

LIST OF FIGURES

Figure No.	Figure Caption	Page No.
Figure 1.1:	Density of some light and heavy metals.	17
Figure 1.2:	Schematic illustration of ball-powder collision of powder mixture.	21
Figure 1.3:	Important variables affecting the final constitution of the milled powders.	22
Figure 1.4:	Refinement of crystallite or grain size as a function of milling time.	23
Figure 1.5:	Schematic diagram of ball mill used for high energy milling operations.	25
Figure 1.6:	Schematic drawing of a high-energy vibratory ball mill.	26
Figure 1.7:	Schematic cross-section of tumbler ball mill showing ball movement.	27
Figure 1.8:	Arrangement of rotating arms on a shaft in the attrition ball mill.	29
Figure 1.9:	Working principle of planetary ball mill.	30
Figure 1.10:	Composition of amorphous phase forming range achieved in the Ni-Nb system by different non-equilibrium processing routes.	35
Figure 1.11:	Phase transformations in Al-Cu-Mn system at various milling intensities in a planetary mill.	38
Figure 1.12:	Schematic representation of formation of metastable phase during ball milling.	39
Figure 1.13:	Breakup of dislocation pile ups: (a) microcrystalline regime and (b) nanocrystalline regime.	44
Figure 2.1:	Schematic of depicting the ball motion inside the two station	51

	high-energy ball mill.	
Figure 2.2:	Fritsch P-6 pulverisette planetary ball mill set up.	52
Figure 2.3:	Fourier optics.	54
Figure 2.4:	Schematic diagram of scanning electron microscopy.	58
Figure 2.5:	Schematic diagram of transmission electron microscopy.	60
Figure 2.6:	Schematic illustration of a DTA instrument.	62
Figure 2.7:	Schematic diagram of the Vickers indenter and an indentation diagonal length.	63
Figure 2.8:	A schematic diagram of a nanoindenter that uses a load coil to impose the load and capacitive gages to measure the displacement.	65
Figure 2.9:	Typical load P as a function of depth h for indentation with a sharp indenter illustrating the depth of the residual hardness impression h_f , the maximum indentation depth h_{max} , and the unloading stiffness S .	65
Figure 3.1:	XRD patterns of unreinforced EN AW6082 powder after 10, 20, 30, 40 and 50 h of ball milling.	67
Figure 3.2:	XRD patterns of EN AW6082/Garnet composite powder after 10, 20, 30, 40 and 50 h of ball milling.	68
Figure 3.3:	XRD patterns of Al/Garnet powder after 10, 20, 30, 40 and 50 h of high energy ball milling.	69
Figure 3.4:	Evolution of d_{111} peak intensity on powder XRD showing the broadening and reduction in intensity milled at different hours for unreinforced EN AW6082.	70
Figure 3.5:	Evolution of d_{111} peak intensity on powder XRD showing the broadening and reduction in intensity milled at different hours for EN AW6082/Garnet.	71
Figure 3.6:	Full width at half maximum intensity of diffraction planes as a function of milling time for unreinforced EN AW6082.	73
Figure 3.7:	Full width at half maximum intensity of diffraction planes as a function of milling time for EN AW6082/Garnet.	74

Figure 3.8:	Full width at half maximum intensity of diffraction planes as a function of milling time for Al/Garnet.	75
Figure 3.9:	Variation in crystallite size and strain as a function of milling time for unreinforced EN AW6082.	76
Figure 3.10:	Variation in crystallite size and strain as a function of milling time for EN AW6082/Garnet.	77
Figure 3.11:	Variation in crystallite size and strain as a function of milling time for Al/Garnet.	77
Figure 3.12:	Particle size distribution of milled powders after 50 h (a) unreinforced EN AW6082, (b) EN AW6082/Garnet and Al/Garnet	79
Figure 3.13	SEM micrographs of as-received powders (a) EN AW6082, (b) Pure Al and (c) Garnet.	81
Figure 3.14	Morphology of milled powders for 50 h (a) unreinforced EN AW6082, (b) EN AW6082/Garnet, (c) Magnified view of EN AW6082/Garnet and (d) its corresponding EDS, (e) Pure Al/Garnet and (f) Magnified view of Pure Al/Garnet.	83
Figure 3.15	Schematic diagram showing the formation of composite powder after high energy ball milling.	84
Figure 3.16	(a) TEM micrographs of 50 h mechanically milled powder particles of EN AW8082 alloy. (b) Magnified view of 'a'.	85
Figure 3.17	(a) TEM bright-field image of EN AW6082/Garnet MM for 50 h and its corresponding SAD pattern and (b) Dark-field image.	86
Figure 3.18	(a) TEM bright-field image of Al/Garnet MM for 50 h and its corresponding SAD pattern and (b) Dark-field image.	86
Figure 3.19	DTA curves of milled powders for 50 h of unreinforced EN AW6082, EN AW6082/Garnet and Al/Garnet.	88
Figure 3.20	Powder hardness as a function of milling time for different systems	89
Figure 3.21	Hardness of milled powders as a function of grain size (a)	93

	unreinforced EN AW6082, (b) EN AW6082/Garnet and (c) Al/Garnet.	
Figure 3.22	Comparison of the model predictions via varying grain size with the experimental data for EN AW6082 and Al composite.	94
Figure 3.23	Load versus penetration depth curves of unreinforced EN AW6082 and composite powders milled for 50 h.	96
Figure 4.1:	XRD patterns of EN AW6082/MWCNT powders after various milling times.	100
Figure 4.2:	XRD pattern of first peak from the diffracting plane (111) of composite.	101
Figure 4.3:	Variation in grain size and lattice stain as a function of milling time.	103
Figure 4.4:	Particle size distribution of 50 h ball milled EN AW6082/MWCNT composite powder.	104
Figure 4.5:	(a) The morphology of as-received Al-alloy particle (b) as-received MWCNTs (c) The morphology of EN AW6082/MWCNT composite powder after 50 h milling and (d) Magnified view of 'c'.	105
Figure 4.6:	TEM bright field micrographs of 50 h MM powder particles of EN AW6082/MWCNT composite and its corresponding SAD pattern.	107
Figure: 4.7:	(a) HRTEM micrograph of composite powders after 50 h of the ball milling time (b) Magnified view of 'a' and (c) the corresponding SADP.	108
Figure 4.8:	DTA scan of 50 h milled composite powder.	109
Figure 4.9:	Effect of hardness of unreinforced EN AW6082 and composite powders with increasing milling time.	111
Figure 4.10:	Hall-Petch effect for unreinforced alloy and composite powders compared with experimental values for crystallite size and hardness.	114

Figure 4.11:	Load versus penetration depth curves of unreinforced EN AW6082 and composite powders as-milled for 50h.	116
Figure 4.12:	Vickers micro and nano-indentation hardness of 50 h ball milled powders.	117
Figure 4.13:	XRD patterns of as-received unreinforced EN AW6082 alloy and mechanically milled EN AW6082/Garnet and EN AW6082/MWCNT composite powders.	118
Figure 4.14:	TEM bright field image of 50 h MM powder particles of EN AW6082/Garnet composite and its corresponding SAD pattern.	120
Figure 4.15:	TEM bright field image of 50 h MM powder particles of EN AW6082/MWCNT composite and its corresponding SAD pattern.	121
Figure 4.16:	HRTEM images of EN AW6082/Garnet and EN AW6082/MWCNT composite powders at different magnifications.	122
Figure 4.17:	Microhardness of EN AW6082/Garnet and EN AW6082/MWCNT composite powders.	124
Figure 4.18	Load vs. displacement curves for garnet and MWCNT as reinforcement.	125
Figure 5.1:	Phase diagram of the Al-Fe system.	128
Figure 5.2:	XRD pattern of Al-25 at.%Fe as-cast alloy showing single θ -Al ₃ Fe intermetallic phase.	130
Figure 5.3:	XRD patterns showing structural evolution of θ -Al ₃ Fe intermetallic phase during MM.	131
Figure 5.4:	Structural evolution of Al-25 at.%Fe alloy powders during MM.	132
Figure 5.5:	Variation of crystallite size and strain with milling duration for Al-25 at. %Fe showing a decrease in crystallite size and an increase in strain with milling duration.	132
Figure 5.6:	XRD patterns Al-35.4 at.%Fe as-cast alloy and after	133

	mechanically milled for 10, 20, 30 and 40 h showing structural evolution with milling time.	
Figure 5.7:	Structural evolution of Al-34.5 at.%Fe alloy powders during MM.	134
Figure 5.8:	SEM micrographs of final milled powders of (a) Al-25 at.%Fe and (b) Al-34.5 at.%Fe alloy.	136
Figure 5.9:	(a) TEM image of 50 h milled product of Al-25 at.%Fe alloy showing crystalline η -Al ₅ Fe ₂ and amorphous phase and its corresponding SAD pattern and (b) a HRTEM image and the corresponding FFT-SAD of Al-35.4 at.%Fe showing a complete amorphous phase after 40 h of milling.	137
Figure 5.10:	Gibbs free energy of the amorphous, solid solution and intermetallic phases of Al-Fe system as a function of composition and grain size.	145
Figure 5.11:	DTA traces of milled powders for (a) Al-25 at.%Fe and (b) Al-34.5 at.%Fe alloy.	146
Figure 5.12:	Variation of microhardness as a function of milling time for Al-25 at.%Fe alloy showing the phase sequence and softening behavior, (b) Variation of microhardness as a function of square root of the grain size to test the Hall-Petch relationship for Al-25 at.%Fe alloy.	149
Figure 5.13:	Microhardness variation as a function of milling time for Al-34.5 at.%Fe alloy showing transition from hardening to softening behavior.	150
Figure 5.14:	Nanoindentation load-displacement curves for Al-25 at.%Fe and Al-34.5 at.%Fe alloy at varying milling time.	152
Figure 6.1:	XRD pattern of as-cast of Al-30 at.% Fe alloy.	156
Figure 6.2:	XRD patterns showing structural evolution of Al ₅ Fe ₂ intermetallic during MM.	157
Figure 6.3:	Variation of crystallite size and lattice strain for Al ₅ Fe ₂ intermetallic as a function of milling time.	157

Figure 6.4:	Bright field image and dark field image of 50 h milled powder for Al-30 at.% Fe alloy.	158
Figure 6.5:	Hall-Petch plot of hardness of Al_5Fe_2 intermetallic against inverse square-root of grain size showing transition from conventional Hall-Petch behavior to inverse Hall-Petch behavior.	160
Figure 6.6	Hardness <i>vs</i> grain size in IHP regime Observed values and calculated values obtained using equation 6.8.	166