## CONTENTS

Preface...........................................................................................................(vii)
Acknowledgements...........................................................................................(ix)

**PART ONE**
**FUNDAMENTALS AND METHODOLOGY**

1. Introduction
   
2. Fracture
   2.1 Ductile and Brittle Fractures
   2.2 Fractography of Ductile and Brittle Fractures
   2.3 Fatigue Fracture
   2.4 Fractography of Fatigue Fracture

3. Tools and Techniques
   3.1 Acquisition of Background Data
   3.2 Selection of Samples
   3.3 Photographic Records
   3.4 Preliminary Examination
   3.5 Nondestructive Testing
   3.6 Chemical Analysis
   3.7 Fractography, Energy Dispersive Analysis by X-Ray (EDAX), and Microscopy using Scanning Electron Microscope (SEM)
   3.8 Optical Microscopy
   3.9 Electron Probe Micro Analysis (EPMA)
   3.10 X-Ray Diffraction
   3.11 Evaluation of Mechanical Properties

**PART TWO**
**CASE STUDIES**

4. Material Selections
   4.1 Case Study: Failure of Hip-Joint Prosthesis
   4.2 Case Study: Failure of Firing Pin of 120mm Low Range Mortar

(xi)
4.3 Case Study: Failure of Shaft of a Gearbox 34
4.4 Case Study: Failure of 7.62mm Cartridge Cases 37
4.5 Case Study: Failure of Fin Mounting Nuts 41

5. Manufacturing Defects 45
5.1 Case Study: Failure of Track Pins of Track Link 48
5.2 Case Study: Failure of Track Shoe of an Infantry Combat Vehicle 51
5.3 Case Study: Failure of Control Lever of Fuel-Metering Unit of an Aeroengine 57
5.4 Case Study: Failure of Drill Rods for Mining 63
5.5 Case Study: Failure of Lifting Lugs of a Missile 68
5.6 Case Study: Failure of Breech Block of Light Machine Gun 71
5.7 Case Study: Failure of Titanium Sponge Cutting Ring 76
5.8 Case Study: Failure of Combustion Chamber Outer Casing of an Aeroengine 80

6. Casting Defects in Iron and Steel 86
6.1 Case Study: Failure of Exhaust Outer Cone of an Aeroengine 88
6.2 Case Study: Failure of Sealing Rings of Centrifugal Breather of an Aeroengine 95
6.3 Case Study: Failure of Grinding Roll of a Bowl Mill 99

7. Overload 103
7.1 Case Study: Failure of Mounting Bolt of Emergency Changeover Valve 104
7.2 Case Study: Failure of Steam Pipe in Unit-VI of a Thermal Power Station 108
7.3 Case Study: Failure of Body of Saddle Assembly 114
7.4 Case Study: Failure of Boiler Tube of a Thermal Power Station 118

8. Fatigue 123
8.1 Case Study: Failure of Wheel Hub of an Aircraft 124
8.2 Case Study: Failure of Bolts of Flapjack Mounting Bracket of an Aircraft 129
8.3 Case Study: Failure of Compressor Rotor Blades of an Aeroengine 132
8.4 Case Study: Failure of Bearing Cage of an Aeroengine 137

9. Corrosion 144
9.1 Case Study: Failure of Nipple of Fuel Pipe Line 146
9.2 Case Study: Failure of Condenser Tubes of Thermal Power Station 151
9.3 Case Study: Failure of High Pressure Air and Hydraulic Pipes 154
9.4 Case Study: Failure of Detonator of Grenade 157

10. Hydrogen Embrittlement and Stress Corrosion Cracking 168
   10.1 Case Study: Failure of Fin Mounting Screws of an Aero Weapon 169
   10.2 Case Study: Failure of Differential Valve Cover of Fuel Metering Unit 172
   10.3 Case Study: Failure of Lever Assembly of Main Under Carriage of an Aircraft 176
   10.4 Case Study: Failure of Cartridge Seat Ejection Secondary of an Aircraft 181

11. Wear 190
   11.1 Case Study: Failure of Interrotor Bearing of an Aeroengine 192
   11.2 Case Study: Failure of Low Temperature Super Heater Tube of a Thermal Power Station 201
   11.3 Case Study: Failure of Main Landing Gear Assembly of an Aircraft 205
   11.4 Case Study: Failure of Coupling Shaft and Bevel Gear of an Aeroengine 215

12. Elevated Temperature Failures 221
   12.1 Case Study: Failure of a Bolt of Nozzle Guide Vane of an Aeroengine 222
   12.2 Case Study: Failure of Vanes of Front Nozzle Diaphragm Assembly of an Aeroengine 226
   12.3 Case Study: Failure of Center Main Bearing of an Aircraft Engine 235
   12.4 Case Study: Failure of Jet Nozzle Casing of an Aeroengine 240
   12.5 Case Study: Failure of Turbine Stator Vanes of an Aeroengine 244

Bibliography 253
Index 257