LA-UR- 08-7903

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Intended for:	Material Science and Engineering A Journal

Los Alamos
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EST. 1943

Form 836 (7/06)

COMPRESSIVE PROPERTIES OF A CLOSED-CELL ALUMINUM FOAM AS A FUNCTION OF STRAIN-RATE AND TEMPERATURE.

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The compressive constitutive behavior of a closed-cell Aluminum foam (ALPORAS) manufactured by Shinko Wire. Co. in Japan was evaluated under static and dynamic loading conditions as a function of temperature. High-strain-rate tests (1000 - 2000/s) were conducted using a split-Hopkinson pressure bar (SHPB). Quasi-static and intermediate-strain-rate tests were conducted on a hydraulic load frame. A small but discernable change in the flow stress behavior as a function of strain rate was measured. The deformation behavior of the Al-foam was however found to be strongly temperature dependent under both quasi-static and dynamic loading. Localized deformation and stress state instability during testing of metal foams is discussed in detail since the mechanical behavior over the entire range of strain rates indicates non-uniform deformation. Additionally, investigation of the effect of residual stresses created during manufacturing on the mechanical behavior was investigated.

INTRODUCTION

The high-strain-rate stress-strain response of metallic foams has received increased interest in recent years related to their lightweight and the potential for large energy absorption during deformation. Understanding the deformation mechanisms present in these materials will enable designers to more fully utilize their energy absorbing characteristics. Previous studies of fully dense annealed Al alloys have shown that temperature more strongly affects the yield and flow stress behavior than strain rate [1].

A number of previous studies have probed the constitutive response of Aluminum-based foams at room temperature [2-27]. Research results by Aly and Hakamada [27, 28] describe the elevated temperature response of aluminum foam and limited studies on the effect of heat treatment [2, 3]. The room temperature compressive response of a variety of Al-based foams at low strain rates [4-10] and under dynamic loading conditions [3, 10-24] has shown that: a) the initial elastic modulus of Al-foams is generally lower than a fully-dense alloy, b) imperfections in the cell walls [4, 9, 29] lead to localized deformation, stress concentrations around the deformed regions, and due to this a decreased elastic modulus, c) Al-foams exhibit yield behavior when the local distortions link to form deformation bands, and d) subsequent oscillations in the stress-strain curves of Al-foams tested in compression are associated with additional deformation band collapse.

Deformation of metallic foams is typically divided into three stages (Fig 1): a linear elastic deformation stage, a plastic deformation and pore collapse stage, and finally a densification stage [20]. The linear elastic stage of the deformation has been shown to be related to elastic bending of the cell walls. Studies have demonstrated that there are weak regions in Al-foam materials due to the inhomogeneous density of the closed-cell foams [4, 9, 29]. At low strain rates the pore collapse stage consists of an initial load drop due to local buckling and failure of the wall structure on a plane normal to the loading direction at the weakest region of the sample. Stresses in the collapse plane will increase as the cell walls interact with one another until the load level reaches a value where the next plane of failure will occur. Additional pore collapse planes will occur randomly across the sample at the same time as there is continued cell wall interaction in the original and subsequent layers reducing the magnitude of oscillations seen in the stress-strain curves due to a plane of pore collapse. At high strain rates, strain rates high enough to cause inertial effects, the mechanism of plastic deformations has been seen to be quite different [25, 26, 22, 23]. The collapse planes are no longer randomly found within the sample but plastic deformation occurs as a

sweeping deformation front starting from the impact surface and propagating across the sample. Statistically, this would reinforce the findings of authors that observed strain rate effects in these materials [12-15, 17, 20-26]. Finally, the densification stage shows a rapid increase in the load carried by the sample.

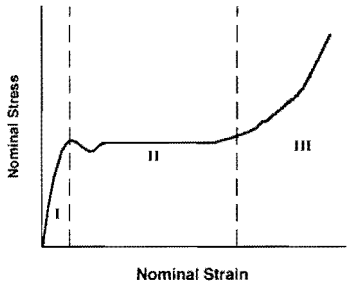


FIGURE 1. A typical stress-Strain curve for metal foam deformation showing stage I, linear elastic "bending", stage II, pore collapse, buckling, and cell wall failure, and stage III, densification.

Although these summary observations are common to the findings of most previous investigators, there remain significant differences in interpretation concerning the nature and controlling mechanisms of the strain-rate sensitivity of Al-alloy foams. There is evidence that the stress-strain behavior of the closed cell Al-foam (Alporas) used in this study exhibits some strain-rate sensitivity [11,13,15,28]. However, other studies have determined that there is no strain-rate sensitivity in other metal foams [8, 10, 12,16]. Geometry effects may for example limit the strain rate sensitivity in low relative density foams. However, there has been to date no evidence linking strain-rate sensitivity to processing or structure although the retention to prior cold work in manufacturing metal foams appears likely. As part of this investigation annealed samples were interrogated under similar conditions as the as-processed Al-foam material. Analysis of the energy absorption will be presented in this study to help quantify the magnitude of the strain-rate sensitivity of the aluminum foam characterized in this study.

A potential previously postulated contributor to the strain rate sensitivity of closed cell aluminum foam is that of compressing the trapped gas, assuming that the cell walls do not fracture during pore collapse. However, it has been shown that the contribution to the strength due to gas compaction is negligible [12, 22]. The calculated increase in strength will be nearly zero at low strains and at higher strains the contribution typically less that about 5% of the yield stress and as such falls within the scatter for the experiments.

Sample-size and lubrication effects are also critical to the quantification of the mechanical response of metal foams due to the cell size, cell wall thickness, and the speed of sound through these structures. The speed of sound in Al-foam structures, which is linked to the stress state stability in dynamic SHPB tests, seems to vary with wall geometry and pore size.

The objective of this paper is to present results illustrating the effect of systematic variations of strain rate and temperature on the constitutive response of Alporas closed cell Al foam.

EXPERIMENTAL TECHNIQUES

This investigation was performed on a commercial closed cell-aluminum alloy foam with the trade name ALPORAS (Shinko Wire Co.)[30]. The chemical composition of the foam is Al-1.42Ca-1.42Ti-0.28Fe-0.007Mg (by weight %) with an approximate relative density of 0.08 (density of foam divided by the density of the parent material). The average cell dimension of this foam is ~3.0 mm in the in plane orientation and ~3.8 mm in the through thickness orientation [30]. The effect of orientation will not be presented in this study as it has been investigated previously [22] and showed only minor differences for metal foams with similar cell structures. The cell wall thickness is reported to be ~ 85μm in the center of a web and thickens nearer the intersection of 3 or more cells. There are morphological defects like cell wall waviness, cell size variation, fractured cell walls, and non-uniform cell wall thickness that are present in all of the foam specimens.

Cylindrical compression samples 18.4mm in diameter by 9.5mm in length (high rate tests) and 25.3mm in diameter by 28.0mm in length or 22.8mm width by 22.8mm thick by 30.2 length (low rate tests) were electro-discharge machined from the as-received foam material. Several samples were subsequently annealed at 373 K for 2 hours. It was hoped that this low temperature anneal would relieve any cold work introduced into the material during the manufacturing of the base material or the machining of the test samples. Compression tests were conducted at strain rates of 0.0001 and 1.0 s^{-1} at 77K, 173K, and 295K in laboratory air using an MTS 880 hydraulic load frame. Dynamic tests were conducted at strain rates from ~1000 to 2000 s^{-1}, and at temperatures of 77K, 173K, and 295K, utilizing a split-Hopkinson pressure bar (SHPB) equipped with 23mm diameter AZ31B magnesium pressure bars. Mg bars were utilized as they offer a higher signal-to-noise level, due to their reduced elastic modulus, compared to the maraging steel bars traditionally

utilized in many Hopkinson-Bar studies [31]. Hopkinson bar experiments showing large strains were generated by multiple loadings using strain limiting rings to sequentially control the deformation in each increment of loading in the Al-foam sample. Without the rings, the stored energy in the SHPB leads to deformation in the samples well beyond the recording ability of the data acquisition system.

The inherent oscillations in the dynamic stress-strain curves and the lack of stress equilibrium in the specimens during the test make the determination of yield strength inaccurate at high strain rates. Cryogenic temperature tests were conducted by immersing the sample in a liquid nitrogen bath. The 173K temperature condition for the quasi-static tests was achieved by allowing cooled nitrogen gas to flow through the compression platens utilized for these tests. SHPB tests at 173K were achieved by passing cold nitrogen gas over a sample and the SHPB bars and allowing the system to equilibrate. Because it is well known that the base material of the foam is more sensitive to temperature than strain rate it was believed that characterizing the material at low temperatures could lead to insights that might otherwise be missed. The test samples were lubricated using either a thin layer of molybdenum disulfide grease or molybdenum disulfide spray lubricant to reduce friction effects at the sample - load frame interface.

RESULTS AND DISCUSSION

SHPB characterization

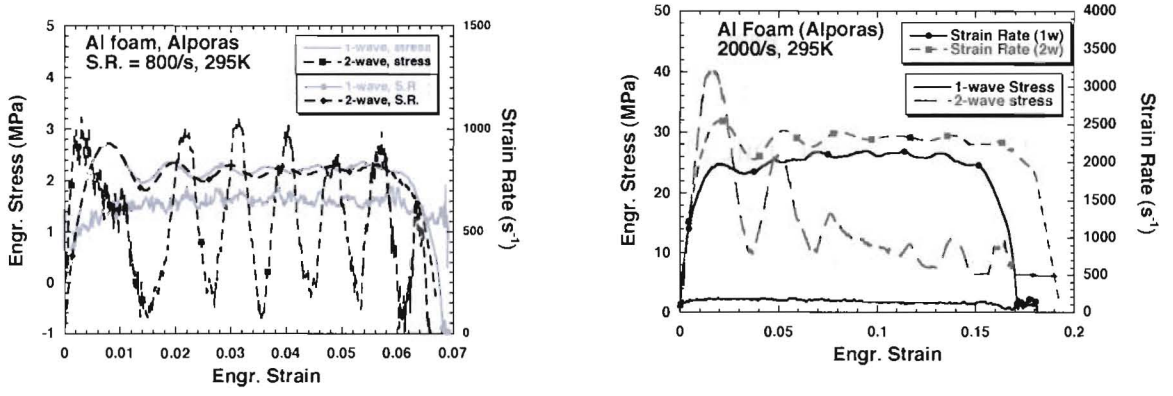
The determination of the stress-strain behavior of a material being tested utilizing a split Hopkinson pressure bar (SHPB) is based on the principle of one-dimensional elastic-wave propagation within the pressure bars and the attainment of a uniaxial stress state in the sample of interest [31]. Due to the documented deformation characteristics of these closed-cell foams [22, 23, 26], i.e., non-uniform plasticity, the data generated in a SHPB studies is ill-posed based on the requirements for valid uniaxial-stress SHPB experiments [31,32]. A uniform uniaxial stress state and homogeneous deformation within a sample, which is essential for valid SHPB tests, is seen to be problematic at best within this material at strain-rates of $0.001s^{-1}$ and above due to non-uniform deformation of the foams. Further, the non-conservancy of volume, i.e., the sample is compressible, eliminates the possibility of determining true-stress true-strain data. Nevertheless, the high-rate constitutive response of the Al-foam in this study was carefully quantified to identify the high-rate

mechanical response of the foam as a means to assess its energy absorption response under dynamic loading.

Additionally, to assure that valid high-rate measurements on the Al foam were being measured, it is instructive to examine the different wave analyses [31, 33] used to calculate sample stress using the incident, reflected, and transmitted bar strains measured in a SHPB as shown in Fig. 2a. In the 1-wave analysis the sample stress is directly proportional to the bar strain measured in the transmitted bar. The 1-wave stress analysis reflects the conditions at the sample-transmitted bar interface and is often referred to as the sample "back stress". This analysis results in smoother stress-strain curves, especially near the yield point. Alternatively in a 2-wave analysis, the sum of the synchronized incident and reflected bar waveforms (which are opposite in sign) is proportional to the sample "front stress" and reflects the conditions at the incident/reflected bar-sample interface.

A valid, uniaxial-stress Hopkinson bar test requires that the stress state throughout the sample achieve equilibrium during the test and this condition can be checked readily by comparing the 1-wave and 2-wave stress-strain responses [31,33]. We know from the observed deformation of the Al-foam samples that the deformation within the samples is not uniform and therefore neither can the achievement of stress-state equilibrium within the sample (Fig. 4c). Since the 2-wave stress analysis oscillates about the 1-wave wave stress at a strain rate of ~ 800 s^{-1}, as seen in Figure 2a we have some confidence that the forces measured represent the overall "bulk" loads on the Al-foam samples. However, at the strain rate of ~1800 s^{-1} the 1-wave and 2-wave signals were found to be divergent at the beginning of each test and the strain rate is seen to slightly increase with plastic strain. Although the 2-wave data oscillates around the 1-wave curve there is sufficient evidence to therefore seriously question the validity of these SHPB results. At even higher strain rates, or impact velocities, the 1-wave and 2-wave wave analyses were found to be divergent for the entire test (Fig 2b.) likely indicating non-equilibrium deformation for the entire duration of the test and accordingly indicating these SHPB tests were ill posed. Even though these tests are invalid based upon the traditional SHPB data analysis, it is believed that the results can be utilized qualitatively to provide insight into the deformation behavior of the Al-foam material under impact loading. However, the reader is advised to not expect the reported values for the high strain rate data to be exact or consistent from one experimentalist to another given this ill posed state and lack of stress-state stability within the samples. Depending on the configuration of the SHPB system used, the impact velocities can be different yet produce the same strain rate based on variables including

sample size, bar diameter, and bar material. It has been reported by several authors [18, 22, 23, 26] that the deformation behavior of the Alphoras Al-foam material used in this study changes from a random pore collapse plane dominated process to collapse that initiates at the impact interface and propagates from there into the sample.



2a 2b

FIGURE 2. Stress-strain response the Al foam showing 1- and 2-wave stress curves in addition to the strain rate for a) a test with a strain rate of 800 s^{-1} where the 2-wave stress oscillates about the 1-wave stress indicating a valid test for incompressible materials, and b) showing 1- and 2-wave stress curves at 2000 s^{-1} where the 1-wave and 2-wave stress curves are divergent.

Compressive Response and Energy Absorption

The compressive engineering-stress versus engineering-strain response of the Alphoras Al-foam was found to be sensitive to the applied strain rate between 0.0001 and 2000 s^{-1}. The plateau stresses were found to be parallel with a small average increase in level for increasing strain rate. The yield strength and plateau flow stress displayed greater dependence on temperature between 77K and 295K. The plateau strength of the foam at 295K, shown in Fig. 3a, increased from ~1.6 MPa at 0.0001 s^{-1} to 1.96 MPa at 0.1 s^{-1} to ~2.5 MPa at a strain rate of 2000 s^{-1}. However, tests above a strain rate of 1700 s^{-1} are complicated, as discussed above, by non-uniform deformation and the lack of attainment of a uniaxial state of stress. The result of the 900 s^{-1} test shows a yield of only ~1.7 MPa, but it exhibits a more uniform state of stress within the sample during dynamic testing. Since the one-wave stress reflects the transmitted force from the foam specimen to the transmitted bar at

the contact end, the absorption energy per unit volume, W, at a specific strain can be evaluated by integrating the area under the stress strain curve by one-wave analysis as given by:

$$W = \int_0^{\varepsilon} \sigma d\varepsilon \qquad (1)$$

For all the samples tested in this study the energy absorbed was found to monotonically increase with plastic strain until the material showed signs of densification. An engineering strain of 0.5 was chosen as the evaluation point because it is near the transition of the pore collapse regime and the densification regime. The absorbed energy ranged from 1.0 to 1.1 MJ/m^3 for strain rates between 0.001 s^{-1} and 0.1 s^{-1} and it went to 1.44 at 2000 s^{-1} (Fig. 3b). There was a significant change in the absorbed energy between the quasi-static (0.001 s^{-1}) and the dynamic rate (2000 s^{-1}). It is interesting to note that there is a marked increase in the energy absorption above a strain rate of ~1000 s^{-1}. This may correlate with the transition from spatially random pore collapse planes to the propagation of the failure from the impact surface in a sweeping wave front manner. Micrographs of the different pore collapse phenomenon are illustrated in Fig. 4

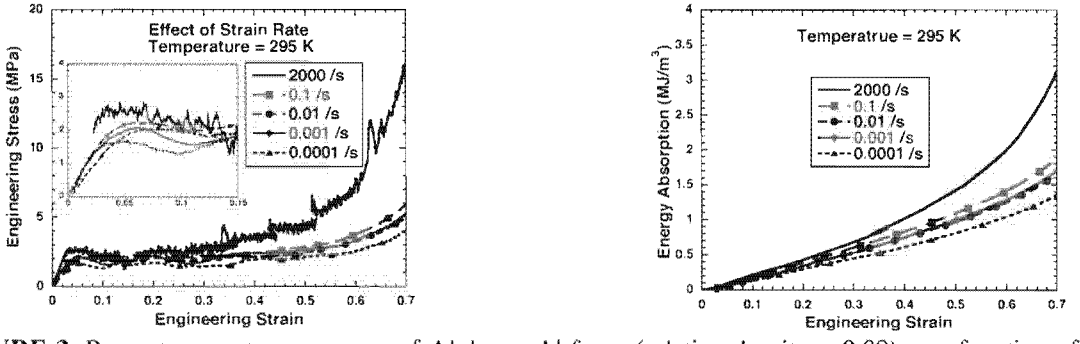


FIGURE 3. Room temperature response of Alphoras Al foam (relative density = 0.08) as a function of strain rate: a) stress-strain response and b) energy absorption.

The plateau stress of the Al foam studied was found to additionally exhibit a dependence on test temperature, decreasing from ~2.4 MPa at 77K to 1.85 MPa at 295K when loaded at a strain rate of ~1000 s^{-1}. A similar effect of temperature on the stress-strain response of the Al foam was seen during quasi-static testing as seen in figure 5a. The plateau stress exhibited a much more pronounced decreased from ~3.4 MPa at 77K to ~1.8 MPa at 295K. This temperature dependency of the Al-foam is thought to reflect the temperature dependence of the pre-existing defect substructure, principally stored dislocations, in the foam formed during the manufacturing process [34]. The effect of cooling the material on energy absorption for tests conducted at 0.001 s^{-1} is ~ 1.0

MJ/m^3 at 295 K, ~1.1 MJ/m^3 at 173 K and ~1.7 MJ/m^3 at 77K (Fig. 5b), a 70% increase relative to the room temperature behavior.

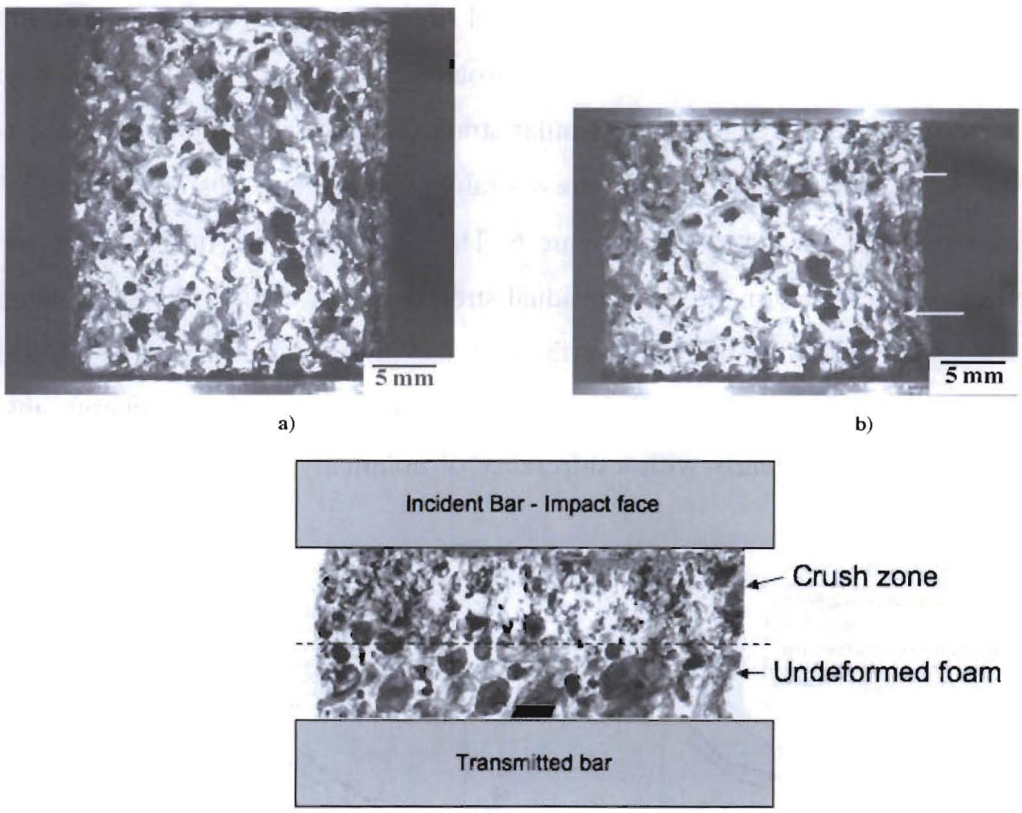


FIGURE 4. In-situ optical micrograph of Alporas Al foam under quasi-static and high strain rate loading: a) as received, b) after 30% strain at 0.001 s^{-1} note the deformation bands indicated by the arrows, and c) at high strain rates advancing deformation wave.

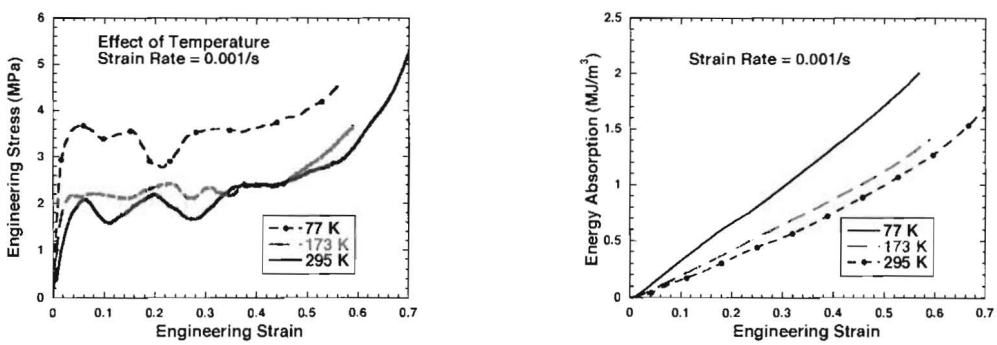


FIGURE 5. Temperature response of Alphoras Al foam (relative density = 0.08) at a strain rate of 0.001 s^{-1}: a) stress-strain response and b) energy absorption.

This study also sought to quantify the effect of residual stresses and/or stored cold-work in the Al-foam samples created during the foaming process. Al-foam samples were heat treated for one hour at 373 K and were subsequently evaluated at similar strain rate and temperature testing conditions as those for the as received material. The stress-strain behavior and absorbed energy for the annealed Al-foam material are presented in figure 6. The subtle decrease in flow stress response suggests the presence of either some level of residual stresses and/or cold-work in the material that has been annealed out by the low temperature thermal soak. The plateau stress was found to be reduced by an average of ~ 0.5 MPa at 77 K and ~ 0.15 MPa at 295 K. The energy absorption (Fig 6b) reflects this variation clearly with a difference of nominally 0.25 MJ/m^3 at 77K and 0.11 MJ/m^3 at room temperature.

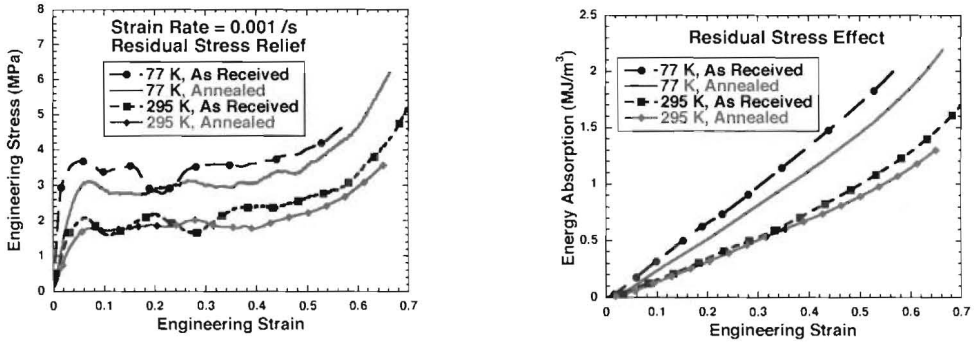


FIGURE 6. Effect of annealing as a function of temperature at a strain rate of 0.001 s^{-1}: a) stress-strain response and b) energy absorption.

Finally, the Al foam samples each displayed strain-rate sensitivity with respect to the densification process during testing. The primary difference between the two loading-rate responses is seen in the strain at which the buckling bands have saturated and "bulk" densification initializes, where the stress begins to increase after the plateau (at ~ 63% strain in the low-strain rate tests and at ~51% for strain rates of 10^3). In addition, there is also the mechanism governing pore collapse, i.e., random versus a sweeping deformation front, as discussed previously.

SUMMARY AND CONCLUSIONS

The strength properties of the ALPORAS aluminum foam with a relative density of 0.08 has been characterized and its response to quasi-static and dynamic loading at various temperatures presented. The initial pore collapse, plateau stress, and densification have been described with the energy absorption calculated form the resultant curves.

It was found that there is a regime where the impact velocity or applied strain rate was high enough to produce localization of the crushing and increase the strength of the foam by allowing inertial effects to dominate the deformation behavior. At these "super-critical" strain rates specimen size, cell structure, and defects become insignificant. Post-impact examination of partially crushed specimens showed that deformation for these super-critical strain rates propagated by progressive cell crushing from the impact surface. For all lower strain rates deformation is through the cumulative interaction of discrete crush bands that are dominated by statistical strength properties of the foam. The onset of "super-critical" dynamic deformation is likely linked to pore and wall geometry, foam density, and morphological defects and is not a material constant. Increased strain rate sensitivity is likely due to cell wall interaction and pore architecture as well as the inherent rate sensitivity of the base metal of the foam material.

These results are consistent with previous strain rate studies on cellular aluminum alloys considering the statistical variation in the material [3, 7-26].

A significant influence on the strength of the material when exposed to low temperatures was observed. The quasi-static loading of the foam material showed the greatest strength increase of all conditions. Part of the rationale behind this response is thought to be that at high loading rates adiabatic heating at a local level can be very high, and since the deformation is propagating through the sample from the impact surface into the sample the local temperatures in the foam materials could be several 10's if not more than a 100 degrees warmer at the point of deformation thus allowing the material to deform at a lower flow stress level. It was also observed that low-temperature annealing reduced the stress at which deformation initiated indicating that the material has some residual stresses and/or cold-work introduced during fabrication of the foam material.

Based upon a study of the influence of strain rate and temperature on the constitutive response of Al foams, the following conclusions can be drawn: 1) the compressive stress-strain response of an Al-foam was found to depend on the applied temperature; 77K to 295K and to a lesser degree on the strain rate; 0.001 to ~2000 s^{-1}, 2) decreasing temperature at 2000 s^{-1} was found to increase the

maximum flow stress in Al foam from ~1.4 to 4 MPa, 3) the deformation of the Al foam was found to be heterogeneous in nature, 4) the Al foam failed at high-strain rate via deformation band collapse and 5) there appear to be residual stresses in the as-processed Al-foam materials that can be relieved by a low temperature anneal.

ACKNOWLEDGEMENTS

Los Alamos National Laboratory is operated by LANS, LLC, for the National Nuclear Security Administration of the U.S. Department of Energy under contract DE-AC52-06NA25396. This work has been performed under the auspices of the United States Department of Energy and was supported by the Joint DoD/DOE Munitions Technology Development Program.

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