Improved Consolidation of Silicon Carbide

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Presented at the  
10th Annual Conference on Composites and Advanced Ceramic Materials  
sponsored by the American Ceramic Society  
*Cocoa Beach, Florida, January 19–22, 1986*
IMPROVED CONSOLIDATION OF SILICON CARBIDE

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SUMMARY

Alpha silicon carbide powder was consolidated by both dry and wet methods. Dry pressing in a double acting steel die yielded sintered test bars with an average flexural strength of 235.6 MPa with a critical flaw size of approximately 100 μm. An aqueous slurry pressing technique produced sintered test bars with an average flexural strength of 440.8 MPa with a critical flaw size of approximately 25 μm. Image analysis revealed a reduction in both pore area and pore size distribution in the slurry pressed sintered test bars. The improvements in the slurry pressed material properties are discussed in terms of reduced agglomeration and improved particle packing during consolidation.

INTRODUCTION

Silicon carbide and silicon nitride are currently being evaluated as replacements for strategic metals in applications ranging from heat engines to industrial heat exchangers (refs. 1 to 3). Their primary drawback is the inability to control fracture generating flaws which lead to component failure (ref. 4). In most cases, the fracture originating flaws are introduced into the "green" compact prior to sintering (refs. 4 to 6). They are commonly agglomerates and metallic inclusions which arise from the starting powder or the subsequent processing steps.

From previous work, it was apparent that agglomerates, which are difficult to eliminate from dry-powder consolidation processes, were controlling the flexural strength of sintered SiC test specimens (refs. 7 and 8). The mechanical property dependence upon these flaws obscured the effect of such important variables as composition and sintering time and temperature on the sintered properties of SiC. Thus, there was a need to develop new consolidation techniques which would avoid or eliminate agglomeration. One such method is slurry pressing (refs. 9 and 10). Since a slurry is fluid, particle arrangement is greatly enhanced during pressing. This avoids residual stresses due to both contact with the die wall and bridging of particles during dry-powder pressing (ref. 11). Also, colloidal techniques may be used to both improve the dispersion of the powder (i.e., avoid van der Waals attractive forces) and control the flocculation of the powder during consolidation into a uniform, dense body.

It was the intention of this study to first demonstrate a difference between the baseline dry pressing process and the new slurry pressing process. Once a difference was shown, it was believed that further progress could be
made by using colloidal techniques to provide the best particle packing possible with the available starting powder.

EXPERIMENTAL PROCEDURE

The slurry pressing die is schematically shown in Figure 1. The die works on a push-pull principle to draw the liquid out of the slurry. The bottom part of the die allows the liquid to be pushed out through exhaust holes in the bottom plunger during pressing. Liquid is pulled out from the slurry through an exhaust hole in the top plunger which is attached to a vacuum pump. The other components of the die include: (1) filter paper to trap the powder, (2) porous stainless steel for uniform expulsion of liquid and forming, and (3) preformed bulk filter paper which swells during pressing to prevent leakage around the plunger.

Both viscometry and sedimentation were used to determine the best dispersion of the powder in water. Twenty grams of SiC were suspended in 200 ml of deionized, distilled water in a 1 liter polyethylene bottle with 400 g of 12 by 12 mm SiC cylinders as a mixing aid. Ten milliliters of the slurry was dispensed into each of enough 2.6 in. by 8.4 cm glass bottles to cover the pH range 2 to 14. The pH was adjusted with appropriate additions of acetic acid, ammonium hydroxide, and distilled water to bring the total volume to 15 ml. Each bottle was then stoppered and inverted end over end 10 times and subjected to 100 W of direct ultrasonic energy for 5 min. Viscosity measurements were made immediately after ultrasonic treatment of each slurry. Measurements were made on at least two separate slurries for each pH level. A separate series of slurries was given ultrasonic treatment, stopped and allowed to stand undisturbed. Sediment height and other characteristics were noted after 2 weeks.

The experimental design for this study is shown in Figure 2. The steps involved in preparing, sintering, and evaluating both dry pressed and slurry pressed specimens are shown. The SiC powder was a 50:50 mixture of two commercially available high purity α-silicon carbides. This mixture was chosen because initial slurry pressing data indicated that the type 1 powder did not sinter alone and the free carbon content of the type 2 powder was excessive. Amorphous boron and carbon resin were added as sintering aids to the powder. The chemical composition of the starting powders and the mixtures is shown in Table I.

The dry pressed specimens were prepared by combining 200 g of SiC powder and additives with 500 ml of ethanol in a 1 liter polyethylene bottle. Four hundred grams of 12 by 12 mm SiC cylinders were added as a mixing aid and

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1The Carborundum Company, Niagara Falls, NY.
2Braunsonic 1510 ultrasonic probe, B. Braun Instruments, South San Francisco, CA.
3Brookfield Model LVT viscometer, Brookfield Engineering Laboratories, Inc., Stoughton, MA.
4Type 1 and Type 2 α-SiC, Hermann C. Starck Co., Berlin.
599.5 percent amorphous boron, Cerac, Inc., Milwaukee, WI.
6Resin 22352, Durez Division, North Tonawanda, NY.
the bottle was rotated at 80 rpm for 72 hr. After mixing, the slurry was dried
on a hot plate at 150 to 200 °C. This procedure produced large, hard flakes
which were then dry milled for several hours to reduce their size. The milled
powder was sieved through a 100 mesh screen. Bars (approximately 3.8 by 0.8
by 0.45 cm) were dry pressed at 83 MPa in a double acting WC - lined die. The
bars were then sealed in latex tubing and hydrostatically pressed at 413 MPa.

Two groups of slurry pressed specimens were fabricated. The specimens of
the first group were prepared by mixing 200 g of S1C powder plus additives with
225 ml ethanol (approximately 22 volume percent solids) and 400 g of S1C media
in a polyethylene bottle for 72 hr. After mixing, the slurry was pressed into
"green" pucks (approximately 5.0 cm in diameter by 0.8 cm thick) using an
applied pressure of 14 MPa. The pucks were kept in a vacuum dessicator over
ethanol for 24 hr followed by drying in ambient air for 24 hr. The pucks were
vacuum sealed in plastic bags and hydrostatically pressed at 413 MPa. The
pucks were removed from the bags and dried at 100 °C in air for 12 hr. These
pucks and test specimens derived from them will hereafter be referred to as
ethanolic slurry pressed specimens.

The second group of slurry pressed specimens were prepared by mixing 200 g
of S1C plus additives with 225 ml solution of water/ammonium hydroxide (pH
11.2) and 400 g of cylindrical S1C media in a polyethylene bottle. The pH of
the slurry was adjusted to 11.0 with ammonium hydroxide. After mixing for 72
hr, the pH was readjusted to 11.0. The slurry was pressed into "green" pucks,
dried, and hydrostatically pressed in a manner similar to the first group.
These pucks and test specimens derived from them will hereafter be referred to
as aqueous slurry pressed specimens.

Both the dry pressed and slurry pressed specimens were randomized, loaded
in an induction furnace, and sintered at 2150 °C for 1.75 hr under an Argon
atmosphere. The heating rate was 50 °C/min. After sintering, the slurry
pressed pucks were machined into MOR test bars (approx 3.0 by 0.6 by 0.3 cm).
Both the dry pressed and slurry pressed bars were surface ground. The finish
surface grinding step required ten passes in the longitudinal direction using
400 grit diamond. All edges of the bar were beveled.

Characterization of the sintered parts included density; determined by
weighing and measuring the MOR bars, 1/4 point four point flexural strength
(0.95 cm inner span, 1.90 cm outer span), and identification of the fracture
origins. In addition, a cross section from two sintered test bars from each
of three fabrication processes was polished and etched in order to evaluate the
effect of the different fabrication processes on the microstructure. The
microstructure of each specimen was evaluated via optical microscopy and image
analysis. Grain size was measured by the line-intercept method. The image
analyzer was capable of determining features on the surface of the specimen
that were different from the matrix. It was also capable of being programmed
to scan about a fixed reference point so that the microstructure of more area
could be efficiently evaluated. Five random points were selected on each
specimen and at each of these points 25 areas were examined (5 across and 5
down). The total area evaluated on each specimen was >0.015 m².

Quantimet 900, Cambridge Instruments Inc., Monsey, NJ.
RESULTS

The results of the viscometry and sedimentation are combined in figure 3. The viscosity versus pH curve shows two areas of low viscosity at pH 2 and 11. This indicates that two regions of maximum dispersion exist. The sediment height versus pH curve has a minimum at pH 11 to 12. The large sediment volume indicates that large floccs formed in the region of pH 2 to 8.5. When the particles repel one another and disperse, the packing arrangement becomes more ideal as they settle. Such a situation is illustrated in the pH range 9 to 13. The two curves indicate that the better operating pH would be approximately 11.0.

The "green" densities of the dry pressed, ethanolic slurry pressed, and aqueous slurry pressed specimens were 2.05, 2.06, and 2.10 g/cm³, respectively. The sintered densities for the same specimens were 2.93, 2.91 and 3.16 g/cm³, respectively. No significant difference in density was observed between the dry pressed and ethanolic slurry pressed bars. However, bars fabricated by aqueous slurry pressing showed a significant increase in both "green" and sintered density over bars produced by both the dry pressing and ethanolic slurry pressing.

A comparison of the flexural strengths for each forming method is shown in table II. The results indicate that significant improvements of 57 and 87 percent in strength were obtained by ethanolic slurry pressing and aqueous slurry pressing, respectively, when compared to dry pressing. Also, aqueous slurry pressing produced specimens which were 19 percent stronger than those produced by ethanolic slurry pressing.

Photomicrographs of polished and etched cross sections of the surface of dry pressed and ethanolic slurry pressed specimens looked similar, as shown in figures 4(a) and (b). The average grain size was 7.0 and 6.8 μm, respectively. However, figures 5(a) and (b) show that the distribution of pores is different. In the dry pressed case, there are large regions of porosity which surround more dense areas to form large circumferential cracks. The ethanolic slurry pressed specimens have a more uniform distribution of pores without the obvious crack formation; however, relatively large domains still exist. The aqueous slurry pressed specimens exhibited a large average grain size (8.0 μm) as shown in figure 4(c). Also evident is grain elongation with grains as long as 50 μm. The largest measured aspect ratio was 5:1. This would suggest that grain elongation occurred after densification since theoretical density was achieved (ref. 12). This indicated that the sintering time was too long for this case. The microstructure in the aqueous slurry pressed case was more uniform and did not exhibit the domains that were present in the other cases (fig. 5(c)).

A compilation of the Image analysis data is shown in table III. In this table the total number of features which were evaluated are shown for each specimen as well as the area examined, average, and the largest pore areas (the area is determined using an elliptical-size pore approximation) and the average and largest pore length. Analysis of the data presented in table III indicates that the average pore area is significantly reduced by aqueous slurry pressing. The average pore area was reduced by aqueous slurry pressing by approximately 80 and 84 percent from those values obtained via dry pressing and ethanolic slurry pressing, respectively. No significant difference in the average pore length was observed between any of three fabrication processes. Figure 6 shows that the distribution of the pore lengths for the aqueous slurry pressed specimens is shifted to lower values than for the other two fabrication processes.
There is no apparent difference in pore length distributions between dry pressed and ethanolic slurry pressed specimens.

Representative fracture surfaces for the three conditions are shown in figure 7. All three exhibit typical transgranular fracture (ref. 13). The dry pressed and ethanolic slurry pressed specimens showed a much greater amount of porosity than the aqueous slurry pressed specimens. The dry pressed specimens typically failed at an approximately 100 µm agglomerate (fig. 7(a)). Other critical flaws such as pores and cracks were noted, but in much lower frequency. The ethanolic slurry pressed specimens exhibited a wide range of fracture origin types; from large (approx 120 µm) agglomerates to small elongated cracks. A typical fracture origin is shown in figure 7(b). Fracture origins for the aqueous slurry pressed specimens were difficult to identify since the majority of the specimens shattered upon fracture. The typical fracture origin in the remaining specimens was a small, 25 to 30 µm, agglomerate as shown in figure 7(c). Again, other flaw types were noted, but in much lower frequency.

DISCUSSION

A 57 percent improvement in room temperature flexural strength was attained by ethanolic slurry pressing instead of dry-powder pressing. This improvement was demonstrated even though the average densities of the two populations were the same and the carbon content of the slurry pressed specimens was lower (table I). Furthermore, the distribution of pore lengths as well as the grain size were nearly identical for the two populations.

The data suggest that the improvement in strength is due to differences in microstructure and fracture origin. As shown in figure 5, the porosity in the dry pressed specimen was inhomogeneous and was frequently associated with large agglomerated structures within the microstructure. Such a microstructure is typically encountered when an agglomerated powder is sintered. The agglomerates sinter at a different rate than the matrix, creating large circumferential cracks in the microstructure (ref. 5). This situation is also encountered on the fracture surface where the critical flaw is a dense agglomerate surrounded by a void area. In contrast, the microstructure of the ethanolic slurry pressed specimens exhibits a more uniform porosity and the domains are much smaller and more evenly dispersed than in the dry pressed case. The fracture origin has a grain morphology comparable to the surrounding matrix and the circumferential crack is not nearly as wide. This indicates that this "agglomerate" did not exist in the slurry and formed as a result of cracking during drying or hydropressing of the puck. It is clear that the differences shown in figure 5 are due only to changes in the fabrication technique, not the chemical composition.

Another possible reason for the strength increase might be the slight reduction in oxide contamination (table I) in the ethanolic slurry pressed specimens relative to those that were dry pressed (ref. 14). It is not known if the decrease in free C in the ethanol pressed specimens contributed to the increase in strength.

The increase in strength for the aqueous slurry pressed specimens is due to the 8 percent reduction in porosity (ref. 15). Also, the homogeneity of the pore distribution is greatly improved and there are no visible domains as noted in the other two cases. The average pore size is reduced by 50 percent,
and although the fracture origins are typical of both of the other cases, they are up to 80 percent smaller.

The combined use of colloidal techniques and slurry pressing reduced the residual agglomerate size and allowed for more uniform particle arrangement (ref. 16). Pressing in water also allowed for a greater retention of free C in the "green" state relative to pressing in alcohol. The source of carbon in the Starck SiC powder is soluble in ethanol and not in water. These aspects led to a stronger, more uniform, and dense structure.

SUMMARY OF RESULTS

A new slurry pressing technique improved the sintered strength of SiC by 57 percent over the dry powder pressing process. The improvement was due to the elimination of agglomerates in the dry powder by going to a wet system and the resulting improvement in microstructural uniformity.

Colloidal techniques improved the dispersion and suspension of the SiC in water and improved the strength by 87 percent over dry pressing. This also represents a 19 percent improvement in strength over ethanolic slurry pressing. This improvement was primarily due to reduced porosity as shown by image analysis and reflected in improved green and sintered densities. Also contributing to the improved strength was a smaller pore size distribution and a reduced critical flaw size.

Thus, with careful colloidal control of the slurry, aqueous slurry pressing provides a means of consolidating ceramic powders to form simple to moderately complex "green" compacts without added binders. This technique should prove useful for producing parts made from particulate and whisker toughened as well as monolithic ceramics. It should also provide an avenue for studying the many other variables which contribute to the reliability of current structural ceramics.

REFERENCES


### Table 1

**Chemical Composition of Starting Powders and Experimental Mixtures (wt%)**

<table>
<thead>
<tr>
<th>Type</th>
<th>C</th>
<th>O</th>
<th>B</th>
<th>N</th>
<th>Al</th>
<th>Fe</th>
<th>Ti</th>
<th>V</th>
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<td>Type I a</td>
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<td>0.60</td>
<td>----</td>
<td>0.15</td>
<td>0.015</td>
<td>0.025</td>
<td>0.016</td>
<td>0.018</td>
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<td>Type II b</td>
<td>6.95</td>
<td>1.25</td>
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<td>0.17</td>
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<td>0.027</td>
<td>0.016</td>
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<td>Dry Press Mix</td>
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<td>0.15</td>
<td>0.015</td>
<td>0.025</td>
<td>0.016</td>
<td>0.015</td>
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<td>Slurry Press - Ethanol c</td>
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<td></td>
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<td>Slurry Press - H₂O/NH₄OH c</td>
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<td>0.96</td>
<td>0.60</td>
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<td></td>
<td></td>
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<td></td>
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</tbody>
</table>

a Hermann C. Starck, Berlin - Type 1 α-SiC
b Hermann C. Starck, Berlin - Type 2 α-SiC
c Composition After Pressing

### Table 2

**Comparison of Specimen Properties**

<table>
<thead>
<tr>
<th>Treatment</th>
<th>Number of Specimens</th>
<th>Green Density p/g cm⁻³</th>
<th>Sintered Density p/g cm⁻³</th>
<th>Sintered MOR (MPa)</th>
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</thead>
<tbody>
<tr>
<td>Dry Pressed</td>
<td>18</td>
<td>2.05 ± 0.02 (64.4% TD)</td>
<td>2.93 ± 0.02 (92.1% TD)</td>
<td>235.6 ± 18.4 (35.2 ± 2.7 ksi)</td>
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<td>Slurry Pressed Ethanol</td>
<td>22</td>
<td>2.06 ± 0.01 (64.7% TD)</td>
<td>2.91 ± 0.04 (91.9% TD)</td>
<td>370.5 ± 56.7 (53.8 ± 8.2 ksi)</td>
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<tr>
<td>Slurry Pressed H₂O/NH₄OH</td>
<td>24</td>
<td>2.09 ± 0.02 (65.7% TD)</td>
<td>3.16 ± 0.04 (99.3% TD)</td>
<td>440.8 ± 100 (640 ± 14.5 ksi)</td>
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</tbody>
</table>

### Table 3

**Compilation of Image Analysis Data**

<table>
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<tr>
<th>Description</th>
<th>Features</th>
<th>Total Area Examined (cm²)</th>
<th>Pore Area Avg. Largest (µm²)</th>
<th>Pore Area Avg. Largest (µm)</th>
<th>Pore Length Avg. Largest (µm)</th>
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</thead>
<tbody>
<tr>
<td>Dry Press</td>
<td>25072</td>
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<td>400</td>
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<td></td>
<td>29079</td>
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<td>1000</td>
<td>400</td>
<td>400</td>
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<tr>
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<td></td>
<td>29618</td>
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<td>1200</td>
<td>400</td>
<td>400</td>
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<tr>
<td>Slurry Press with H₂O/NH₄OH</td>
<td>23022</td>
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<td></td>
<td>20894</td>
<td>0.018</td>
<td>360</td>
<td>190</td>
<td>360</td>
</tr>
</tbody>
</table>

*The three largest features determined from image analysis are cited.*
Figure 1. - Schematic drawing of the slurry pressing die.

Figure 2. - Flow diagram of experimental procedure.

50% TYPE 1 SiC + ADDITIVES
+ 50% TYPE 2 SiC

MIX WITH ETHANOL FOR 72 hr
FLASH DRY
SIEVE -100 MESH
DRY PRESS 83 MPa
SLURRY PRESS 14 MPa
ISOSTATIC PRESS 413 MPa
SINTER 2150 °C/1.75 hr
MACHINE TO TEST BAR
DENSITY MEASUREMENT
POLISH AND ETCH 1/4 - 4 POINT MOR
GRAIN SIZE MEASUREMENT
PORE DISTRIBUTION
FRACOGRAPHY
Figure 3. - The effect of pH on the dispersion of alpha-SiC.

Figure 4. - Photomicrographs of polished and etched cross-sections of alpha-SiC specimens sintered for 1.75 hr at 2150°C and fabricated by (a) dry pressing, (b) slurry pressing from ethanolic slurry, and (c) slurry pressing from pH adjusted aqueous slurry. (1000 X).
Figure 5. - Photomicrographs of polished and etched cross-sections of alpha-SiC specimens sintered for 1.75 hr at 2150 °C and fabricated by (a) dry pressing, (b) slurry pressing from ethanolic slurry, and (c) slurry pressing from pH adjusted aqueous slurry. (250 X).

Figure 6. - Pore distribution of sintered alpha-SiC for three different fabrication methods.
Figure 7. - Typical fracture origins found in sintered alpha-SiC specimens fabricated by (a) dry pressing, (b) slurry pressing from ethanolic slurry, and (c) slurry pressing from pH adjusted aqueous slurry.
NASA TM-87243

2. Government Accession No.

3. Recipient's Catalog No.

4. Title and Subtitle
Improved Consolidation of Silicon Carbide

5. Report Date

6. Performing Organization Code
505-63-01

7. Author(s)
Marc R. Freedman and Michael L. Millard

E-2921

9. Performing Organization Name and Address
National Aeronautics and Space Administration
Lewis Research Center
Cleveland, Ohio 44135

10. Work Unit No.

11. Contract or Grant No.

12. Sponsoring Organization Name and Address
National Aeronautics and Space Administration
Washington, D.C. 20546

13. Type of Report and Period Covered
Technical Memorandum


15. Supplementary Notes

16. Abstract
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17. Key Words (Suggested by Author(s))
Silicon carbide
Colloid
Slurry pressing

18. Distribution Statement
Unclassified - unlimited
STAR Category 27

19. Security Classification of This Report
Unclassified

20. Security Classification of This Page
Unclassified

21. No of Pages
22 Price*

*For sale by the National Technical Information Service, Springfield, Virginia 22161