Glass formation via solidification

All occurring at elevated pressures + high temperatures

- AND, the contaminant adds complexity…
    - Natural sand → compositional variation, different grain sizes, and different morphologies based on the age and location of the desert.
- Synthetic sand developed to create a representative baseline
    - AFRL 02/03 represents the state-of-the-art
        - AFRL 02 → small grains, used for bench-level and component-level testing
        - AFRL 03 → larger grain distribution, used for engine-level testing

Layered and Composite TBCs Exposed to Full Scale Sand Ingestion Engine Test:

CMAS Adhesion and TBC Microstructural Evolution

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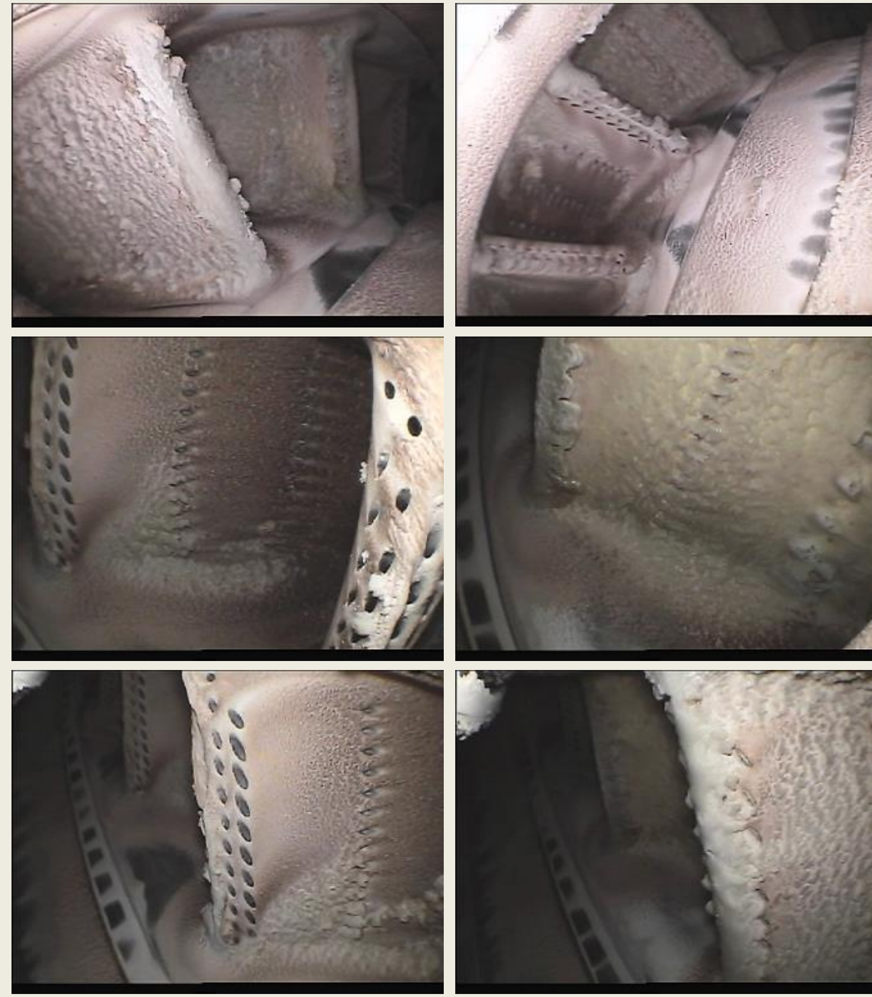
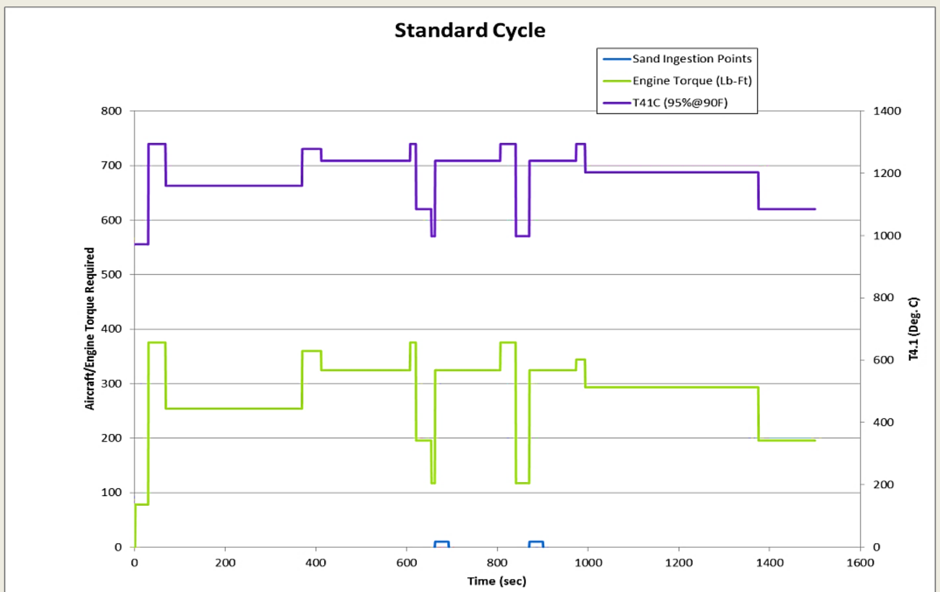
Sand Ingestion Jet Engine Test

ARL

As-built nozzle ring

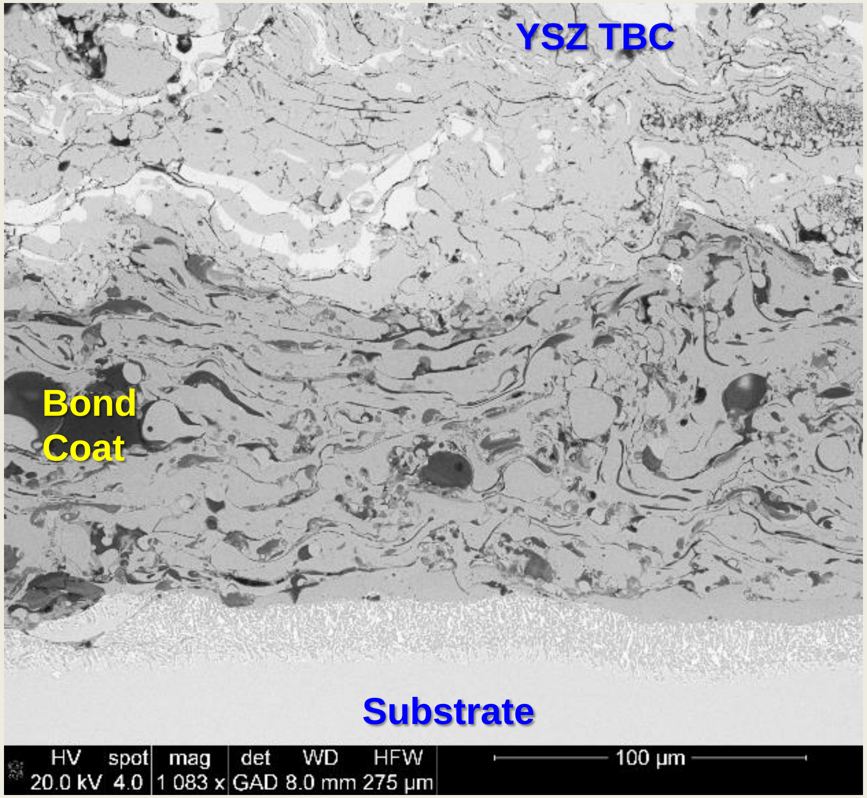
Borescope images from engine run

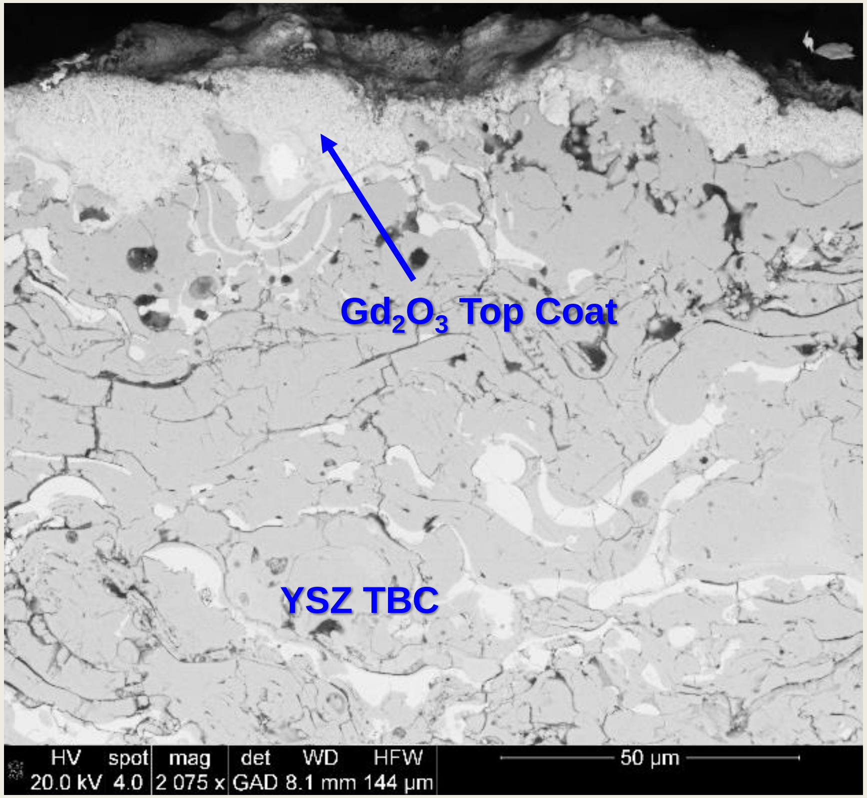




Engine Tested Consisted of Two 25 min Cycles
MAX Temperature of 1240 °C

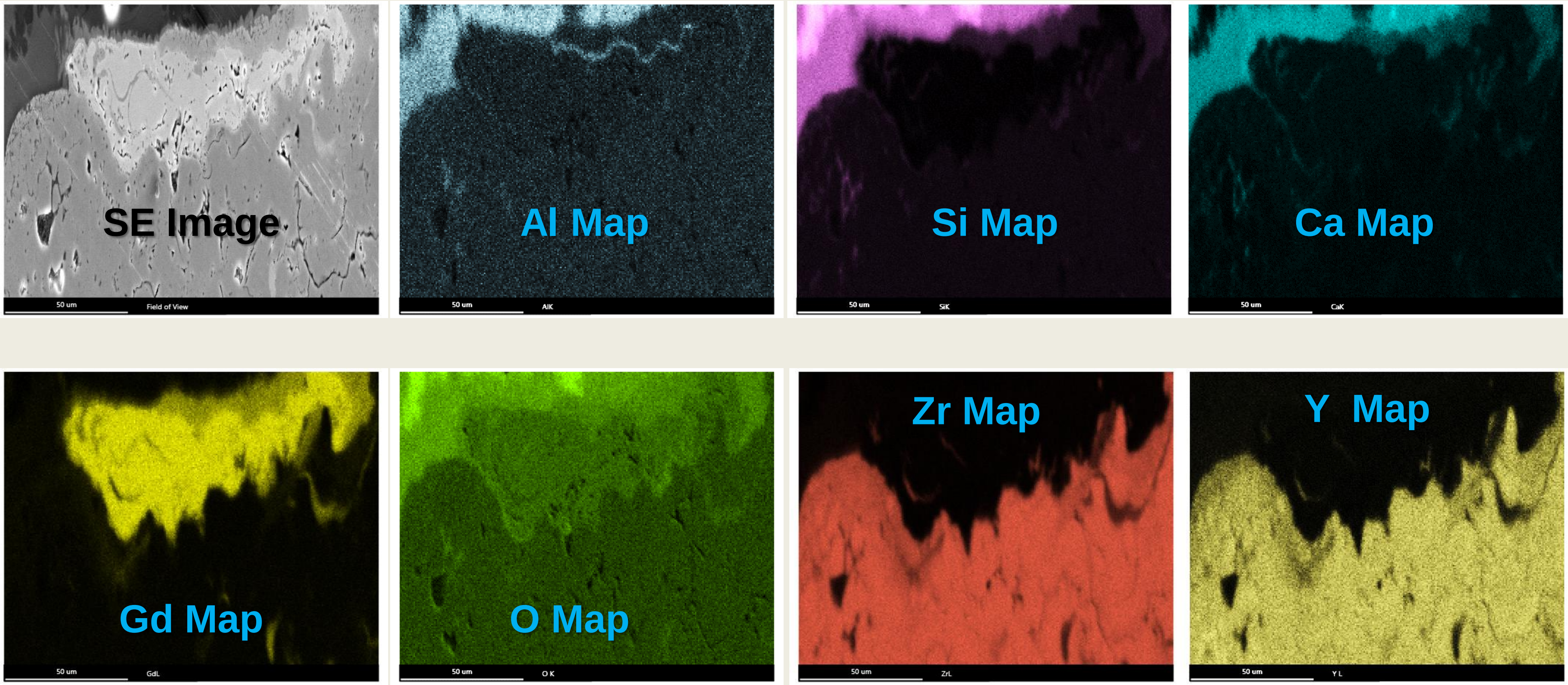
ARL-NASA-02 – Layered and Composite TBC



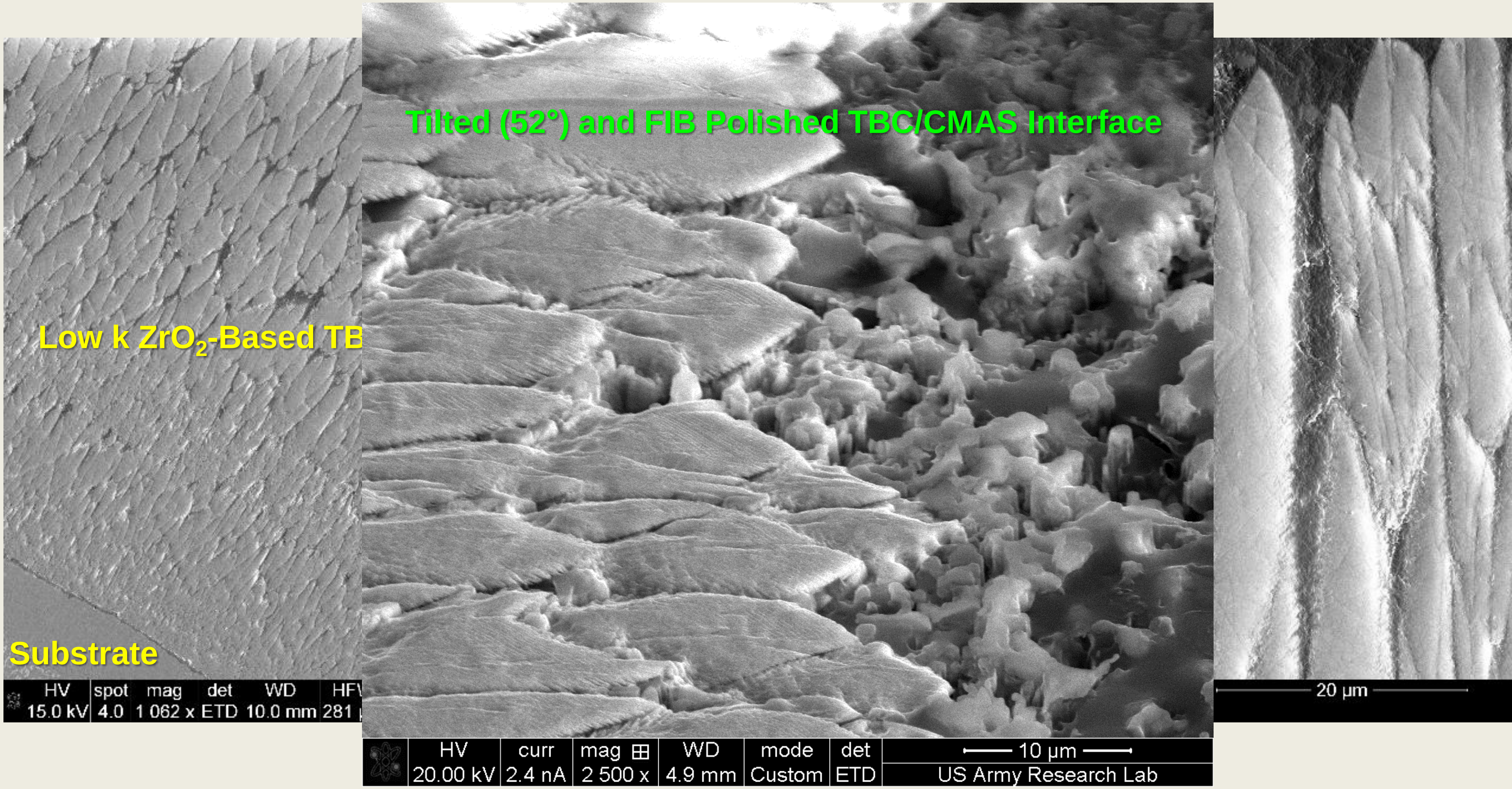


- No significant damage or chemical degradation observed on ARL-NASA-02
- Thin segments (10-20 µm) of Gd_2O_3 top coat are found throughout the specimen

ARL-NASA-02 EDS

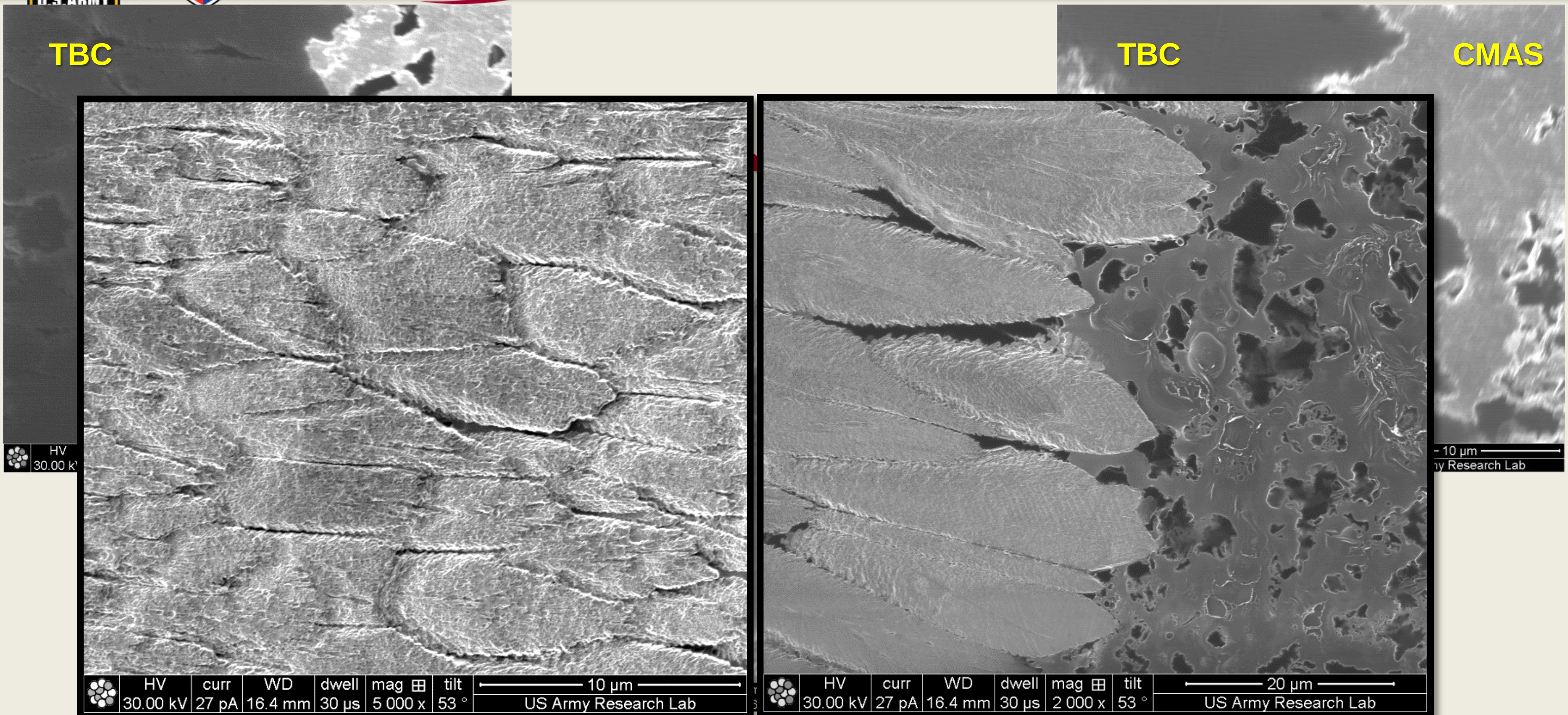


ARL-NASA-06 – Doped TBC



- ARL-NASA-06 exhibits minimal signs of structural damage
- Porous columnar structure does not lead to CMAS infiltration

ARL-NASA-06 – FIB Imaging



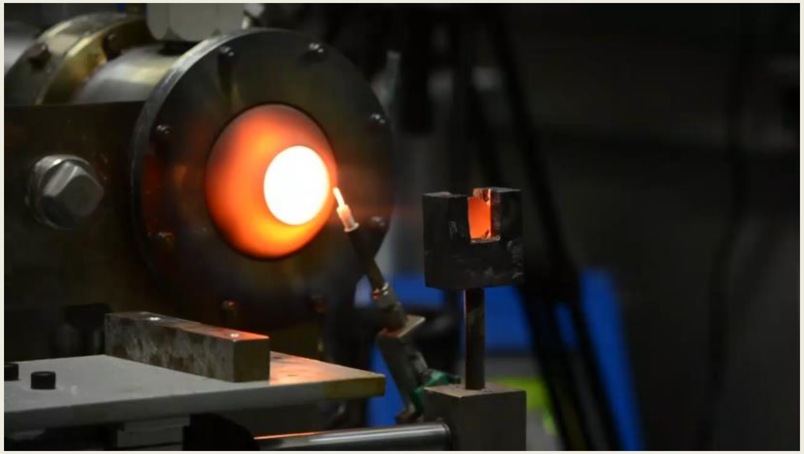
- **FIB ion milling and imaging provides distinct contrast between TBC & CMAS**
  - **CMAS infiltration can be assessed *w/out EDS mapping***
- **FIB polishing removes surface artifacts due to mechanical preparation (e.g., debris, polishing media)**

Environmental Barrier Coatings (EBC) under Sand Laden Combustion Flows

Burner Rig Testing and Microstructural Evolution

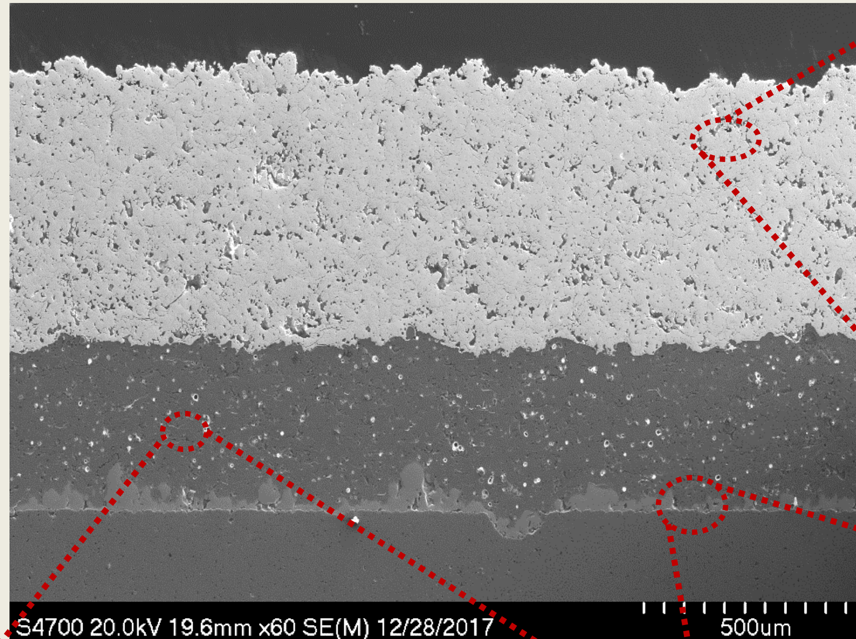
EBC Infiltration Kinetics

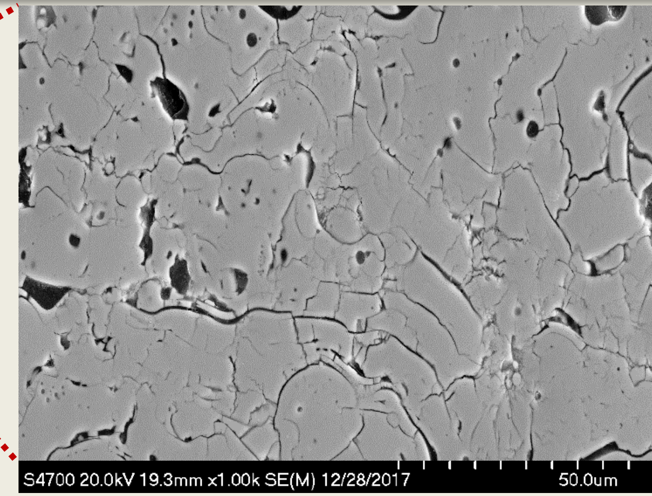
- Burner Rig testing with sand ingestion will be conducted on several promising EBCs to evaluate resistance to CMAS infiltration
- EBCs will be held under continuous exposure to sand laden combustion flow at ~0.5 Ma and ~1550 °C, for set time intervals (5 – 60 min)
  - Times can be adjusted based on CMAS infiltration behavior and EBC durability
- Objective is to quantify the CMAS infiltration kinetics on different EBC systems, and if possible, within individual layers of the EBC



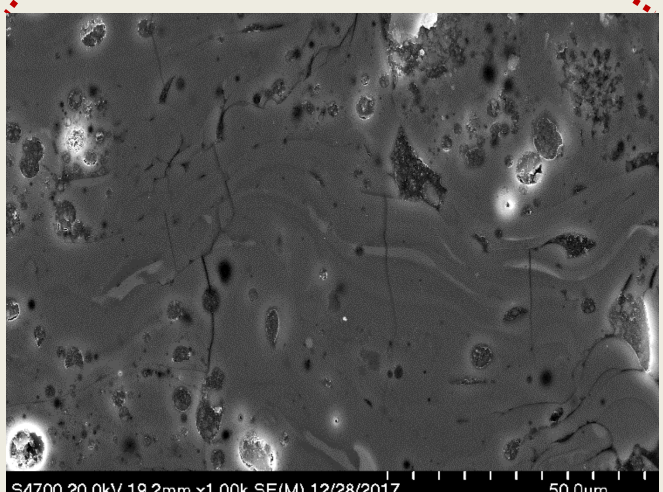
ZrO_2-Y_2O_3 based EBC Systems: As Sprayed

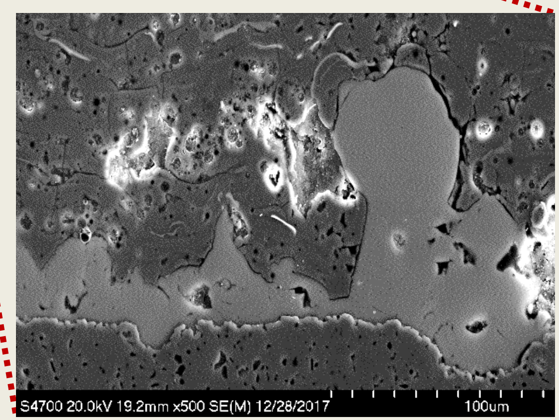
APS ZrO_2-Y_2O_3 based top coat provides low thermal conductivity a good damage tolerance





Alumina-rich Mullite Layer





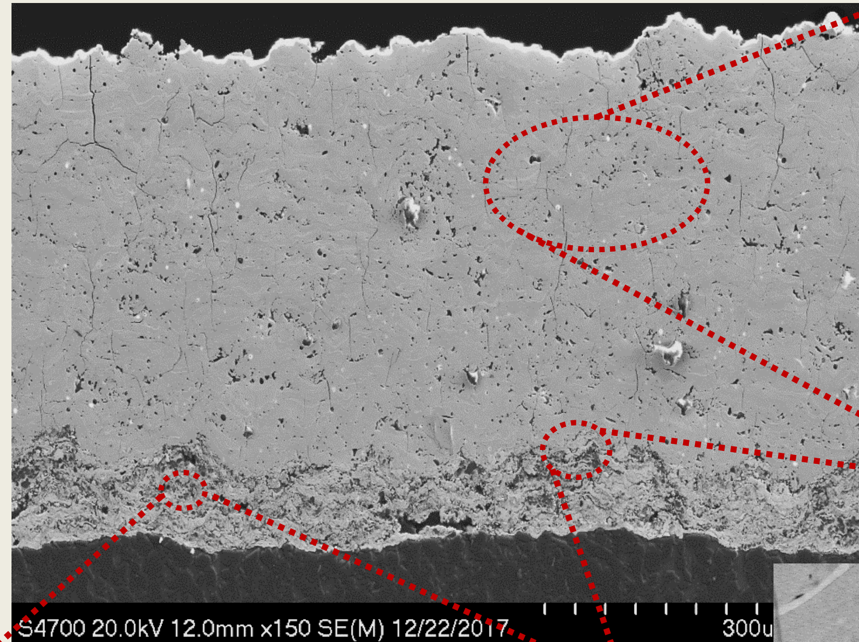
Si Layer serves as oxygen barrier for Substrate

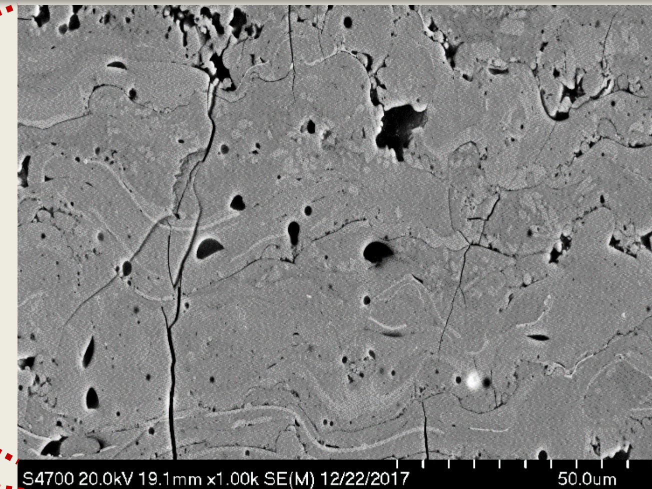
-Sensitive to surface roughness

-Uneven thickness

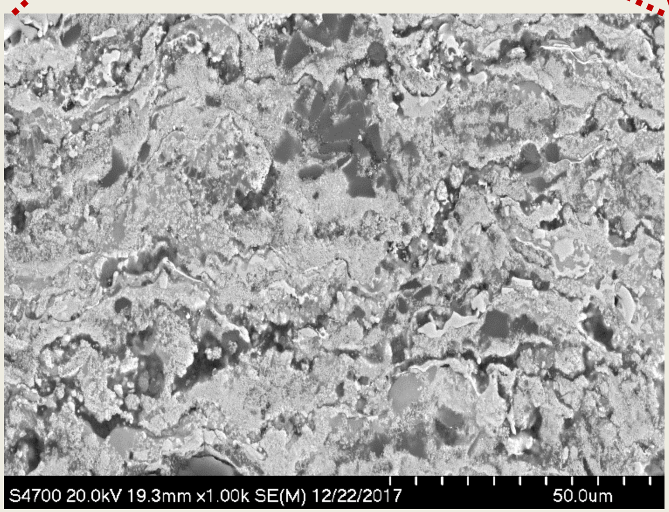
RE DS on HfO_2-Si Bond Coat EBCs: As Sprayed

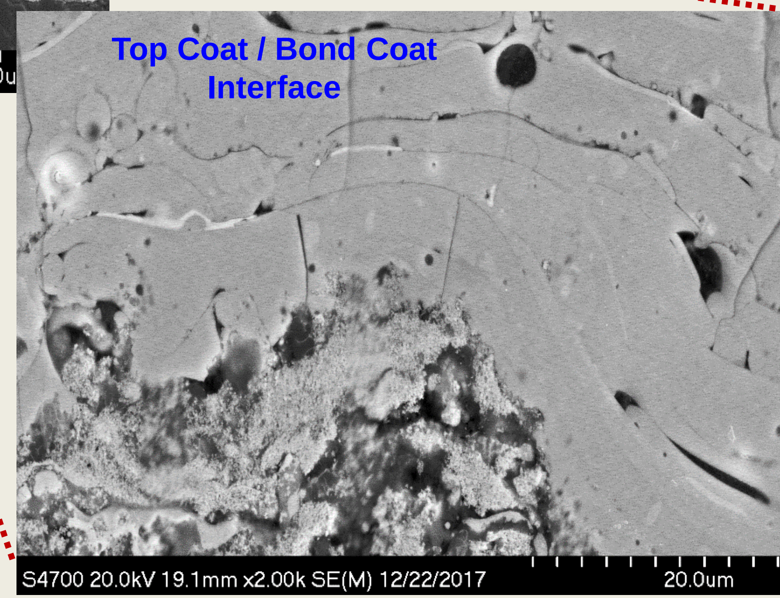
RE DS Top coat w/ Vertical Cracks for Improved Damage Tolerance





HfO_2-Si bond coat for reduced CTE mismatch with SiC-SiC CMCs





Characteristics and Chemical / Microstructural Evolution of Sand/CMAS

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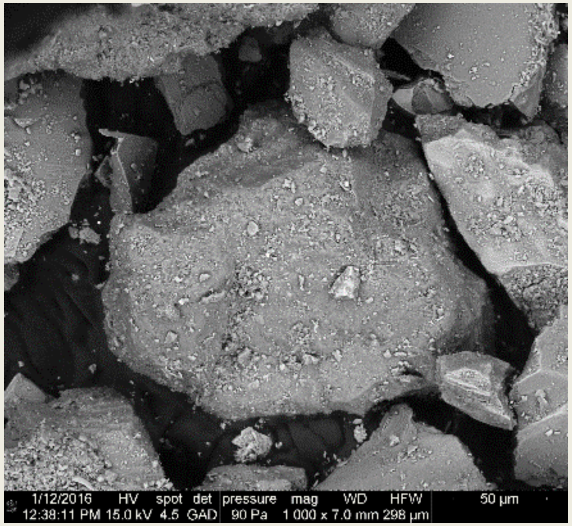
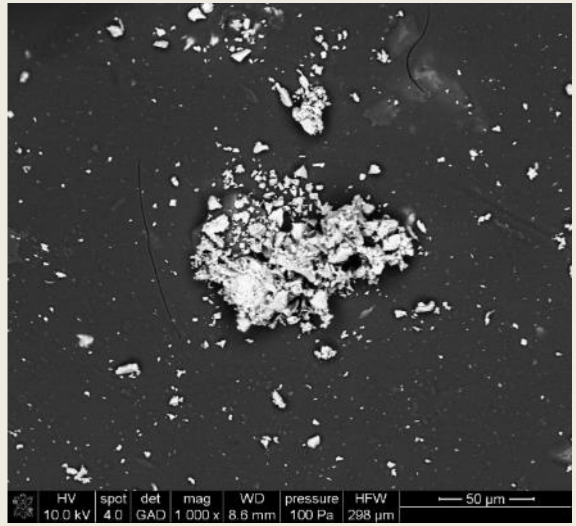
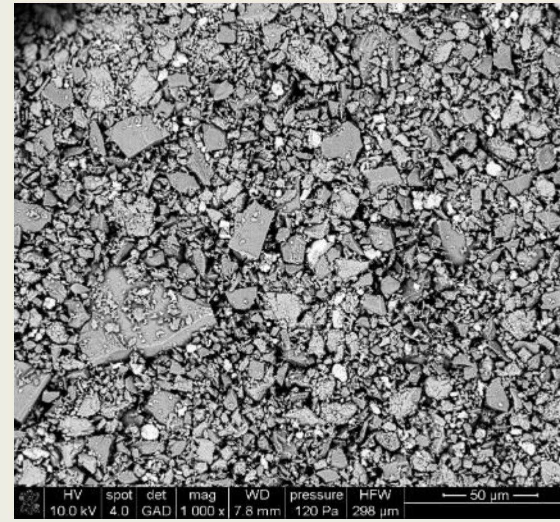
Sand Morphology

Natural Sand	AFRL 02 Sand	AFRL 03 Sand

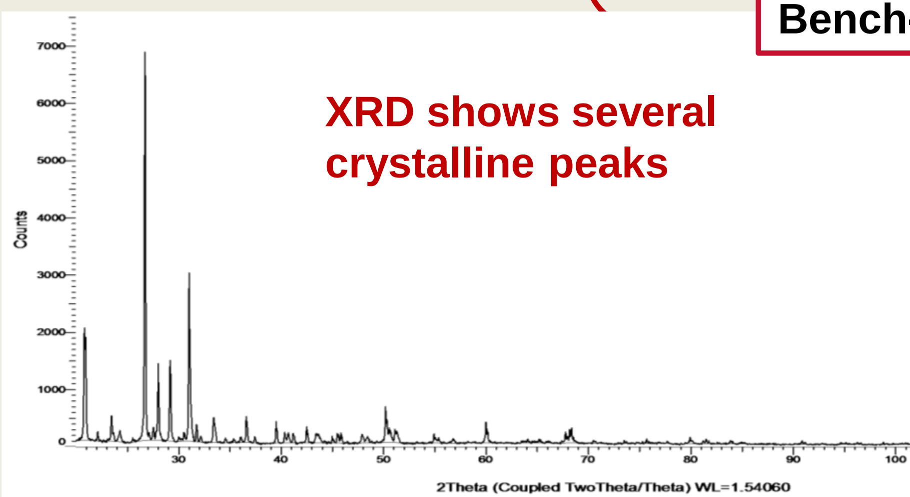






Bench-level (AFRL 02 Sand)

Engine-level (AFRL 03 Sand)



XRD shows several crystalline peaks

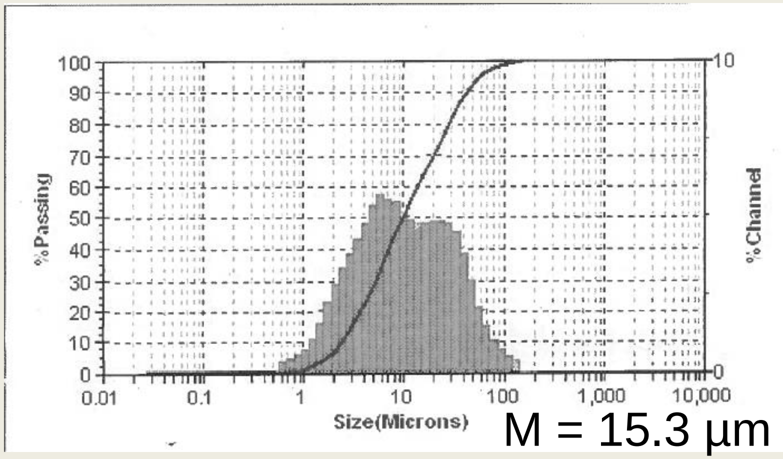
AFRL synthetic sand

- 34 % quartz (SiO_2)
- 30 % gypsum ($CaSO_4 \cdot 2H_2O$)
- 17 % aplite (SiO_2 + $KAlSi_3O_8/NaAlSi_3O_8/CaAl_2Si_2O_8$)
- 14 % dolomite ($CaMg(CO_3)_2$)
- 5 % salt (NaCl)

Sand size distribution

PTI Information

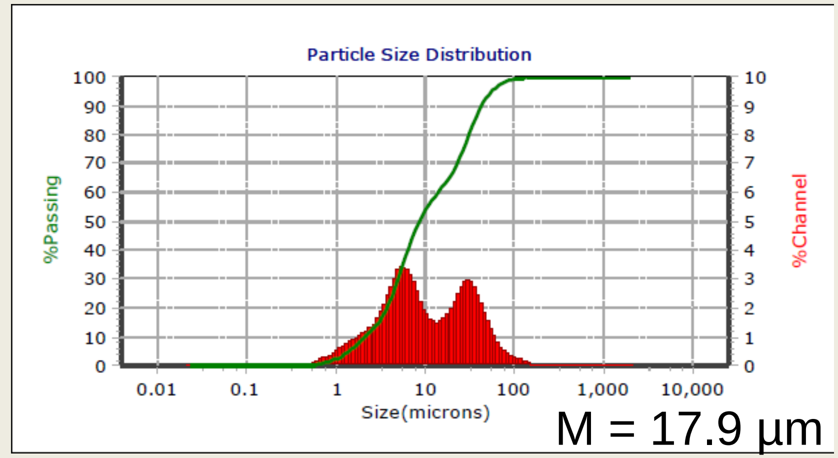
AFRL 02



M = 15.3 µm

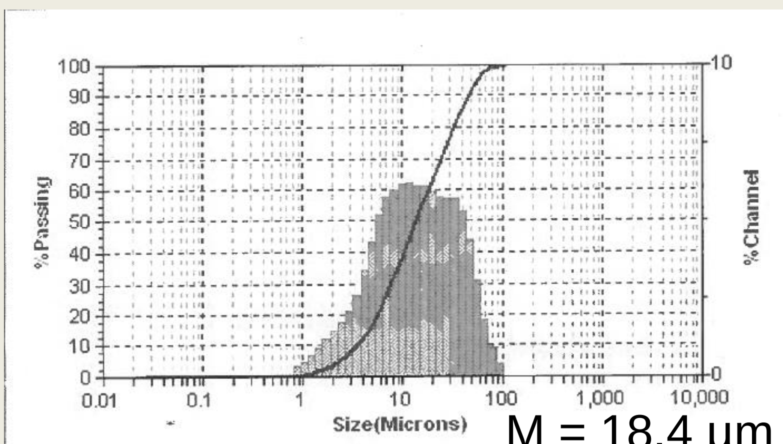
ARL Demonstration

AFRL 02



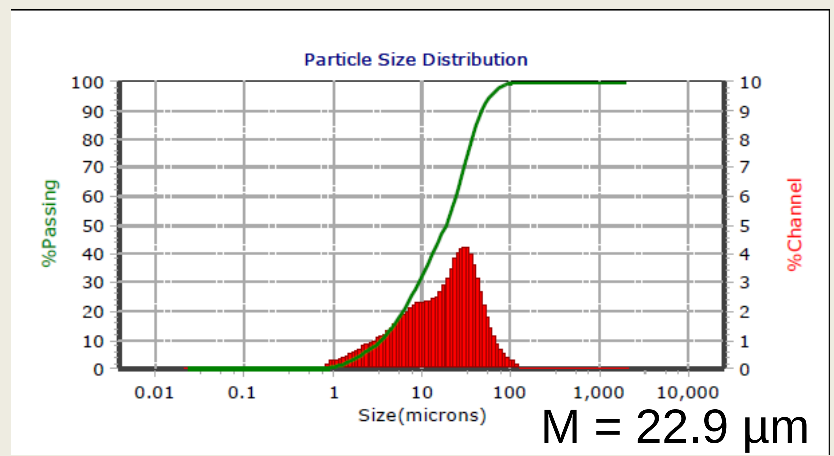
M = 17.9 µm

AFRL 03



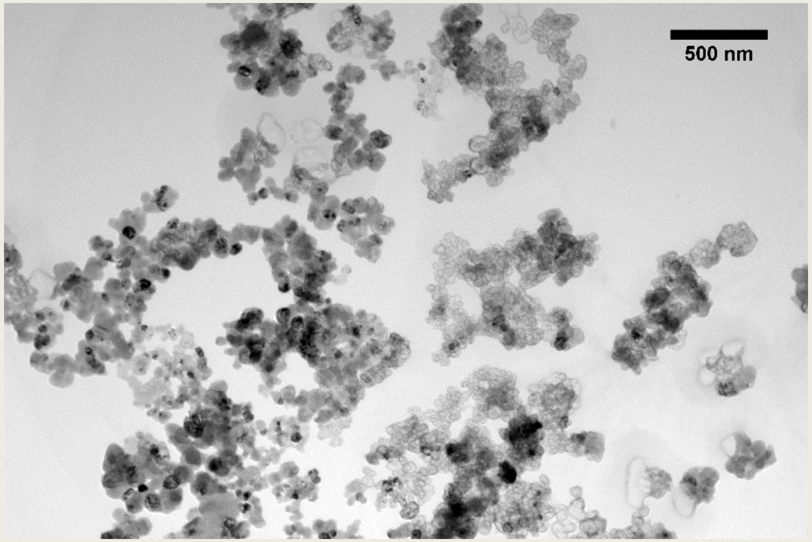
M = 18.4 µm

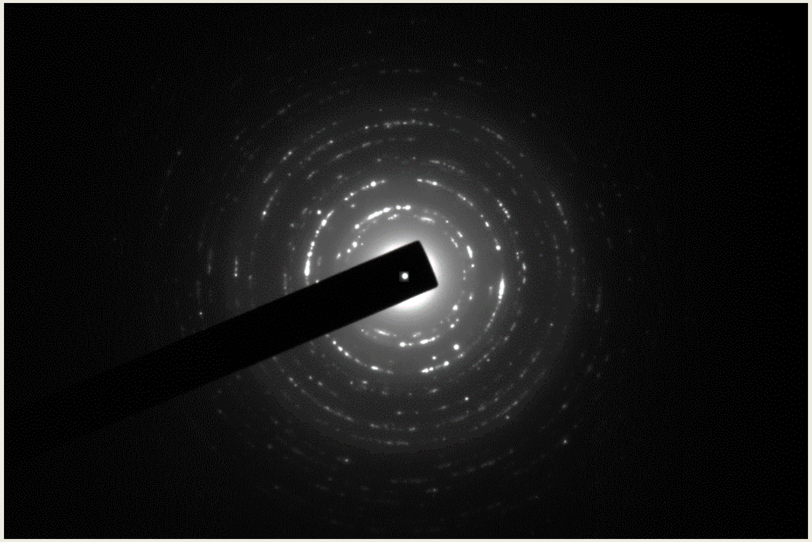
AFRL 03

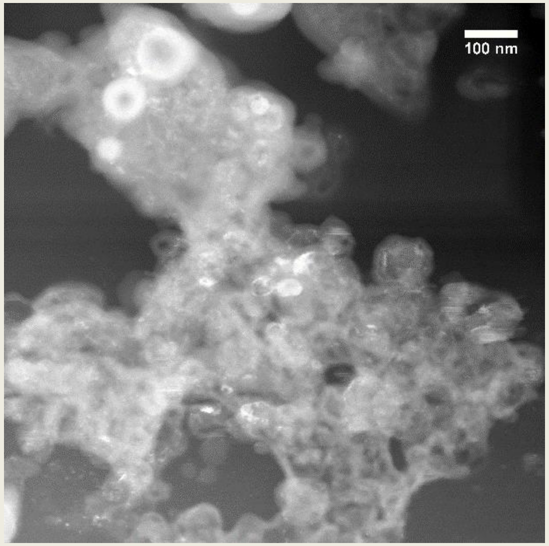


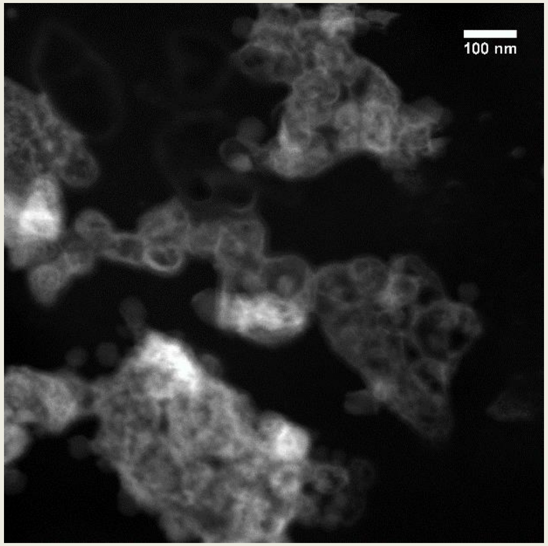
M = 22.9 µm

TEM of Nanometric Crystals in AFRL-02

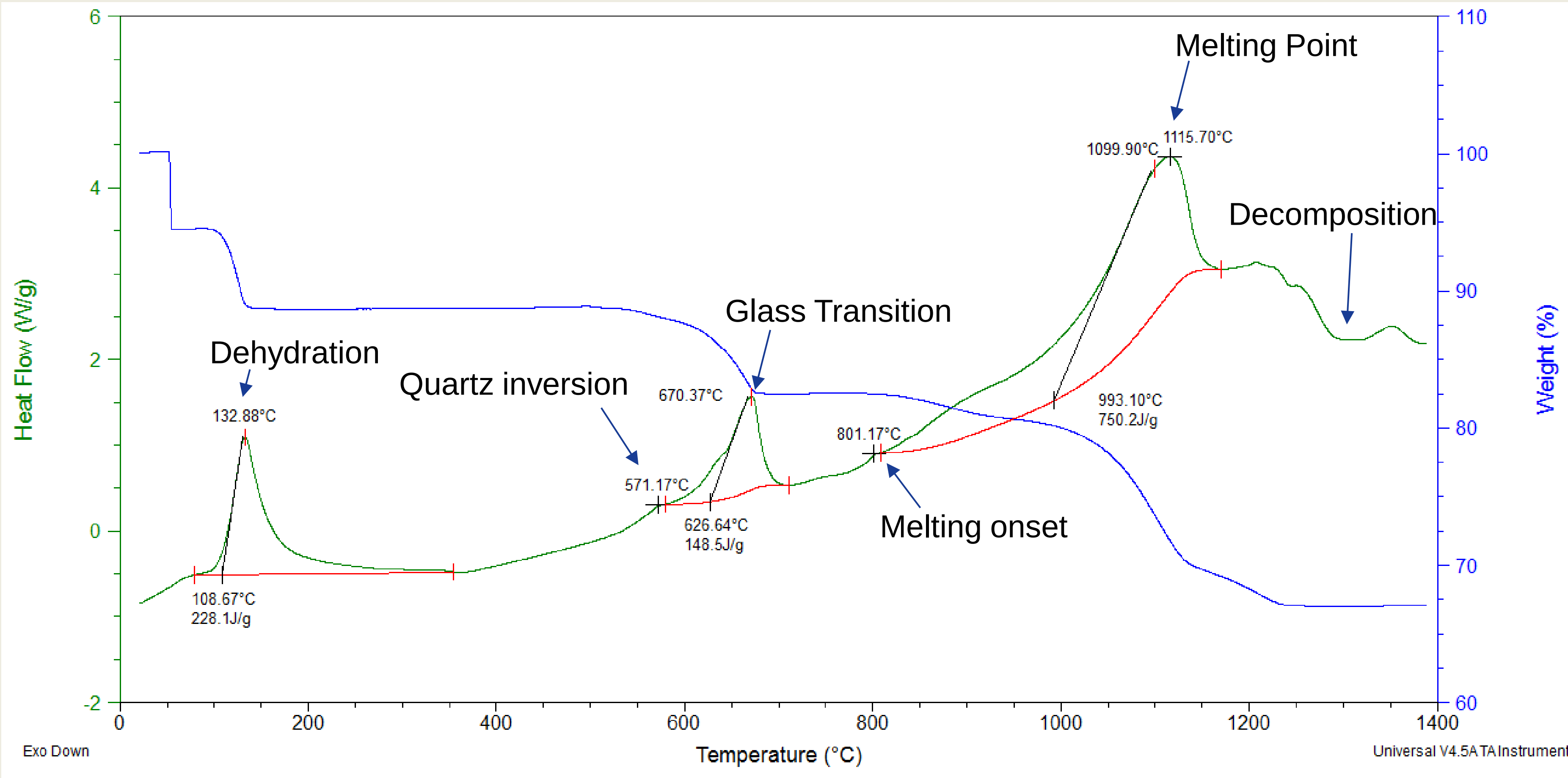








Differential Scanning Calorimetry AFRL-02

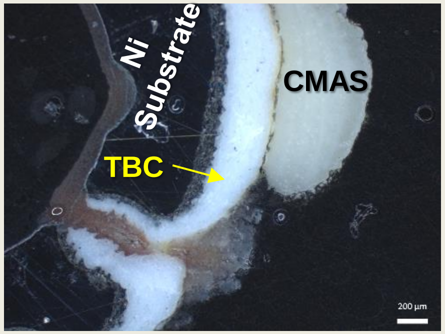


under Ar gas flow

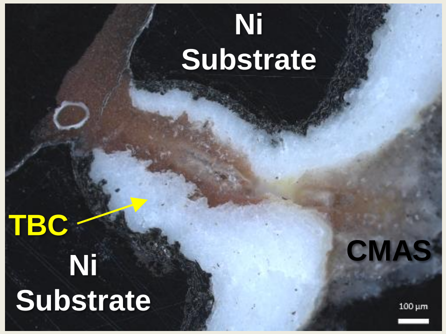
Optical Microscopy (OM) - Nozzle Cross-Sections

ARL-NASA-02

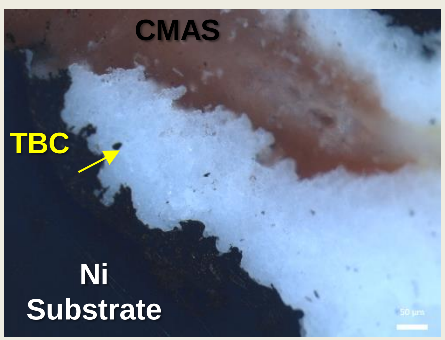
50x Dark Field



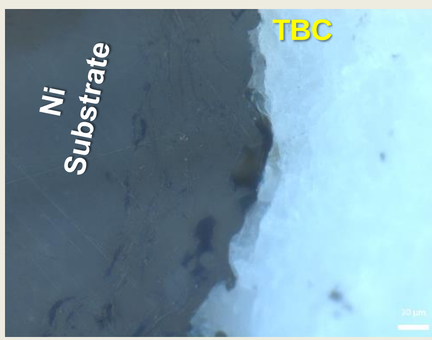
100x Dark Field



200x Polarized



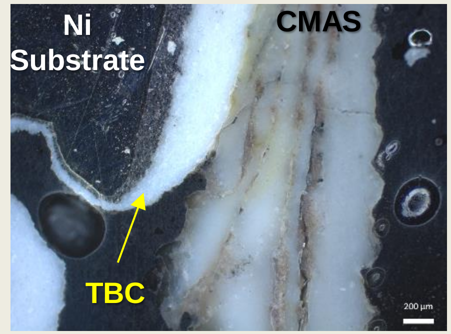
500x Polarized



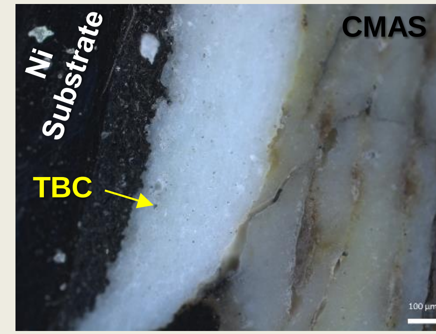
Leading Edge (LE)

ARL-NASA-03

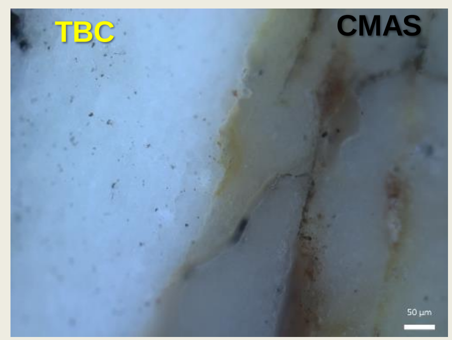
50x Dark Field



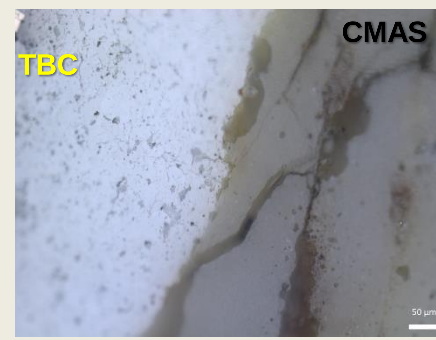
100x Dark Field



200x Polarized

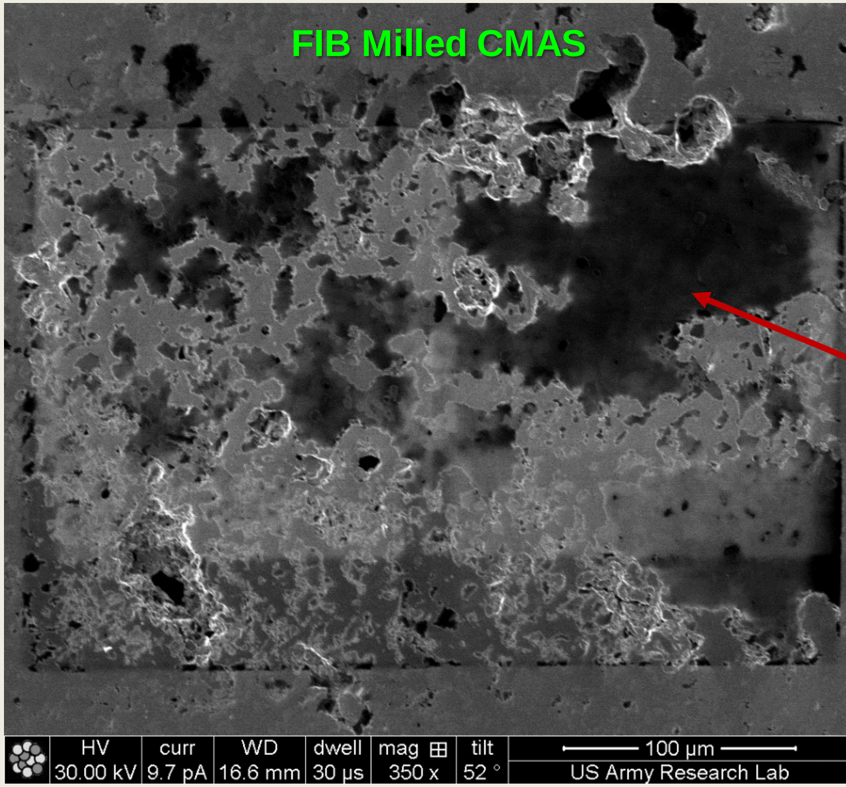


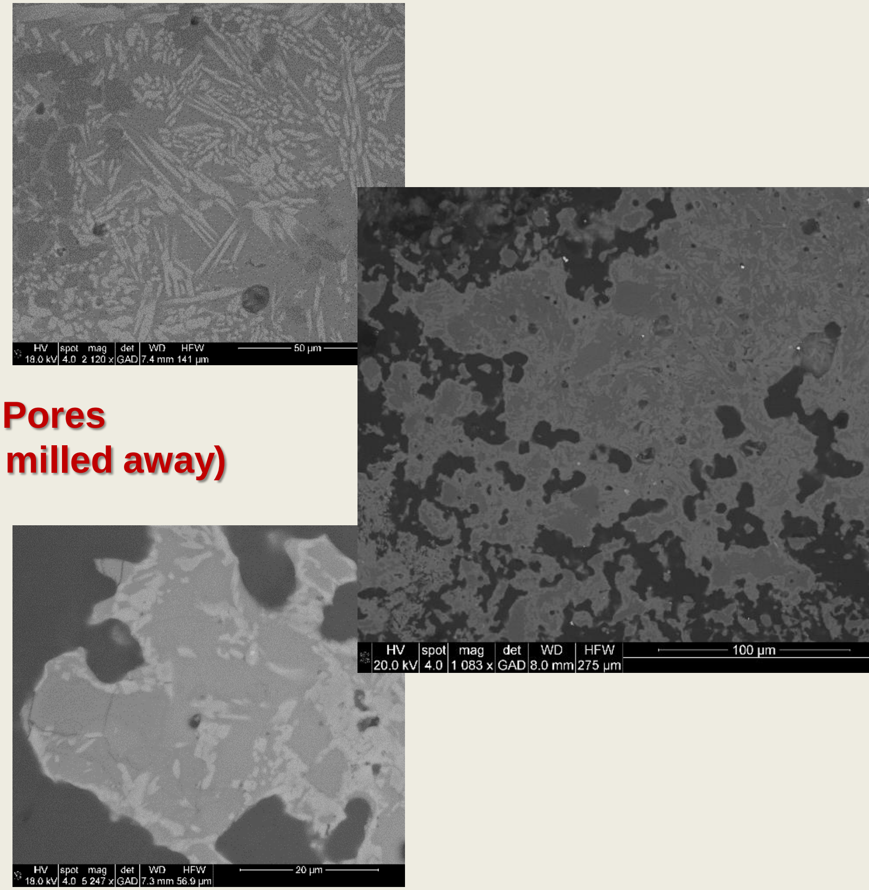
200x Bright Field



Pressure Side (PS) - Near TE

CMAS Characterization





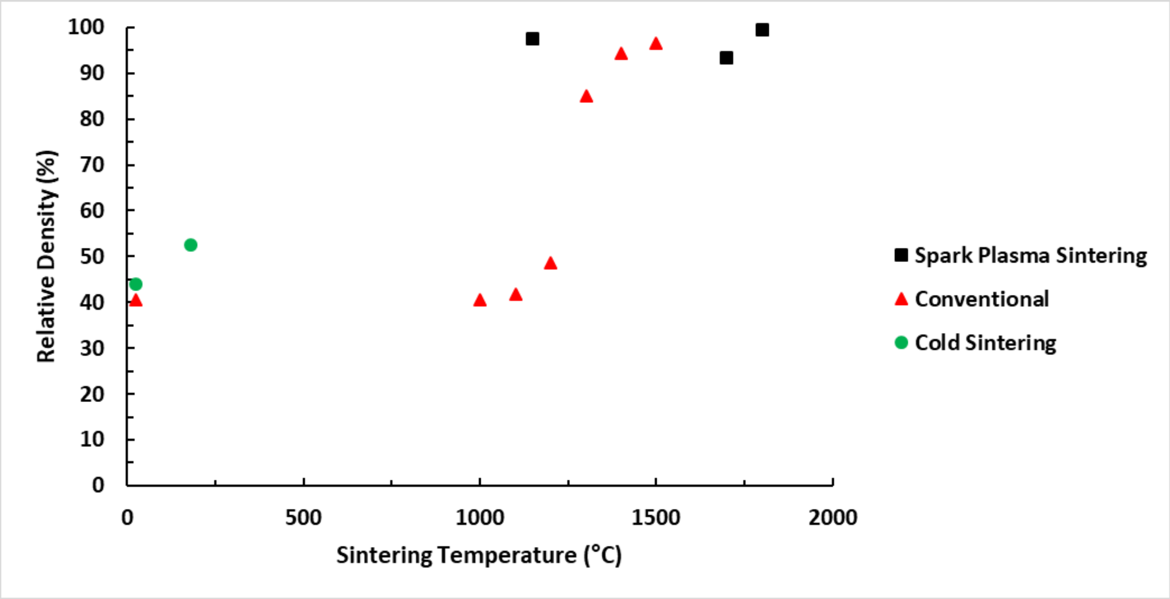
- ➢ **CMAS deposits exhibit chemical and microstructural variances**
- ➢ **Complex environment coupled with complex CMAS chemistry leads to a range of material responses and behaviors**

Model YSZ-based Sintered Compacts under Controlled CMAS Attack:

Effect of Porosity on CMAS Infiltration and YSZ/CMAS Interactions

YSZ Pellet Synthesis

- Approximately 25 pellets synthesized
  - 3 mol%, 8 mol%, 7 wt% (~4 mol%)
  - Conventional (pressureless), spark plasma, and cold sintering
- Cold Sintering: ~50% relative density
- Spark Plasma Sintering: ~95-99.5% relative density
- Conventional Sintering: ~40-95% relative density

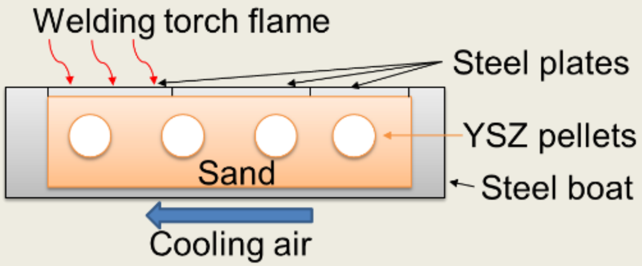


Comparison of relative densities achieved through varying sintering methods

CMAS Attack Testing

Button Cell Flame Test Rig

- Pellets buried in sand
- 1300°C
- 15 min exposure time
- Stationary contact

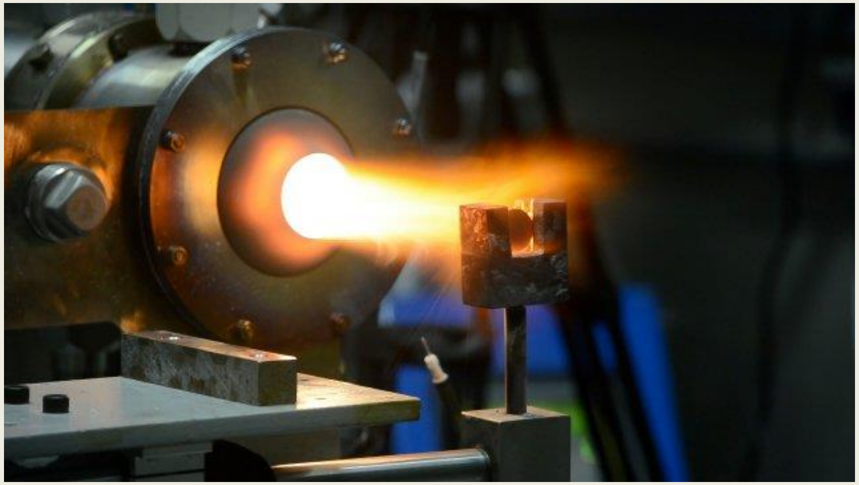


Button Cell Flame Rig

Schematic of the button cell flame rig along with the actual set-up

Hot Particulate Ingestion Rig

- Replicates temperature and velocity conditions of a jet engine
- Settings:
  - 1300°C
  - 0.3 M
  - 1 g of sand/min,
  - 3 cycles of 5 min exposure; 15 min total
- Dynamic CMAS Contact



Hot particulate ingestion rig in operation

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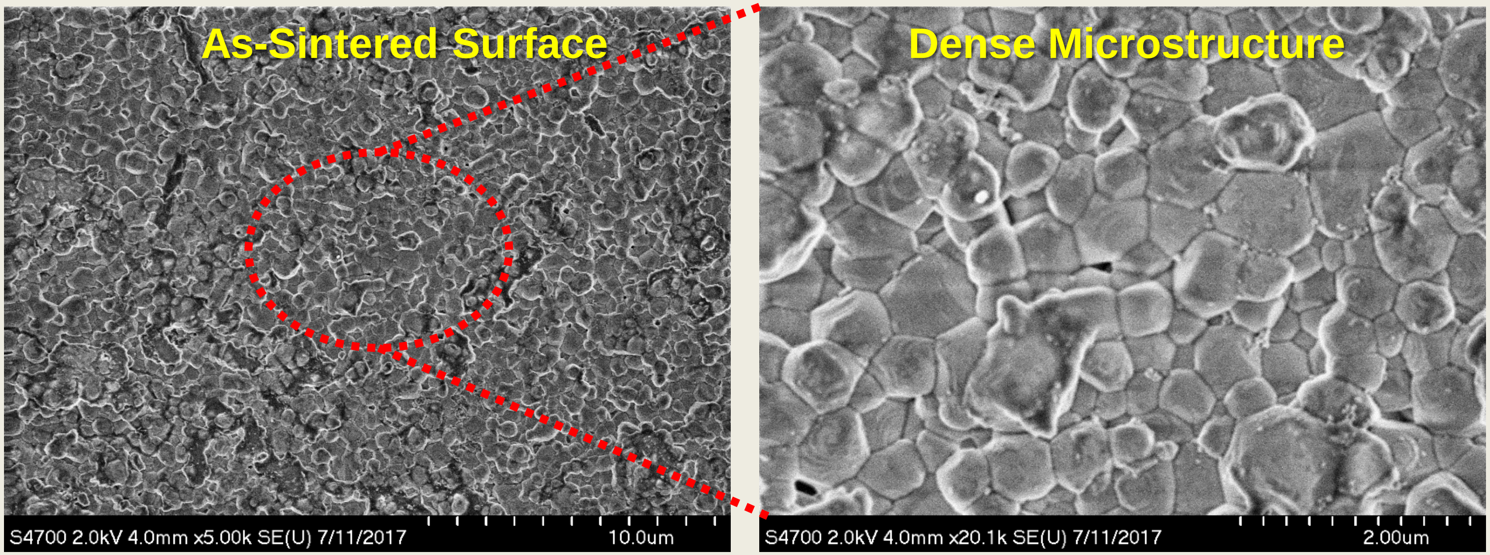
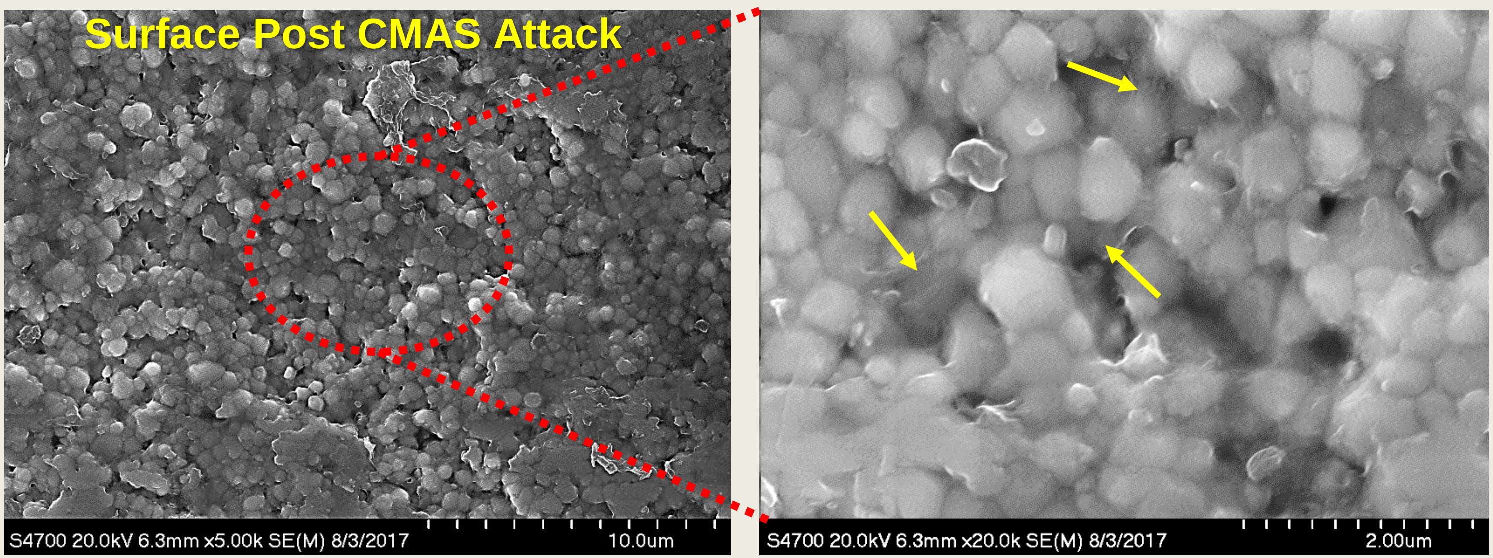
Surface Morphology – Dense SPS'd Compact

ARL



- SPS consistently produced densest pellets
  - 97% Dense pellet exhibits dense microstructure on as-sintered surface
  - Grain structure is relatively fine (~ 1 – 2 μm)

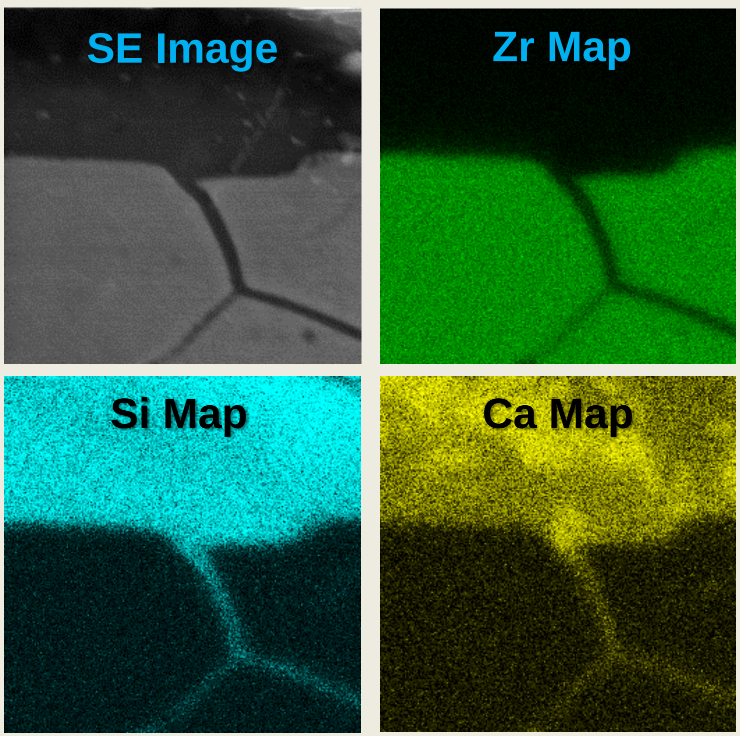


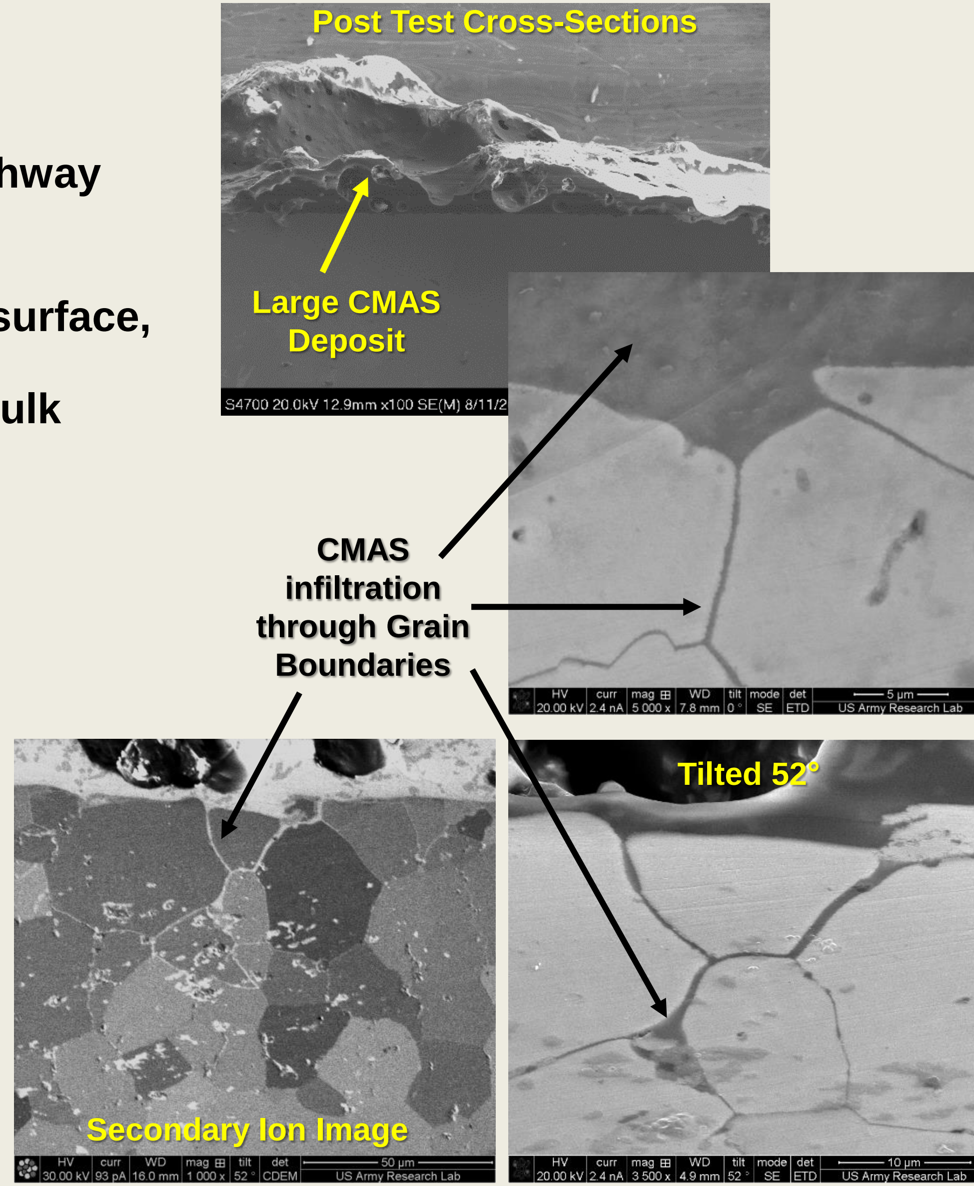
- Post CMAS attack grains appear to be covered in CMAS 'glaze'
  - Thin, transparent CMAS strands seen
  - Thin deposits not seen via visual inspection
  - Grains appear to be less faceted, suggesting possible dissolution

CMAS Attack on 99.5% Dense SPS Pellet

- Highly dense pellets were expected to mitigate CMAS attack by preventing infiltration
  - Lack of pores eliminates facile pathway for infiltration

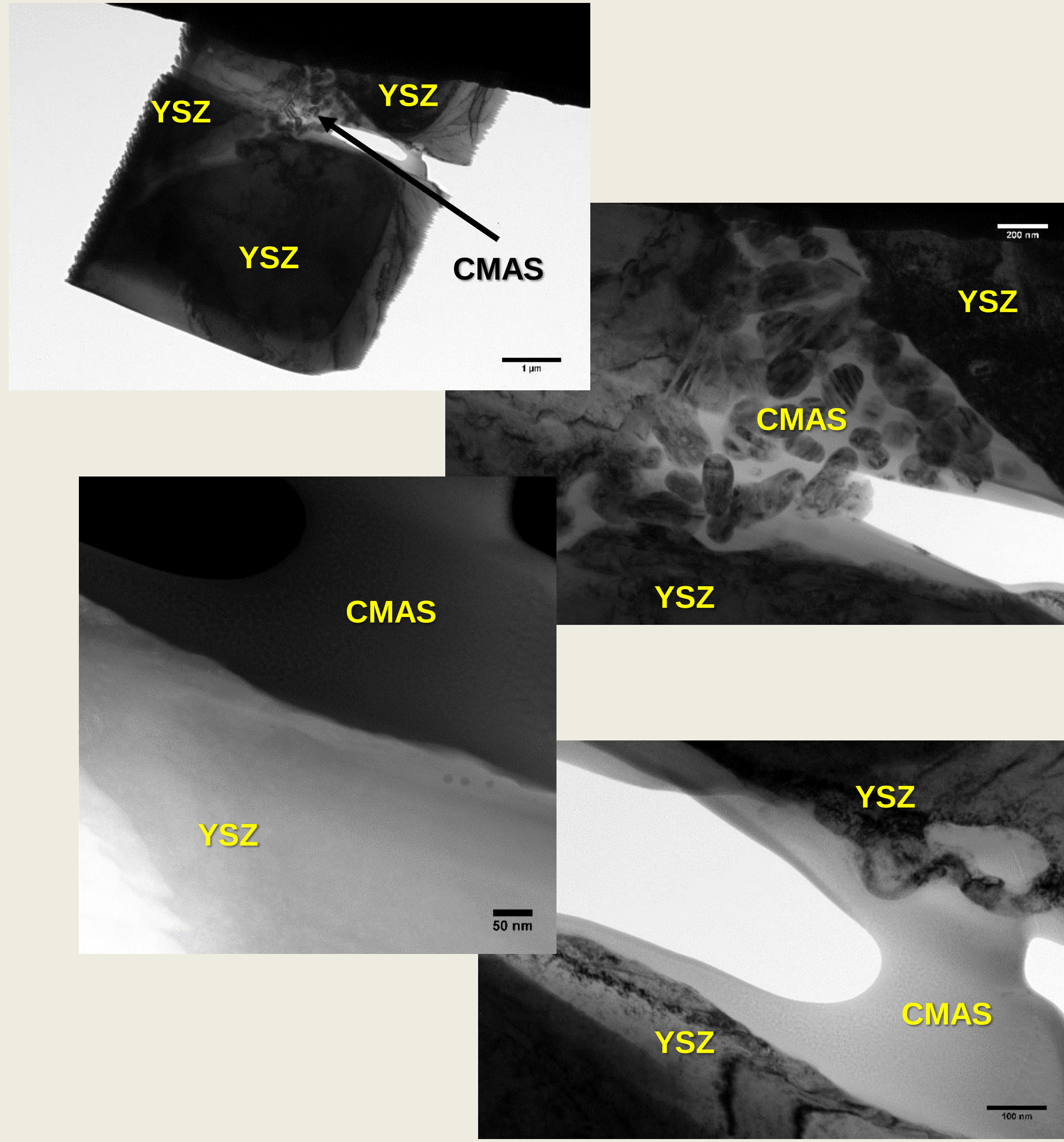
- CMAS infiltration is observed on near surface, adjacent to surface deposits
  - Infiltration depth over 50 μm into bulk





Infiltrated YSZ Grain Boundary Characterization

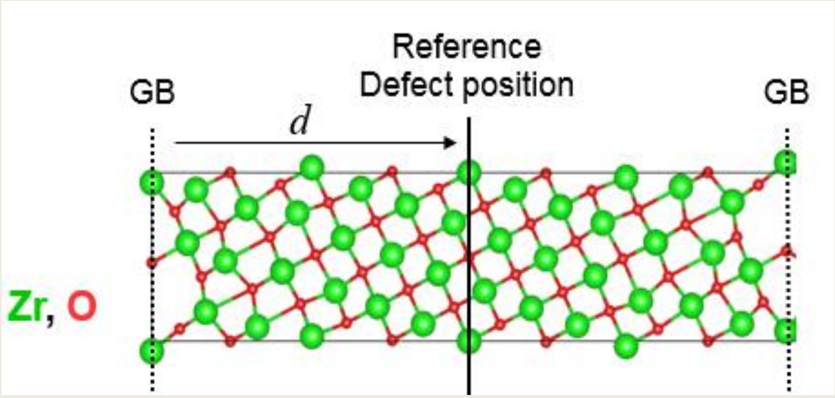
- TEM studies underway to elucidate CMAS infiltration mechanism in the absence of porosity
- Nanometric YSZ particles at triple junction exhibit severe twinning
  - Not seen in YSZ grains away from CMAS
  - Deformation twinning suggests CMAS induced strains play a role in infiltration/dissolution/reaction mechanisms
- STEM/EDS/EELS analysis will attempt to determine atomic scale diffusion mechanisms at CMAS/YSZ interface

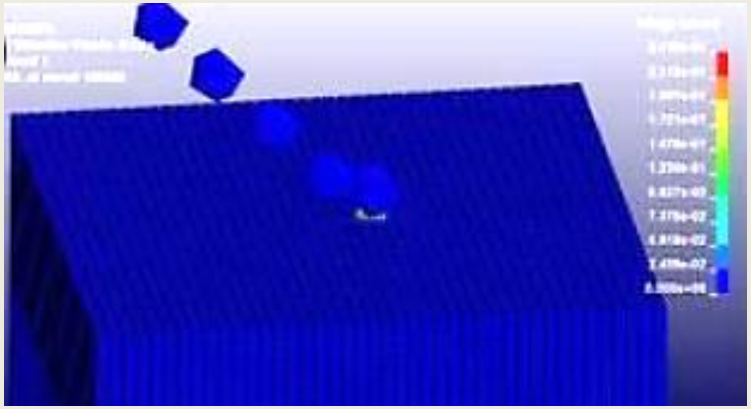


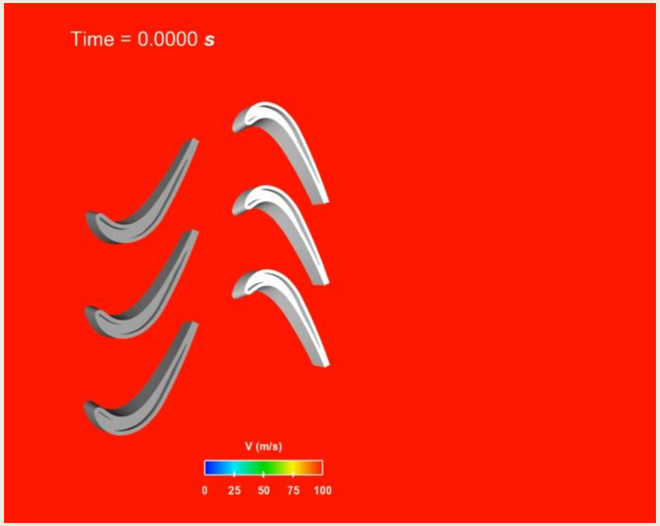
Future Work

Computational Materials Modeling

- Flow field modeling in gas turbine engine to determine regions in components exposed to most severe CMAS attack and accumulation conditions
- Molecular dynamics (MD) simulations on CMAS constituent element segregation on YSZ boundaries, with Prof. Kesong Yang at University of California San Siego
- Particle impact/adhesion simulations on EBC/CMC systems





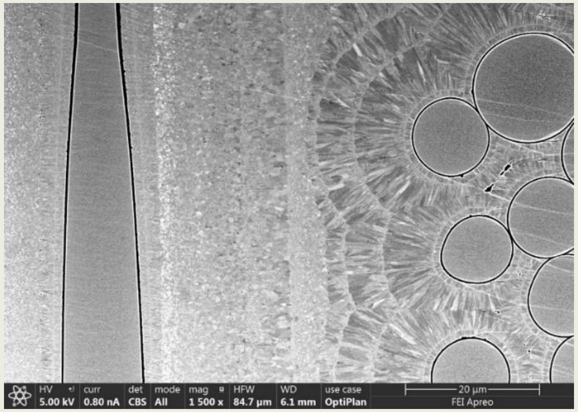


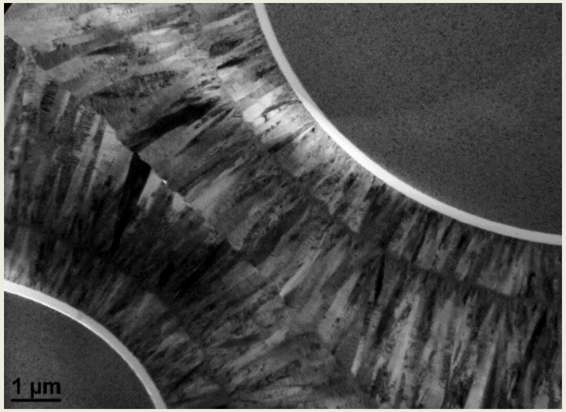
Future Work

Nanoscale Interfacial Characterization

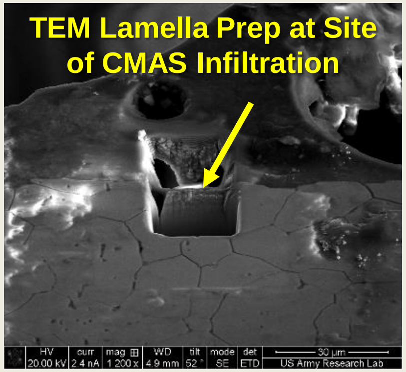
- Evaluation of CMAS kinetics in RE silicate / disilicate EBCs on SiC and CMC substrates will be conducted at ARL under engine relevant conditions
- Site specific TEM studies (EELS, SAD) will be conducted at CMAS/TBC/EBC/CMC interfaces and on CMAS phases.
- Evaluation of microstructure and properties of various commercially available CMCs and ceramic fibers.

CMC Cross Section



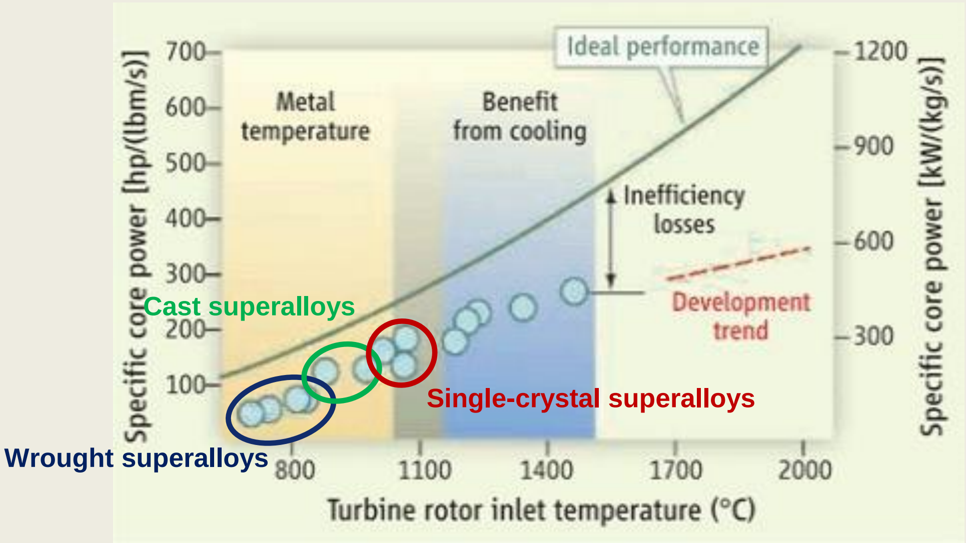


Site Specific TEM Characterization via FIB

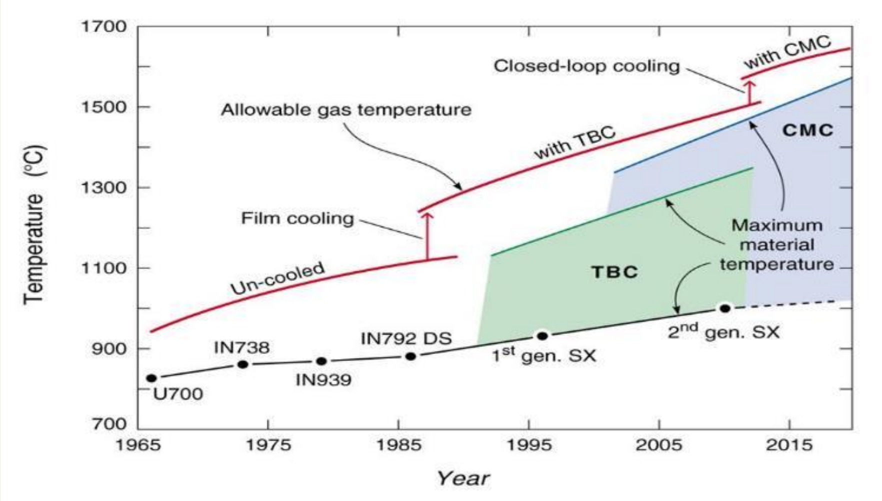


Back-up

Protective ceramic coatings



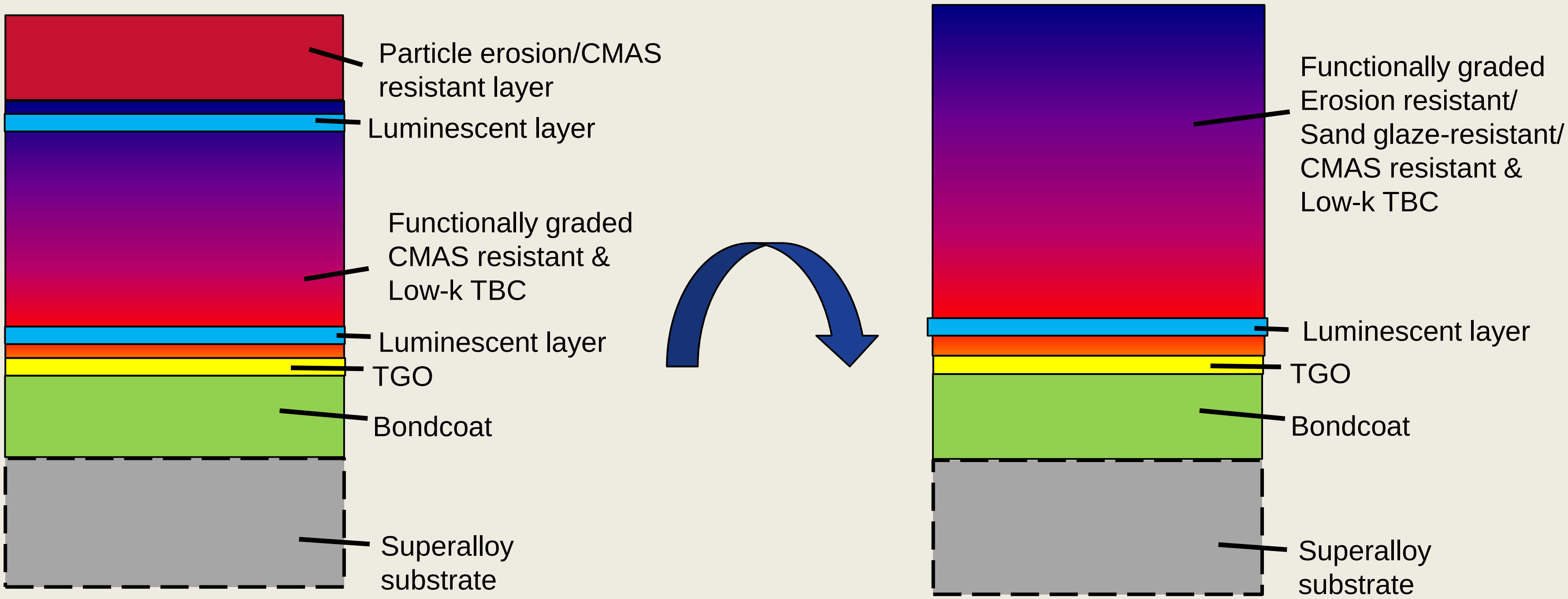
J.H. Perepezko, Science 326, 1068 (2009); used with permission



Source: http://www.virginia.edu/ms/research/wadley/high-temp.html

- **Current state-of-the-art turbine nozzles & blades:**
  - **Single-crystal Ni superalloy blades**
  - **Metal bond-coat: (Pt, Pd)Al**
  - **Ceramic thermal barrier coating (TBC): 7 wt % Y_2O_3: ZrO_2**
- **Other hot section components (such as shrouds and combustor liners):**
  - **Polycrystalline, cast Ni superalloys**
  - **M-CrAlY (NiCo-CrAlY) bond-coats**
  - **Ceramic TBC: 7 wt % Y_2O_3: ZrO_2**

Proposed Sandphobic TBC System – Ni-Superalloy Turbine Blade



Hybrid Approach (Layered & Graded)

Functionally Graded Approach

- Luminescent layers will provide self-aware coating capability
- Functionally graded layer has multifunctional capability

Accumulation and Infiltration

Identification of Primary Mechanism(s) for Sand Accumulation and its abatement include:

- **Surface finish improvement**
- **Surface debris 'wetting' reduction/repellant**
- **Ablative**
- **Limit infiltration through microstructural tuning**

Primary Mechanism(s) for Sand Melt/ CMAS Infiltration depth, glassification and mitigation:

- **Viscosity and surface tension of the melt**
- **Operational temperature and surface temperature of the substrate**
- **Shape of the inter-columnar gaps**
- **Thermal conductivity and Porosity of TBC**
- **Size and shape of original sand particulate (spherical vs nonspherical)**

Button cell tests

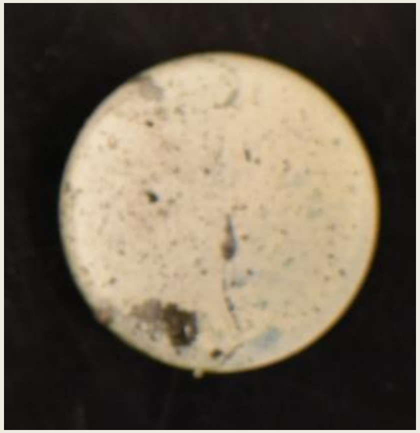
- Oxy-propane torch
- Motorized rotary stage
- Temperature measurement → Optical pyrometer
- Test parameters
  - Surface temperature ~ 1300 °C
  - 3 cycles – IN/OUT: 3 min/3 min
  - AFRL-02 sand → slurry deposited on surface, and allowed to dry before test

Visual Inspection

Button cell Flame Test Rig

Pre-test
YSZ, topped with YSZ-GdO

Post-test
YSZ, topped with GdO



Post-test
YSZ, topped with YSZ-GdO

Hot Particulate Ingestion Rig

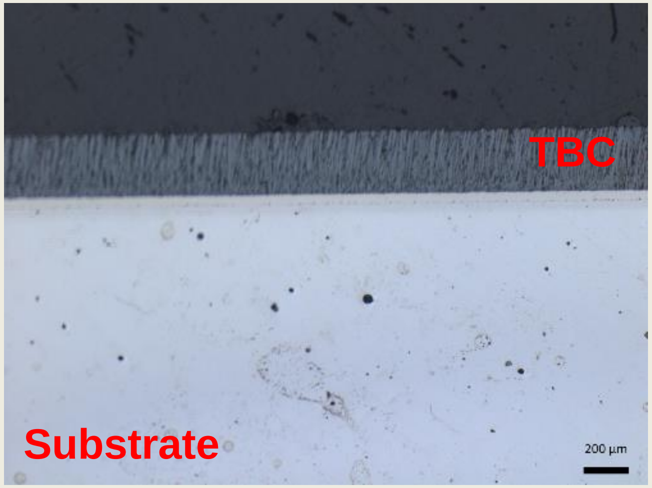
Pre-test
MAX-phase: Ti2AlC

Post-test
Low-k ZrO2-based

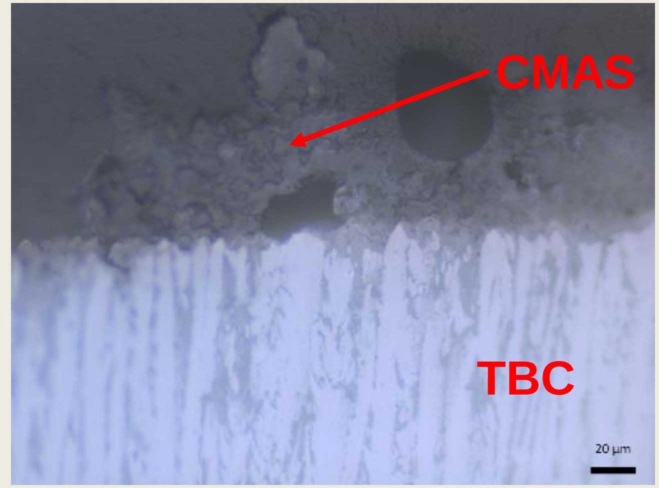
Post-test
MAX-phase: Ti2AlC

Optical Microscopy (OM)
HM-3848

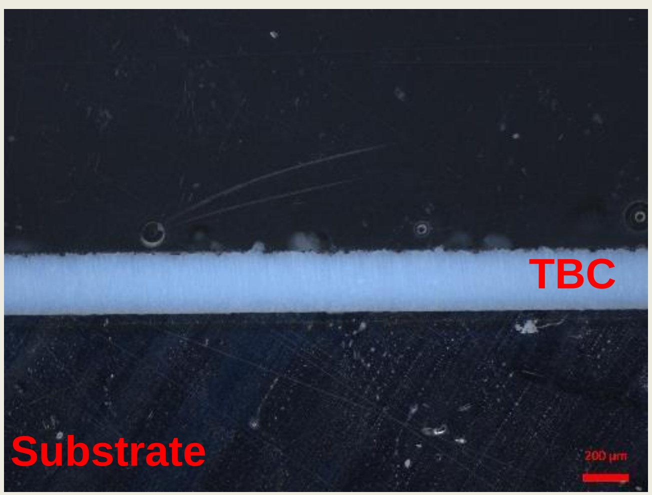
BF @ 5X



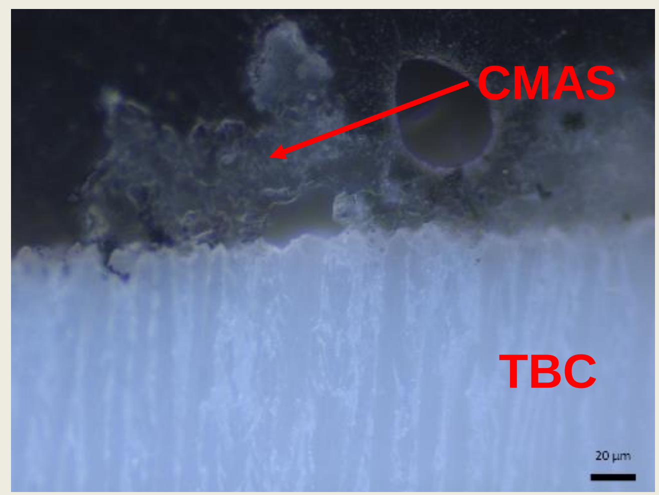
BF @ 50X



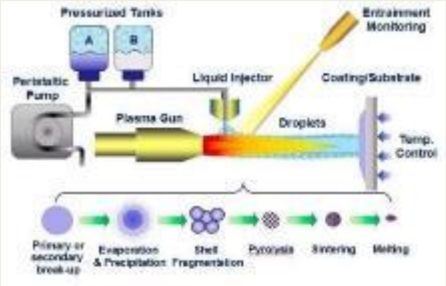
DF @ 5X

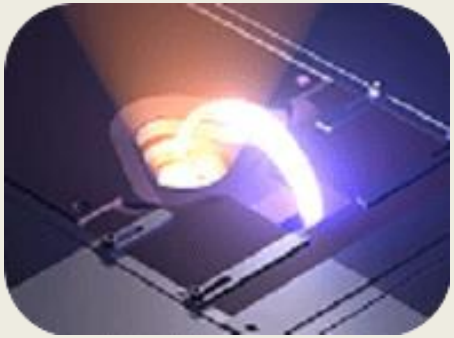


DF @ 50X



Down-selected Compositions





ID	Processing	Coating Architecture	Post-deposition treatment	Suspected Mitigation Mechanism
1	SPPS	8YSZ	None	Finer microstructure, with limited infiltration paths
2	APS	7YSZ / Gd_2O_3	None	Reduced wetting by debris
3	APS	(7YSZ+Gd_2O_3 blend) / GZO	None	Crystallization of deposits
4	APS	7YSZ / GZO	None	Crystallization of deposits
5	APS	7YSZ / (7YSZ + Gd_2O_3 blend)	None	Reduced wetting by debris
6	EB-PVD	Low-k ZrO_2-based	None	Reduced wetting by debris
7	EB-PVD	low-k HfO_2-based	None	Reduced wetting by debris

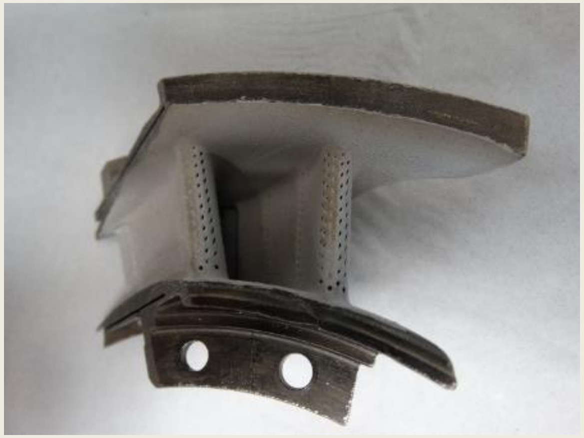
Process Optimization – Nozzles

Nozzle 1 – 7YSZ via APS

- Leading Edge Holes are largely clear
- Clogging increases as you approach the vane's trailing edge

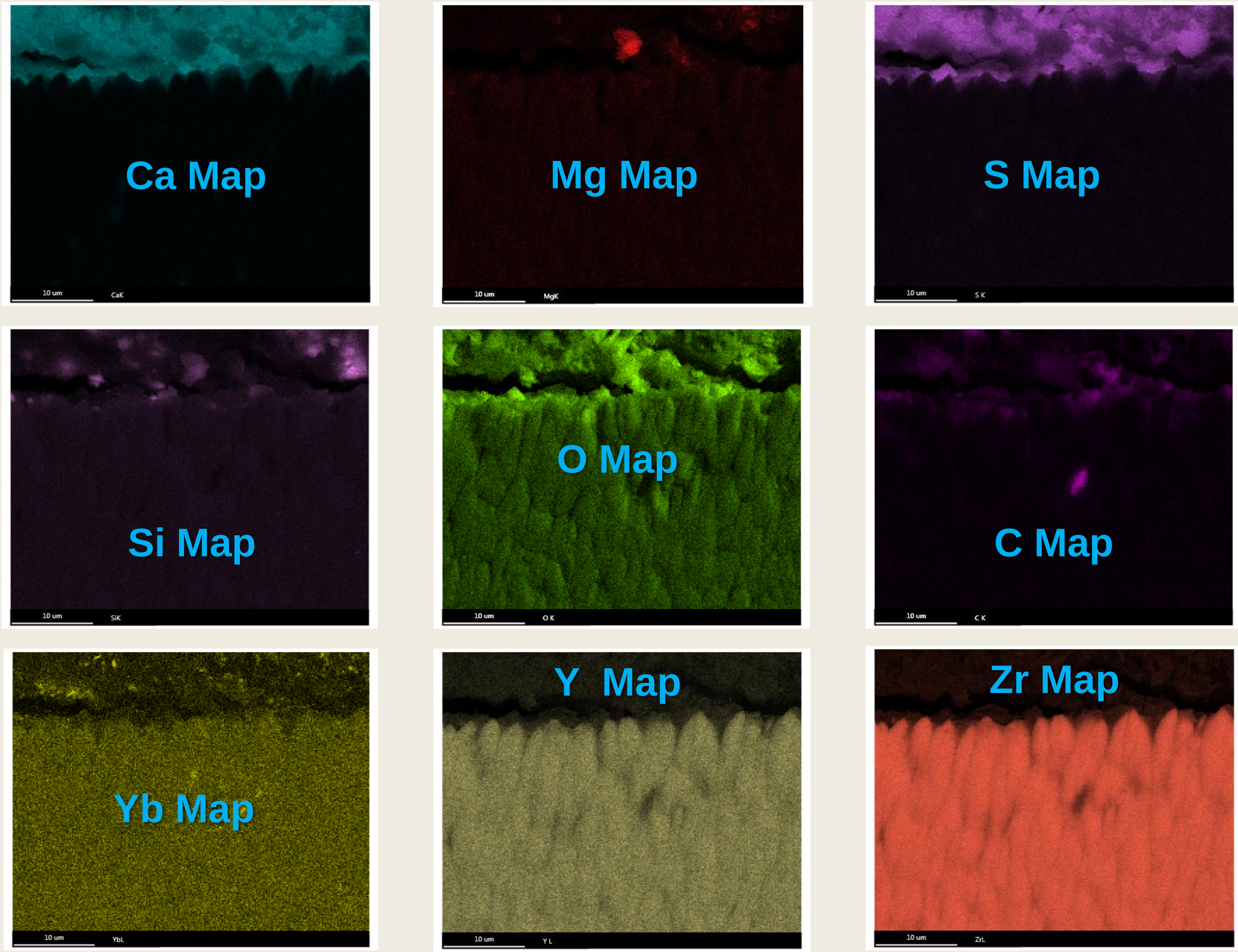
NOTE: Samples were grit-blasted for coating adhesion

Nozzle 2 – 8YSZ via SPPS

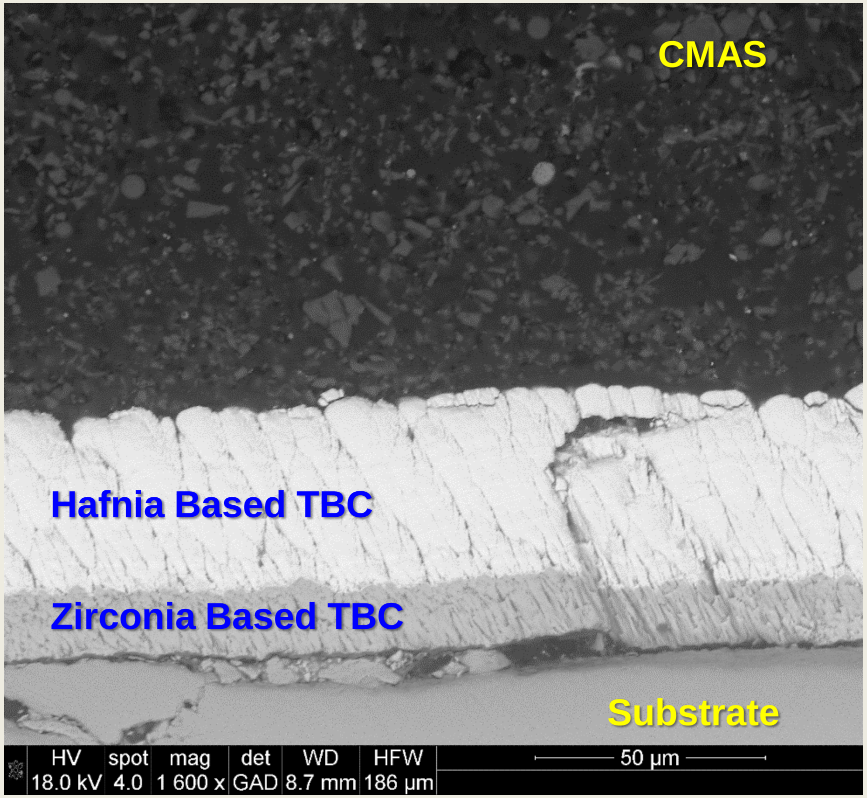


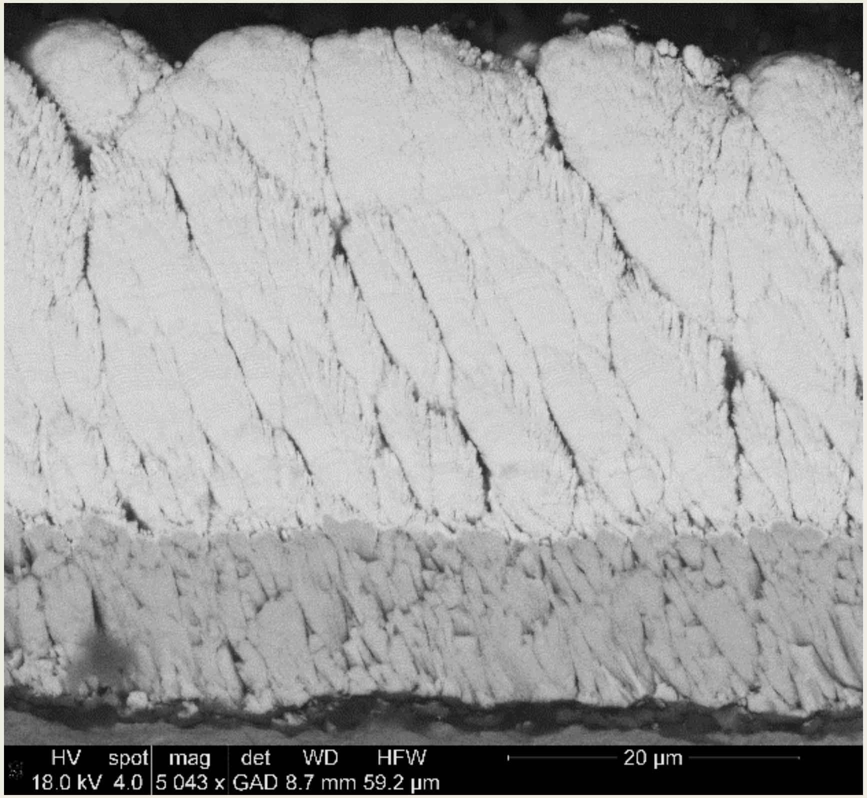
- Cooling hole row at the peak of the leading edge is clogged
- Trailing edge shows less clogging than Nozzle 1, despite identical spray path
- Finer Coating Droplets (Solution Plasma Topcoat) appear to bridge cooling holes more easily/thoroughly, despite increased bleed air inlet pressure/flow.

ARL-NASA-06


Ca Map
10 um
CaK
Mg Map
10 um
MgK
S Map
10 um
S K
Si Map
10 um
SiK
O Map
10 um
O K
C Map
10 um
C K
Yb Map
10 um
YbL
Y Map
10 um
Y L
Zr Map
10 um
ZrL

ARL-NASA-07





- ARL-NASA-07 shows signs of delamination from the substrate, as well as significant cracking on TBC itself (*aside from columnar structure*)
- Columnar structure of hafnia based EB-PVD TBC is significantly different from that of 5YSZ EB-PVD TBC (*ARL-NASA-07 is also much thinner*)

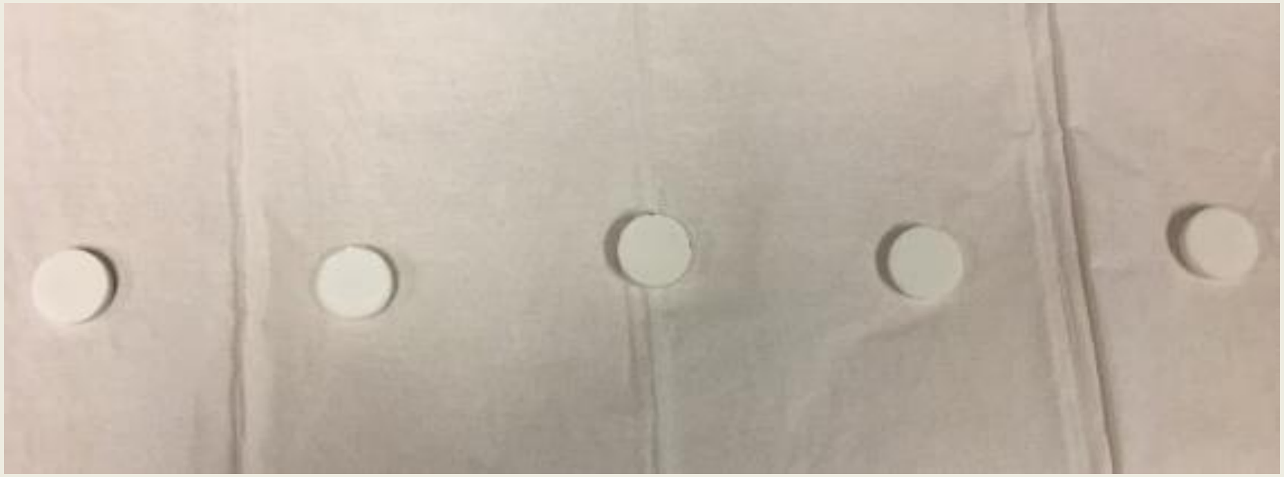
ARL-NASA-05

- CMAS constituents exhibit rich variety of morphologies and microstructures
- Different CMAS constituents will have distinct reactions to high temperatures and different interactions w/ TBCs

- Most CMAS deposits are very rough and porous
- CMAS deposits can be white, red, or both.

CMAS deposits Post CMAS Attack Testing

As-Sintered Pellets



Pellets Post CMAS Attack Testing

Adhesion, morphology, and size of CMAS deposits can be seen to vary significantly