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**MODELLING OF THE FATIGUE CRACK INITIATION AND PROPAGATION
BEHAVIOUR IN METALS AND ALLOYS**

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VÍCTOR HUGO RIBEIRO

**MODELLING OF THE FATIGUE CRACK INITIATION AND
PROPAGATION BEHAVIOUR IN METALS AND ALLOYS**

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*“The ear that heareth the reproof of life abideth
among the wise.
He that refuseth instruction despiseth his own soul,
but he that heareth reproof getteth understanding.”*

Proverbs 15:31-32

RESUMO

A fadiga é uma das principais causas de falhas e também de fraturas mecânicas em detalhes estruturais sob carregamento cíclico. Existem vários modelos para descrever o comportamento de fadiga de baixo ciclo com base em critérios de dano por deformação, como Coffin-Manson-Morrow, utilizado na fase iniciação de trinca. A lei de Paris só é aplicável na região estável de crescimento de trinca (região II), e como consequência, surgiram diversos modelos dela derivados para contornar essa limitação, aumentando o número de variáveis e parâmetros necessários e, conseqüentemente, tornando a solução onerosa. Outros modelos como UniGrow, Huffman, Pecker, entre outros, descrevem as fases de iniciação e propagação de trincas de fadiga, adotando o conceito de reinicializações sucessivas de trincas (incrementos) com base em abordagens locais.

Nesta pesquisa, a modelagem de fadiga de baixo ciclo baseada na abordagem de Huffman usando a densidade de energia de deformação e considerando a densidade de discordâncias é investigada e discutida. Para isso, várias metodologias para avaliar a resistência à fadiga de baixo ciclo com base na abordagem de Huffman e explorar diferentes parâmetros de densidade de deslocamento são sugeridas: (i) densidade de discordâncias crítica associada a maior amplitude de deformação; (ii) valor médio da densidade de discordâncias dos dados experimentais de fadiga disponíveis e, (iii) predição estocástica de Monte Carlo(MC) considerando a variabilidade da densidade de discordâncias e o coeficiente de endurecimento por deformação cíclica. Dados experimentais de fadiga das ligas de Al1050, Al6061-T651 e AlMgSi0.8 da literatura são usados neste estudo. E ainda, é feita uma comparação entre os dados experimentais de fadiga e as curvas de tensão-vida com base nas várias metodologias sugeridas.

Adicionalmente, é apresentada uma comparação do efeito de vários modelos de fechamento/abertura de trinca no comportamento de crescimento de trinca por fadiga da liga de Al6061-T651. Os modelos de fechamento de trinca em consideração são: Elber; Katcher-Kaplan; Clerivet-Bathias; Schijve; Zhang; Newman; Savaidis; Codrington-Kotousov; Correia. Uma comparação entre esses modelos é feita.

Além disso, foi sugerida modelagem do comportamento de crescimento de trinca por fadiga para a liga 6061-T651 através do modelo Huffman com base na densidade de

energia de deformação das discordâncias considerando os efeitos das tensões residuais à frente da ponta da trinca(x), onde essas tensões estão relacionadas ao dano por fadiga de um incremento de fissura Δa , como parâmetro do calibrador. Duas abordagens sugeridas por Noroozi e Huffman são estudadas e discutidas. Na modelagem do comportamento de crescimento de trinca por fadiga, a influência da densidade de energia de deformação calculada para os valores de densidade de discordâncias crítica associada a maior amplitude de deformação e o valor médio da densidade de discordâncias para os resultados de fadiga experimentais disponíveis também foram considerados nesta investigação. Os valores de densidade de discordâncias estudados não influenciam significativamente o comportamento de propagação de trincas por fadiga. Conclui-se também que o procedimento de consideração dos efeitos das tensões residuais influencia o calibrador, Δa , não sendo possível concluir qual é o melhor método para descrever os efeitos das tensões residuais.

Palavras-chave: ligas de alumínio; fadiga de baixo ciclo; taxa de crescimento de trincas; efeitos do fechamento de trincas; energia de deformação; densidade de discordâncias; efeitos de tensões residuais.

ABSTRACT

Fatigue is the main causes of mechanical fractures in structural details under cyclic loading. There are several models to describe low-cycle fatigue behavior based on strain damage criteria, such as Coffin-Manson-Morrow, which is used in the crack initiation phase. The Paris law is only applicable in the stable region of crack growth (region II), and, as a consequence of this, several models have emerged derived from it emerged to overcome this limitation, increasing the number of variables and parameters required and, consequently, making the solution costly. Other models such as UniGrow, Huffman, Pecker, among others, describe the initiation and propagation phases of fatigue cracks, adopting the concept of successive crack restarts (increments) based on local approaches.

In this research, low-cycle fatigue modeling based on the Huffman approach using strain energy density and considering dislocation density is investigated and discussed. To this end, several methodologies to evaluate low-cycle fatigue resistance based on the Huffman approach and exploring different dislocation density parameters are suggested: (i) critical dislocation density associated with greater strain amplitude; (ii) average value of dislocation density from available experimental fatigue data and, (iii) stochastic Monte Carlo (MC) prediction considering the variability of dislocation density and the cyclic strain hardening coefficient. Experimental fatigue data of Al1050, Al6061-T651 and AlMgSi0.8 alloys from the literature are used in this study. Furthermore, a comparison is made between the experimental fatigue data and the stress-life curves based on the various suggested methodologies.

Additionally, a comparison of the effect of various crack closure/opening models on the fatigue crack growth behavior of Al6061-T651 alloy is presented. The crack closure models under consideration are: Elber; Katcher-Kaplan; Clerivet-Bathias; Schijve; Zhang; Newman; Savaidis; Codrington-Kotosov; and Correia. A comparison between these models is done.

Furthermore, modeling of the fatigue crack growth behavior for the Al6061-T651 alloy was suggested using the Huffman model based on the strain energy density of the dislocations considering the effects of residual stresses ahead of the crack tip(x), where these stresses are related to the fatigue damage of a crack increment Δa , as a calibrator parameter. Two approaches suggested by Noroozi and Huffman are studied and discussed. In modeling fatigue crack growth behavior, the influence of the

calculated strain energy density for the critical dislocation density values associated with the largest strain amplitude and the average dislocation density value for available experimental fatigue results were also considered in this investigation. The dislocation density values studied do not significantly influenced the fatigue crack propagation behavior. It is also concluded that the procedure for considering the effects of residual stresses influences the calibrator, Δa , and it is not possible to conclude which is the best method to describe the effects of residual stresses.

Keywords: aluminium alloys; low-cycle fatigue; crack growth rates; crack closure effects; strain energy; dislocation density; residual stress effects.

LIST OF FIGURES

Figure 2.1 - Fatigue crack propagation regimes.....	38
Figure 2.2 - Fatigue crack propagation regimes ¹¹	41
Figure 2.3 - Definitions of the effective stress intensity factor range and related parameters.	43
Figure 2.4 - Fatigue crack growth data correlated with the updated CCS crack growth model taking into account the crack closure effects for all stress R-ratios ²⁹	47
Figure 2.5 - Crack discretization according to the UniGrow model: a) crack and the discrete elementary material blocks; b) crack shape at the tensile maximum and compressive minimum loads ³⁷	50
Figure 2.6 - Crack discretization with elements according to the model proposed by Peekers and Niemi ³⁸	50
Figure 2.7 - Fatigue crack growth data for Al 2024 T351 aluminium alloy according to UniGrow model ³⁹	51
Figure 2.8 - Fatigue crack growth data for Eiffel bridge steel (R=0.1) according to updated UniGrow model proposed by Correia ⁴⁵	52
Figure 2.9 - Fatigue crack growth data for Fão bridge steel (R=0.0) according to updated UniGrow model proposed by Correia ⁴⁵	53
Figure 2.10 - Fatigue crack growth data for S355 steel (R=0.0) according to updated UniGrow model proposed by Correia ⁴⁵	53
Figure 2.11 - Huffman fatigue crack growth model applied to A588C steel ²⁸	54
Figure 3.1 - Schematic representation of proposed workbench.	60
Figure 3.2 - Overview of the first proposed workbench.	60
Figure 3.3 - Proposed workbench after some modifications, identifying the load cell, the linear guide (rail and car) and test specimen.....	61
Figure 3.4 - Eccentrically loaded single edge cracked geometry ESE(T) specimen geometry.	63
Figure 3.5 - Details about crack tip position identification and measurement results.....	64
Figure 3.6 - Crack length vs. number of cycles diagram.	66
Figure 3.7 - FCG rates vs. stress intensity factor range curves.....	67
Figure 3.8 - EDS of the aluminium alloys under investigation.	68
Figure 3.9 - Vickers hardness tester.....	70

Figure 3.10 - Identification of locations in the samples Al1100 and Al1050 for Vicker hardness measurements.....	70
Figure 3.11 - Specimen geometry used in monotonic tensile test.	72
Figure 3.12 - Tensile strength curves for the specimens manufactured in longitudinal direction.....	73
Figure 3.13 - Tensile strength curves for the specimens manufactured in transversal direction.....	73
Figure 3.14 - Compact tension specimen geometry used in fatigue crack growth tests.....	75
Figure 3.15 - Experimental fatigue crack growth data for stress ratios, 0.05, 0.1 and 0.25, for the aluminium 1050.....	77
Figure 3.16 - Fatigue crack growth data and Paris curve for the stress R-ratio equal to 0.05 for the aluminium 1050.....	77
Figure 3.17 - Fatigue crack growth data and Paris curve for the stress R-ratio equal to 0.1 for the aluminium 1050.....	78
Figure 3.18 - Fatigue crack growth data and Paris curve for the stress R-ratio equal to 0.25 for the aluminium 1050.....	78
Figure 3.19 - Comparison between fatigue crack propagation rate trends for different stress ratios obtained for the aluminium 1050.....	79
Figure 3.20 - Experimental fatigue crack growth data for stress ratios, 0.1 and 0.25, for the aluminium 1100.....	79
Figure 3.21 - Fatigue crack growth data and Paris curve for the stress R-ratio equal to 0.1 for the aluminium 1100.....	80
Figure 3.22 - Fatigue crack growth data and Paris curve for the stress R-ratio equal to 0.25 for the aluminium 1100.....	80
Figure 3.23 - Comparison between fatigue crack propagation rate trends for different stress ratios obtained for the aluminium 1100.....	81
Figure 3.24 - Comparison between fatigue crack propagation rate trends for stress R-ratio equal to 0.1 obtained for the Al 1100 and Al 1050.....	82
Figure 3.25 - Comparison between fatigue crack propagation rate trends for stress R-ratio equal to 0.25 obtained for the Al 1100 and Al 1050.....	82
Figure 3.26 – Thickness effect for the aluminium alloys under consideration.	83
Figure 3.27 - Macro microscopy of fractured specimens.....	84
Figure 3.28 - Microscopy details of regions A and B.	85

Figure 3.29 - Microscopy details of regions B/C and C..	86
Figure 4.1 - Strain-life data of Al 1050 – Experimental data vs. deterministic curve..	95
Figure 4.2 - Strain-life data of AA 6061-T651 – Experimental data vs. deterministic curve.	96
Figure 4.3 - Strain-life data of AlMgSi0.8 – Experimental data vs. deterministic curve.	96
Figure 4.4 - Strain-life behaviour of Al 1050 – Experimental data vs. Huffman model.	100
Figure 4.5 - Strain-life behaviour of Al 6061-T651 – Experimental data vs. Huffman model.	100
Figure 4.6 - Strain-life behaviour of AlMgSi 0.8 – Experimental data vs. Huffman model.	101
Figure 4.7 - Strain-life behaviour of Al 1050 – Experimental data vs. modified Huffman model.	103
Figure 4.8 - Strain-life behaviour of AA 6061-T651 – Experimental data vs. modified Huffman model.	103
Figure 4.9 - Strain-life behaviour of AlMgSi 0.8 – Experimental data vs. modified Huffman model.	104
Figure 4.10 - Monte Carlo stochastic procedure for low-cycle fatigue modelling of aluminium alloys.	106
Figure 4.11 - Input distributions used in the Monte Carlo stochastic prediction for Al 1050.	107
Figure 4.12 - Input distributions used in the Monte Carlo stochastic prediction for AA 6061-T651.	108
Figure 4.13 - Input distributions used in the Monte Carlo stochastic prediction for AlMgSi 0.8.	109
Figure 4.14 - Output distributions from the Monte Carlo stochastic simulation for Al 1050.	109
Figure 4.15 - Output distributions from the Monte Carlo stochastic simulation for AA 6061-T651.	111
Figure 4.16 - Output distributions from the Monte Carlo stochastic simulation for AlMgSi 0.8.	112
Figure 4.17 - Strain-life behaviour of Al 1050 – Experimental data vs. stochastic prediction (mean values) based on the Huffman model.	113

Figure 4.18 - Strain-life behaviour of AA 6061-T651 – Experimental data vs. stochastic prediction (mean values) based on the Huffman model.	114
Figure 4.19 - Strain-life behaviour of AlMgSi0.8 – Experimental data vs. stochastic prediction (mean values) based on the Huffman model.	114
Figure 4.20 - Fit comparison between the probabilistic density functions considered for Al 1050.	115
Figure 4.21 - Fit comparison between the probabilistic density functions considered for AA 6061-T651.	116
Figure 4.22 - Probabilistic strain-life prediction for Al 1050 through the Huffman model using Monte Carlo stochastic modelling.	118
Figure 4.23 - Probabilistic strain-life prediction for Al 6061-T651 through the Huffman model using Monte Carlo stochastic modelling.	119
Figure 4.24 - Predicted number of cycles, NP , versus experimental number of cycles, NE for Al 1050: Huffman model; Huffman model with $\mu\rho$; MC stochastic modelling.	123
Figure 4.25 - Predicted number of cycles, NP , versus experimental number of cycles, NE for AA 6061-T651: Huffman model; Huffman model with $\mu\rho$; MC stochastic modelling.	124
Figure 4.26 - Predicted number of cycles, NP , versus experimental number of cycles, NE for AlMgSi 0.8: Huffman model; Huffman model with $\mu\rho$; MC stochastic modelling.	124
Figure 5.1 - Fatigue crack growth curve for all regions.	133
Figure 5.2 - Scheme of the CT specimen with load P and function of the aiw ratio.	134
Figure 5.3 - Scheme on the definition of the crack closure/opening concept and effective stress intensity factor.	137
Figure 5.4 - Scheme for various crack closure mechanisms.	137
Figure 5.5 - FCG data of AA 6061-T651 collected from Correia et al. ³¹ and Henkel et al. ³²	146
Figure 5.6 - $dadN$ vs. ΔK curves based on Paris law for the AA 6061-T651 ^{31,32}	147
Figure 5.7 - Relationship between quantitative parameter, U , and applied stress ratio, R : experimental data ($U1$) and deterministic curve ($Ud, 1$) for the 1 st cycle measurements.	149

Figure 5.8 - Relationship between quantitative parameter, U , and applied stress ratio, R : experimental data (U_s) and deterministic curve ($U_{d,s}$) for the stabilised measurements.....	149
Figure 5.9 - $dadN$ vs. ΔK_{eff} data based on experimental measurements.	150
Figure 5.10 - $dadN$ vs. ΔK_{eff} data using Elber's crack closure model.	152
Figure 5.11 - $dadN$ vs. ΔK_{eff} data using Katcher and Kaplan's crack closure model.	153
Figure 5.12 - $dadN$ vs. ΔK_{eff} data using Clerivet and Bathias's crack closure model.	153
Figure 5.13 - $dadN$ vs. ΔK_{eff} data using Schijve's crack closure model.	154
Figure 5.14 - $dadN$ vs. ΔK_{eff} data using Zhang's crack closure model.	154
Figure 5.15 - $dadN$ vs. ΔK_{eff} data using Newman's crack closure model.	155
Figure 5.16 - $dadN$ vs. ΔK_{eff} data using Savaidis's crack closure model.	155
Figure 5.17 - $dadN$ vs. ΔK_{eff} data using Codrington-Kotousov's crack closure model.	156
Figure 5.18 - $dadN$ vs. ΔK_{eff} data using Correia's crack closure model.	156
Figure 5.19 - $dadN$ vs. ΔK_{eff} curves obtained for the crack closure models under consideration.	157
Figure 5.20 - Relation between $Reff$ and R for the various crack closure models..	162
Figure 5.21 - Relationship between effective stress ratio, $Reff$, and applied stress ratio, R : experimental data and deterministic curve for the 1 st cycle measurements.	163
Figure 5.22 - Relationship between effective stress ratio, $Reff$, and applied stress ratio, R : experimental data and deterministic curve for the stabilised measurements.	164
Figure 6.1 - Strain-life data of AA 6061-T651 – Experimental data vs. deterministic curve.	180
Figure 6.2 - Fatigue crack propagation behaviour of AA 6061-T651 – Experimental data vs. deterministic curve.	181
Figure 6.3 - Finite element mesh of the CT specimen: a) global mesh and boundary conditions; b) zoom of the mesh around the crack tip.	186
Figure 6.4 - Comparison of numerical and analytical elastoplastic stress distributions for the CT geometry with $a = 10\text{mm}$ and $R = 0.1$: a) σ_{yy} ; b) σ_{xx}	187

Figure 6.5 - Comparison of numerical and analytical elastoplastic stress distributions for the CT geometry with $a = 10\text{mm}$ and $R = 0.5$: a) σ_{yy} ; b) σ_{xx}	188
Figure 6.6 - Comparison of numerical and analytical residual stress distributions for the CT geometry under two distinct stress ratios: a) $R = 0.1$; b) $R = 0.5$	189
Figure 6.7 - ΔK_{tot} vs. $\Delta K_{applied}$ for the CT geometry made of Al 6061-T651 using Neuber rule, as suggested by Noroozi et al. ²³⁻²⁵	191
Figure 6.8 - Fatigue propagation behaviour of Al 6061-T651 – Experimental data vs. Strain energy density model considering the Neuber rule-based residual stress effects ($\rho_c = 5.90E + 15 \text{ m/m}^3$).	191
Figure 6.9 - Fatigue propagation behaviour of Al 6061-T651 – Experimental data vs. Strain energy density model considering the Neuber rule-based residual stress effects ($\rho_c = 6.088E + 15 \text{ m/m}^3$).	192
Figure 6.10 - ΔK_{tot} vs. $\Delta K_{applied}$ for the CT geometry made of Al 6061-T651 using Huffman residual stress effects.	194
Figure 6.11 - Fatigue propagation behaviour of Al 6061-T651 – Experimental data vs. Strain energy density model considering the Huffman residual stress effects ($\rho_c = 5.90E + 15 \text{ m/m}^3$).....	194
Figure 6.12 - Fatigue propagation behaviour of Al 6061-T651 – Experimental data vs. Strain energy density model considering the Huffman residual stress effects ($\rho_c = 6.088E + 15 \text{ m/m}^3$).....	195

LIST OF TABLES

Table 3.1 - Equipment used in this research.	61
Table 3.2 - Chemical composition provided by the seller (mass fraction,%) of Al 1100.	62
Table 3.3 - Mechanical properties of Al 1100 provided by the seller.	62
Table 3.4 - Specimen nominal parameters in [mm].	63
Table 3.5 - Material constants calculated fitting experimental data.	67
Table 3.6 - Chemical composition of the aluminium alloys detected by the EDS technique.....	69
Table 3.7 - Vickers hardness of the aluminium alloys.	71
Table 3.8 - Specimen geometry for the considered 1100 aluminium alloy.	72
Table 3.9 - Al 1050 properties from tensile test for the longitudinal direction specimen.....	74
Table 3.10 - Al 1050 properties from tensile test for the transversal direction specimens.	74
Table 3.11 - Mean, standard deviation and COV properties obtained using the longitudinal, transversal, and all direction specimens.....	74
Table 3.12 – Compact Tension specimen nominal parameters in millimeters.	75
Table 3.13 – Number of tested specimens for each stress ratios for each alloy.....	76
Table 3.14 - Crack growth constants obtained for both materials under consideration.	83
Table 4.1 - Mechanical properties and cyclic elastoplastic parameters of the aluminium alloys under consideration ^{26,47,48}	93
Table 4.2 - Low-cycle fatigue data of Al 1050 ⁴⁷ (* run-outs).	94
Table 4.3 - Low-cycle fatigue data of AA 6061-T651 ^{26,48}	94
Table 4.4 - Low-cycle fatigue data of AlMgSi0.8 ⁴⁷	94
Table 4.5 - Strain-life parameters of the aluminium alloys under consideration ^{26,47,48}	95
Table 4.6 - Strain-life parameters based on the Huffman model for various metal alloys under consideration.....	99
Table 4.7 - Dislocation density evaluated for each failed LCF specimen for the Al 1050	102
Table 4.8 - Dislocation density evaluated for each failed LCF specimen for the AA 6061-T651.....	102

Table 4.9 - Dislocation density evaluated for each failed LCF specimen for the AlMgSi 0.8.	103
Table 4.10 - Monte Carlo stochastic prediction of $\sigma f'$ and $\varepsilon f'$ for the materials under consideration.	113
Table 4.11 - Statistical parameters of the distribution functions under consideration for the strain-life parameters, $\sigma f'$ and $\varepsilon f'$, of Al 1050.	117
Table 4.12 - Statistical parameters of the distribution functions under consideration for the strain-life parameters, $\sigma f'$ and $\varepsilon f'$, of AA 6061-T651.	117
Table 4.13 - Goodness-of-fit statistical tests evaluated for several probabilistic density functions for Al 1050.	117
Table 4.14 - Goodness-of-fit statistical tests evaluated for several probabilistic density functions for Al 6061.	118
Table 4.15 - Predicted number of cycles calculated by Huffman model to estimating the strain-life parameters for the materials under consideration.	120
Table 4.16 - Predicted number of cycles calculated by modified Huffman model (with $\mu\rho$) to estimating the strain-life parameters for the materials under consideration. .	121
Table 4.17 - Predicted number of cycles calculated by Huffman model and the Monte Carlo stochastic modelling (mean values) to estimating the strain-life parameters for the materials under consideration.	122
Table 5.1 - Fatigue crack growth models.	135
Table 5.2 - Crack closure/opening models.	141
Table 5.3 - Mechanical properties, cyclic elastoplastic and strain-life parameters of the 6061-T651 aluminum alloy ^{31,34}	145
Table 5.4 - Material constants concerning the Paris law of the 6061-T651 aluminum alloy.	146
Table 5.5 - Experimental results of R versus U for the 1 st cycle and stabilised measurements ³³	148
Table 5.6 - Material constants concerning the Paris law of the 6061-T651 aluminum alloy.	151
Table 5.7 - Variables and non-dimensional constants of Newman's model.	151
Table 5.8 - Variables and non-dimensional constants of Savaidis's model.	152
Table 5.9 - Variables and non-dimensional constants of Codrington-Kotousov's model.	152
Table 5.10 - Variables of Correia's model.	152

Table 5.11 - Quantitative parameter, U , evaluated for each model under consideration and the deterministic curve, $Ud, 1$.	159
Table 5.12 - Quantitative parameter, U , evaluated for each model under consideration and the deterministic curve, Ud, s .	160
Table 5.13 - Experimental results of R versus $Reff$ for the 1 st cycle and stabilised measurements ³³ .	161
Table 5.14 - Effective stress ratio, $Reff$, evaluated for each model under consideration and the deterministic value, $Reff, 1$.	166
Table 5.15 - Effective stress ratio, $Reff$, evaluated for each model under consideration and the deterministic value, $Reff, s$.	167
Table 6.1 - Mechanical properties and cyclic elastoplastic parameters ^{16,30} .	179
Table 6.2 - Strain-life parameters of the AA 6061-T651 under consideration ^{16,30} .	179
Table 6.3 - Fatigue crack growth constants - Strain energy density model considering the Neuber rule-based residual stress effects.	190
Table 6.4 - Fatigue crack growth constants - Strain energy density model considering the Huffman residual stress effects.	194

NOMENCLATURE

LATIN

a	Crack length
a^*	Normalized crack length
a_1, a_i	Initial crack size, crack size increment
a_n	Distance of load-line to notch tip
a_0	Notch size
Δa	Calibration parameter
Δa_i	Crack range increment
A	Elongation at fracture, Codrington-Kotousov model parameter
A_0, A_1, A_2, A_3	Newman's or Savaidis model parameters
b	Fatigue strength exponent
$\vec{b}$	Burger's vector
B	Thickness, Codrington-Kotousov model parameter
c	Fatigue ductility exponent
$C, C_1, C_2, C_C,$ $C_{el}, C_{pl}, C_F, C_{HS},$ C_{MOD}, C_P, C_W	Material constant; parameter related to endurance limit in probabilistic fatigue model, Codrington-Kotousov model parameter
COV	Coefficient of variation
d	Distance of load-line from edge of the plate
D	Huffman fatigue damage parameter
$\frac{da}{dN}, \frac{da^*}{dN^*}$	Fatigue crack growth rate
e	Eccentricity of load-line, error
$\bar{e}$	Mean error
E	Modulus of elasticity or Young's modulus
E_{steel}	Elastic modulus of steel
$f, f()$	Function of the stress intensity factor range; frequency; yield function
$F(), F^{-1}()$	Cumulative distribution function
f_y	Higher yield strength
f_u	Ultimate tensile strength
F_T	Geometric factor for tension
F_B	Geometric factor for bending
F_{max}	Maximum force
F_{min}	Minimum force
ΔF	Force range
H	Distance between the points of load application
K	Stress intensity factor; Applied stress intensity factor; Strain hardening coefficient; Material constant

K_0	Stress intensity factor for $R = 0$.
K_L	Limiting K_{max} value for detectable closure
K'	Cyclic strength coefficient
K_C, K_{IC}	Fracture toughness
K_{mat}	Material toughness measured by stress intensity factor
K_{max}	Maximum stress intensity factor
$K_{max,applied}$	Applied maximum stress intensity factor
$K_{max,tot}$	Total maximum stress intensity factor
K_{min}	Minimum stress intensity factor
K_{op}	Opening Stress intensity factor
$K_r, K_{residual}$	Residual stress concentration factor
ΔK	Stress intensity factor range
$\overline{\Delta K}$	Walker equivalent stress intensity range
ΔK_I	Stress intensity factor range in mode I
$\Delta K_{I,Tension}$	Tension component of stress intensity factor range in mode I
$\Delta K_{I,Bending}$	Bending component of stress intensity factor range in mode I
$\Delta K_{app}, \Delta K_{applied}$	Applied stress intensity factor range
ΔK_{cl}	Stress intensity factor range at closing
ΔK_{eff}	Effective stress intensity factor range
$\Delta K_{eff,0}$	Effective stress intensity factor range for $R = 0$
$\Delta K_{eff,max}$	Maximum Effective stress intensity factor range
$\Delta K_{eff,min}$	Minimum effective stress intensity factor range
ΔK_{op}	Stress intensity factor range at opening
ΔK_{tot}	Total stress concentration factor range
$\Delta K_{th,eff}$	Effective threshold ΔK_{eff}
$\Delta K_{up,eff}$	Effective limiting ΔK_{eff}
ΔK_{eff}^*	Normalized ΔK_{eff}
$\Delta K_{th,eff}^*$	Normalized $\Delta K_{th,eff}$
$\Delta K_{up,eff}^*$	Normalized $\Delta K_{up,eff}$
ΔK_{th}	Threshold of stress intensity factor range
$\Delta K_{th,0}$	Threshold of stress intensity factor range for $R = 0$
$\Delta K_{th,steel}$	Threshold of stress intensity factor range of steel
ΔK_{up}	Ultimate stress intensity factor range
ΔK^*	Normalized ΔK
ΔK^{*+}	Normalizing variable of ΔK
ΔK_{th}^*	Normalized ΔK_{th}
ΔK_{up}^*	Normalized ΔK_{up}
J_{mat}	Material toughness measured by J-methods
ΔJ	Strain energy release density
ΔJ_{up}	Ultimate value of J-integral range
ΔJ_{th}	Threshold value of the cyclic J-integral

ΔJ^{*+}	Normalizing variable of ΔJ
ΔJ_{th}^*	Normalized ΔJ_{th}
ΔJ_{up}^*	Normalized ΔJ_{up}
L, L_1, L_2	Characteristic length
L_{0p}	Length at fracture
$m, m_1, m_2, m_C,$ $m_{el}, m_{pl}, m_F, m_{HS},$ m_{MOD}, m_P, m_W	Material constant
n	Strain hardening exponent, number of specimens
n'	Cyclic strain-hardening exponent
N	Number of cycles (fatigue life)
N^*	Normalized number of cycles
N_0	Reference number of cycles; Threshold value of lifetime
N_E	Experimental number of cycles
N_f	Number of cycles to failure
N_i	Number of cycles in crack initiation; Number of cycles of the specimen i
N_P	Predicted number of cycles
$2N_f$	Reversals to failure
$2N_{f,i}$	Reversals to failure of the specimen i
p	Material constant; Probabilistic to failure
$P1, P2 \dots P5$	Transversal direction specimen identification
P_{max}	Maximum force
P_{min}	Minimum force
ΔP	Eccentric applied force range
r	Crack tip polar coordinate, radius
R, R_σ	Stress ratio, radius
R_{eff}	Effective stress R-ratio
$R_{eff,1}$	Deterministic effective stress R-ratio for first cycle measurement
$R_{eff,s}$	Deterministic effective stress R-ratio for stabilized measurement
R_ϵ	Strain ratio
$R_{p,0.2}$	Monotonic 0.2% proof stress
R_m	Ultimate tensile stress
R^2	Determination coefficient
S_{max}	Maximum stress
$S_{op,phen}$	Opening stress
T	Thickness
SWT	Smith, Watson and Topper fatigue damage parameter
U, U_{SIF}	Quantitative closure parameter; Effective stress intensity ratio
U_1	Quantitative closure parameter for the first cycle

U_d	Dislocation strain energy
$U_{d,1}$	Deterministic quantitative closure parameter for the first cycle measurement
$U_{d,s}$	Deterministic quantitative closure parameter for the stabilised measurement
U_e	Tensile elastic strain energy density
U_i	Quantitative closure parameter related to crack increment i
U_s	Quantitative closure parameter for stabilised measurement
U_{th}	Quantitative closure parameter for the first crack length
U_{up}	Quantitative closure parameter for the last crack length
U_p^*	Complimentary plastic strain energy density
W	Characteristic length, width
$W1, W2 \dots W5$	Longitudinal direction specimen identification
x	Distance from the crack tip, calibration parameter
$\bar{x}$	Mean value
X	Cartesian component
Y	Cartesian component, function depending on geometric and loading conditions
Z	Reduction in cross-section at failure

GREEK

α	Material constant; scale parameter of 2-parameter Weibull and Logistic distribution; relation of crack length and specimen width
β	Shape parameter of the 2-parameter Weibull and Logistic distribution
$\gamma, \gamma_{th}, \gamma_w$	Curve fitting parameter; Fatigue crack growth equation exponent, parameter of the statistical Gumbel distribution
δ	Scale parameter of Weibull model; Elementary material blocks of length
δ^*	Elementary material blocks of length in the process zone
ε	Strain
ε_a	Amplitude Strain; Principal in-plane strain (axial direction)
ε'_f	Fatigue ductility coefficient
ε_w	Walker strain
$\Delta\varepsilon$	Strain range
$\Delta\varepsilon^E$	Elastic strain range
$\Delta\varepsilon^P$	Plastic strain range
η	Material property, Codrington-Kotousov non-dimensional parameter
ν	Poisson ratio
ρ	Dislocation density
ρ^*	Notch tip radius; Elementary material block size

ρ_c	Critical blunt tip radius, critical dislocation density
ρ_i	Dislocation density for each tested specimen
ρ_m	Mean dislocation density of available experimental fatigue results
σ	Stress, standard deviation of Normal distribution
σ_0	Cyclic yield stress; Stress fatigue limit
σ_a	Stress amplitude
$\sigma_{a,i}$	Stress amplitude obtained during low-cycle fatigue tests for the specimen i
σ_f, σ_o	Flow stress
σ'_f	Fatigue strength coefficient
σ_M, σ_{max}	Maximum stress
$\sigma_{max,i}$	Maximum stress amplitude obtained during low-cycle fatigue tests for the specimen i
σ_M^*	Normalized maximum stress
σ_m, σ_{min}	Minimum stress, mean stress
σ_m^*	Normalized minimum stress
σ_{med}	Mean stress
σ_{op}	Opening stress
σ_x	Elastic stress along the x direction
σ_{xx}, σ_{yy}	Analytical elastoplastic stress distributions
σ_y	Yield stress; Elastic stress along the y direction
$\sigma_r, \sigma_{residual}$	Residual stress
$\Delta\sigma$	Stress range
$\Delta\sigma^*$	Normalized stress range
$\Delta\sigma_0$	Endurance fatigue limit
$\Delta\sigma_T$	Tensile stress range
$\Delta\sigma_B$	Bending stress range
$\sigma_{\varepsilon_p=0.05}$	Stress at 0.05 plastic strain
$\sigma_{\varepsilon_p=0.001}$	Stress at 0.001 plastic strain
$\Delta\kappa$	Fatigue crack growth driving force
μ	Mean value of Normal distribution

ACRONYMS

AA	Aluminum association
ASME	American Society of Mechanical Engineers
ASTM	American Society for Testing and Materials
BS	British standards
CAPES	Coordenação de Aperfeiçoamento de Pessoal de Nível Superior

CCS	Castillo-Canteli-Siegele model
COV	Coefficient of variation
CT	Compact tension specimen
CTOD	Crack tip opening displacement
DIC	Digital image correlation
DNVGL	Det Norske Veritas (Norway) and Germanischer Lloyd (Germany)
EC3	Eurocode 3: Design of steel structures
EDM	Electrical discharge machining
ESE(T)	Single-edge cracked geometry
FCG	Fatigue crack growth
FEA	Finite element analysis
FEUP	Faculdade de Engenharia da Universidade do Porto
IFSP	Instituto Federal de São Paulo
iLAPS	Improved LAPS
LAPS	Long and physically short crack model
LCF	Low cycle fatigue
LEFM	Linear elastic fracture mechanics
MC, M.C.	Monte Carlo
NASA/FLAGRO	NASGRO computer program for fracture control analysis
SENB	Single-edge notched bending specimen
STP	Special technical publication (ASTM)
SWT	Smith-Watson-Topper (damage parameter)
TEM	Transmission electron microscopy
UNESP	Universidade Estadual Paulista “Júlio de Mesquita Filho”

CONTENTS

1	INTRODUCTION	30
1.1	MOTIVATION	30
1.2	OBJECTIVES	30
1.3	ORGANIZATION OF THESIS	31
1.4	RESEARCH CONTRIBUTIONS	33
	REFERENCES	34
2	REVIEW ON FATIGUE CRACK GROWTH MODELLING.....	36
2.1	INTRODUCTION	36
2.2	FATIGUE CRACK GROWTH LAWS.....	36
2.3	FATIGUE CRACK GROWTH LAWS INCLUDING CRACK CLOSURE EFFECTS	42
2.4	FATIGUE CRACK PROPAGATION MODELLING BASED ON LOCAL DAMAGE CRITERIA	47
	REFERENCES	55
3	AN EXPERIMENTAL PROGRAM TO CHARACTERIZE THE FATIGUE CRACK GROWTH OF 1100 ALUMINIUM ALLOY	59
3.1	INTRODUCTION	59
3.2	WORKBENCH PROPOSAL	59
3.2.1	Suggested workbench and required equipment.....	59
3.2.2	Specimen material and geometry	61
3.2.3	Test conditions and procedures - suggested methodology	63
3.2.4	Analytical solutions – stress intensity factor calculation	64
3.3	RESULTS AND DISCUSSION.....	66
3.3.1	Workbench results	66
3.3.2	Standardized experimental program to characterize commercially pure aluminium alloys.....	68
3.3.2.1	Chemical composition	68
3.3.2.2	Hardness measurements	69
3.3.2.3	Tensile test.....	71
3.3.2.4	Fatigue crack growth tests	75
3.3.2.4.1	<i>Aluminium 1050.....</i>	76

3.3.2.4.2	<i>Aluminium 1100</i>	79
3.3.2.4.3	<i>Comparison of suggested workbench and standard fatigue crack growth results and thickness effect</i>	81
3.3.2.5	Microstructure Analysis	83
3.4	CONCLUSION.....	86
	REFERENCES	87
4	LOW-CYCLE FATIGUE MODELLING SUPPORTED BY STRAIN ENERGY DENSITY-BASED HUFFMAN MODEL CONSIDERING THE VARIABILITY OF DISLOCATION DENSITY	89
4.1	INTRODUCTION	89
4.2	EXPERIMENTAL FATIGUE DATA OF VARIOUS ALUMINIUM ALLOYS ..	92
4.2.1	Cyclic elastoplastic behaviour	92
4.2.2	Strain-life behaviour.....	93
4.3	LOW-CYCLE FATIGUE MODELLING: APPLICATION AND DISCUSSION	96
4.3.1	Strain energy density-based Huffman model	97
4.3.2	Strain energy density-based Huffman model considering the ρ mean value	101
4.3.3	Monte Carlo stochastic prediction	104
4.3.4	Comparison and discussion	119
4.4	CONCLUSIONS	124
	REFERENCES	126
5	APPLICATION AND DISCUSSION OF VARIOUS CRACK CLOSURE MODELS TO PREDICT FATIGUE CRACK GROWTH IN 6061-T651 ALUMINIUM ALLOY	131
5.1	INTRODUCTION	131
5.1.1	Fatigue crack growth models	132
5.1.2	Fatigue crack closure models	136
5.2	EXPERIMENTAL FATIGUE DATA OF AA 6061-T651	143
5.2.1	Cyclic elastoplastic behaviour	143
5.2.2	Fatigue crack growth behaviour	145
5.3	APPLICATION AND DISCUSSION	147

5.3.1	dadN vs. ΔK_{eff} curves based on various crack closure models.....	147
5.3.2	A comparison between all dadN vs. ΔK_{eff} curves	156
5.3.3	Reff versus R: experimental results and analytical models	161
5.4	CONCLUDING REMARKS	168
	REFERENCES	169
6	FATIGUE CRACK GROWTH MODELLING SUPPORTED BY STRAIN ENERGY DENSITY-BASED HUFFMAN MODEL CONSIDERING THE RESIDUAL STRESS EFFECTS.....	176
6.1	INTRODUCTION	176
6.2	EXPERIMENTAL LCF AND FCG DATA	178
6.2.1	Cyclic elastoplastic data	178
6.2.2	Strain-life data.....	179
6.2.3	Fatigue crack growth data	180
6.3	FATIGUE CRACK GROWTH MODELLING: APPLICATION AND DISCUSSION	181
6.3.1	Stresses and strains near the crack tip.....	185
6.3.2	Strain energy density model considering the Neuber rule-based residual stress effects.....	189
6.3.3	Strain energy density model considering the Huffman residual stress effects.....	192
6.4	CONCLUSIONS	195
	REFERENCES	197
7	CONCLUSIONS	202
7.1	CONCLUDING REMARKS	202
7.2	FUTURE WORKS.....	206
	REFERENCES	207
	APPENDIX	210

CHAPTER I

1 INTRODUCTION

1.1 MOTIVATION

Fatigue is the main cause of mechanical failures and fractures in mechanical components when subjected to load fluctuations¹⁻³. Its studies had begun in the early nineteenth century and today it is still much addressed by the scientific and technical community. Despite the many advances, the infinity of proposed models, and its huge application in design codes⁴⁻⁶, fatigue modeling is always linked to experimental results due to the high complexity of the phenomenon. In view of the recent evolution of experimental techniques⁷⁻⁹, what is seen most in fatigue is the development of models that depend less and less on experimental data, either because of the scarcity of data, high occupancy of available equipment, or its high testing cost.

In this context, this research started with the development of a low-cost workbench (methodology) combining an experimental-analytical analysis to characterize the fatigue crack growth behaviour for the ESE(T) specimens of small thickness. A comparison between the crack growth constants (e.g. slope m) obtained in the low-cost workbench combining an experimental-analytical analysis and application of the ASTM E647 standard is done. A low-cycle fatigue modelling supported by the Huffman approach based on strain energy density considering the variability of the density of dislocations was suggested. In addition, the crack closure effects on fatigue crack propagation behaviour is also studied and discussed. Finally, the modelling of the fatigue crack growth behaviour based on the strain energy density approach suggested by Huffman¹⁰, taking into account residual stress effects, is presented. In this investigation, experimental data on low cycle fatigue and fatigue crack propagation of 1050/1100¹¹, 6061-T651^{12,13}, and AlMgSi0.8¹¹ aluminium alloys were used.

1.2 OBJECTIVES

The general objective of this research project thesis is to investigate and discuss the modelling of the fatigue crack initiation and propagation behaviour in metals and alloys. To achieve this goal the main objectives are the following:

- To create a simple low-cost useful workbench, to establish a measurement setup for studying the fatigue crack propagation; To use the conventional machines to describe the fatigue crack propagation, the tensile test, hardness and microstructure of the selected material; and finally, to discuss and compare the results obtained in the workbench and conventional system.
- To investigate and discuss the low-cycle fatigue modelling based on the Huffman approach using the strain energy by suggesting different approaches for the dislocation density parameter. To apply Monte Carlo stochastic simulations for obtaining the strain-life parameters, fatigue strength and ductility coefficients, and to generate probabilistic fields for the low-cycle fatigue behaviour of metals. To analyse the various suggested methodologies using available experimental data from the literature, and compare them with each other.
- To compare and discuss the effects of various crack closure/opening models on the fatigue crack growth behaviour of 6061-T651 aluminium alloy and additionally to compare the models to experimental results of crack closure available in the literature.
- To model the fatigue crack growth behaviour for the 6061-T651 aluminium alloy through the Huffman fatigue crack growth approach based on the strain energy density from dislocations considering the residual stress effects, where a comparison with the fatigue crack growth data is done.

1.3 ORGANIZATION OF THESIS

This thesis is organized by: an introduction (Chapter I); a review on fatigue crack growth modelling (Chapter II); an experimental program to characterize the fatigue crack growth of 1100 aluminium alloy (Chapter III); a low-cycle fatigue modelling supported by strain energy density-based Huffman model considering the variability of dislocation density to (Chapter IV); an application and discussion of various crack closure models to predict fatigue crack growth in 6061-T651 aluminium alloy (Chapter V); a fatigue crack growth modelling supported by strain energy density-based Huffman model considering the residual stress effects (Chapter VI); and, finally, the main conclusions and future works (Chapter VII).

The thesis begins with an Introduction (Chapter I), presenting the motivation, the objectives, thesis organization and research contribution. The scope of the

introductory part of this thesis is to describe and integrate each piece of this project and give the reader a broad view of the organization of this research.

Then, in Chapter II, a review on fatigue crack growth modelling is presented, where the following topics were addressed – fatigue crack growth laws, fatigue crack growth laws including crack closure effects and fatigue crack propagation based on local damage criteria.

Next, Chapter III is presented, whose title is **an experimental program to characterize the fatigue crack growth of 1100 aluminium alloy**, containing a useful low-cost workbench to describe fatigue crack propagation of very thin aluminium alloy specimens using digital image correlation. The chemical composition, hardness measurements, tensile strength, fatigue crack propagation, and microscopy analysis for Al1100 and Al1050 are also assessed. Furthermore, a comparison between the crack growth constants obtained in the low-cost workbench combining an experimental-analytical analysis and application of the ASTM E647 standard, considering the thickness effects, was also done.

In Chapter IV, entitled **Low-cycle fatigue modelling supported by strain energy density-based Huffman model considering the variability of dislocation density**, it is suggested various methodologies to evaluating low-cycle fatigue strength based on Huffman approach and exploring different dislocation density parameters: the critical dislocation density, the mean value of dislocation density of available experimental fatigue data, and a Monte Carlo stochastic prediction considering the variability of dislocation density and the cyclic strain hardening coefficient. Monte Carlo stochastic simulations are also used to obtain the strain-life parameters, fatigue strength and ductility coefficient, and to generate probabilistic fields for the low-cycle fatigue behaviour. Experimental fatigue data of aluminium alloys were used to apply and compare the suggested methodologies.

Chapter V, proposes **an application and discussion of various crack closure models to predict fatigue crack growth in 6061-T651 aluminium alloy**. At first, a review of fatigue crack growth laws considering the regions of applicability, and laws including crack closure effects is presented. Then, a comparison of the effect of various crack closure/opening models on the fatigue crack growth behaviour is done. Experimental data obtained from literature is compared with these models using deterministic quadratic relation. It was possible to observe that few models presented

good fit to experimental crack closure results for the first or stabilised cycles, and many models are inappropriate to do the same.

In Chapter VI, the **modelling of the fatigue crack growth behaviour for the 6061-T651 aluminium alloy through the Huffman fatigue crack growth approach based on the strain energy density** from dislocations considering the residual stress effects was suggested. The Huffman fatigue crack growth modelling is based on the cyclic stress-strain behaviour of the material as well as the local elastoplastic stresses and strains obtained for a distance ahead of the crack tip (x), where those stresses are related to the fatigue damage of a crack increment Δa , as calibrator parameter. The calculations of the elastoplastic stresses and strains are done using Neuber's or Glinka's approach. Two approaches supported by the Noroozi and Huffman's suggestions to consider the residual stress effects were studied and discussed. Besides, in the modelling of the fatigue crack growth behaviour, the influence of the strain energy density calculated for values of critical dislocation density driven by the highest strain amplitude specimen and the mean value of the dislocation density for the available experimental fatigue results was also considered in this investigation.

And finally, in Chapter VII, the main conclusions and future works are presented. It starts with a summary of the main results obtained in each section, and then, it lists the contributions that were made and future steps for the continuity of this research.

1.4 RESEARCH CONTRIBUTIONS

The research contributions presented in this research project thesis are the following:

- A low-cost useful workbench to characterize the fatigue crack propagation in thin specimens;
- Fatigue crack propagation behaviour, mechanical properties, microstructure of commercially pure aluminium were evaluated;
- A comparison of the effect of various crack closure/opening models on the fatigue crack growth behaviour of 6061-T651 aluminium alloy was presented.
- Various fatigue crack closure/opening models were explored.

- Deterministic quadratic relations between U vs. R and R_{eff} vs. R , for the 6061-T651 aluminium alloy, were suggested.
- Low-cycle fatigue behaviour based on the Huffman approach, 1050, 6061-T651 and AlMgSi0.8 aluminium alloys, was studied and discussed.
- Variability of dislocation density on the low-cycle fatigue behaviour was introduced.
- A Monte Carlo stochastic procedure for probabilistic low-cycle fatigue modelling was suggested.
- A comparison between the experimental fatigue data and strain-life curves, 1050, 6061-T651 and AlMgSi0.8 aluminium alloys, is done.
- Fatigue crack growth modelling based on the Huffman FCG approach based on strain energy density and residual stress effects, for the fatigue data of the 6061-T651 aluminium alloy, was done.
- Strain energy density for values of critical dislocation density driven by the highest strain amplitude specimen and the mean value of the dislocation density for the available experimental fatigue results was discussed.
- Residual stress effects based on Noroozi and Huffman's suggestions were studied.

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CHAPTER VII

7 CONCLUSIONS

7.1 CONCLUDING REMARKS

This thesis was dedicated to contributing to: - development of a low-cost workbench (methodology) combining an experimental-analytical analysis to characterize the fatigue crack growth behaviour for the ESE(T) specimens of small thickness (0.3mm) made of 1100 aluminium alloy and constant amplitude tests up to 100N. A comparison between the crack growth constants obtained in the low-cost workbench combining an experimental-analytical analysis and application of the ASTM E647 standard was done.; low-cycle fatigue modelling supported by strain energy density-based Huffman model considering the variability of dislocation density applied to the experimental fatigue data of 1050, 6061-T651, and AlMgSi0.8 aluminium alloys; - application and discussion of various crack closure models to predict fatigue crack growth in 6061-T651 aluminium alloy; and, - fatigue crack growth modelling supported by strain energy density-based Huffman model considering the residual stress effects for the 6061-T651 aluminium alloy.

An experimental programme to characterize the fatigue crack growth of 1100 aluminium alloy

Understanding the current political and scientific scenario in which future researchers are inserted in and knowing the difficulty in obtaining financial support, studies involving less-time-consuming experiments and low-cost workbenches are always welcome. Therefore, this investigation also aims to assess FCG data from the proposed workbench combining an experimental-analytical analysis for the 1100 aluminium alloy specimens, where results seem to be promising for fatigue crack propagation from the stable crack growth (Paris region II). However, in the actual configuration, it is limited to very thin specimens and for non-structural metals. Additionally, the chemical composition, hardness measurements, tensile strength, fatigue crack propagation, and microscopy analysis for Al1100 and Al1050, were also assessed. The results obtained are in line with those recommended for the materials under study. A comparison between the crack growth constants obtained in the low-cost workbench combining an experimental-analytical analysis and application of the

ASTM E647 standard, considering the thickness effects, was done. The results obtained for both approaches, although for different thicknesses (0.3mm and 3mm, respectively, low-cost workbench and ASTM E647 standard), showed consistent and aligned values for the Paris law constants.

Low-cycle fatigue modelling supported by strain energy density-based Huffman model considering the variability of dislocation density

The main conclusions on the low-cycle fatigue modelling supported by strain energy density-based Huffman model considering various addressed methodologies, applied to the experimental fatigue data of 1050, 6061-T651, and AlMgSi0.8 aluminium alloys¹ are given by

- The various methodologies studied were able to model the low-cycle fatigue behaviour based on the strain energy density approach and a good agreement between the experimental fatigue data and the modelled curve is found.
- The strain-life parameters, σ'_f and ε'_f , were estimated based on the Huffman model through the critical dislocation density (ρ_c), the mean value of the dislocation density (ρ_m), and the dislocation density (ρ) stochastically considered.
- Among the various methodologies used, the strain-life parameters, σ'_f and ε'_f , estimated by strain energy density-based Huffman approach through the mean value of dislocation density (ρ_m) and the dislocation density (ρ) stochastically considered lead to better results when the comparison is made with experimental fatigue data since according to the literature, the dislocation structure changes with the total strain amplitude.
- The output discrete distributions generated by Monte Carlo (MC) stochastic simulation for the strain-life parameters, σ'_f and ε'_f , shows that there is not a single probability distribution function suitable to describe each of these variables, for the metal materials under consideration.
- The Weibull and Logistic distribution functions showed the best fitting when compared with the output distributions obtained by stochastic prediction for the fatigue strength coefficient, σ'_f , and the fatigue ductility coefficient, ε'_f , respectively, for the 1050 aluminium. While, for the 6061-T651 aluminium alloy, the Normal and Weibull distributions exhibited the best fitting with the MC

simulation-based output distributions for the fatigue strength coefficient, σ'_f , and the fatigue ductility coefficient, ϵ'_f , respectively.

- The probabilistic strain-life curves generated through the Huffman approach using the Monte Carlo stochastic simulation to estimating the output distributions of the strain-life parameters σ'_f and ϵ'_f are presented. It can be concluded that the Monte Carlo stochastic prediction allowed the generation of a probabilistic strain-life field through the ρ random variable (ρ is the dislocation density), where the experimental fatigue data are between the 5% and 95% failure probability curves.

Application and discussion of various crack closure models to predict fatigue crack growth in 6061-T651 aluminium alloy

The main conclusions on a comparative study of the fatigue crack propagation rates (da/dN) versus effective stress factor range (ΔK_{eff}) data, in 6061-T651 aluminium alloy, calculated through the various crack closure models under consideration can be summarized as follows²:

- The deterministic values of the quantitative parameter, U , and the effective stress ratio, R_{eff} , based on the first cycle and stabilised measurements were obtained. Also, the values of U and R_{eff} were calculated for each crack closure model under consideration.
- Correia's model³ presents good results for U and R_{eff} when compared to the deterministic data based on stabilised measurements, where the mean values of the error index module are of 2.46% and 6.73%, respectively. Newman's model also shows good results in terms of U and R_{eff} , presenting error index modules of 6.64% and 21.93%, respectively, when the comparison is made with deterministic data based on stabilised measurements. When the same comparison is made with the deterministic values based on the 1st cycle measurements, the Newman's⁴, Codrington-Kotousov's⁵ and Katcher and Kaplan's⁶ models present a good agreement, where the mean values of the error index module of 7.34%, 5.41% and 6.30%, and 12.19%, 8.27% and 9.97%, respectively. The other models also studied based on the 1st cycle and stabilised measurements have mean values of the error index module, $\bar{e}$, greater than 20%, and are not considered adequate to describe the crack closure effects.

- The assumptions suggested in the Hudak and Davidson's⁷ investigations and later also recommended by Ellyin⁸ were confirmed by the use of the Correia's model³, where the crack closure quantitative parameter is a function of applied stress R-ratio, maximum stress intensity factor (or ΔK), and driven by threshold stress intensity factor range, ΔK_{th} . Also, Correia's crack closure model based on experimental data suggest the limit stress intensity factor (K_L) in estimating the quantitative parameter (U) to describe the crack closure effects. In this study, the quantitative parameter (U) was estimated by using the maximum stress intensity factor (K_{max}) for stabilised cycles.

Fatigue crack growth modelling supported by strain energy density-based Huffman model considering the residual stress effects

The main conclusions on the fatigue crack growth modelling for the 6061-T651 aluminium alloy supported by the strain energy density-based Huffman approach considering the residual stress effects ahead of the crack tip are the following⁹:

- An elastoplastic stress/strain analytical analysis at the crack tip region based on the multiaxial Neuber¹⁰ and Glinka's¹¹ rules was assumed, where the both approaches revealed similar elastoplastic stress distributions.
- A comparison on the elastoplastic stress distributions between the numerical results from the finite element modelling of the CT specimen and the analytical results based on Neuber and Glinka's rules was done. A good agreement for the maximum elastoplastic stresses was found.
- The comparison on the residual stress distributions between numerical and analytical solutions showed deviations that increase for a stress ratio equal 0.5, revealing that the analytical solutions overestimate the residual stresses.
- For values of critical dislocation density of $5.90\text{E}+15$ and $6.088\text{E}+15 \text{ m}^{-2}$, both modelling analyses of the fatigue crack propagation behaviour based on the strain energy density approach, considering the residual stress effects estimated by Noroozi et al.²³⁻²⁵ or Huffman suggestions^{10,12}, exhibited very similar results.
- The critical dislocation density, driven by the highest strain amplitude specimen or by mean value of the dislocation density for the available experimental fatigue results, does not influence significantly the fatigue crack propagation behaviour modelled by the strain energy density approach.

- For both procedures to consider the residual stress effects, Noroozi and Huffman suggestions, the fatigue crack growth constants obtained from the modelling based on the strain energy density approach are very similar with the exception of the Δa calibration parameter. It is concluded that the procedure for considering the residual stress effects influences the Δa calibrator. Therefore, it is not possible to conclude which is the most recommended method to describe the residual stress effects, since there is no measured data to support such analysis.
- The used approach allows to model the fatigue crack propagation behaviour for the near-threshold and Paris regions.

7.2 FUTURE WORKS

This study tries to cover the most relevant aspects of fatigue crack initiation and propagation modelling based on the strain energy density of aluminium alloys, as well as to discuss the residual stress effects ahead of the crack tip, i.e.; the concept of virtual crack closure effects, where various issues and challenges still need to be investigated in next steps. Future works can be considered as the following:

An experimental programme to characterize the fatigue crack growth of 1100 aluminium alloy

The low-cost workbench approach combining an experimental-analytical analysis to characterize the fatigue crack growth behaviour needs to be able to perform tests in accordance with ASTM E647 standard, test thicker specimens, measure the crack closure, and implement an automatic measurement system of fatigue crack propagation rates, applied stress intensity factor ranges, and virtual crack closure effects.

Low-cycle fatigue modelling supported by strain energy density-based Huffman model considering the variability of dislocation density

A comparison between the dislocation densities obtained based on the strain energy density approach and experimental techniques, such as special metallographic procedures, X-ray diffraction, and transmission electron microscopy (TEM), must be performed. In addition, a study on the evolution of the dislocation density as a function of the level of strain amplitude and number of cycles to failure must be carried out. Adequate relationships between the dislocation density (ρ) and the cyclic stress-strain parameters, considering that this parameter may vary throughout the low-cycle fatigue

test for each strain amplitude, supported eventually by stochastic analysis, must be found. Further studies should be done on the use of approaches based on the strain energy density to model the fatigue crack initiation and propagation phases.

Application and discussion of various crack closure models to predict fatigue crack growth in 6061-T651 aluminium alloy

It can be stated that the simultaneous monitoring of CTOD-based experimental measurements of the crack closure effects and getting the crack tip stress–strain field based on digital image correlation (DIC) measurements, supported by analytical/numerical solutions, seems to be a good way to describe the fatigue crack growth correctly, as suggested by Ferreira-Castro-Meggiolaro^{13,14}. This analysis may be relevant to evaluate the residual stress effects and find a relationship with the concept of virtual crack closure, since the phenomena may be related.

Fatigue crack growth modelling supported by strain energy density-based Huffman model considering the residual stress effects

The residual stress effects need to be determined experimentally by digital image correlation, where the stresses and strains ahead of the crack tip for some crack sizes and different stress ratios can be estimated. This analysis will be used to understand what residual stress approaches (Noroozi¹⁵ or Huffman¹² suggestions) are more suitable to model the fatigue crack propagation behaviour. Therefore, the fatigue crack propagation calibration parameters (Δa , x) to be estimated by applying the approach based on the Huffman strain energy density may be seen to be representative of the metals under study. Another aspect to be explored is perhaps the probabilistic fatigue crack propagation modelling using the strain energy density approach through a stochastic analysis, where the parameters of the cyclic stress-strain curve, mainly the cyclic strain hardening coefficient (K'), are described by probability density functions.

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