

# CONTENTS

List of Figures	xii
List of Tables	xviii
Nomenclature	xix
<b>1 Introduction</b>	
<b>1.1 Objectives</b>	1
<b>1.2 Scope and objectives of work</b>	3
<b>1.3 Important research findings</b>	4
<b>2 Theory and Review of Literature</b>	
<b>2.1 Fatigue of metals</b>	
2.1.1 Introduction to fatigue	6
2.1.2 History of metal fatigue	7
2.1.3 Mechanism of fatigue	8
2.1.4 Macro and microscopic features of fatigue	10
2.1.5 Types of fatigue loading	13
2.1.6 Effect of nature of loading on fracture surface appearance	14
2.1.7 Fatigue evaluation methods	15
2.1.7.1 Stress-life approach	15
2.1.7.2 Strain-life approach	16
2.1.7.3 Linear elastic fracture mechanics approach	16
2.1.8 Fatigue testing procedure	16
2.1.9 Standard practices related to fatigue testing of metals	19
2.1.10 Fatigue life diagram or S-N curve	20
2.1.11 Factors affecting fatigue life	22
<b>2.2 Surface engineering</b>	
2.2.1 Introduction to surface engineering	24
2.2.2 Various methods of surface treatment	25
2.2.2.1 Hard chrome plating	25
2.2.2.2 Induction hardening	28
2.2.2.3 Thermal spray methods	29
2.2.2.3.1 Flame spray processes	31
2.2.2.3.2 High velocity Oxy-Fuel (HVOF) process	32
2.2.2.3.3 Detonation gun spray process	33
2.2.2.3.4 Electric wire-arc process	34
2.2.2.4 Nitriding	39
2.2.2.4.1 Basics of nitriding	39
2.2.2.4.2 Structure and composition of nitrided layer	42
2.2.2.4.3 Plasma nitriding	45

2.2.3 Role of residual stresses in compound layer on fatigue life	55
<b>2.3 Finite Element Analysis</b>	58
<b>3 Experimental work</b>	
<b>3.1 Work Plan</b>	59
<b>3.2 Material selection</b>	60
<b>3.3 Specimen design and fabrication</b>	61
<b>3.4 Surface treatments</b>	63
3.4.1 Hard chrome plating	63
3.4.2 Thermal spray coating of alumina powder	64
3.4.3 Plasma nitriding	65
<b>3.5 Fatigue testing</b>	69
3.5.1 Fatigue test method and equipment details	69
3.5.2 Methodology for fatigue testing	72
3.5.3 Stress versus life cycle data	72
3.5.3.1 Fatigue stress modification factor	73
3.5.3.2 Cycle modification factor	73
<b>3.6 Post-surface treatment characterization</b>	74
3.6.1 Coating thickness measurement	74
3.6.2 Surface hardness measurement	74
3.6.3 Surface roughness ( $R_a$ ) measurement	74
3.6.4 Microhardness profile determination	75
3.6.5 EDS analysis	75
3.6.6 Macrofractography	75
3.6.7 Microfractography	75
3.6.8 Microstructural examination	76
3.6.9 XRD analysis	76
<b>3.7 Finite element analysis (FEA)</b>	76
3.7.1 FEM based analysis on fatigue test specimen	77
<b>4 Results and discussion</b>	
<b>4.1 Pre-fatigue test phase</b>	82
4.1.1 Measurement of thickness / depth of coating	82
4.1.2 Surface roughness measurements	84
4.1.3 Measurement of surface hardness	85
4.1.4 Microhardness profile for plasma nitrided specimens	86
4.1.5 Compositional analysis of surface layers by EDS	88

<b>4.2 Post-fatigue test phase</b>	95
4.2.1 Analysis of fatigue test data	95
4.2.1.1 S-N (Stress versus life cycle) data	95
4.2.1.2 Conversion of S-N data using Basquin relationship	96
4.2.1.3 Calculation of Stress modification & Cycle modification factors	97
<b>4.3 Fractography of fatigue tested specimens</b>	111
<b>4.4 Microstructural examination</b>	119
<b>4.5 XRD analysis</b>	121
<b>4.6 Finite Element Analysis to determine stress state in white layer</b>	126
4.6.1 Validation of FEM analysis procedure using closed form equivalent composite beam	126
4.6.2 Results of validation	128
4.6.3 FEM based analysis on fatigue test specimen	129
<b>5 Conclusions</b>	137
<b>Suggestions for future work</b>	139
<b>References</b>	140
<b>Appendices</b>	
Appendix-I EDS Data for Nitrogen Profiling	150
Appendix-II Sample Calculations for Fatigue Data Analysis	165
Appendix-III JCPDS Data Cards for XRD Analysis	176
Annexure-IV The Finite Element Method in Solid Mechanics	179
<b>Publications from present research work</b>	189