LIST OF FIGURES

Fig. 1. 1: Comparison of capabilities of different alloy systems **5**

Fig. 1. 2: Schematic representation of marine gas turbine engine. **12**

Fig. 1. 3: Principle of ultrasonic shot peening. **26**

Fig. 2. 1: Components of ultrasonic shot peening device: (a) The peening head and (b) the central unit of the ultrasonic shot peening device.....**32**

Fig. 2. 2: Salt coating set-up: (a) Air brush (Model-BD203) and (b) hot plate for salt coating. **33**

Fig. 2. 3: (a) Hour glass geometry of HCF test specimen for R=-1, (b) Digital photographs of salt deposition system in central region of the curved section. **35**

Fig. 2. 4: Geometry of HCF test specimen used at stress ratio of 0.5 and 0.7 .....**36**

Fig. 2. 5: 50 kN Servo material testing system. **37**

Fig. 3. 1: Microstructure of the peak aged superalloy IN718 (a) optical micrograpgh, (b) SEM micrograph and (c) TEM micrograph.....**43**

Fig. 3. 2: Bright field TEM micrograph and the corresponding SAD pattern of the superalloy IN718 subjected to ultrasonic shot peening for 5 min. **44**

Fig. 3. 3: Effect of surface roughness on: (a) dislocation density and (b) microhardness. **45**

Fig. 3. 4: X-ray diffraction of un-shot peened and ultrasonic shot peened superalloy IN718. .....**46**

Fig. 3. 5: Digital photographs of the #400 grit ground samples oxidized/hot corroded at 600^{o}C for 0.5 h (a-d) and 100 h (e-h). **47**

Fig. 3. 6: Effect of surface roughness on corrosion behavior of the specimens coated with 1S salt and exposed at 600ºC up to 100 h: (a) Weight gain per unit area vs time; (b) square of weight gain per unit area vs time..... **49**

Fig. 3. 7: Effect of surface roughness on corrosion behavior of the specimens coated with 2SM salt mixture and exposed at 600ºC up to 100 h: (a) Weight gain per unit area vs time; (b) square of weight gain per unit area vs time. **50**

Fig. 3. 8: Effect of surface roughness on corrosion behavior of the specimens coated with 3SM salt mixture and exposed at 600ºC up to 100 h: (a) Weight gain per unit area vs time; (b) square of weight gain per unit area vs time. **50**

Fig. 3. 9: SEM micrographs showing the effect of different surface roughness on the depth of penetration of corrodants in the samples coated with 1S salt and exposed at 600ºC for 100 h: (a) #400, (b) #600, (c) #800 and (d) #1000..... **53**

Fig. 3. 10: SEM micrographs showing the effect of surface roughness on the depth of penetration of corrodants in the samples coated with 2SM salt and exposed at 600ºC for 100 h: (a) #400, (b) #600, (c) #800 and (d) #1000 ..... **53**

Fig. 3. 11: SEM micrographs showing the effect of surface roughness on the depth of penetration of corrodants in the samples coated with 3SM salt and exposed at 600ºC for 100 h: (a) #400, (b) #600, (c) #800 and (d) #1000. ..... **54**

Fig. 3. 12: X-ray diffraction patterns of the uncoated sample and those coated with different salt/salt mixtures exposed at 600ºC, up to 100 h: (a) uncoated, (b) coated with 1S salt (100 wt% NaCl), (c) coated with salt mixture 2SM (60 wt% Na_2SO_4 + 40 wt% V_2O_5) and (d) coated with salt mixture 3SM (75 wt% Na_2SO_4 + 15 wt% NaCl + 10 wt% V_2O_5)..... **56**

Fig. 3. 13: SEM micrograph showing morphology of the 1S salt coated sample exposed at 600ºC for 100 h. The EDS analysis shows concentration of the different elements. **58**

Fig. 3. 14: SEM micrograph showing morphology of the sample coated with salt mixture 2SM and exposed at 600ºC for 100 h. The EDS analysis shows concentration of the different elements. **58**

Fig. 3. 15: SEM micrograph showing morphology of the sample coated with salt mixture 3SM and exposed at 600ºC for 100 h. The EDS analysis shows concentration of the different elements. **58**

Fig. 3. 16: Elemental distribution in cross section of the specimen ground with #400, up to the depth of 40 µm from the surface, coated with 1S salt and exposed at 600ºC for 100 h. **60**

Fig. 3. 17: EPMA/SE X-ray mapping of cross section of the 1S salt coated sample exposed at 600ºC up to 100 h, showing distribution of different elements: (a) Nickel, (b) Iron, (c) Chromium and (d) Oxygen. **60**

Fig. 3. 18: Elemental distribution in cross section of the specimen ground with #400, up to the depth of 40 µm from the surface, coated with 2SM salt mixture and exposed at 600ºC for 100 h. **61**

Fig. 3. 19: EPMA/SE X-ray mapping of cross section of the specimen coated with salt mixture 2SM and exposed at 600ºC for 100 h, showing distribution of different elements: (a) Nickel, (b) Iron, (c) Chromium and (d) Oxygen. **61**

Fig. 3. 20: Elemental distribution in cross section of the specimen ground with #400, up to the depth of 40 µm from the surface, coated with 3SM salt mixture and exposed at 600ºC for 100 h. **62**

Fig. 3. 21: EPMA/SE X-ray mapping of cross section of the specimen coated with salt mixture 3SM and exposed at 600ºC for 100 h, showing distribution of different elements: (a) Nickel, (b) Iron, (c) Chromium and (d) Oxygen. **62**

Fig. 3. 22: Effect of ultrasonic shot peening for 5 min on hot corrosion resistance of the specimens coated with 1S exposed at 600^0C, up to 100 h: (a) Weight gain per unit area vs time; (b) Square of weight gain per unit area vs time. **64**

Fig. 3. 23: Effect of ultrasonic shot peening for 5 min on hot corrosion resistance of the specimens coated with 2SM exposed at 600^0C, up to 100 h: (a) Weight gain per unit area vs time; (b) Square of weight gain per unit area vs time. **65**

Fig. 3. 24: Effect of ultrasonic shot peening for 5 min on hot corrosion resistance of the specimens coated with 3SM exposed at 600^0C, up to 100 h: (a) Weight gain per unit area vs time; (b) Square of weight gain per unit area vs time. **65**

Fig. 3. 25: EPMA/SE X-ray mapping of cross sections of specimens coated with salt 1S and exposed at 600°C for 100 h, showing distribution of different elements: Nickel, Chromium, Iron and Oxygen for (a) non shot peened sample and (b) 5 min USP treated sample. **66**

Fig. 3. 26: EPMA/SE X-ray mapping of cross sections of specimens coated with salt mixture 2SM and exposed at 600°C for 100 h, showing distribution of different elements: Nickel, Chromium, Iron and Oxygen for (a) non shot peened sample and (b) 5 min USP treated sample. **67**

Fig. 3. 27: EPMA/SE X-ray mapping of cross sections of specimens coated with salt mixture 3SM and exposed at 600°C for 100 h, showing distribution of different elements: Nickel, Chromium, Iron and Oxygen for (a) non shot peened sample and (b) 5 min USP treated sample. **68**

Fig. 3. 28: Schematic presentation showing the process of corrosion on the specimen with coarse surface, coated with 1S salt (100 wt% NaCl), and exposed at 600ºC up to 100 h. **71**

Fig. 4. 1: Digital photographs of the #400 grit ground samples oxidized/hot corroded at 600ºC for 0.5 h (a-d) and 100 h (e-h). **79**

Fig. 4. 2: Effect of surface roughness on corrosion behavior of the specimens coated with 1S salt and exposed at 700ºC up to 100 h: (a) Weight gain per unit area vs time; (b) Square of weight gain per unit area vs time.....**81**

Fig. 4. 3: Effect of surface roughness on corrosion behavior of the specimens coated with 2SM salt mixture and exposed at 700ºC up to 100 h: (a) Weight gain per unit area vs time; (b) Square of weight gain per unit area vs time. **82**

Fig. 4. 4: Effect of surface roughness on corrosion behavior of the specimens coated with 3SM salt mixture and exposed at 700ºC up to 100 h: (a) Weight gain per unit area vs time; (b) Square of weight gain per unit area vs time. **82**

Fig. 4. 5: Comparison of weight gain/area vs time of exposure at 600 and 700ºC for different salt/salt mixture coatings. **84**

Fig. 4. 6: X-ray diffraction patterns of the un-shotpeened and 5 min ultra sonic shot peened samples coated with 2SM salt mixture and exposed at 700ºC up to 100 h.....**85**

Fig. 4. 7: SEM micrographs showing the effect of surface roughness on the depth of penetration of corrosion products in the samples coated with salt mixture 2SM and exposed at 700ºC for 100 h: : (a) #400, (b) #600, (c) #800 and (d) #1000. .....**86**

Fig. 4. 8: Effect of ultrasonic shot peening for 5 min on hot corrosion resistance of the specimens coated with 1S and exposed at 700^0C up to 100 h: (a) Weight gain per unit area vs time; (b) Square of weight gain per unit area vs time. **87**

Fig. 4. 9: Effect of ultrasonic shot peening for 5 min on hot corrosion resistance of the specimens coated with 2SM and exposed at 700^0C up to 100 h: (a) Weight gain per unit area vs time; (b) Square of weight gain per unit area vs time..... **87**

Fig. 4. 10: Effect of ultrasonic shot peening for 5 min on hot corrosion resistance of the specimens coated with 3SM and exposed at 700^0C up to 100 h: (a) Weight gain per unit area vs time; (b) Square of weight gain per unit area vs time..... **88**

Fig. 4. 11: SEM micrographs showing the comparison of the depth of penetration of corrosion products in the samples coated with salt mixture 2SM and exposed at700ºC for 100 h (a) non-USP and (b) 5 min USP treated..... **89**

Fig. 4. 12: EPMA/SE X-ray mapping of cross sections of the specimens coated with the salt mixture 2SM and exposed at 700ºC for 100 h, showing distribution of different elements: Nickel, Chromium, Iron and Oxygen for (a) non-USP and (b) 5 min USP treated..... **90**

Fig. 4. 13: Schematic showing the effect of surface roughness on hot corrosion of the superalloy IN718 at 700ºC..... **93**

Fig. 5. 1: Digital photographs of the hot corroded HCF specimen. **99**

Fig. 5. 2: X-ray diffraction pattern of the sample coated with $75Na_2SO_4$ + 15NaCl + $10V_2O_5$ (wt.%) salt mixture (3SM) and exposed at 600ºC for 100 h..... **100**

Fig. 5. 3: Variation of fatigue life with stress amplitude at 600ºC, in air, for the as heat treated and pre hot corroded conditions..... **103**

Fig. 5. 4: SEM microgaphs of the sample coated with $75Na_2SO_4$ + 15NaCl + $10V_2O_5$ (wt.%) salt mixture and exposed at 600ºC for 100 h: (a) surface topography, (b) transverse cross section. **103**

Fig. 5. 5: Histograms showing fatigue life of the as heat treated and pre hot corroded samples, at different stress amplitudes, at 600ºC..... **104**

Fig. 5. 6: Fractographs of the as heat treated sample fractured at the stress amplitude of ±650 MPa at 600ºC showing: (a) the fracture surface and crack initiation sites, (b) transgranular crack propagation and extremely fine fatigue striations in the encircled region. **104**

Fig. 5. 7: Fractographs of the as heat treated sample fractured at the stress amplitude of ±750 MPa at 600ºC showing: (a) fracture surface and crack initiation sites, (b) transgranular crack propagation and coarse fatigue striations. **105**

Fig. 5. 8: Fractographs of the fatigue sample pre-corroded and fractured from HCF at the stress amplitude of ±500 MPa at 600ºC in air showing: (a) fracture surface and crack initiation sites, (b) fatigue striations and (c) EDS analysis close to the crack initiation site..... **106**

Fig. 5. 9: Fractographs of the fatigue sample pre-corroded and fractured from HCF at the stress amplitude of ±550 MPa at 600ºC in air showing: (a) fracture surface and crack initiation sites, (b) fatigue striations and (c) EDS analysis close to the crack initiation site..... **107**

Fig. 5. 10: Fractographs of the fatigue sample pre-corroded and fractured from HCF at the stress amplitude of ±650 MPa at 600ºC in air showing: (a) fracture surface and crack initiation sites, (b) fatigue striations, and (c) EDS analysis close to the crack initiation site..... **108**

Fig. 5. 11: Fractographs of the fatigue sample pre-corroded and fractured from HCF at the stress amplitude of ±750 MPa at 600ºC in air showing: (a) fracture surface and crack initiation sites, (b) fatigue striations, and (c) EDS analysis close to the crack initiation site..... **109**

Fig. 5. 12: Backscattered SEM images of curved surfaces of the HCF fractured specimens close to fracture ends, pre corroded in salt mixture with Na_2SO_4 + NaCl +

V_2O_5 and tested in HCF at 600ºC at different stress amplitudes: (a) ±500 MPa, (b) ±550 MPa, (c) ±650 MPa and (d) ±750 MPa..... **112**

Fig. 5. 13: Backscatter SEM images of longitudinal sections of the specimens pre hot corroded in salt mixture of Na_2SO_4+NaCl+V_2O_5 and HCF tested at different stress amplitudes: (a) ±500 MPa, (b) ±550 MPa, (c) ±650 MPa, and (d) ±750 MPa. **113**

Fig. 5. 14: Mechanism of hot corrosion and crack initiation/growth during the high cycle fatigue: (I) hot corrosion (II) fatigue crack initiation and growth. **115**

Fig. 6. 1: Effect of stress ratio on fatigue life at 600^0C. **120**

Fig. 6. 2: Nicolas Haigh diagram: Maximum stress and stress amplitude vs mean stress at R=0.7, at 600°C..... **120**

Fig. 6. 3: Effect of mean stress on plastic strain accumulation in the superalloy IN718 with number of cycles at R= 0.7 and 600°C showing variation of cumulative plastic strain with number of cycles. **121**

Fig. 6. 4: Fractographs of the sample fractured at the stress amplitude of ±600 Mpa (R= -1) at 600ºC showing: (a) the fracture surface and crack initiation site, (b) transgranular crack propagation and fatigue striations with smaller interstriation spacing. **122**

Fig. 6. 5: Fractographs of the sample fractured at the stress amplitude of ±800 MPa (R= -1) at 600ºC showing: (a) the fracture surface and crack initiation site, (b) transgranular crack propagation and fatigue striations with larger interstriation spacing. **123**

Fig. 6. 6: Fractographs of the sample fractured at the mean stress of 750 MPa (R = 0.5) at 600ºC showing: (a) the fracture surface and crack initiation site, (b) transgranular crack propagation and fatigue striations. **123**

Fig. 6. 7: Fractographs of the sample fractured at the mean stress of 900 MPa (R = 0.5) at 600ºC showing: (a) the fracture surface and crack initiation site, (b) transgranular crack propagation and fatigue striations. **124**

Fig. 6. 8: Fractographs of the sample fractured at the mean stress of 900 MPa (R = 0.7) at 600ºC showing: (a) the fracture surface and crack initiation sites, (b) mixed mode of fracture with fatigue striations and dimples. **124**

Fig. 6. 9: Fractographs of the sample fractured at the mean stress of 950 MPa (R = 0.7) at 600ºC showing: (a) the fracture surface and crack initiation sites, (b) overload fracture showing dimples. **125**