

1-1-2011

Modified Logistical Creep Strain Prediction Method : A Constitutive Creep Strain Model Of A Nickel Based Super-Alloy

Amir Seif
Ryerson University

Follow this and additional works at: <http://digitalcommons.ryerson.ca/dissertations>

 Part of the [Aerospace Engineering Commons](#)

Recommended Citation

Seif, Amir, "Modified Logistical Creep Strain Prediction Method : A Constitutive Creep Strain Model Of A Nickel Based Super-Alloy" (2011). *Theses and dissertations*. Paper 1633.

MODIFIED LOGISTICAL CREEP STRAIN PREDICTION METHOD
A CONSTITUTIVE CREEP STRAIN MODEL OF A NICKEL BASED SUPER-ALLOY

By

Amir Seif

Bachelor of Aerospace Engineering

2011

A thesis

Presented to Ryerson University

In partial fulfillment of the
Requirements for the degree of
Master of Applied Science
In the Program of
Aerospace Engineering

Toronto, Ontario, Canada, 2011

©Amir Seif 2011

Author's Declaration

I hereby declare that I am the sole author of this thesis or dissertation.

I authorize Ryerson University to lend this thesis or dissertation to other institutions or individuals for the purpose of scholarly research.

A handwritten signature in black ink, appearing to be 'Arnell G. B. J.', written in a cursive style.

I further authorize Ryerson University to reproduce this thesis or dissertation by photocopying or by other means, in total or in part, at the request of other institutions or individuals for the purpose of scholarly research.

A handwritten signature in black ink, appearing to be 'Arnell G. B. J.', written in a cursive style.

MODIFIED LOGISTICAL CREEP STRAIN PREDICTION METHOD
A CONSTITUTIVE CREEP STRAIN MODEL OF A NICKEL BASED SUPER-ALLOY

MASTER OF APPLIED SCIENCE

2011

AMIR SEIF

AEROSPACE ENGINEERING

RYERSON UNIVERSITY

In turbine blade design, all three stages of creep are of concern. Moreover, for most commonly employed materials, creep rupture data is readily available where as long term creep strain data is not [1]. Recently, effort has been expended by many researchers in the development of material models incorporating all three stages of creep at varying stress and temperatures. Several developed models are complex or burdened by large numbers of material fitting constants. There is need for the development of a constitutive creep strain prediction formulation that is simplistic and requires minimal empirical data.

In this thesis, the creep strain model proposed by Holmstrom et al., called the Logistic Creep Strain Prediction (LCSP) method was modified and used to model all three stages of creep of the well known nickel based super alloy Inconel 718 [1]. The LCSP is robustness and accurate, and possesses a simplistic formulation ideal for algebraic manipulation and differentiation making it a very attractive solution.

ACKNOWLEDGEMENTS

I would like to thank, first and foremost, my Academic Supervisor Doctor Kamran Behdinan for taking an interest in me and guiding me through this process. I am forever grateful to Doctor Jeffrey W. Yokota for encouraging me to pursue Postgraduate studies. I recognize Doctor Jason V. Lassaline for his long standing support of my academic career and his guidance. I wish to acknowledge my RIADI Supervisor Chao Zhang for instilling an interest in creep phenomenon and creep modeling. Finally, a special thanks to my personal computer programmer Mohammed Buttu for his contribution and consultation in this research endeavour. All of the distinguished persons mentioned above have given me support and guidance that is invaluable.

DEDICATION

I'd like to dedicate this endeavour to my parents Faisal and Pierrette Seif. They nurtured me and told me I could do whatever I set my mind too. Thanks Mom and Dad. I'd also like to dedicate my efforts to my beautiful wife, Hana Alziadeh, for her endearing love and support. It's just a memory now Dad!

TABLE OF CONTENTS

Chapter 1	Introduction.....	1
1.1	Research Motivation & Goals	1
1.2	The Concept of creep	2
1.3	Primary/Secondary Creep.....	4
1.4	Tertiary Creep	7
Chapter 2	Literature Survey	9
2.1	Historical Background	9
2.2	Rabotnov-Kachanov Method.....	12
2.3	Theta θ Projection Method.....	14
2.4	Omega (Ω) Method.....	16
2.5	Logistic Creep Strain Prediction (LCSP) Method.....	17
Chapter 3	Theory & Application	19
3.1	ANSYS User-Programmable Features.....	19
3.2	LCSP Limits & constraints	20
3.3	LCSP user-defined creep equations.....	22
Chapter 4	Procedure	24
4.1	Material Data Collection.....	24
4.2	Creep Strain Curve Fitting.....	26
4.3	Fortran Compiling and Linking	29
4.4	CATIA V5 Geometry Creation.....	29
4.5	Workbench Meshing.....	30
4.6	APDL Creep Analysis Input Files	32
Chapter 5	Results & Discussion.....	32
Chapter 6	Conclusion	42
Chapter 7	Recommendations & Future work.....	44
References	65

LIST OF TABLES

TABLE 1 SPECIFIC FITTING OPTIONS FOR MATERIAL CONSTANTS	29
TABLE 2 MATLAB LCSP CURVE FITTING RESULTS.....	33
TABLE 3 MATERIAL CONSTANT $\beta\sigma$	33
TABLE 4 MATERIAL CONSTANT $x\sigma, T$	34
TABLE 5 MATERIAL CONSTANT $p\sigma, T$	34
TABLE 6 LARSON-MILLER PARAMETER $LMP\sigma$	34
TABLE 7 IS TAKEN FROM ADVANCED MECHANICS OF MATERIALS [4 PP. 630-31].....	45

LIST OF FIGURES

FIGURE 1 IS A TYPICAL METAL CREEP CURVE, DISPLAYING ALL THREE STAGES [4].....	3
FIGURE 2 ILLUSTRATES THE TYPE OF CURVE EQUATION 1.4 PRODUCES [4].....	7
FIGURE 3 P – PRIMARY, S – SECONDARY, T – TERTIARY CREEP STAGES.....	11
FIGURE 4 ORIGINAL CREEP CURVES FROM YEOM ET AL [3].....	25
FIGURE 5 LISTS ELEMENT COMPOSITIONAL PERCENTAGE IN THE IN718 SAMPLES.....	25
FIGURE 6 POISSON'S RATIO (LEFT PLOT, SECOND COLUMN DIGITIZED DATA TABLE ON RIGHT) FROM AEROSPACE STRUCTURAL METALS HANDBOOK [2] AND MODULUS OF ELASTICITY (HIGH TEMP METALS COMPANY WEBSITE, FIRST COLUMN TABLE ON RIGHT) [23].....	26
FIGURE 7 CATIA SMOOTH AXI-SYMMETRIC CROSS-SECTION SKETCH.....	30
FIGURE 8 SURFACE GEOMETRY OF CATIA AXI-SYMMETRIC MODEL.....	31
FIGURE 9 AXI-SYMMETRIC SMOOTH SPECIMEN MESH.....	32
FIGURE 10 MATLAB GENERATED PLOT OF MATERIAL CONSTANT BETA VERSUS STRESS.....	35
FIGURE 11 EXAMPLE OF A LOGISTIC FUNCTION $f_x = 11 + e - x$	36
FIGURE 12 MATLAB GENERATED PLOT OF MATERIAL CONSTANT XO VERSUS LOGARITHMIC STRESS.....	37
FIGURE 13 MATLAB GENERATED PLOT OF MATERIAL CONSTANT P VERSUS STRESS.....	38
FIGURE 14 COMPARATIVE CREEP CURVE PLOT (109 KSI & 1112 °F).....	39
FIGURE 15 COMPARATIVE CREEP CURVE PLOT (123 KSI & 1112 °F).....	39
FIGURE 16 COMPARATIVE CREEP CURVE PLOT (138 KSI & 1112 °F).....	39
FIGURE 17 COMPARATIVE CREEP CURVE PLOT (58 KSI & 1292 °F).....	40
FIGURE 18 COMPARATIVE CREEP CURVE PLOT (65 KSI & 1292 °F).....	40
FIGURE 19 COMPARATIVE CREEP CURVE PLOT (80 KSI & 1292 °F).....	40
FIGURE 20 SNAP SHOT OF EXCEL TABULATED DIGITIZED CREEP STRAIN AND RESPECTIVE TIME DATA (YEOM ET AL.)[3].....	47

LIST OF APPENICES

APPENDIX A: TABLES AND CHARTS.....	45
APPENDIX B: ANSYS SOURCE CODE	48
APPENDIX C: MATLAB SOURCE CODE.....	55

NOMENCLATURE

- ε_c or ε : Creep strain
- $\dot{\varepsilon}_c$ or $\dot{\varepsilon}$: Creep strain rate
- σ : Stress
- T: Temperature
- t: Time
- t_f : Rupture time
- ω : Damage parameter
- $\dot{\omega}$: Rate of damage
- S_{ij} : Deviatoric Stress
- $\bar{\sigma}$: Equivalent stress
- σ_r : Rupture stress
- σ_1 : First principle stress
- θ_i : Theta projection constants where $i = 1,2,3,4$
- Ω : Omega method material parameter
- $\dot{\varepsilon}_0$: Imaginary initial strain
- α, β, x_0, p : Logistic Creep Strain Prediction Material Parameters
- $\Delta\sigma$: Incremental stress
- $\Delta\varepsilon$: Incremental strain

CHAPTER 1 INTRODUCTION

1.1 RESEARCH MOTIVATION & GOALS

In the aviation industry gas turbines push their components to the very limit of their thermal capacity. The ever increasing demand on the design of engines with greater thermal performance has spurred a major need in the development of models expressing all three stages of creep. The first two stages of creep for design are no longer adequate. Since, long term creep strain data is not as common as long term rupture time data, a need for the development of constitutive creep strain models has been incited. Models that are capable of predicting long term creep strain data from short term experiments, with a simple formulation. This research was motivated by the need of a constitutive formulation that encompassed the entire creep strain curve at varying stress levels and temperatures. The criteria of the development effort focused on a simplistic formulation, encompassing all three creep stages, requiring minimal empirical data and containing a minimal number of material fitting parameters. The criteria are derived from what is termed the goals of applicability. The goals of applicability are concerned with the following qualities:

- Ease of application
- Cost of application
- Versatility

Ease of application was met by the simplistic formulation of the modified LCSP and the minimal number of material fitting constants. Cost of application is met by the fact that the model for Inconel 718 could be developed from whatever empirical data could be found from the literature. Versatility is met by the evidence that the material constants of the modified LCSP are connected to the mechanisms of creep rather than the specific material. The implied connection of the material fitting constants and the mechanisms of creep would reason that the proposed model can be easily applied to other similar materials. The modified LCSP presented in this thesis fills the need of a constitutive creep strain prediction model, encompassing all three stages of creep. The modified LCSP also has the potential of giving greater understanding of the mechanisms of creep through state variable type material constants due to the constraints applied to them. Since a vast majority of proposed constitutive models have yet to be widely accepted or standardized through batteries of benchmarking exercises, most commercial Finite Element Method (FEM) software packages do not include full creep strain curve modeling in the default installation. Most FEM packages such as

ANSYS or ABACAS offer the user the ability to customize a user defined subroutine. In this research, the modified LCSP will be written into an ANSYS User-Programmable Feature (UPF). The user subroutine is an example of the modified LCSP's easy application and versatility. The UPF is discussed in greater detail in Chapter 3, section 3.1.

1.2 THE CONCEPT OF CREEP

The advancement of technology and the need for stronger materials for high temperature applications has driven researchers to study material behaviour at high temperature. Moreover, the need to understand the critical modes of failure at high temperature and the ability to predict failure is at the forefront of many engineering problems. A long standing interest has existed in creep phenomenon and its initial observation is obscured in the pages of human history. If someone were to try pinpointing a time in history as the beginning of major interest in the analysis of creep, one might choose the work of French engineer L. J. Vicat in 1834 as a beginning. Vicat's primary interest was in the application of wire for load-carrying members in suspension bridges. His observations lied within what is now accepted as the primary creep stage of the creep curve (Figure 1) [2].

At the beginning of the twentieth century, Phillips (1905) and Andrade (1910) introduced the concept of the full creep curve with the creep curves for iron and several other materials. Creep phenomenon is broken up into three stages, namely primary, secondary and tertiary. The three stages correspond to a decreasing, constant and increasing strain rate respectively. A typical creep strain versus time curve is presented in Figure 1.

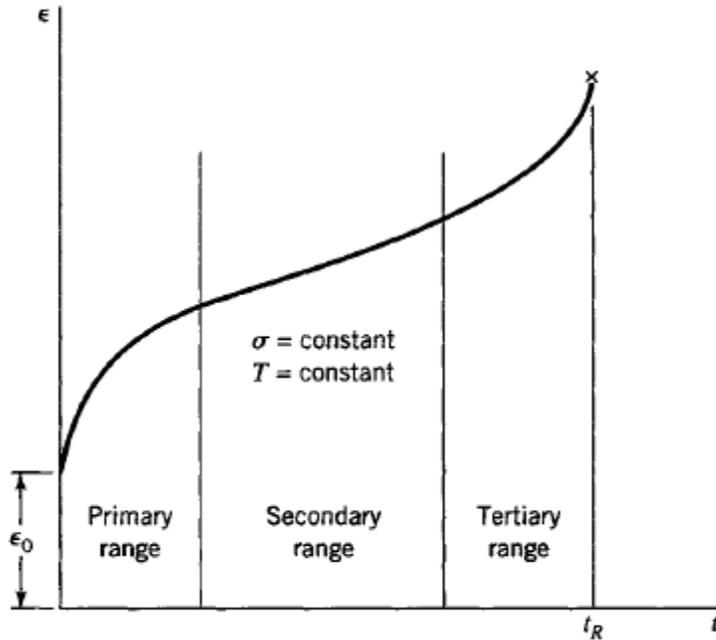


Figure 1 is a typical metal creep curve, displaying all three stages [2]

Since the achievements of Phillips and Andrade, the remainder of the twentieth century to the present is littered with the work of many in the study of creep behaviour. The resurgence of the industrial revolution required machinery that could operate at high temperatures for greater thermal efficiency. The advancements in aircraft technologies during the two Great World Wars required engine components that could handle greater temperatures as humanity moved into the jet age. During the late 1950's to the 1960's interest in nuclear power generation peaked another great surge in interest in the studies of creep analysis [2].

At present, there is great interest in creep modeling that incorporates all three stages of creep in a single unified model. This interest is driven by the demands of turbo-machinery technology which is found in both aircraft and power generation industries. Many researchers have developed and studied a plethora of modeling techniques, some of which will be discussed in the literature survey.

The remainder of this introduction is intended as a summary of the twentieth century equations and models describing individual creep stages or multiple stages at once. A literal description of the mechanisms and mechanics of the creep phenomenon will also be presented. There will, however, be little or no effort to present a detailed derivation of any equations in this section. This section is merely intended to introduce the concept and is in no way exhaustive. The equations presented in this section are intended to give an awareness of some of the commonly accepted fundamental

mathematical relations of the various stages of creep. Detailed derivation is left to the literature survey section detailing full creep curve modeling techniques, the primary interest of this thesis.

Since the creep phenomenon is a complex material behaviour, its analysis is often based on curve-fitting of experimental creep data. Typically, an effort is made to describe creep strain ϵ_c or creep strain rate $\dot{\epsilon}_c$ as a function of stress σ , temperature T , and time t . The relations and models producing constitutive equations are most commonly derived by one of three methods [2; 3],

- Phenomenological (macroscopic, empirical): Derivation of empirical formulas that model experimental data
- Physical (microscopic): Derivation of equations based on metallurgical creep mechanisms
- Physical-Phenomenological (micro-macroscopic): As its name implies these types of equations combine the first two types. These formulations are dominated by state variables representing prevailing creep mechanisms.

Table 7 is duplicated in APPENDIX A: Tables AND CHARTS

from Advance Mechanics of Materials of empirical one-dimensional creep formulas [2]. Table 7 is a good summary of the generally accepted equations and concepts developed over the twentieth century.

The proceeding sections of the introduction will briefly give a literal description of the mechanisms controlling the different stages of creep. The literal description will be followed by a discussion of some of the basic mathematical relations describing the stage. First the Primary/Secondary stages will be discussed as they are similar in mechanism. Finally, the introduction will finish off with a discussion on the tertiary creep stage.

1.3 PRIMARY/SECONDARY CREEP

Dislocation creep theory is based on the principle of crystallographic dislocation of a material's atoms arranged in a crystal structure or lattice. The atoms dislocate by means of gliding along their slip planes, but are not restricted to glide only. The atoms can climb, meaning they are not forced to only move along their slip planes. Dislocation theory is the premise that a material is hardened with deformation and softened with time [3]. The primary and secondary creep stages are characterized by this process of simultaneous hardening and softening. The concept was first coined by Bailey and Orowan.

At high temperatures roughly one-third of the absolute material melting temperature, dislocations obtain a new degree of freedom. This degree of freedom is climb. The climb mechanism allows for the gradual freeing of dislocations previously created by increasing strain. The strain dependent dislocation or glide dislocation can be halted by obstacles such as other dislocations or second-phase particles. The dislocation is said to recover if it undergoes a climb mechanism, releasing the dislocation to slide to the next obstacle. The glide mechanism is the principal creep mechanism of the primary stage. The glide-climb mechanism is dubbed the hardening-recovery mechanism. Hardening is the process of the dislocation being restrained by an obstacle and recovery is the freeing of the dislocation by climb.

Empirical evidence would suggest the dislocations are arranged in a network. Creep consists of continuous events of recovery and hardening within this network. Network consistency is ensured by the repulsive and attractive forces among the dislocations.

The stress and high temperature subjected dislocations lengthen and therefore increase in density. This causes strain and hardening to increase. At the initiation of the stress the glide mechanism is predominate such that there is initially a large number of loosely connected dislocations. This results in a high initial creep strain rate. Eventually, the number of loosely held dislocations is reduced over time which gives the primary stage's characteristic decreasing strain rate (hardening). The decreasing strain rate or hardening process is countered by the recovery mechanism (softening). The climb trend is increasing with increasing dislocation density over time. Finally, equilibrium is achieved by both mechanisms of hardening and softening. The effect is a steady state creep rate or the beginning of the secondary creep stage.

The objective of mathematical descriptions of material phenomenon is to accurately relate empirically determined values of creep strain, stress, temperature and time. The developed mathematical relation can take the form of a single equation or a system of equations. Historically, efforts have been centered to the fitting of single portions of the creep curve.

The primary creep stage, characterized by a monotonic decrease in creep strain rate, strain ϵ can be described simplistically by the time-hardening-theory.

$$\epsilon = A\sigma^n t^m \quad \text{Equation 1.1}$$

The variables σ and t are constant uniaxial stress and temperature respectively. The parameters A, n and m are temperature dependent material constants determined from uni-axial stress creep tests.

Furthermore, differentiating Equation 1.1 with respect to time (t), the creep rate $\dot{\epsilon}_c$ can be determined as,

$$\dot{\epsilon}_c = Am\sigma^n t^{m-1} \quad \text{Equation 1.2}$$

If time t is substituted from Equation 1.1 into Equation 1.2, we get the relation,

$$\dot{\epsilon}_c = m A^{1/m} \sigma^{n/m} \epsilon_c^{(m-1)/m} \quad \text{Equation 1.3}$$

Equation 1.3 is referred to as the strain-hardening-theory [4].

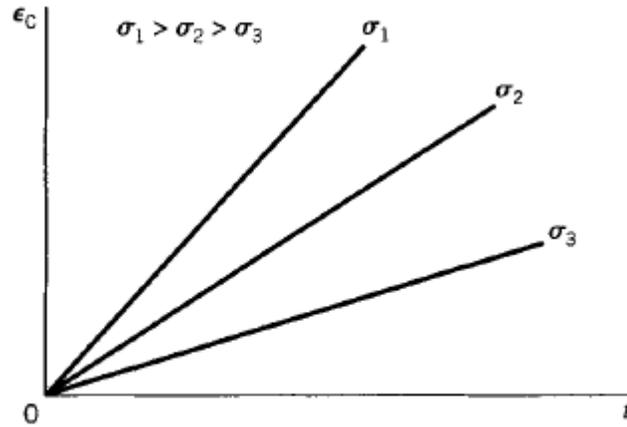
Both time-hardening and strain-hardening theories are default models provided in Ansys mechanical modeling software. Among the two theories mentioned above, Generalized Exponential, Generalized Graham, Generalized Blackburn, Modified Time-Hardening, and Modified Strain-Hardening are the available default primary creep models available in Ansys 12 Finite Element Method (FEM) software package.

Secondary stage creep is similar in behaviour to pure plastic behaviour. Moreover, creep deformations “of metals will usually be uninfluenced if a hydrostatic pressure is superimposed” [4]. A similar behaviour observed of pure plastic deformations and, as such, creep can be described by methods employing the mathematical theories of plasticity. The secondary stage can also be described by its characteristic constant strain rate, at constant stress level and temperature.

For uni-axial tensile tests all at the same temperature but different stress levels, the constant creep strain rate of the secondary stage can be described as a function of the stress level σ [2 p. 635]:

$$\dot{\epsilon}_c = \dot{\epsilon}_{sc}(\sigma) \quad \text{Equation 1.4}$$

Equation 1.4 ignores primary and tertiary stages and is only applicable to situations when a component exhibits a curve that appears dominated by a secondary creep stage. In this instance creep strain is approximated by straight lines such as those in Figure 2.



Straight-line approximation of creep curves.

Figure 2 illustrates the type of curve Equation 1.4 produces [2]

Models employing formulations such as Equation 1.4 are termed steady-state creep models. Equation 1.3 or the strain-hardening-theory can be used to model both primary and secondary stages together. Available default creep models in Ansys 12 are, Generalized Garofalo, Exponential Form, or Norton.

1.4 TERTIARY CREEP

The final stage of creep before rupture is the tertiary stage. This stage is characterized by an exponentially increasing creep strain rate. The increasing strain rate is related to the damage accumulation within the internal crystalline structure of the material. The dislocation mechanisms of the primary/secondary stages cause cavities (microscopic cracks) on the grain boundaries. These cavities are initially small and have negligible effect on the strain rate. However, with increasing time and creep strain the cracks grow and meet to form larger cavities. Eventually, the growing creep damage becomes a prominent factor in the behaviour of the strain rate. It is at this point the characteristic exponentially increasing strain rate of the tertiary stage can be observed [3; 4].

Other forms of damage may arise such as void formation from a certain stress history. Less certain, but still of interest is the effect of oxidation on or below the surface causing microscopic cavities [3].

Hence, was born an interest and study of damage mechanics and specifically continuum damage mechanics (CDM) methods. However, there has been little benchmarking to date on CDM methods and therefore it is often difficult to “establish the accuracy of the numerical formulations”

[5]. Since it is difficult to establish the accuracy of such methods, commercial general-purpose Finite Element (FE) codes leave it to the individual users to incorporate in-house FE codes.

Among some of the modeling methods explored in this paper are Theta-Projection, Omega, and Typical Katchanov-Robotnov (CDM) and Logistic Creep Strain Prediction methods. The descriptions of the methods are left to the section within the literature survey entitled continuum damage mechanics Methods.

CHAPTER 2 LITERATURE SURVEY

Initially, the literature survey served to familiarize the author with not only previously proposed creep models encompassing the entire creep strain curve, but also the mechanics and basic mathematical relations of the creep phenomenon. It became apparent at the beginning of this study that the subject of creep was immense and that a focus was going to be required. A literature survey that encompassed a review of the major historical mathematical relations developed in twentieth century would be a task in itself. The primary goal of this research project is the development of a procedural method in modeling a material's entire creep strain evolutionary curve. This was to be done by choosing an appropriate existing creep model that fits the development criteria outlined previously. As a consequence this literature review reflects the main formulations of interest that were considered for use in this thesis.

2.1 HISTORICAL BACKGROUND

There has been a great deal of interest within the past century in the study of creep behaviour and development of modelling techniques. Arguably the first researcher to introduce the concept of the creep strain curve with all three stages as it is known today was Andrade [6]. Initially, many scientists approached the analysis of creep modeling within its individual stages. One of the most well known formulations is the Norton-Bailey relation:

$$\dot{\epsilon} = \sigma^{\hat{n}} \exp\left(-\frac{\hat{Q}}{RT}\right) \quad \text{Equation 2.1}$$

Where \hat{n} and \hat{Q} are material constants and R, T and σ are the global constant, absolute temperature and applied constant stress respectively. However, as remarked by Batsoulas, "the use of this relation in the design means that (i) the creep curve is a straight line, (ii) the initial and tertiary creep are neglected, and (iii) the rate of secondary creep, $\dot{\epsilon}_m$ (and the creep life, t_f) is, essentially defined as the exclusive designing parameter"[3]. As might be imagined this is simply unacceptable in most, if not all serious creep analysis of modern components. The majority of relations developed early in this century till relatively recently have tackled one or two stages of the creep and not the entire curve. Batsoulas lists several of these concerning the first and second creep stages. Herein, only a few representing some of the more well known relations will be reproduced.

Andrade's Relation

$$\varepsilon = \exp[\ln(1 + \varepsilon_0) + \ln(1 + Z_1 t)^{1/3} + Z_2 t] - 1 \quad \text{Equation 2.2}$$

Mott and Nabarro's relation

$$\varepsilon = \varepsilon_0 [\ln(1 + Z_1 t)]^{2/3} \quad \text{Equation 2.3}$$

McVetty and Garofalo's relation

$$\varepsilon = \varepsilon_0 + Z_1(1 - e^{-b_1 t}) + Z_2 t \quad \text{Equation 2.4}$$

Andrade, Nabarro, Garofalo and many other notable scientists are found in the literature for their contributions to the understanding of creep. As some of their postulated relations became accepted researchers of the present are modifying the old to create more robust and accurate all encompassing relations. Some of the relations accepted as fundamental formulations are found in popular Finite Element Method (FEM) software packages such as a generalized Garofalo relation in ANSYS 12.

Recently, there have been efforts by some researchers to compile and provide benchmarks of some of the past proposed creep strain models [3; 7; 8]. Figure 3 is a table taken from the European Creep Collaborative Committee's (ECCC) publication entitled, Recommendations and Guidance for the Assessment of Creep Strain and Creep Strength Data [8; 9]. The table is a modest compilation of models most commonly used by organizations currently active in the ECCC.

MODEL EQUATION	EQN REF	RANGE OF APPLICATION	
		REGIME	MATERIALS
Norton [1]	<i>i)</i>	S	low/high alloy ferritic & austenitic steels, Ni-base alloys, non-ferrous alloys
Mod-Norton	<i>ii)</i>	S	Ni-base alloys
Norton-Bailey	<i>iii)</i>	P/S	low/high alloy ferritic & austenitic steels
RCC-MR [2]	<i>iv)</i>	P/S	low alloy ferritic steels & austenitic steels
Bartsch [3]	<i>v)</i>	P/S	low/high alloy ferritic, austenitic steels
Garofalo [4]	<i>vi)</i>	P/S	low/high alloy ferritic & austenitic steels, Ni-base alloys, non-ferrous alloys
Mod-Garofalo [5]	<i>vii)</i>	P/S/T	low/high alloy ferritic steels, Ni-base alloys
BJF [6]	<i>viii)</i>	P/S	high alloy ferritic steels
Theta [7]	<i>ix)</i>	P/S/T	low/high alloy ferritic & austenitic steels, Ni-base alloys, non-ferrous alloys
Mod-Theta	<i>x)</i>	P/S/T	low/high alloy ferritic, austenitic steels, Al-alloys, Al-matrix composites
Graham-Walles [8]	<i>xi)</i>	P/S/T	<i>to be advised</i>
Classical strain hardening	<i>xii)</i>	S/T	<i>to be advised</i>
Rabotnov-Kachanov [9]	<i>xiii)</i>	P/S/T	low alloy ferritic steels
Baker-Cane [10]	<i>xiv)</i>	P/S/T	low alloy ferritic steels
Dyson-McLean [11]	<i>xv)</i>	P/S/T	low alloy ferritic steels, Ni-base alloys
I.Mech.E [12]	<i>xvi)</i>	P/S	CMn, low/high alloy ferritic & austenitic steels
Bolton [13]	<i>xvii)</i>	P/S/T	low/high alloy ferritic & austenitic steels
Omega [14]	<i>xviii)</i>	S/T	low/high alloy ferritic steels

Figure 3 P – Primary, S – Secondary, T – Tertiary creep stages.

In the past two or three decades, a shift was made to model the creep curve in its entirety. Either, it was to be modelled by macroscopic phenomenological curve fitting techniques, or continuum damage mechanics (CDM) approaches incorporating state variables corresponding to the dominant physical procedures of damage [3]. Three methods listed in Figure 3 were of particularly interest, the Rabotnov-Kachanov, Theta and Omega models. Additionally, one other model is presented and described in addition to the aforementioned methods. The Logistic Creep Strain Prediction (LCSP) model developed by Holmstrom and Auerkari is the final model studied in this paper. The LCSP model is a phenomenological model or a non-linear asymmetric transition function with regulated steepness, as described by its authors [10]. A detailed description of the Rabotnov-Kachanov, Theta, Omega and LCSP models is provided in the ensuing subsections of the literature survey.

2.2 RABOTNOV-KACHANOV METHOD

Kachanov has been dubbed the founder and developer of classical Continuum Damage Mechanics or CDM as it is referred to. His original work has been revised and adapted by many researchers with considerable success to many applications [3; 7; 11; 12; 13].

Initially, Kachanov introduced the concept of CDM for the case of creep damage [13]. He represented the accumulation of damage as the loss in material cross-section, due to cavitation [14]. His initial concept took the form,

$$\varphi = A/A_0 \quad \text{Equation 2.5}$$

φ is Kachanov's damage parameter he called the 'continuity'. The state variable 'continuity' is defined as the ratio of the remaining effective area (A) to the initial area (A_0). This continuity state variable could be taken a step further to relate to initial stress (σ_0) and effective stress (σ) as,

$$\sigma = \sigma_0 A_0 / A \quad \text{Equation 2.6}$$

In Equation 2.6, the effective stress is increasing due to increasing damage or decreasing effective area (A). Later Rabotnov would modify Kachanov's state variable 'continuity' concept with the damage parameter ω . The new damage parameter is defined as,

$$\omega = 1 - \varphi = 1 - A/A_0 \quad \text{Equation 2.7}$$

Equation 2.6 can be re-written to reflect Rabotnov's modification as,

$$\sigma = \sigma_0 / (1 - \omega) \quad \text{Equation 2.8}$$

Eventually, with the combined effort of Kachanov, Rabotnov, and Hayhurst and co-workers, the damage rate ($\dot{\omega}$) would be expressed in terms of applied stress and current state of damage (ω) as,

$$\dot{\omega} = C \sigma_0^x / (1 - \omega)^\phi \quad \text{Equation 2.9}$$

The constants C , x , and ϕ are material constants. Two more fundamental equations can be derived using the conditions that $\omega = 0$ at $t = 0$, $\omega = 1$ at $t = t_f$ (t is time and t_f is time to failure). Integrating Equation 2.9 using the conditions described above gives,

$$t_f = \sigma_0^{-x} / (C(1 + \phi)) \quad \text{Equation 2.10}$$

Finally, the instantaneous damage state can be derived as,

$$\omega(t) = 1 - (1 - t/t_f)^{1/(1+\phi)} \quad \text{Equation 2.11}$$

In 1958 Kachanov proposed a modified Norton's creep rate equation utilizing his effective stress for the applied stress used in the original Norton's equation [14]. The modified Norton's steady state creep rate equation took the form,

$$\dot{\varepsilon}_s = G\sigma^n = G(\sigma_0/(1 - \omega))^n \quad \text{Equation 2.12}$$

Equation 2.12 is suitable for uni-axial secondary/tertiary creep modeling.

A commonly used single-state variable constitutive multi-axial stress equation based on the original Kachanov type equation takes the form [12],

$$\frac{d\varepsilon_{ij}^c}{dt} = \frac{3}{2} A' \left(\frac{\bar{\sigma}}{1 - \omega} \right)^n \frac{S_{ij}}{\bar{\sigma}} t^m \quad \text{Equation 2.13}$$

Here, S_{ij} and $\bar{\sigma}$ are the deviatoric and equivalent stresses respectively and A' , n and m are material constants. Researchers such as Hyde, Becker, Sun and many others have found success in a variety of applications employing Kachanov adaptations such as Equation 2.13 in their work [12]. Accompanying Equation 2.13 is the rate of change of the damage parameter which takes the form [7],

$$\frac{d\omega}{dt} = M \frac{(\sigma_r)^\chi}{(1 + \phi)(1 + \omega)^\phi} t^m \quad \text{Equation 2.14}$$

Where M , ϕ and χ are continuum damage material constants. In Equation 2.14, σ_r is a rupture stress that can be calculated by [7],

$$\sigma_r = \alpha\sigma_1 + (1 - \alpha)\bar{\sigma} \quad \text{Equation 2.15}$$

In Equation 2.15 α is a material constant that ranges from 1 (maximum first principle stress dominant) to 0 (equivalent or Von Mises stress dominant) [7].

Equation 2.13 to Equation 2.15 can be applied to multi-axial stress cases that lie primarily in the secondary/ tertiary creep stages. The equations can be modified to incorporate the primary creep stage [7].

As it stands, the Kachanov based equations 2.13 to 2.15 have a total of 9 material constants. This formulation does not even include the primary creep region.

The Kachanov style formulation represented in this section was eliminated during the selection process on several accounts. The number of material constants required implies the need for a great deal of material data for accurate modeling of creep strain curve family. The model would not be easily integrated into a FEM software package. It was concluded that a Kachanov style model would

not best achieve the development criterions of the proposed constitutive modeling procedural method.

2.3 THETA Θ PROJECTION METHOD

The Theta Projection (TP) method is a parametric method used to obtain approximations of long-term creep strain or time data from short term experimental creep data [15]. The TP method is one that has gained some favour among researchers as a promising constitutive creep formulation. The TP method expresses creep strain evolution with respect to time in the form,

$$\varepsilon_c = \theta_1(1 - e^{-\theta_2 t}) + \theta_3(e^{\theta_4 t} - 1) \quad \text{Equation 2.16}$$

Where ε_c is creep strain, t is time to specific creep strain, θ_i terms are experimentally determined material constants [16]. The method attempts to perform two functions, empirically fitting experimental strain-time data and provide insight into the processes characteristic of creep damage mechanics [16]. Though this method is not explicitly a CDM approach, it does however have similar attributes as it relies on the failure mechanisms of both primary and tertiary creep.

The first group of terms in Equation 2.16 model's the primary stage and the second group of terms models tertiary. Any constant secondary creep stage is considered an inflection in the curve. In other word, the first group is representative of the primary stages characteristic hardening process. The second group is representative of the tertiary stages mechanism of accumulated damage or softening. The balancing of the two groups of terms results in an equilibrium being achieved. This equilibrium is representative of the secondary stage. Furthermore, though the TP method does not contain any damage parameter, it is reminiscent of the Kachanov damage state variable concept.

The creep strain rate can be defined by differentiating Equation 2.16 to give,

$$\dot{\varepsilon}_c = \theta_1\theta_2 e^{-\theta_2 t} + \theta_3\theta_4 e^{\theta_4 t} \quad \text{Equation 2.17}$$

The theta θ_i terms can be expressed as functions of applied constant stress σ and temperature T as,

$$\log \theta_i = A_i + B_i\sigma + C_iT + D_i\sigma T \quad (i = 1,2,3,4) \quad \text{Equation 2.18}$$

The theta terms vary approximately linearly with respect to stress and temperature [16]. It has been shown that the TP method is capable of predicting creep rupture strains as a function of stress and temperature.

$$\varepsilon_{cr} = A_i + B_iT + C_i\sigma + D_i\sigma T \quad (i = 5) \quad \text{Equation 2.19}$$

The TP method is a favourable creep strain evolution formulation. It has become more widely used as its advantage and flexibility have become appreciated [3; 15; 16; 17]. Despite the fewer number of

material constants than a Kachanov style CDM method, there still exists a modeling formulation incorporating some well established relations with fewer material constants. Moreover, the TP method appears more dependent on empirical data to accurately model a family of creep curves. It was believed that the TP method would be dependent on the number of points defining a single curve of a family of curves in order to adequately model its shape. Furthermore, several curves at multiple conditions would be required with a great deal of data to extrapolate/interpolate other curves within that same family of curves. It was concluded that a model with even fewer material constants was required and a model that could utilize master curve data such as the Larson-Miller relation to specified creep strains and creep rupture time. For the abovementioned reasons, the TP method was eliminated as the modeling choice.

2.4 OMEGA (Ω) METHOD

Developed by the Materials Properties Council (MPC) and presented by Prager, the MPC Omega method is founded on the premise that the current creep strain rate along with a brief history of creep strain rates is adequate to predict past and future creep behaviour of a component [12]. The MPC Omega (Ω) method has received some interest from several researchers [12; 18].

The Ω method relies on the premise that a materials ability to resist a given stress decreases with increasing creep damage. Creep strain rate $\dot{\epsilon}_c$ is therefore defined by,

$$\dot{\epsilon}_c = \dot{\epsilon}_0 \cdot e^{\Omega \cdot \epsilon_c} \quad \text{Equation 2.20}$$

Where $\dot{\epsilon}_0$ is the imaginary initial creep strain rate, ϵ_c is creep strain (at some time), Ω is the omega material parameter. A small primary creep region results in a $\dot{\epsilon}_0$ that is near the minimum creep strain rate (secondary creep stage).

The factor material parameter omega is implicitly a function of stress, mechanical damage and micro-structural changes [18]. Integrating Equation 2.20 with respect to time gives a relation with strain and time t.

$$t = \frac{1}{\dot{\epsilon}_0 \cdot \Omega} (1 - e^{-\Omega \cdot \epsilon_c}) \quad \text{Equation 2.21}$$

Finally, at large values of $\Omega \cdot \epsilon_c$, such as those at creep rupture. The value of the exponential term in Equation 2.21 can be considered negligible. Moreover, creep rupture time t_r can be approximated as [18],

$$t_r \approx \frac{1}{\dot{\epsilon}_0 \cdot \Omega} \quad \text{Equation 2.22}$$

The imaginary initial strain rate $\dot{\epsilon}_0$ and omega Ω parameters are stress and temperature dependent. The determination of the appropriate fitting function that relates stress and temperature for either parameter is material dependent (i.e. polynomial, exponential). For instance, Jong-Taek Yeom et al. initially chose an exponential power law to express the material parameter with respect to stress and temperature. It was found that the developed power law expressions did not fit the material parameters accurately, and a hyperbolic sine formulation was used to describe imaginary initial strain rate $\dot{\epsilon}_0$ and omega Ω parameters as functions of stress and temperature [18].

At first glance the MPC Ω method appeared very promising. However, of concern was the fact that the type of curve required to fit the material parameters (polynomial, exponential, etc.) is material

dependent. This would be a serious disadvantage when trying to develop a creep model that can be somewhat standardized for multiple materials for application in a user-defined creep model in a FEM software package. The number of constants and the accuracy of the MPC model are not in question, but the concern over curve fitting issues even among similar materials disqualified this model as a choice for the development of the proposed constitutive creep strain procedural method.

2.5 LOGISTIC CREEP STRAIN PREDICTION (LCSP) METHOD

The Logistic Creep Strain Prediction (LCSP) model, developed by Holmstrom and Auerkari, is a logistic non-linear asymmetric transition function that fits logarithmic strain versus time in its basic form. The LCSP model relies on time to rupture to control the end point of each curve. Time to rupture can be provided via true data or master curve predicted data such as that predicted by a Larson-Miller relation. The formulation of the LCSP provides three parameters for data fitting each curve or curve family (β, x_0, p) . A unique feature of the LCSP formulation is that strain as a function of time and strain rate as a function of time can all be determined algebraically. The equation of the LCSP is described as logarithmic time t to specified logarithmic strain ε at engineering stress and temperature as [10],

$$\log t = \frac{\log \alpha t_r + \beta}{1 + \left(\frac{\log \varepsilon}{x_0}\right)^p} - \beta \quad \text{Equation 2.23}$$

Where t_r is the time to rupture and x_0, p, β and α are fitting factors. In its simplest form the fitting factors are found to be constants. However, typically some of the fitting factors will be a function of stress and temperature. Equation 2.23 can be re-written algebraically to describe strain as a function of time as,

$$\log \varepsilon = (LTF - 1)^{1/p} x_0 \quad \text{Equation 2.24}$$

Where,

$$LTF = \frac{\log(\alpha t_r) + \beta}{\log t + \beta} \quad \text{Equation 2.25}$$

It should be noted, equations 2.23 - 2.25 implies that at strain $\varepsilon_t = 1$ the time to rupture is attained, assuming $\alpha = 1$. The variable α can be used to correct the strain at time to rupture to correspond to the actual creep ductility. For most creep ductile materials, however, this is most likely not necessary [10].

Moreover, differentiating Equation 2.25 with respect to time gives the algebraic expression for creep strain rate as,

$$\dot{\varepsilon} = -\varepsilon \cdot k_1 \cdot k_2 \cdot x_0 \quad \text{Equation 2.26}$$

Where ε is determined by Equation 2.24, and

$$k_1 = \frac{(LTF - 1)^{1/p}}{p} \quad \text{Equation 2.27}$$

And

$$k_2 = \frac{\log(\alpha \cdot t_r) + \beta}{[\log t + \beta]^2 \cdot t \cdot (LTF - 1)} \quad \text{Equation 2.28}$$

The LCSP method is attractive for several reasons. First, if we assume $\alpha = 1$ the model is reduced to a total of three fitting material constants that can be determined by a minimal amount of actual data or master curve data. Furthermore, the formulation is easily manipulated algebraically from one form to another, which is ideal for characterizing creep in terms of creep strain or creep strain rate. The LCSP's robust and simplistic nature made it the ideal constitutive model for application in this research.

CHAPTER 3 THEORY & APPLICATION

3.1 ANSYS USER-PROGRAMMABLE FEATURES

ANSYS provides thirteen creep formulations for implicit analysis. The Norton law and Blackburn model are examples of the models available in ANSYS implicit creep analysis [19]. Despite the many included implicit creep analysis tools, some users may wish to use a customized creep equation that has already been validated through testing. Or perhaps, the application of a damage parameter is required for a certain application. The creep laws that come preinstalled assume creep is to be used in design rather than failure analysis and as a consequence the available creep laws are meant to model primary and secondary creep only.

In order to surmount this limitation ANSYS provides a means of allowing the user the ability to customize a user defined creep subroutine via ANSYS User-Programmable Features (UPF). Since, ANSYS has an open architecture it allows the user to write their own routines or subroutines in C or FORTRAN. The routines or subroutines can either be linked to ANSYS or used externally as commands [20]. Therefore, using UPF's the user can tailor the ANSYS program to their specific needs.

The UPF of particular interest in this research is the `usercreep.F` subroutine. The `usercreep` subroutine is activated by “the TB command with the CREEP option and with TBOPT =100” [20]. For the `usercreep` subroutine, a uniaxial creep law can be used which will be generalized to the multi-axial state by the general time-dependent viscoplasticity material formulation implemented in ANSYS.

The original ANSYS installation provides a `usercreep.F` file, as source code based on the strain hardening law $TBOPT = 1$ [19]. The `usercreep.F` source code provided with the original installation is reproduced in Appendix B, Source Code 1.

Available variables for use in the subroutine are effective creep strain or time, effective stress, and temperature. Also available is hydrostatic pressure [19]. The `TBDATA` command used in creating a material model input file is used to input the creep material constants right after the `TB, CREEP, , , ,100` command is given. Other temperature dependent material properties such as Modulus of Elasticity are also input in this way. For specifics on material property input, the user manuals provided with the ANSYS installation can be reviewed. Moreover, an example of a material property input file is provided in Appendix B, Source Code 3.

Three outputs are required by ANSYS for the calculation of creep strain from the subroutine. First, the incremental creep strain designated ‘delcr’ is required. The last two outputs required are, “the derivatives of the incremental creep strain with respect to effective stress and creep strain, which are dcrda(1) and dcrda(2), respectively” [19]. It is crucial that these derivatives are calculated correctly as ANSYS requires them to calculate the material tangent stiffness matrix. Miscalculating the derivatives can negatively impact the convergence behaviour and accuracy of the subroutine. In the case that the model to be used is complex and the derivative cannot be evaluated directly, it is suggested that numerical differentiation be used [19]. Therefore from first principles, dcrda(1) would take the form,

$$\text{dcrda}(1) = \frac{\text{delcr}(\sigma + \Delta\sigma) - \text{delcr}(\sigma)}{\Delta\sigma} \quad \text{Equation 3.1}$$

The value of stress increment ($\Delta\sigma$) is a very small arbitrarily chosen number that may require adjustment to achieve acceptable accuracy. The value of dcrda(2) would take a similar form to Equation 3.1 with creep strain increment ($\Delta\epsilon$) in place of stress increment.

ANSYS UPF usercreep.F subroutine was implemented using the LCSP method as the means of constructing and analysing creep material properties of all three stages of the creep strain curve of Inconel 718. The derivation of the equations used in the source code which is reproduced in Appendix B, Source Code 2, will be covered in the next section entitled LCSP. The specific equations used to calculate the values of incremental creep strain, dcrda(1) and dcrda(2) are derived in the next section.

3.2 LCSP LIMITS & CONSTRAINTS

Upon careful observation of the original LCSP formulation, two limitations can be identified. The original LCSP formulation, time to specified strain is reiterated below for convenience.

$$\log t = \frac{\log \alpha t_r + \beta}{1 + \left(\frac{\log \epsilon}{x_0}\right)^p} - \beta \quad \text{Equation 2.23}$$

The condition of creep strain (ϵ) equal to zero, would imply time to specified strain (t_ϵ) is also zero. However, if zero is subbed into the left side of Equation 2.23, a complex value results. In order to avoid the calculation of a complex value, a value of one is added to each value of time to specified strain such that Equation 2.23 can be re-written as,

$$\log(t + 1) = \frac{\log \alpha t_r + \beta}{1 + \left(\frac{\log \varepsilon}{x_0}\right)^p} - \beta \quad \text{Equation 3.2}$$

Although, typically researchers and engineers are not concerned with cases where rupture time is zero, for completeness the same logic was applied to rupture time (t_r) and Equation 3.2 is re-written to take the form,

$$\log(t + 1) = \frac{\log(\alpha(t_r + 1)) + \beta}{1 + \left(\frac{\log \varepsilon}{x_0}\right)^p} - \beta \quad \text{Equation 3.3}$$

The final constraint of the original LCSP involves the denominator of the right side of Equation 2.23. It is possible to calculate a complex value in the denominator in two situations. In both cases the value of the material constant p , which is fractional, has an even denominator (eg. If $p = 3.5 = 7/2$). A complex value will be calculated if $\log \varepsilon$ is negative which will result from any creep strain value less than 1. Finally, a negative value of the material constant x_0 can produce a complex value in the denominator of Equation 2.23. Therefore, a value of one is added to each value of creep strain such that Equation 3.3 is further modified to give,

$$\log(t + 1) = \frac{\log(\alpha(t_r + 1)) + \beta}{1 + \left(\frac{\log(\varepsilon + 1)}{x_0}\right)^p} - \beta \quad \text{Equation 3.4}$$

Furthermore, to avoid the calculation of a complex value or infinity a lower limit is imposed on the material constant x_0 , specifically,

$$x_0 > 0 \quad \text{Equation 3.5}$$

In this research, MATLAB software and FORTRAN are used as a mathematical computer aid and programming language of the subroutine respectively. In both software packages the command log is the natural logarithm (ln). Therefore, all logarithms of the LCSP are interpreted as natural logarithms. This was done primarily for aesthetic purposes of the programming of any m code or FORTRAN programming.

Finally, the LCSP method was developed with the fitting of creep strain as a percent, but ANSYS calculates strain as a fraction. Therefore, fractional strain is multiplied by one hundred percent and Equation 3.4 takes it's finally form as,

$$\log(t + 1) = \frac{\log(\alpha t_r + 1) + \beta}{1 + \left(\frac{\log(100\varepsilon + 1)}{x_0}\right)^p} - \beta \quad \text{Equation 3.6}$$

In its final modified form (Equation 3.6), creep strain (ε), is interpreted as fractional strain. Moreover, Equation 3.6 can be algebraically rearranged for creep strain as,

$$\varepsilon = \left(e^{x_0(LTF-1)^{1/p}} - 1 \right) / 100 \quad \text{Equation 3.7}$$

Where LTF is now,

$$LTF = \frac{\log(\alpha t_r + 1) + \beta}{\log(t_\varepsilon + 1) + \beta} \quad \text{Equation 3.8}$$

The creep strain rate is found by taking the derivative of Equation 3.7 with respect to time, which follows,

$$\dot{\varepsilon} = -x_0 \cdot k_1 \cdot k_2 \cdot (\varepsilon \cdot 100 + 1) \quad \text{Equation 3.9}$$

In Equation 3.9 creep strain can be calculated via Equation 3.7 and k_1 and k_2 are,

$$k_1 = \frac{(LTF - 1)^{1/p}}{p} \quad \text{Equation 3.10}$$

And,

$$k_2 = \frac{\log(\alpha \cdot t_r) + \beta}{100 \cdot (1 + t) \cdot (\log(t + 1) + \beta)^2 \cdot (LTF - 1)} \quad \text{Equation 3.11}$$

3.3 LCSP USER-DEFINED CREEP EQUATIONS

As mentioned previously, ANSYS requires three outputs from the user subroutine for analysis. The first of these outputs is incremental creep strain or $delcr$, which from Equation 3.9 takes the form,

$$d\varepsilon = -x_0 \cdot k_1 \cdot k_2 \cdot (\varepsilon \cdot 100 + 1) \cdot dt = delcr \quad \text{Equation 3.12}$$

Here dt is incremental time, which in ANSYS is the sub-step time size. The last two outputs are the derivatives of incremental creep strain with respect to stress and strain. It is apparent that the evaluation of the derivatives would be complex and therefore it was decided that numerical differentiation would be employed.

The numerical differentiation of incremental creep strain with respect to stress, $dcrda(1)$, is defined by Equation 3.1. Since creep strain in Equation 3.12 can be replaced by Equation 3.7 which implies that Equation 3.12 is a function of stress and temperature solely. Therefore, the derivative of incremental creep strain with respect to creep strain, $dcrda(2)$, is equal to zero. Equations 3.1, 3.12 and the fact that $dcrda(2)$ is equal to zero are the three required output of the ANSYS usercreep

subroutine that was compiled and linked into ANSYS. The usercrrep.F file is presented in APPENDIX B: ANSYS Source Code

CHAPTER 4 PROCEDURE

The procedure of the proposed constitutive creep strain modeling method involved several steps. They are listed and discussed in order within this chapter under their respective subchapters. This chapter includes the following subchapters,

- Material Data Collection
- Creep Strain Curve Fitting
- FORTRAN Compiling and Linking
- CATIA V5 Geometry Creation
- Workbench Meshing
- APDL Creep Analysis Input Files

4.1 MATERIAL DATA COLLECTION

The proposed model was to be based on creep strain and rupture data that could be found in the literature. As a starting point, the Aerospace Structural Metals Handbook was consulted for a commonly used material in Turbine Blade design. A well know nickel based super alloy employed in Turbo-Machinery, Inconel 718 (IN718), was found to be well documented [21].

Data was collected for IN718 under the following heat treatment [21; 18]:

- Annealing for 1 hour at 1750°F - 1800°F then air cooled
- Two Step aging treatment
 - 8 hours at 1325°F then furnace cooled to 1150°F at 100-108°F/hour
 - Held at 1150°F for an additional 8 hours and finally air cooled

The above heat treatment is the most commonly used treatment procedure with regards to optimum creep properties [22]. Creep strain data was digitized from creep curves presented by Yeom et al [18]. Modulus of Elasticity was taken from the High Temp Metals Inc website and poison's ratio was taken from the Aerospace Structural Metals Handbook [21; 23]. OriginPro 8 SRO v8.0724 was used to digitize all required data which is then output to text files by the program. The text files can then be read into Excel. Figure 4 is the illustrated original creep strain curves taken [18] from Yeom et al for IN718 [18]. The digitized data points for the Creep Strain Curves are provided in APPENDIX A: Tables AND CHARTS

, Figure 20.

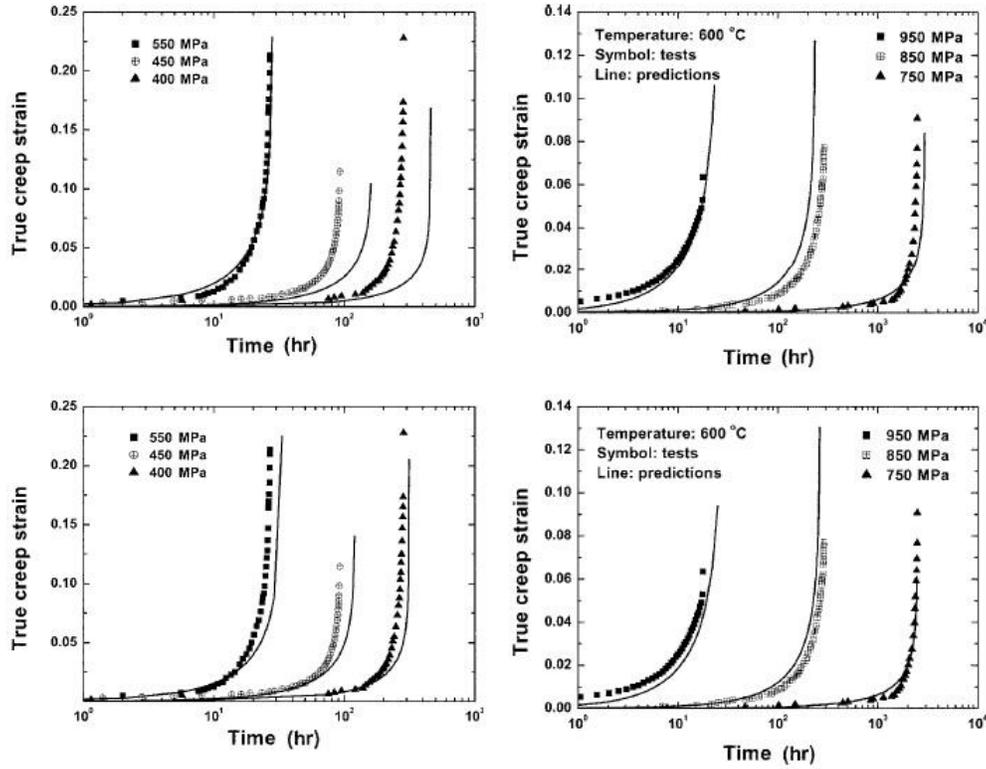


Figure 4 Original creep curves from Yeom et al [18]

The chemical composition of the material in Yeom’s research was the following,

Element	Compositions
C	0.027
S	0.0005
Mn	0.06
Si	0.05
Cr	18.03
Mo	2.87
Co	0.34
Ti	0.96
Al	0.47
B	0.04
Fe	17.81
Cu	0.05
Nb+Ta	5.38
Ni	Balance

Figure 5 lists Element compositional percentage in the IN718 Samples

Finally, to complete the material model the following two charts are the mechanical properties of IN718 used for this thesis project.

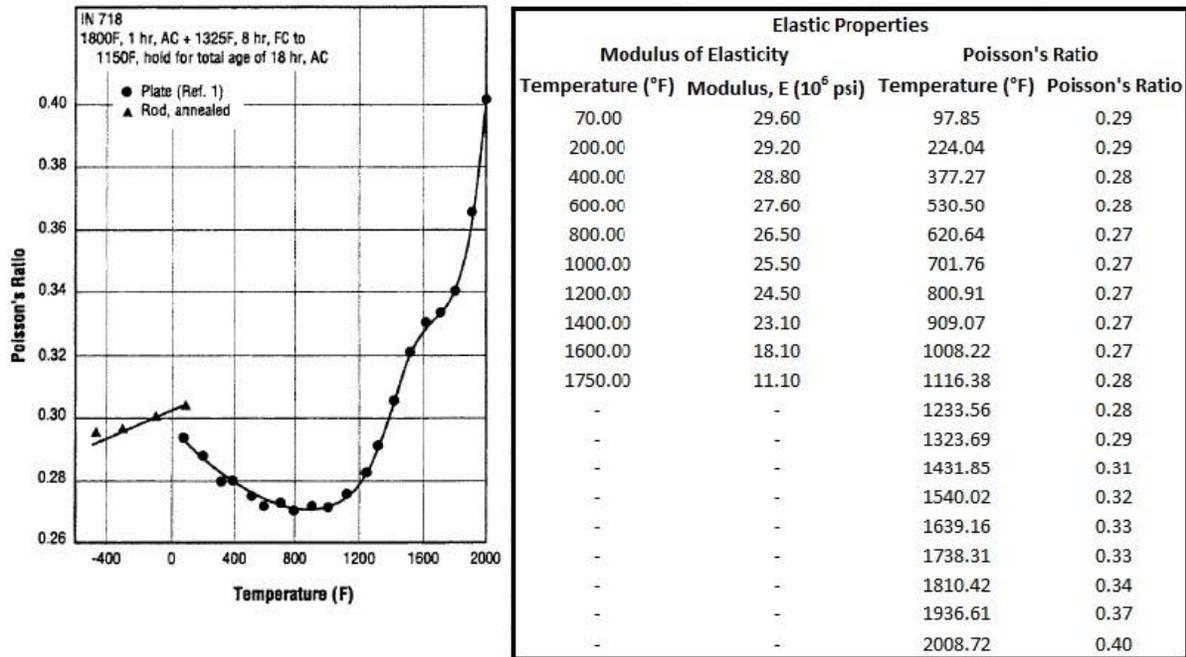


Figure 6 Poisson's Ratio (left plot, second column digitized data table on right) from *Aerospace Structural Metals Handbook* [21] and Modulus of Elasticity (High Temp Metals company website, first column table on right) [23]

The table in Figure 6 is a snap shot of the table created in Excel.

4.2 CREEP STRAIN CURVE FITTING

The LCSP is fitted in the form of time as a function of the creep strain (Equation 3.6). Three material constants result from each stress/temperature case. MATLAB Version 7.10.0.499 64-bit (win64) was used for all curve fitting procedures.

The MATLAB curve fitting tool uses x and y data in the form of,

$$y = f(x) \tag{Equation 4.1}$$

In order to use Equation 3.6 within the MATLAB curve fitting tool graphical user interface (GUI), the equation was re-written as,

$$y = \frac{\log(\alpha t_r + 1) + \beta}{1 + \left(\frac{x}{x_0}\right)^p} - \beta \tag{Equation 4.2}$$

Where,

$$y = \log(t + 1) \tag{Equation 4.3}$$

And,

$$x = \log(100\varepsilon + 1) \tag{Equation 4.4}$$

Values of x and y were calculated using the digitized creep strain and corresponding time data (APPENDIX A: Tables AND CHARTS)

, Figure 20) in Excel. Since the creep strain data is to rupture, the last time data point was taken to be the rupture time of each curve.

The x and y data for each creep curve at specified stress and temperature was read into MATLAB from Excel and the curve fitting tool was opened in MATLAB with the command 'cftool'. Data is selected within the Data tab of the cftool GUI. From the 'Data' tab the x and y data was loaded from the MATLAB workspace where data was earlier read from excel. Next, fit options and the data to be fitted are selected. The specific options chosen in the 'Fit Editor' accessed through the fitting button are as follow,

- Select new fit
- Populate fit name in the 'Fit name' field
- Selected desired data from the 'Data set' drop down menu
- Custom Equations is selected from the drop down menu of 'Type of fit'
- Under Custom Equations, the 'New' button is selected to create new custom equation
- In the 'New Custom Equations' window under 'General Equations' tab right side of *Equation 4.2* is input into the field to the right of the equal sign, the appropriate rupture time was subbed in and then ok was selected.
- Back in the Fit Editor, 'Fit options' button is pressed and the following options are selected in the 'Fit Options' window:
 - Robust: Off
 - Algorithm: Trust-Region
 - x_0 Lower: 0

Each creep curve at specified temperature and stress is fitted using the steps and options listed above. Once all creep curves where created, m-code representing the fitting of all the curves was generated by selecting the Generate M-file option from the file drop down menu in the 'Curve Fitting Tool' window. This serves three purposes,

- Document the fitting procedure
- Incorporate generated m-function into Excel data reading m-code
- Saves fitting information in a MATLAB Structure Array that can be retrieved for further use

The generated code for curve fitting is modified slightly to output structural arrays containing the goodness of the fit (R-squared value) and the values of the three material constants of each

respective creep strain curve. The m-code reading and writing the Excel data and the generated modified curve fitting m-function is reproduced in APPENDIX C: MATLAB SOURCE CODE , Source Code 5 and Source Code 6 respectively.

The next phase of curve fitting was done to fit relations to the material constants as functions of stress level. Temperature dependence was accounted for by determining the relations as a function of stress level at a particular temperature. Similar procedure was followed for the fitting of the material constants versus stress level at specified temperature as the curve fitting procedure of the creep strain curves. In the case of the material constant fitting, the material constants were the y values and their corresponding stress level was the x values. The values of x and y were again read in from Excel. The values of the material constants (x) are the values that had just been written in by MATLAB from the first curve fitting procedure of the creep strain curves.

Also, curve fitted was a relation describing the Larson-Miller Parameter versus logarithmic stress level. The Larson-Miller Parameter relation is used in the user defined creep subroutine to calculate rupture time. The Larson-Miller Parameter (LMP) is defined as,

$$LMP = (T + 460)(\log_{10} t_r + C) \quad \text{Equation 4.5}$$

Where T is temperature in degrees Fahrenheit and stress is in kilo-pound per square inch (ksi). The value of C is a constant that is typically 20 for metals. The LMP was calculated for each creep curve. For curve fitting x data is represented by $\log_{10} \sigma$ and corresponding y values are the respective LMP value. The values are again read into MATLAB from Excel.

The curve fitting of the material constants and LMP is analogous to that of the creep strain curves with a few notable differences. The differences are tabulated below.

Table 1 Specific Fitting Options for Material Constants

Material Constant	Type of Fit Option	Fit Options		Custom Equation Input
		Robust	Algorithm	
β	exp2	Off	Trust-Region	N/A
P	poly2	Off	N/A	N/A
x_0	Custom Equations	Off	Trust-Region	$a/(1+\exp(b*x+c))+d$
LMP	fourier2	Off	Trust-Region	N/A

N/A not applicable.

The fitting equations of the material constants and the LMP were chosen based on known constraints ($x_0 > 0$) and the observable pattern of the resulting data points.

4.3 FORTRAN COMPILING AND LINKING

In order to be capable of utilizing the UPF features in ANSYS, the incumbent must have the proper software and setup requirements. For this it is recommended that they refer to the specific user's manuals such as the Guide to ANSYS User Programmable Features provided with every version of ANSYS [24]. Several other sources provided insightful information regarding UPF's [25; 26].

The method of compiling and linking the usercreep.F will not be detailed here as this information can be found for each individual version of ANSYS being used. The usercreep.F subroutine code used for this work can be found in Appendix B.

4.4 CATIA V5 GEOMETRY CREATION

The two-dimensional axi-symmetric model of the smooth specimen for use in ANSYS was constructed in CATIA Version 5 Release 20. The model geometry is derived from a smooth cylindrical specimen with dimensions of a 25 mm (0.9843 inches) gauge section and 6 mm (0.2362

inches) diameter [18]. Figure 7 is an illustration of the CATIA geometry later imported into ANSYS Workbench 12.

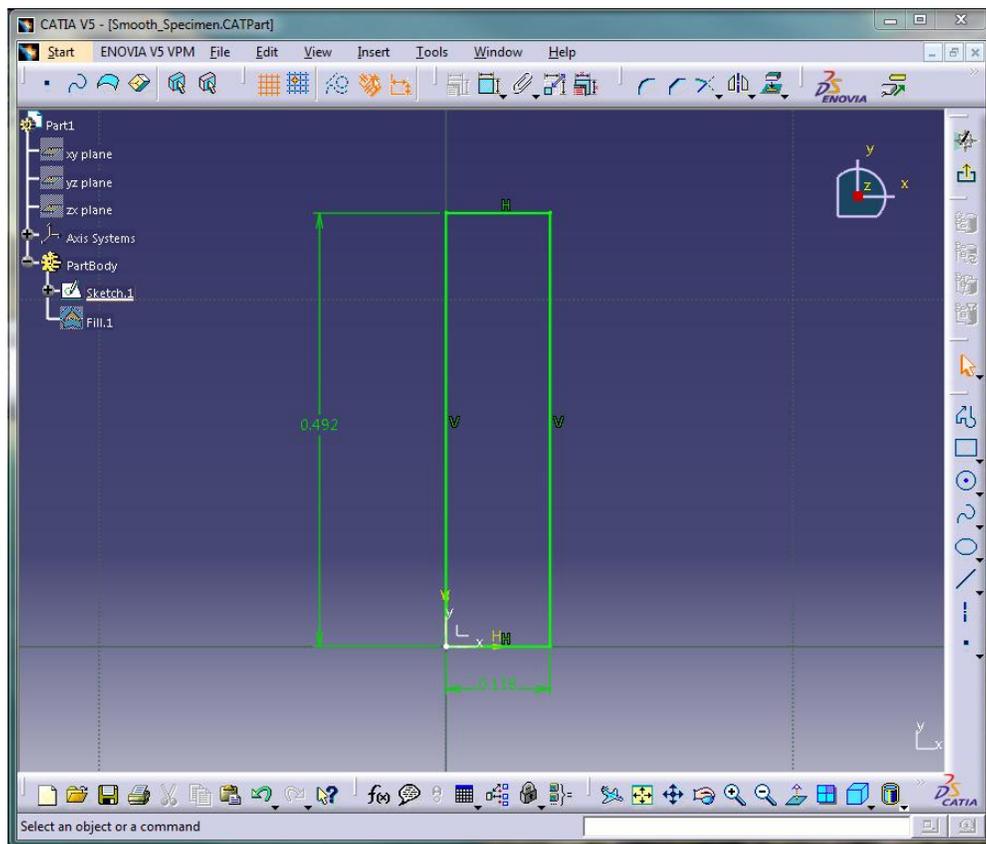


Figure 7 Catia Smooth Axi-Symmetric Cross-Section Sketch

4.5 WORKBENCH MESHING

The CATIA surface part, Figure 8, was imported as an igs geometry file into ANSYS Workbench Version 12 for meshing.

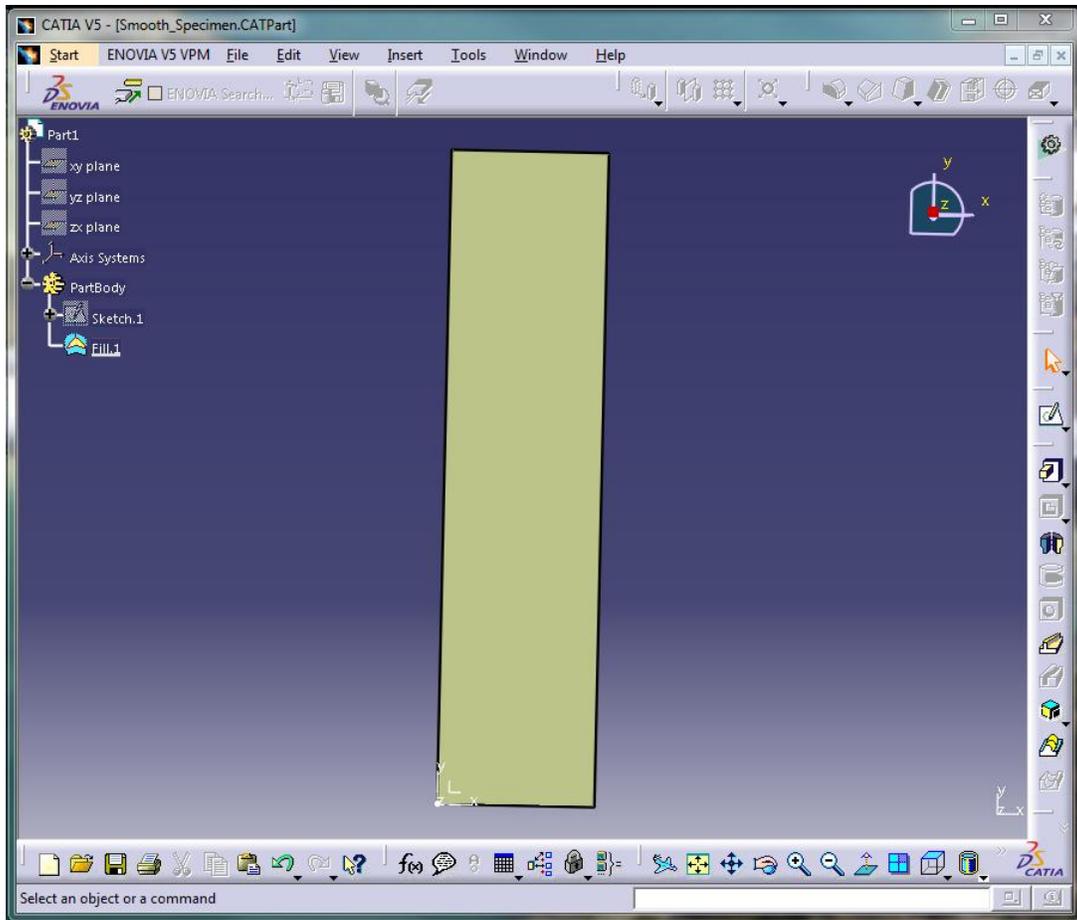


Figure 8 Surface Geometry of Catia Axi-Symmetric Model

The two-dimensional model is simple and therefore default settings were kept for meshing. Only one option was used, Face Sizing of the surface of the model with an element size of $1.0E-2$ inches. The resulting mesh is adequate for the simplicity of the model. The mesh is illustrated in Figure 9.

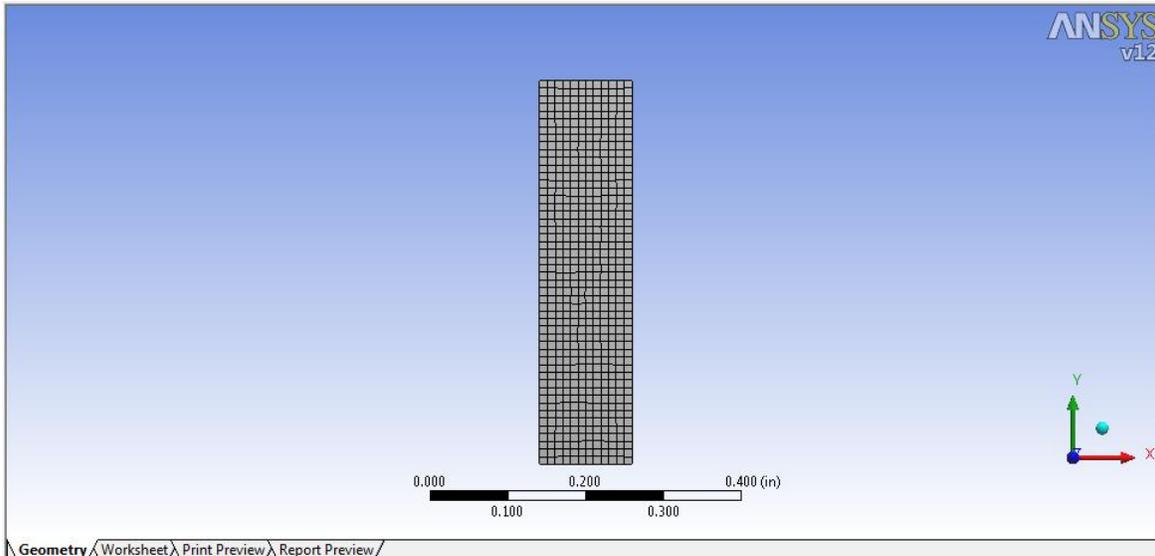


Figure 9 Axi-Symmetric Smooth Specimen Mesh

From the meshed model an input file was written to transfer the mesh into ANSYS classical.

4.6 APDL CREEP ANALYSIS INPUT FILES

The ANSYS analysis options and commands are written in ANSYS Parametric Design Language (APDL) text files. APDL presents the advantage of documenting the analysis details as well as automation of the analysis, simplifying consistent reruns of the analysis. It is a quick efficient way of avoiding the need to setup the analysis each and every trial run through the Graphical User Interface (GUI). The example of an input file for the case of 109 ksi and 1112 °F is provided in APPENDIX B: ANSYS Source Code

CHAPTER 5 RESULTS & DISCUSSION

This chapter is a summary and discussion of the results of the work performed. The first results to be discussed are the curve fitting of the creep strain curves and their resulting material constants. This is followed by the results of the equations relating the material constants with stress level and the LMP with logarithmic stress. The measure of accuracy is presented by the R-squared value or also known as the coefficient of determination as calculated by MATLAB for each curve fit. In MATLAB the R-squared value is described as the goodness of the fit. The last results to be presented, is a comparison of the analytical creep strain curves as generated by ANSYS and the LCSP usercreep subroutine against the original empirical curves.

The resulting material constants of the MATLAB curve fitting procedure for the LCSP fitting of the creep strain curves are tabulated in Table 2 below.

Table 2 MATLAB LCSP Curve Fitting Results

Temperature	Stress	B	p	xo	R-Square
1112	109	3.114E-03	-1.531E+00	8.834E-02	0.999
1112	123	-4.942E-04	-1.511E+00	2.138E-01	0.993
1112	138	-8.918E-02	-2.792E+00	7.036E-01	0.988
1292	58	1.489E-01	-2.340E+00	3.425E-01	0.990
1292	65	1.074E-02	-2.617E+00	4.496E-01	0.972
1292	80	7.584E-03	-2.008E+00	5.301E-01	0.986

It should be noted that 'B' is actually the material constant β . Table 2 was generated from the data output by MATLAB into an Excel spreadsheet. Given the very high R-Square values for each of the curves approximated by the modified LCSP formulation, is evidence of the methods considerable accuracy. The apparent accuracy and robustness of the method with minimal empirical data usage is attractive for application to user-defined creep models, incorporating all three stages of creep, within Finite Element Method (FEM) software packages.

In order to interpolate between creep curves at varying stress and temperature, it was necessary to determine functions of stress and temperature for each material constant. The relations and their R-Squared fitting accuracies are presented in Tables 3 - 5.

Table 3 Material Constant $\beta(\sigma)$

B(σ)	$a*\exp(b*\sigma) + c*\exp(d*\sigma)$	
Temperature	1112	1292
a	-1.0821E-14	4.0165E+08
b	2.1575E-01	-3.7441E-01
c	4.8801E-03	0.0000E+00
d	-3.6150E-03	0.0000E+00
R-Squared	≈ 1	9.9465E-01

Table 4 Material Constant $x_o(\sigma, T)$

$x_o(\sigma)$	$a/(1+\exp(b*\sigma+c))+d$	
Temperature	1112	1292
a	7.499E-01	3.572E-01
b	-6.224E+01	-2.462E+01
c	1.314E+02	4.373E+01
d	6.478E-02	1.932E-01
R-Squared	9.990E-01	9.993E-01

Table 5 Material Constant $p(\sigma, T)$

$p(\sigma)$	$p1*\sigma^2 + p2*\sigma + p3$	
Temperature	1112	1292
p1	-2.994E-03	3.644E-03
p2	6.961E-01	-4.878E-01
p3	-4.183E+01	1.370E+01
N/A	N/A	N/A
R-Squared	≈ 1	≈ 1

The functions fitted to the material constants β and p was chosen intuitively from the observable graphical pattern of the material constants plotted versus stress at specified temperature. The function fitted to x_o was chosen partially via the observable graphical pattern of the parameter plotted versus stress. Also considered in the choice of the function, was the imposed constraints of the modified LCSP.

Also, the Larson-Miller parameter was described by a function of logarithmic base 10 stress. The Larson-Miller parameter is used to determine the rupture time of the new creep strain curve. The Larson-Miller Parameter as a function of stress is presented in Table 6.

Table 6 Larson-Miller Parameter $LMP(\sigma)$

LMP(σ)	$a0 + a1*\cos(\log_{10}(\sigma)*w) + b1*\sin(\log_{10}(\sigma)*w) + a2*\cos(2*\log_{10}(\sigma)*w) + b2*\sin(2*\log_{10}(\sigma)*w)$
a0	3.595E+04
a1	1.357E+03
b1	3605
a2	1669
b2	72.87
w	7.627
R-Squared	≈ 1

Some notable observations were made concerning the pattern of the relations of the material constants to stress. β versus stress at 1112°F tends towards some small value above zero as stress

drops (infinite rupture). As stress increases β tends toward negative infinity (no rupture life). In contrast, β versus stress at 1292°F tends toward positive infinity as stress decreases (infinite rupture) and tends toward some horizontal asymptote just below zero as stress increases (no rupture life). An illustration of the described behaviour is presented in Figure 10,

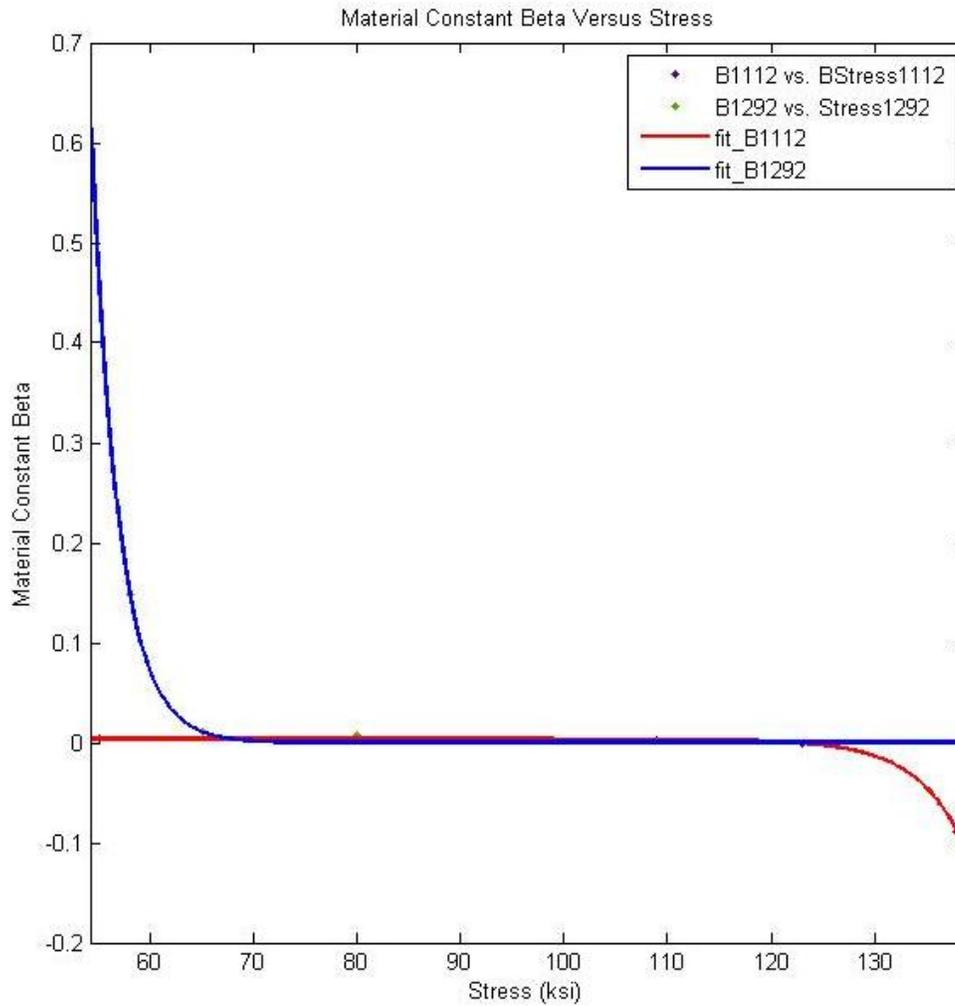


Figure 10 MATLAB Generated Plot of Material Constant Beta Versus Stress

The inverse in the trend indicates the possibility that β is actually related to stress by a logistic function, which is characterized by two horizontal asymptotes. Figure 11 is an example of a logistic function plot,

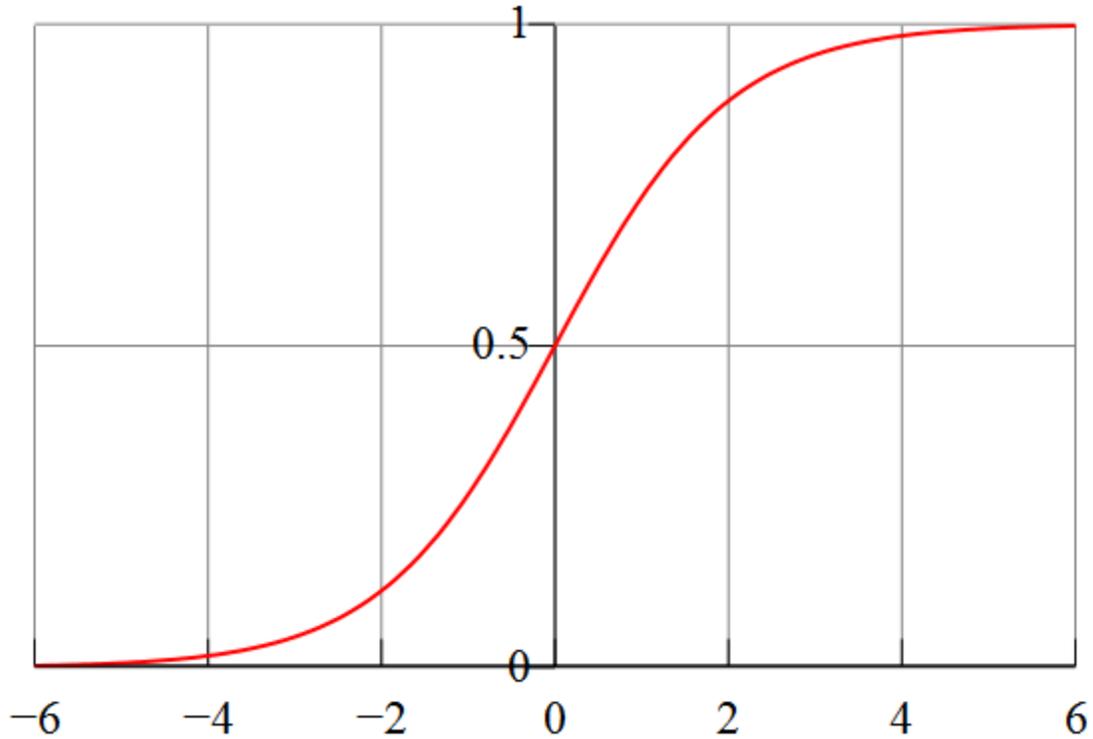


Figure 11 Example of a logistic function $f(x) = \frac{1}{1+e^{-x}}$

The horizontal asymptotes are inductive of an upper and lower limit on β which are governed by minimum rupture life (zero rupture life) and infinite rupture life. More empirical creep strain curves at other stress levels would be required to produce more values of β to confirm this pattern. A stress low enough to produce large life and a stress high enough to produce nearly immediate rupture is required to acquire a true sense of the relationship of material constant β and stress.

The graphical relationship of the material constant x_0 is considerably more apparent than that of β . The plot in Figure 12 illustrates the observed logistical relationship of material constant x_0 with stress.

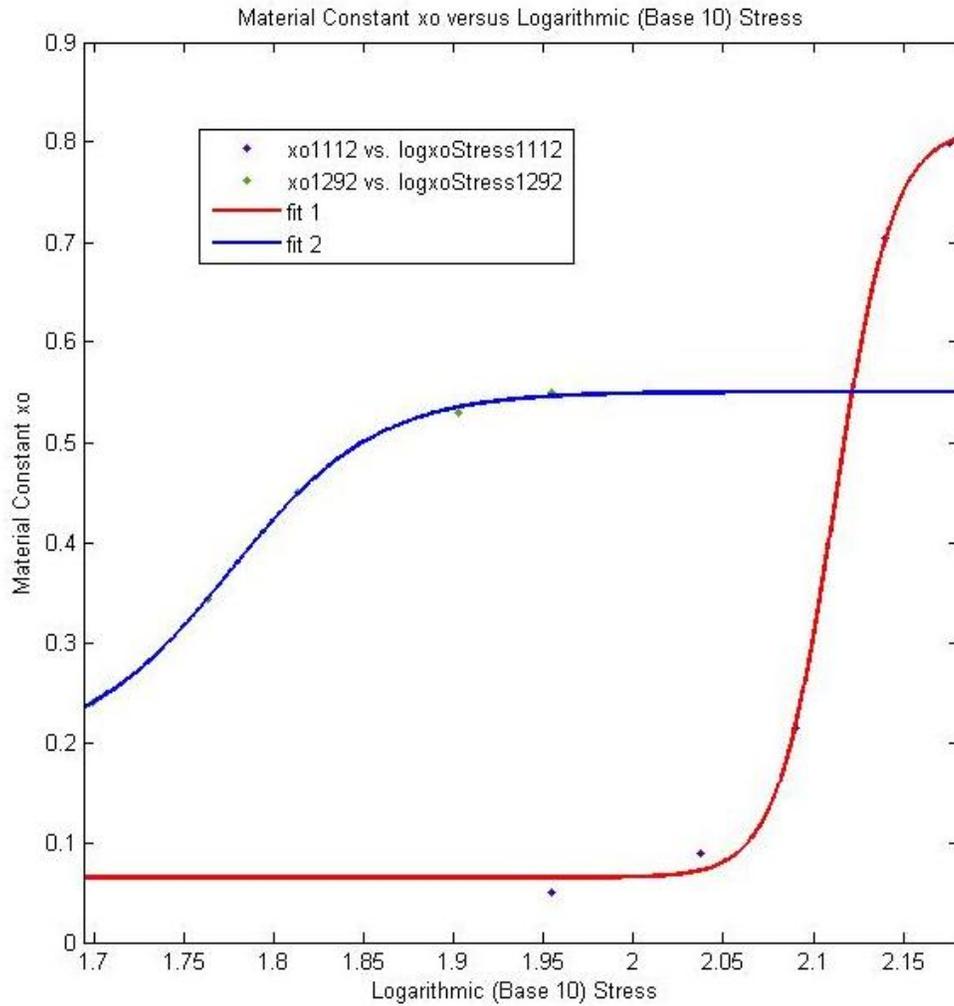


Figure 12 MATLAB Generated Plot of Material Constant x_0 versus Logarithmic Stress

The effect of temperature seems to manifest as shifting and compression/stretching of the logistical function.

The material constant p , displays a polynomial relation of power two. Figure 13 illustrates the polynomial relation of material constant p with respect to stress level.

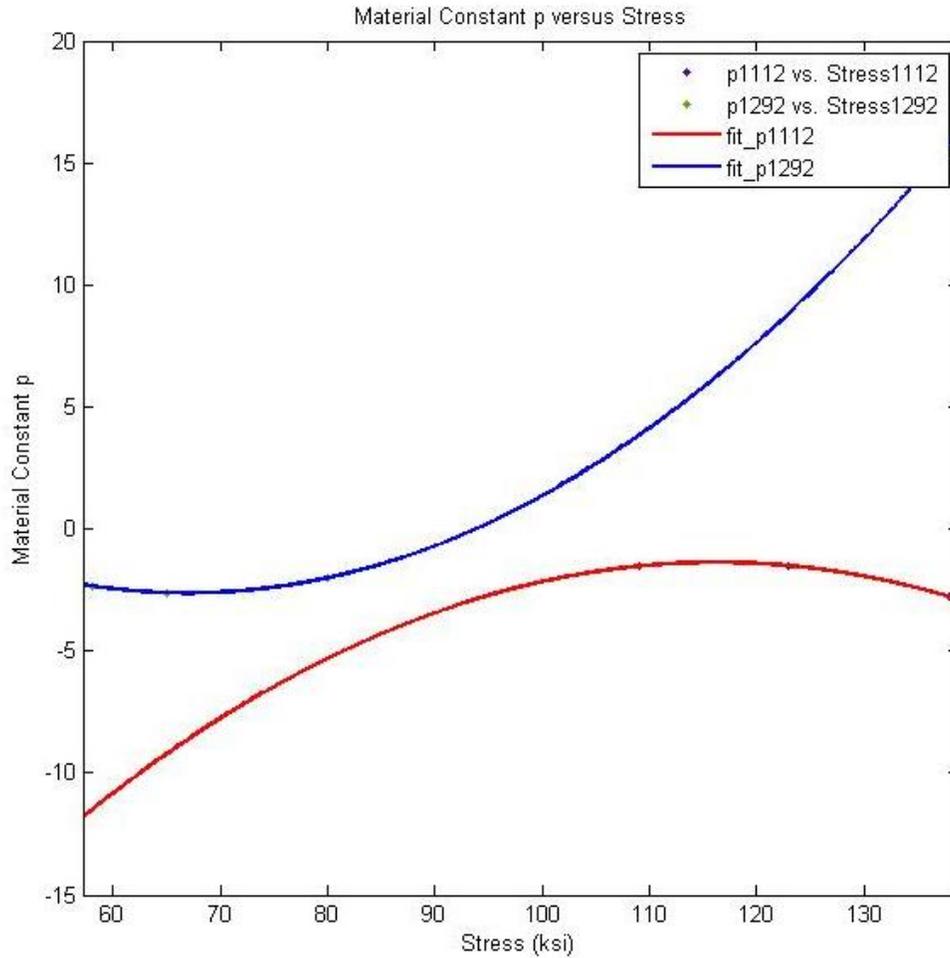


Figure 13 MATLAB Generated Plot of Material Constant p versus Stress

The characteristic point of inflection in a polynomial function of power two (quadratic relation) is indicative of the material constant p controlling the inflection characterizing the transition of primary creep to tertiary creep. Therefore, the quadratic relation of p with stress implies that the material constant p has some effect on curve shape and specifically on the length and presence of a secondary stage. Temperature appears to manifest itself in the concavity of the quadratic relation.

The last and most important results to be presented is the analytical results of the ANSYS User-creep LCSP based subroutine generated creep strain curves compared against the empirical data points. Creep strain versus time data was output into text files through the Time History Post-Processor for each of the six cases analyzed. The creep strain curves of the six cases are illustrated in Figure 14 - 19.

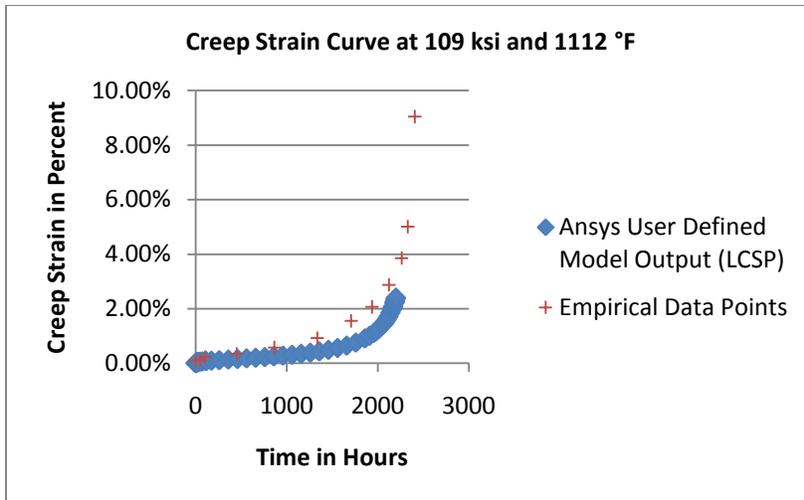


Figure 14 Comparative Creep Curve Plot (109 ksi & 1112 °F)

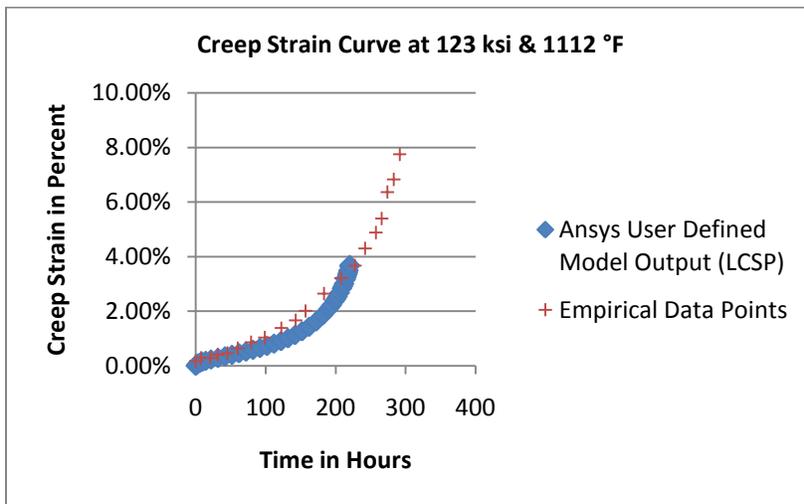


Figure 15 Comparative Creep Curve Plot (123 ksi & 1112 °F)

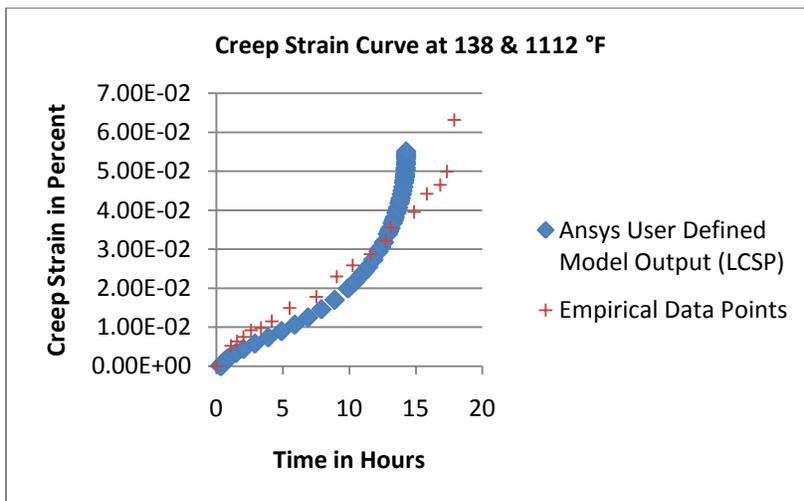


Figure 16 Comparative Creep Curve Plot (138 ksi & 1112 °F)

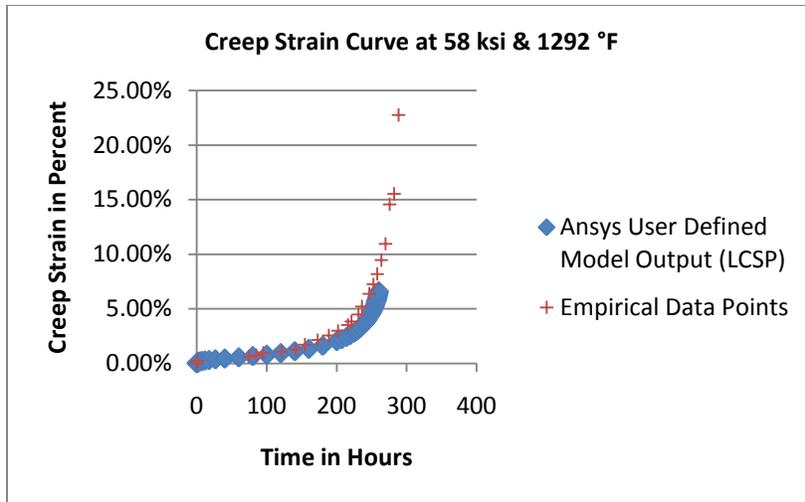


Figure 17 Comparative Creep Curve Plot (58 ksi & 1292 °F)

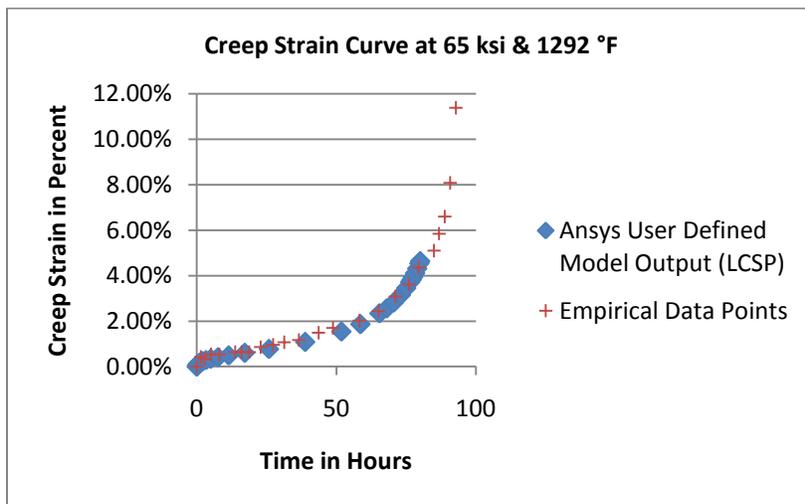


Figure 18 Comparative Creep Curve Plot (65 ksi & 1292 °F)

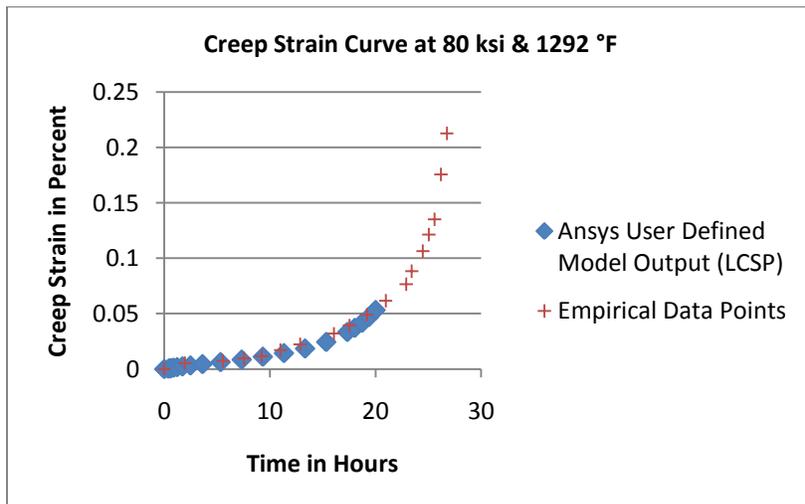


Figure 19 Comparative Creep Curve Plot (80 ksi & 1292 °F)

The figures - 16 demonstrated the most significant divergence with R-Squared values of approximately .916, .936 and .787 respectively. The remaining figures 17 - 19, possessed R-Squared values of approximately .844, .982, and .958. Several sources of error were noted. First, it was observed that the LCSP is highly sensitive to the model used to predict rupture time which is used to determine the end point of each curve [10]. Slight deviations of predicted rupture time result in either stretched or compressed creep curves such as figures 14 and 16 respectively. Moreover, empirical data scatter that is slightly irregular such as Figure 16 are difficult to quantify, such that they do not conform to the expected creep curve shape. Finally, it should be noted that there is also combined error. The fitting error of the original curve fits is compounded with the fitting error of the material constant relations and the Larson Miller relation. Furthermore, the element formulation and calculations internally performed within ANSYS have their own error to contend with.

It should be noted no attempt was made to characterize the relationship between the material constants and temperature. This was done for two reasons. First, since data for only two temperatures was acquired from the literature, only a linear relation with temperature can be inferred which may be misleading. Moreover, typically in ANSYS material parameters are described with respect to stress at a given temperature and ANSYS is allowed to interpolate between temperatures internally. Finally, temperature interpolation is not suggested for the reasons stated earlier. More data would be required to better understand the relation between the material constants and temperature. Therefore, the model of IN718 developed in this paper is not suggested for use when temperature interpolation or extrapolation is required.

CHAPTER 6 CONCLUSION

In summary, a modified Logistic Creep Strain Prediction (LCSP) method was developed and applied to the material IN718. The formulation maintains a simplistic formulation that encompasses all three stages of creep without limitations that the original LCSP method contained. In this thesis several modifications and constraints were proposed eliminating limitations the original formulation contained. Specifically, the modelling limitation on a minimum of 1 percent creep and minimum of 1 hour for effective creep modeling. The modified LCSP formulation of this thesis suffers no minimums in its modelling capabilities. Furthermore, the proposed modifications and constraints present evidence of a possible insight into the mechanisms of creep rather than simply being material fitting constants. The research performed was guided by the following development criteria:

- Minimal empirical data requirements
- Simplistic formulation
- Easy commercial FEM software integration

The development criteria are derived from what was termed the goals of applicability. Reiterating the goals of applicability, a model's applicability is founded on the principles of

- It's easy application
- Cost of application
- Versatility

From this research, several things can be concluded. First, the LCSP modeling technique devised by Holmstrom et al. is a robust method that, with some modification, accurately predicts the creep strain curve of super alloys such as IN718. The modified LCSP formulation proposed in this thesis, offers a creep strain prediction method that encompasses all three stages of creep while maintaining a simplistic formulation. The modified LCSP, once again, does not contain any of the limitations the original formulation contained. Moreover, the modified formulation gives some insight into the mechanisms of creep rather than simply define the shape of a specific creep curve for a specified material. Furthermore, application of the modified modelling method to IN718 in an ANSYS user-defined creep strain subroutine is evidence of the simplicity, robustness and versatility of the modified LCSP modeling method developed in this work.

Finally, the development of the modified LCSP modelling method accomplishes all the development criteria set out at the beginning of this endeavour. The modified LCSP model does not need a great deal of empirical data to describe any particular creep strain curve. In fact, a few points from within each stage present in the curve which can be acquired from master curve data such as the LMP for time to specified strain can be used. The modified LCSP is a simplistic formulation not requiring complex variable data such as deviatoric stress or activation energies. It is easily algebraically manipulated from one form to another. Its formulation includes, in this case, a total of three material fitting constants, such that the fourth fitting constant α from the original formulation is assumed to equal 1. The value of α is set to one as is suggested by Holmstrom et al [10]. As for the very last of the criteria, easy commercial FEM software integration, the LCSP was shown to be easily integrated via a user-defined subroutine that was compiled and linked into ANSYS 12. The simplistic nature of the LCSP formulation made it easy to manipulate it into a form similar to the already standard creep material models pre-installed in ANSYS 12. In conclusion, despite any compounded error, the fact that only two of the modelled cases have R-Squared values lower than .9 is evidence of the accuracy and robustness of the proposed formulation. The modified LCSP model proposed achieves the requirements of a model robust and accurate describing all three stages of creep at varying stress and temperature. The ease, of which the modified LCSP was integrated into a FEM package (ANSYS), is a testament to its simplicity and versatility. It presents itself as a viable modeling technique to be utilized for creep analysis requiring the incorporation of all three stages of creep. While, still maintaining the criteria outlined in this thesis.

CHAPTER 7 RECOMMENDATIONS & FUTURE WORK

Several recommendations can be made with regard to the work performed in this thesis. Despite the fact that the LCSP method requires little empirical data for anyone specific creep strain curve. In order to accurately assess the relationship between material constant and stress, creep strain curves at extremes (extreme low: rupture life < 15 hours; extreme high: rupture life > 5000 hours) should be included amongst a few more creep strain curves in-between. Also, as a standard of good practice the influence of temperature on creep material constants should include more than two temperatures to avoid the assumed linear relation between them.

Furthermore, the interesting observation of the possible representation of creep stages by specific material constants as remarked earlier should be studied further. This could be done by observing the behaviour of the relation of the material constants and creep strain curve shape, and the presence or lack of particular stages of creep.

Finally, the proposed model and the application of the LCSP model should be extended to the study of notched acuity and multi-axial states of stress. Moreover, many researchers have studied notched behaviour using other methods of creep strain modeling, that include all three stages of creep [13; 22; 27; 28; 29; 30]. This would be the natural step forward in the complete development of a well rounded creep material modeling method.

APPENDIX A: TABLES AND CHARTS

Table 7 is taken from Advanced Mechanics of Materials [2 pp. 630-31]

TABLE 18.1 Empirical One-Dimensional Creep Formulas

Equation form	References	Equation
Time Dependence		
Rational		
$\epsilon_C = at/(1 + bt)$	(Freudenthal, 1936)	(a)
Logarithmic		
$\epsilon = a + b \ln(t)$	(Phillips, 1905)	(b)
$\epsilon = a + b \ln(1 + ct)$	Modification of (b)	(c)
Exponential		
$\epsilon = a + bt - c \exp(-dt)$	(McVetty, 1934)	(d)
$\epsilon_C = at + b[1 - \exp(-ct)]$	(McVetty, 1934; Söderberg, 1936)	(e)
Power		
$\epsilon_C = bt^n; 1/3 < n < 1/2$	(Bailey, 1935)	(f)
Power series		
$\epsilon_C = at^m + bt^n; m > 1, 0 < n < 1$	(de Lacombe, 1939)	(g)
$\epsilon_C = at_m + bt_n + ct_p + \dots$	(Graham, 1953)	(h)
Combined exponential power		
$\epsilon_C = a(1 + bt^{1/3}) \exp(kt) - a$	(Andrade, 1910)	(i)
Combined logarithmic power		
$\epsilon_C = a \ln(t) + bt^n + ct$	(Wyatt, 1953)	(j)
Temperature Dependence		
Exponential		
$\dot{\epsilon}_C = a \exp(-Q/RT)$	(Mott, 1953)	(k)
$\epsilon_C = a[t \exp(-Q/RT)]$	(Dorn, 1962)	(l)
$\dot{\epsilon}_C = aT \exp(-Q/RT)$	(Stowell, 1957)	(m)
Rational		
$\epsilon_C = aT^{2/3}f(t)$	(Mott and Nabarro, 1948)	(n)
$\epsilon_C = aTf(t)$	(Smith, 1948)	(o)
$\epsilon_C = f\{T[a + \ln(t)]\}$	(Larson and Miller, 1952)	(p)
$\epsilon_C = f\{(T - a)/\ln(t - b)\}$	(Manson and Haferd, 1953)	(q)
Hyperbolic exponential		
$\dot{\epsilon}_C = a \exp(-Q/RT) \sinh(b/RT)$	(Feltham, 1953)	(r)

Other		
$\epsilon_C = cf[t(T - T')^{-B}]$	(Warren, 1967)	(s)

Stress Dependence

Exponential		
$\epsilon_C = af(t)\exp(b\sigma)$	(Dorn, 1962)	(t)
$\dot{\epsilon}_C = a \exp(b + c\sigma)$	(Nadai, 1931)	(u)
$\dot{\epsilon}_C = a[\exp(b\sigma) - 1]$	(Söderberg, 1936)	(v)
Power		
$\epsilon_C = af(t)\sigma^b$	(Dorn, 1962)	(w)
$\epsilon_C = at^n\sigma^b; 0 < n < 1, b > 1;$ Bailey–Norton law	(Bailey, 1935; Norton, 1929)	(x)
Hyperbolic		
$\dot{\epsilon}_C = a \sinh(b\sigma)$	(Ludwik, 1908; McVetty, 1943)	(y)
$\dot{\epsilon}_C = a \sinh(b\sigma/RT)$	(Feltham, 1953)	(z)
Other		
$\dot{\epsilon}_C = a\sigma \exp[f(\sigma)]$	(Kanter, 1938)	(aa)
Other		
$\epsilon_C = cf[t(T - T')^{-B}]$	(Warren, 1967)	(s)

Stress Dependence

Exponential		
$\epsilon_C = af(t)\exp(b\sigma)$	(Dorn, 1962)	(t)
$\dot{\epsilon}_C = a \exp(b + c\sigma)$	(Nadai, 1931)	(u)
$\dot{\epsilon}_C = a[\exp(b\sigma) - 1]$	(Söderberg, 1936)	(v)
Power		
$\epsilon_C = af(t)\sigma^b$	(Dorn, 1962)	(w)
$\epsilon_C = at^n\sigma^b; 0 < n < 1, b > 1;$ Bailey–Norton law	(Bailey, 1935; Norton, 1929)	(x)
Hyperbolic		
$\dot{\epsilon}_C = a \sinh(b\sigma)$	(Ludwik, 1908; McVetty, 1943)	(y)
$\dot{\epsilon}_C = a \sinh(b\sigma/RT)$	(Feltham, 1953)	(z)
Other		
$\dot{\epsilon}_C = a\sigma \exp[f(\sigma)]$	(Kanter, 1938)	(aa)

Combined Time–Temperature–Stress Dependencies

$\dot{\epsilon}_C = T \exp(-a/T - b + c\sigma)$	(Nadai, 1931)	(bb)
$\epsilon_C = a \exp(-A/T)\sigma^n t^k$	(Pickel et al., 1971)	(cc)
$\epsilon_C = a \exp(-A/T)\sinh(a\sigma)t^k$	(Pickel et al., 1971)	(dd)
$\epsilon_C = a \exp(-A/T) \times [\sinh(b\sigma)]^m t^k$	(Pickel et al., 1971)	(ee)
$\epsilon_C = a \exp(-A/T)(\sigma/b)^c + (\sigma/d)^e t$	(Odqvist, 1953)	(ff)
$\epsilon_C = \sum_{i=1}^n C_i \sigma^{a_i} \phi^{b_i}; \phi = t(T' - T)^{-A}$	(Graham and Wallis, 1955)	(gg)

Creep Strain Time History											
Creep Curves at Temperature of 600 and Varying Stress						Creep Curves at Temperature of 700 and Varying Stress					
Stress 750 MPa		Stress 850 MPa		Stress 950 MPa		Stress 400 MPa		Stress 450 MPa		Stress 550 MPa	
Time (Hrs)	Creep Strain (Fraction)	Time (Hrs)	Creep Strain (Fraction)	Time (Hrs)	Creep Strain (Fraction)	Time (Hrs)	Creep Strain (Fraction)	Time (Hrs)	Creep Strain (Fraction)	Time (Hrs)	Creep Strain (Fraction)
0	0	0	0	0	0	0	0	0	0	0	0
46.79470047	0.000947238	7.739212647	0.001732035	1.09807266	0.005196104	1.117627846	0.002118644	1.394031046	0.004237288	1.946095223	0.005330782
104.7889622	0.001147238	20.89670463	0.002874441	1.543330876	0.00633851	74.33741079	0.006424276	2.775515476	0.003212138	5.526050643	0.007449426
449.9072316	0.002294475	31.30181234	0.002874441	2.039331319	0.007480916	84.99859846	0.007449426	5.0585351	0.005330782	7.540486744	0.00956807
864.3229245	0.003441713	45.32781819	0.004016847	2.615466537	0.009176099	94.9980047	0.00956807	8.063090753	0.005330782	9.219468448	0.011686714
1333.936256	0.005773196	60.01475681	0.004606475	3.354366768	0.009765728	121.2247595	0.010661564	13.74296674	0.006424276	11.0023655	0.017017496
1707.386977	0.009214909	79.30248472	0.00633851	4.167158978	0.011497763	141.6066313	0.012780208	16.05361175	0.006424276	12.85222524	0.022348278
1935.507683	0.01554322	98.51816573	0.008623322	5.506413401	0.01492498	154.6940765	0.017017496	18.75275223	0.006424276	16.05361175	0.031916348
2121.101675	0.020724293	122.3899732	0.010355357	7.511547438	0.017799421	172.8904075	0.021323127	22.89561544	0.00854292	17.53730473	0.039365774
2260.607686	0.028791964	142.9473603	0.013782574	9.039139319	0.022958673	188.8691347	0.025560416	27.36224346	0.00956807	19.18545645	0.048933844
2329.123758	0.038598996	156.9665882	0.016657015	10.24684142	0.025833114	201.958975	0.029797704	31.28643196	0.010661564	20.95859807	0.061714051
2404.498009	0.05010838	183.3316803	0.020084233	11.59280309	0.028707555	215.956025	0.035128486	36.54671085	0.011686714	22.89561544	0.076612903
2477.375209	0.090446735	207.4129951	0.026385891	12.72974012	0.032134772	220.9390314	0.038340623	43.61425746	0.014898852	23.4239128	0.088298617
		227.7545392	0.032134772	13.11556194	0.035598842	230.9231602	0.044696555	48.7445086	0.017017496	24.48242818	0.106410607
		242.251382	0.036741248	14.86790707	0.039578837	235.9149255	0.052145981	58.25390958	0.020229634	25.04793993	0.121309459
		257.6709657	0.043042906	15.81426674	0.044185312	246.5758077	0.063832695	65.10619146	0.024466922	25.58877736	0.135114817
		266.0096193	0.048791787	16.82086332	0.046470124	252.2653402	0.072375615	71.12337942	0.030891197	26.1792172	0.175574084
		274.0720241	0.05395104	17.33068175	0.049934193	258.086154	0.081943685	76.05268498	0.036153636	26.74512192	0.21275287
		282.9414427	0.063679916	17.89153094	0.063127139	263.6650899	0.094723893	79.48946931	0.043603062		
		291.5170289	0.068286391			269.7489435	0.109622745	84.99859846	0.051052488		
		300.9509964	0.07746249			275.5799887	0.145776381	86.83597609	0.058501914		
						281.9387687	0.155344451	88.83964432	0.06595134		
						288.4442723	0.227651722	90.76005217	0.080850191		
								92.8542652	0.113860033		

Figure 20 snap shot of Excel tabulated digitized creep strain and respective time data (Yeom et al.)[18]

APPENDIX B: ANSYS SOURCE CODE

Source Code 1: Original Usercreep.F Source (TBOP = 1)

```

*deck,usercreep      USERDISTRIB  parallel                               gal
      SUBROUTINE usercreep (impflg, ldstep, isubst, matId, elemId,
&                                kDInPt, kLayer, kSecPt, nstatv, nprop,
&                                prop, time, dtime, temp, dtemp,
&                                tofst, Ustatev, creqv, pres, seqv,
&                                delcr, dcrda)
C*****
C      *** primary function ***
C      Define creep laws when creep table options are
C      TB, CREEP with TBOPT=100.
C      Demonstrate how to implement usercreep subroutine
C
C      Creep equation is
C      dotcreq := k0 * seqv ^ n * creqv ^ m * exp (-b/T)
C
C      seqv is equivalent effective stress (Von-Mises stress)
C      creqv is equivalent effective creep strain
C      T is the temperature
C      k0, m, n, b are materials constants.
C
C      This model corresponds to primary creep function TBOPT = 1
C
C
C
C      gal 10.01.1998
C*****
C      input arguments
C      =====
C      impflg (in ,sc ,i)      Explicit/implicit integration
C                               flag (currently not used)
C      ldstep (in ,sc ,i)      Current load step
C-----
C      isubst (in ,sc ,i)      Current sub step
C-----
C      matId (in ,sc ,i)      number of material index
C      elemId (in ,sc ,i)      Element number
C      kDInPt (in ,sc ,i)      Material integration point
C      kLayer (in ,sc ,i)      Layer number
C      kSecPt (in ,sc ,i)      Section point
C      nstatv (in ,sc ,i)      Number of state variables
C      nprop (in ,sc ,i)      size of mat properties array
C
C      prop (dp ,ar(*),i)      mat properties array
C                               This array is passed all the creep
C                               constants defined by command
C                               TB, CREEP
C                               TB, CREEP
C                               (do not use prop(13), as it is used
C                               elsewhere)
C
C      time      Current temperature
C      dtime     Current temperature increment
C      temp      Current temperature
C      dtemp     Current temperature increment
C      tofst (dp, sc, i)      temperature offset from absolute zero
C      seqv (dp ,sc , i)      equivalent effective stress
C      creqv (dp ,sc , i)      equivalent effective creep strain
C      pres (dp ,sc , i)      hydrostatic pressure stress, -(Sxx+Syy+Szz)/3
C
C      input output arguments      input desc      / output desc
C      =====      =====
C      Ustatev (dp,ar(*), i/o)      user defined internal state variables at
C                                     time 't' / 't+dt'.
C                                     This array will be passed in containing the
C                                     values of these variables at start of the
C                                     time increment. They must be updated in this
C                                     subroutine to their values at the end of
C                                     time increment, if any of these internal
C                                     state variables are associated with the
C                                     creep behavior.

```

```

c      output arguments
c      =====
c      delcr      (dp ,sc , o)          incremental creep strain
c      dcrda      (dp,ar(*), o)        output array
c                                          dcrda(1) - derivitive of incremental creep
c                                          strain to effective stress
c                                          dcrda(2) - derivitive of incremental creep
c                                          strain to creep strain
c
c      local variables
c      =====
c      c1,c2,c3,c4 (dp, sc, l)          temporary variables as creep constants
c      con1        (dp ,sc, l)          temporary variable
c      t           (dp ,sc, l)          temporary variable
c
c*****
c
c --- parameters
c
#include "impcom.inc"

      DOUBLE PRECISION ZERO
      PARAMETER      (ZERO = 0.0d0)
c
c --- argument list
c
      INTEGER          ldstep, isubst, matId , elemId,
&                    kDInPt, kLayer, kSecPt, nstatv,
&                    impflg, nprop
      DOUBLE PRECISION dtime , time , temp , dtemp , tofst,
&                    creqv , seqv , pres
      DOUBLE PRECISION prop(*), dcrda(*), Ustatev(nstatv)
c
c --- local variables
c
      DOUBLE PRECISION c1 , c2 , c3 , c4 ,
&                    con1 , delcr , t
c
c*****
c
c *** skip when stress and creep strain are all zero
c if (seqv.LE.ZERO.AND.creqv.LE.ZERO) GO TO 990
c *** add temperature off set
c t = temp + tofst
c *** Primary creep function
c delcr := c1 * seqv ^ n * creqv ^ m * exp (-b/T) * dtime
c1 = prop(1)
c2 = prop(2)
c3 = prop(3)
c4 = prop(4)
c *** user need to make sure if c4 has nonzero value, temperature should be also nonzero.
con1 = ZERO
if(c4.ne.ZERO.and.t.gt.ZERO) con1 = c4/t
c *** calculate incremental creep strain
c if (creqv .le. TINY) creqv = sqrt(TINY)
delcr = ZERO
IF(c1.gt.ZERO) delcr = (exp( log(c1) + c2 * log(seqv) +
&                    c3 * log(creqv) - con1 )) * dtime
c *** derivitive of incremental creep strain to effective stress
dcrda(1)= c2 * delcr / seqv
c *** derivitive of incremental creep strain to effective creep strain
dcrda(2)= c3 * delcr / creqv
c *** write the effective creep strain to last state variable for verification
Ustatev(nstatv) = creqv
990 continue
return
end

```

Source Code 2: LCSP Usercreep.F Source (TBOP = 100)

```

*deck, usercreep  USERDISTRIB  parallel  gal
      SUBROUTINE usercreep (impflg, ldstep, isubst, matId, elemId,
&      kDInPt, kLayer, kSecPt, nstatv, nprop,
&      prop, time, dtime, temp, dtemp,
&      tofst, Ustatev, creqv, pres, seqv,
&      delcr, dcrda)
C*****
C      *** primary function ***
C      Define creep laws when creep table options are
C      TB, CREEP with TBOPT=100.
C      Demonstrate how to implement usercreep subroutine
C
C      Creep equation is
C      dotcreq := k0 * seqv ^ n * creqv ^ m * exp (-b/T)
C
C      seqv is equivalent effective stress (Von-Mises stress)
C      creqv is equivalent effective creep strain
C      T is the temperature
C      k0, m, n, b are materials constants.
C
C      This model corresponds to primary creep function TBOPT = 1
C
C      gal 10.01.1998
C*****
C
C      input arguments
C      =====
C      impflg (in ,sc ,i)      Explicit/implicit integration
C                               flag (currently not used)
C      ldstep (in ,sc ,i)      Current load step
C      isubst (in ,sc ,i)      Current sub step
C      matId (in ,sc ,i)       number of material index
C      elemId (in ,sc ,i)      Element number
C      kDInPt (in ,sc ,i)      Material integration point
C      kLayer (in ,sc ,i)      Layer number
C      kSecPt (in ,sc ,i)      Section point
C      nstatv (in ,sc ,i)      Number of state variables
C      nprop (in ,sc ,i)       size of mat properties array
C
C      prop (dp ,ar(*) ,i)     mat properties array
C                               This array is passed all the creep
C                               constants defined by command
C                               TB, CREEP
C                               TB, CREEP
C                               (do not use prop(13), as it is used
C                               elsewhere)
C-----
C      time at temperature temp.
C      dtime Current time
C      temp Current time increment
C      dtemp Current temperature
C      tofst (dp, sc, i) temperature offset from absolute zero
C      seqv (dp ,sc , i) equivalent effective stress
C      creqv (dp ,sc , i) equivalent effective creep strain
C      pres (dp ,sc , i) hydrostatic pressure stress, -(Sxx+Syy+Szz)/3
C
C      input output arguments      input desc      / output desc
C      =====                    =====
C      Ustatev (dp,ar(*) , i/o)    user defined internal state variables at
C      time 't' / 't+dt'.
C      This array will be passed in containing the
C      values of these variables at start of the
C      time increment. They must be updated in this
C      subroutine to their values at the end of
C      time increment, if any of these internal
C      state variables are associated with the
C      creep behavior.

```

```

C
C   output arguments
C   =====
C   delcr   (dp ,sc , o)           incremental creep strain
C   dcrda   (dp,ar(*), o)         output array
C                                     dcrda(1) - derivitive of incremental creep
C                                     strain to effective stress
C                                     dcrda(2) - derivitive of incremental creep
C                                     strain to creep strain
C
C   local variables
C   =====
C   c1,c2,c3,c4 (dp ,sc, l)         temporary variables as creep constants
C   con1       (dp ,sc, l)         temporary variable
C   t          (dp ,sc, l)         temporary variable
C
C*****
C
C --- parameters
C
#include "impcom.inc"
C
C   DOUBLE PRECISION ZERO
C   PARAMETER      (ZERO = 0.0d0)
C
C --- argument list
C
C   INTEGER      ldstep, isubst, matId , elemId,
C   &            kDInPt, kLayer, kSecPt, nstatv,
C   &            impflg, nprop
C   DOUBLE PRECISION  dtime , time , temp , dtemp , tofst,
C   &            creqv , seqv , pres
C   DOUBLE PRECISION prop(*), dcrda(*), Ustatev(nstatv)
C
C --- local variables
C
C   DOUBLE PRECISION c1 , c2 , c3 , c4 , c5 ,
C   &            c6 , c7 , c8 , c9 , c10 ,
C   &            c11 , c12 , epsl , delcr , delcr2 ,
C   &            t , B , p , xo , LMP ,
C   &            tr , LTF , k1 , k2 , delseqv
C
C*****
C
C *** skip when stress and creep strain are all zero
C   if (seqv.LE.ZERO.AND.creqv.LE.ZERO) GO TO 990
C *** add temperature off set
C   t = temp + tofst
C *** Primary creep function
C   delcr := -k1*k2*(creqv+1.0D0)*xo
C   c1 = prop(1)
C   c2 = prop(2)
C   c3 = prop(3)
C   c4 = prop(4)
C   c5 = prop(5)
C   c6 = prop(6)
C   c7 = prop(7)
C   c8 = prop(8)
C   c9 = prop(9)
C   c10 = prop(10)
C   c11 = prop(11)
C *** numerical differentiation (may need to adjust)
C   delseqv is delta(stress) while del_3 is delta(creep strain)
C   delseqv = 1.0D-5
C
C *** ICSP Equations required for delcr:
C   B = c1*EXP(c2*seqv)+c3*EXP(c4*seqv)
C   p = c5*seqv**2+c6*seqv+c7
C   xo = c8/(1.0D0+EXP(c9*LOG10(seqv)+c10))+c11
C   LMP = 3.595D4+1357.0D0*cos(7.627D0*LOG10(seqv))+1669.0D0*
C   & cos(7.627D0*LOG10(seqv)*2.0D0)+3605.0D0*sin(7.627D0*
C   & LOG10(seqv))+72.87D0*sin(7.627D0*LOG10(seqv)*2.0D0)

```

```

tr = 1.0D1**((LMP/(t+4.6D2))-2.0D1)
LTF = (B+log(tr+1.0D0))/(B+log(time+1.0D0))
eps1 = exp(xo*(LTF-1.0D0)**(1.0D0/p))*(1.0D0/1.0D2)-1.0D0/1.0D2
k1 = (LTF-1.0D0)**(1.0D0/p)/p
k2 = (1.0D0/(B+log(time+1.0D0))**2*(B+log(tr+1.0D0)))/
& ((time*1.0D2+1.0D2)*(LTF-1.0D0))
c *** calculate incremental creep strain
if (creqv .le. TINY) creqv = sqrt(TINY)
delcr = ZERO
delcr2 = ZERO

IF(t.gt.1000.0D0) delcr = -k1*k2*xo*(eps1*1.0D2+1.0D0)*dttime

c *** ICSP Equations required for delcr2 (delta stress):
B = c1*EXP(c2*(seqv+delseqv))+c3*EXP(c4*(seqv+delseqv))
p = c5*(seqv+delseqv)**2+c6*(seqv+delseqv)+c7
xo = c8/(1.0D0+EXP(c9*LOG10((seqv+delseqv))+c10))+c11
LMP = 3.595D4+1357.0D0*cos(7.627D0*LOG10((seqv+delseqv)))+
& 1669.0D0*cos(7.627D0*LOG10((seqv+delseqv))*2.0D0)+
& 3605.0D0*sin(7.627D0*LOG10((seqv+delseqv)))+72.87D0*
& sin(7.627D0*LOG10((seqv+delseqv))*2.0D0)
tr = 1.0D1**((LMP/(t+4.6D2))-2.0D1)
LTF = (B+log(tr+1.0D0))/(B+log(time+1.0D0))
eps1 = exp(xo*(LTF-1.0D0)**(1.0D0/p))*(1.0D0/1.0D2)-1.0D0/1.0D2
k1 = (LTF-1.0D0)**(1.0D0/p)/p
k2 = (1.0D0/(B+log(time+1.0D0))**2*(B+log(tr+1.0D0)))/
& ((time*1.0D2+1.0D2)*(LTF-1.0D0))

IF(t.gt.1000.0D0) delcr2 = -k1*k2*xo*(eps1*1.0D2+1.0D0)*dttime

c *** derivative of incremental creep strain to effective stress
dcrda(1) = (delcr2 - delcr)/delseqv
c *** derivative of incremental creep strain to effective creep strain
dcrda(2) = 0
c *** write the effective creep strain to last state variable for verification
Ustatev(4) = creqv
990 continue
return
end

```

Source Code 3: IN718 Material Properties Input Code

```

!---Inconel 718-----!
/COM, Typical Material Properties For IN 718
/NOPI      ! suppress printout for this macro
/COM, IN 718 at Heat Treatment: 1 hr 1750 to 1800 F air cooled,
/COM, 8 hr 1325 F furnace cooled at 100 F/hr to 1150 F,
/COM, 1150 F hold 8 hr air cool
/COM, Units in BU (ksi, lb, etc)

!---Modulus of Elasticity (psi)-----!
MPTEMP, 1, 70
MPDATA, EX, 1, 1, 29.6E3
MPDATA, PRXY, 1, 1, 0.302943

MPTEMP, 2, 200
MPDATA, EX, 1, 2, 29.2E3
MPDATA, PRXY, 1, 2, 0.2924

MPTEMP, 3, 400
MPDATA, EX, 1, 3, 28.8E3
MPDATA, PRXY, 1, 3, 0.2808

MPTEMP, 4, 600
MPDATA, EX, 1, 4, 27.6E3
MPDATA, PRXY, 1, 4, 0.2748

MPTEMP, 5, 800
MPDATA, EX, 1, 5, 26.5E3
MPDATA, PRXY, 1, 5, 0.2744

MPTEMP, 6, 1000
MPDATA, EX, 1, 6, 25.5E3
MPDATA, PRXY, 1, 6, 0.2796

MPTEMP, 7, 1200
MPDATA, EX, 1, 7, 24.5E3
MPDATA, PRXY, 1, 7, 0.2904

MPTEMP, 8, 1400
MPDATA, EX, 1, 8, 23.1E3
MPDATA, PRXY, 1, 8, 0.3068

MPTEMP, 9, 1600
MPDATA, EX, 1, 9, 18.1E3
MPDATA, PRXY, 1, 9, 0.3288
-----
MPTEMP, 10, 1750
MPDATA, EX, 1, 10, 11.1E3
MPDATA, PRXY, 1, 10, 0.348975

!---Creep Material Properties as Defined by usercreep.F-----!
tb,creep,1,2,11,100
TBTEMP,1112,1
tbdat,1, -1.08211E-14
tbdat,2, 2.15745E-01
tbdat,3, 4.88011E-03
tbdat,4, -3.61500E-03
tbdat,5, -2.99446E-03
tbdat,6, 6.96141E-01
tbdat,7, -4.18334E+01
tbdat,8, 0.749940767
tbdat,9, -62.2375932
tbdat,10, 131.4482724
tbdat,11, 0.064780637

```

```

TBTEMP,1292,2
tbdatt,1, 4.01651E+08
tbdatt,2, -3.74410E-01
tbdatt,3, 0.00000E+00
tbdatt,4, 0.00000E+00
tbdatt,5, 3.64436E-03
tbdatt,6, -4.87836E-01
tbdatt,7, 1.36954E+01
tbdatt,8, 0.357187494
tbdatt,9, -24.61835819
tbdatt,10, 43.72803618
tbdatt,11, 0.193225784

```

Source Code 4: APDL Input File (Case of 109 ksi and 1112 °F)

```

-----
/FILNAME, Smooth_Creep_109_1112
/COM, Original Smooth Creep Verification Test Created Febuary 22, 2011
/COM, Modified to represent case at 109 ksi and 1112 Fahrenheit
/TITLE, Smooth Bar Specimen Creep Analysis at (109 Ksi & 1112 F)
RESUME, Smooth, db

```

C*** Entering Preprocessor ***

```

/PREP7
ALLSEL
TUNIF,1112
CMSEL, , BC_NODE
D, ALL, UY, 0
ALLSEL
CMSEL, , TOP_NODE
SF, ALL, PRES, -109

```

C*** Application of Load (Elastic Analysis) ***

```

/SOLU
ALLSEL
NLGEOM, ON
RATE, OFF
TIME, 1E-8
EQSLV, PCG, 1E-8
OUTRES, ALL, LAST
SOLVE

```

C*** Beginning of Creep Analysis (Assumed Primary) ***

```

/SOLU          ! Second load step, apply mechanical loading
RATE, ON       ! Creep analysis turned on
NLGEOM, ON     ! Turn on non-linear Geometry
DELT, 1, .1, 100
TIME, 2200     ! Time period set to desired value
AUTOTS, 1      ! Automatic-time-stepping turned on
EQSLV, PCG, 1E-8
OUTRES, ERASE
OUTRES, , all
SOLVE

```

APPENDIX C: MATLAB SOURCE CODE

Source Code 5: Excel Data Reading & Result Writing M-code

```
%%
clear
clc

Titles = { 'Temperature', 'Stress', 'B', 'p', 'xo', 'rsquare' };
Stress_Temp = [1112 109; 1112 123; 1112 138; 1292 58; 1292 65; 1292 80];
xlswrite('Inconel_718_Material_Data.xlsx', Titles, 'Graphical', 'A1');
xlswrite('Inconel_718_Material_Data.xlsx', Stress_Temp, 'Graphical', 'A2:B7');
%%
%This routine loads creep data for curves at varying stress and
%temperature and there respective curve equations are defined:
%Temperature = 1112, Stress = 109:
LTIME_1112_109 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'A43:A55');
LSTRAIN_1112_109 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'B43:B55');
%Temperature = 1112, Stress = 123:
LTIME_1112_123 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'C43:C63');
LSTRAIN_1112_123 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'D43:D63');
%Temperature = 1112, Stress = 138:
LTIME_1112_138 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'E43:E61');
LSTRAIN_1112_138 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'F43:F61');
%Temperature = 1292, Stress = 58:
LTIME_1292_58 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'G43:G65');
LSTRAIN_1292_58 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'H43:H65');
%Temperature = 1292, Stress = 65:
LTIME_1292_65 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'I43:I66');
LSTRAIN_1292_65 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'J43:J66');
%Temperature = 1292, Stress = 80:
LTIME_1292_80 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'K43:K60');
LSTRAIN_1292_80 = xlsread('Inconel_718_Material_Data.xlsx', 'Creep', 'L43:L60');
%%
%Curve Fitting Function:
[cf_1112_109,goodness_1112_109,cf_1112_123,goodness_1112_123,...
 cf_1112_138,goodness_1112_138,cf_1292_58,goodness_1292_58,...
 cf_1292_65,goodness_1292_65,cf_1292_80,goodness_1292_80]...
 = createLCSPFit(LSTRAIN_1112_109,LTIME_1112_109,...
 LSTRAIN_1112_123,LTIME_1112_123,LSTRAIN_1112_138,LTIME_1112_138,...
 LSTRAIN_1292_58,LTIME_1292_58,LSTRAIN_1292_65,LTIME_1292_65,...
 LSTRAIN_1292_80,LTIME_1292_80);
%%
rsquare = goodness_1112_109.rsquare;
B = cf_1112_109.B;
p = cf_1112_109.p;
xo = cf_1112_109.xo;
Curve_Parameters = [B p xo rsquare];
xlswrite('Inconel_718_Material_Data.xlsx', Curve_Parameters, 'Graphical', 'C2')
```

```

%%
rsquare = goodness_1112_123.rsquare;
B = cf_1112_123.B;
p = cf_1112_123.p;
xo = cf_1112_123.xo;
Curve_Parameters = [B p xo rsquare];
xlswrite('Inconel_718_Material_Data.xlsx', Curve_Parameters, 'Graphical', 'C3')

%%
rsquare = goodness_1112_138.rsquare;
B = cf_1112_138.B;
p = cf_1112_138.p;
xo = cf_1112_138.xo;
Curve_Parameters = [B p xo rsquare];
xlswrite('Inconel_718_Material_Data.xlsx', Curve_Parameters, 'Graphical', 'C4')

%%
rsquare = goodness_1292_58.rsquare;
B = cf_1292_58.B;
p = cf_1292_58.p;
xo = cf_1292_58.xo;
Curve_Parameters = [B p xo rsquare];
xlswrite('Inconel_718_Material_Data.xlsx', Curve_Parameters, 'Graphical', 'C5')

%%
rsquare = goodness_1292_65.rsquare;
B = cf_1292_65.B;
p = cf_1292_65.p;
xo = cf_1292_65.xo;
Curve_Parameters = [B p xo rsquare];
xlswrite('Inconel_718_Material_Data.xlsx', Curve_Parameters, 'Graphical', 'C6')

%%
rsquare = goodness_1292_80.rsquare;
B = cf_1292_80.B;
p = cf_1292_80.p;
xo = cf_1292_80.xo;
Curve_Parameters = [B p xo rsquare];
xlswrite('Inconel_718_Material_Data.xlsx', Curve_Parameters, 'Graphical', 'C7')

%%
close all

```

Source Code 6: LCSP Generated Modified Curve Fitting Function

```
function [cf_1112_109,goodness_1112_109,cf_1112_123,goodness_1112_123,...
    cf_1112_138,goodness_1112_138,cf_1292_58,goodness_1292_58,...
    cf_1292_65,goodness_1292_65,cf_1292_80,goodness_1292_80]...
    = createLCSPFit(LSTRAIN_1112_109,LTIME_1112_109,...
    LSTRAIN_1112_123,LTIME_1112_123,LSTRAIN_1112_138,LTIME_1112_138,...
    LSTRAIN_1292_58,LTIME_1292_58,LSTRAIN_1292_65,LTIME_1292_65,...
    LSTRAIN_1292_80,LTIME_1292_80)
%CREATEFIT Create plot of data sets and fits
% CREATEFIT(LSTRAIN_1112_109,LTIME_1112_109,LSTRAIN_1112_123,
% LTIME_1112_123,LSTRAIN_1112_138,LTIME_1112_138,LSTRAIN_1292_58,
% LTIME_1292_58,LSTRAIN_1292_65,LTIME_1292_65,LSTRAIN_1292_80,
% LTIME_1292_80)
% Creates a plot, similar to the plot in the main Curve Fitting Tool,
% using the data that you provide as input. You can
% use this function with the same data you used with CFTOOL
% or with different data. You may want to edit the function to
% customize the code and this help message.
%
% Number of data sets: 6
% Number of fits: 6

% Data from data set "LTIME_1112_109 vs. LSTRAIN_1112_109":
% X = LSTRAIN_1112_109:
% Y = LTIME_1112_109:
% Unweighted

% Data from data set "LTIME_1112_123 vs. LSTRAIN_1112_123":
% X = LSTRAIN_1112_123:
% Y = LTIME_1112_123:
% Unweighted

% Data from data set "LTIME_1112_138 vs. LSTRAIN_1112_138":
% X = LSTRAIN_1112_138:
% Y = LTIME_1112_138:
% Unweighted

% Data from data set "LTIME_1292_58 vs. LSTRAIN_1292_58":
% X = LSTRAIN_1292_58:
% Y = LTIME_1292_58:
% Unweighted

% Data from data set "LTIME_1292_65 vs. LSTRAIN_1292_65":
% X = LSTRAIN_1292_65:
% Y = LTIME_1292_65:
% Unweighted
```

```

% Data from data set "LTIME_1292_80 vs. LSTRAIN_1292_80":
%   X = LSTRAIN_1292_80:
%   Y = LTIME_1292_80:
%   Unweighted

% Auto-generated by MATLAB on 13-Jul-2011 08:55:29
% Modified by user on 13-Jul-2011

% Set up figure to receive data sets and fits
f_ = clf;
figure(f_);
set(f_, 'Units', 'Pixels', 'Position', [692 9 667 619]);
% Line handles and text for the legend.
leg_h_ = [];
leg_t_ = {};
% Limits of the x-axis.
xlim_ = [Inf -Inf];
% Axes for the plot.
ax_ = axes;
set(ax_, 'Units', 'normalized', 'OuterPosition', [0 0 1 1]);
set(ax_, 'Box', 'on');
axes(ax_);
hold on;

% --- Plot data that was originally in data set "LTIME_1112_109 vs. LSTRAIN_1112_109"
LSTRAIN_1112_109 = LSTRAIN_1112_109(:);
LTIME_1112_109 = LTIME_1112_109(:);
h_ = line(LSTRAIN_1112_109, LTIME_1112_109, 'Parent', ax_, 'Color', [0.333333 0 0.666667], ...
    'LineStyle', 'none', 'LineWidth', 1, ...
    'Marker', '.', 'MarkerSize', 12);
xlim_(1) = min(xlim_(1), min(LSTRAIN_1112_109));
xlim_(2) = max(xlim_(2), max(LSTRAIN_1112_109));
leg_h_(end+1) = h_;
leg_t_(end+1) = 'LTIME_1112_109 vs. LSTRAIN_1112_109';

% --- Plot data that was originally in data set "LTIME_1112_123 vs. LSTRAIN_1112_123"
LSTRAIN_1112_123 = LSTRAIN_1112_123(:);
LTIME_1112_123 = LTIME_1112_123(:);
h_ = line(LSTRAIN_1112_123, LTIME_1112_123, 'Parent', ax_, 'Color', [0.333333 0.666667 0], ...
    'LineStyle', 'none', 'LineWidth', 1, ...
    'Marker', '.', 'MarkerSize', 12);
xlim_(1) = min(xlim_(1), min(LSTRAIN_1112_123));
xlim_(2) = max(xlim_(2), max(LSTRAIN_1112_123));
leg_h_(end+1) = h_;
leg_t_(end+1) = 'LTIME_1112_123 vs. LSTRAIN_1112_123';

```

```

% --- Plot data that was originally in data set "LTIME_1112_138 vs. LSTRAIN_1112_138"
LSTRAIN_1112_138 = LSTRAIN_1112_138(:);
LTIME_1112_138 = LTIME_1112_138(:);
h_ = line(LSTRAIN_1112_138,LTIME_1112_138,'Parent',ax_,'Color',[0 0 0],...
    'LineStyle','none', 'LineWidth',1,...
    'Marker','.', 'MarkerSize',12);
xlim_(1) = min(xlim_(1),min(LSTRAIN_1112_138));
xlim_(2) = max(xlim_(2),max(LSTRAIN_1112_138));
legh_(end+1) = h_;
legt_{end+1} = 'LTIME_1112_138 vs. LSTRAIN_1112_138';

% --- Plot data that was originally in data set "LTIME_1292_58 vs. LSTRAIN_1292_58"
LSTRAIN_1292_58 = LSTRAIN_1292_58(:);
LTIME_1292_58 = LTIME_1292_58(:);
h_ = line(LSTRAIN_1292_58,LTIME_1292_58,'Parent',ax_,'Color',[0.333333 1 0.666667],...
    'LineStyle','none', 'LineWidth',1,...
    'Marker','.', 'MarkerSize',12);
xlim_(1) = min(xlim_(1),min(LSTRAIN_1292_58));
xlim_(2) = max(xlim_(2),max(LSTRAIN_1292_58));
legh_(end+1) = h_;
legt_{end+1} = 'LTIME_1292_58 vs. LSTRAIN_1292_58';

% --- Plot data that was originally in data set "LTIME_1292_65 vs. LSTRAIN_1292_65"
LSTRAIN_1292_65 = LSTRAIN_1292_65(:);
LTIME_1292_65 = LTIME_1292_65(:);
h_ = line(LSTRAIN_1292_65,LTIME_1292_65,'Parent',ax_,'Color',[0 0.333333 0.666667],...
    'LineStyle','none', 'LineWidth',1,...
    'Marker','.', 'MarkerSize',12);
xlim_(1) = min(xlim_(1),min(LSTRAIN_1292_65));
xlim_(2) = max(xlim_(2),max(LSTRAIN_1292_65));
legh_(end+1) = h_;
legt_{end+1} = 'LTIME_1292_65 vs. LSTRAIN_1292_65';

% --- Plot data that was originally in data set "LTIME_1292_80 vs. LSTRAIN_1292_80"
LSTRAIN_1292_80 = LSTRAIN_1292_80(:);
LTIME_1292_80 = LTIME_1292_80(:);
h_ = line(LSTRAIN_1292_80,LTIME_1292_80,'Parent',ax_,'Color',[0.666667 1 0.333333],...
    'LineStyle','none', 'LineWidth',1,...
    'Marker','.', 'MarkerSize',12);
xlim_(1) = min(xlim_(1),min(LSTRAIN_1292_80));
xlim_(2) = max(xlim_(2),max(LSTRAIN_1292_80));
legh_(end+1) = h_;
legt_{end+1} = 'LTIME_1292_80 vs. LSTRAIN_1292_80';

% Nudge axis limits beyond data limits
if all(isfinite(xlim_))
    xlim_ = xlim_ + [-1 1] * 0.01 * diff(xlim_);
    set(ax_,'XLim',xlim_)
else
    set(ax_,'XLim',[-0.029208690850601175, 2.9500777759107186]);
end

```

```

% --- Create fit "fit_1112_109"
fo_ = fitoptions('method','NonlinearLeastSquares','Lower',[-Inf -Inf 0]);
ok_ = isfinite(LSTRAIN_1112_109) & isfinite(LTIME_1112_109);
if ~all( ok_ )
    warning( 'GenerateMFile:IgnoringNansAndInfs',...
            'Ignoring NaNs and Infs in data.' );
end
st_ = [0.51273481479723582 0.10555324817127809 0.12724328289643227 ];
set(fo_,'Startpoint',st_);
ft_ = fittype('(log(2477.375209+1)+B)/(1+(x/xo)^p)-B',...
            'dependent',{'y'},'independent',{'x'},...
            'coefficients',{'B', 'p', 'xo'});

% Fit this model using new data
[cf_1112_109,goodness_1112_109] = fit(LSTRAIN_1112_109(ok_),LTIME_1112_109(ok_),ft_,fo_);
% Alternatively uncomment the following lines to use coefficients from the
% original fit. You can use this choice to plot the original fit against new
% data.
% cv_ = { 0.0034442735017392984, -1.5283309768260096, 0.088278872533368594};
% cf_ = cfit(ft_,cv_{:});

% Plot this fit
h_ = plot(cf_1112_109,'fit',0.95);
set(h_(1),'Color',[1 0 0],...
    'LineStyle','-','LineWidth',2,...
    'Marker','none','MarkerSize',6);
% Turn off legend created by plot method.
legend off;
% Store line handle and fit name for legend.
legh_(end+1) = h_(1);
legt_{end+1} = 'fit_1112_109';

% --- Create fit "fit_1112_123"
fo_ = fitoptions('method','NonlinearLeastSquares','Lower',[-Inf -Inf 0]);
ok_ = isfinite(LSTRAIN_1112_123) & isfinite(LTIME_1112_123);
if ~all( ok_ )
    warning( 'GenerateMFile:IgnoringNansAndInfs',...
            'Ignoring NaNs and Infs in data.' );
end
st_ = [0.94259264420212985 0.58257080277832785 0.69095139861978072 ];
set(fo_,'Startpoint',st_);
ft_ = fittype('(log(300.950996+1)+B)/(1+(x/xo)^p)-B',...
            'dependent',{'y'},'independent',{'x'},...
            'coefficients',{'B', 'p', 'xo'});

```

```

% Fit this model using new data
[cf_1112_123,goodness_1112_123] = fit(LSTRAIN_1112_123(ok_),LTIME_1112_123(ok_),ft_,fo_);
% Alternatively uncomment the following lines to use coefficients from the
% original fit. You can use this choice to plot the original fit against new
% data.
%   cv_ = { 0.0022985454283962945, -1.4987787592533985, 0.21312618243574782};
%   cf_ = cfit(ft_,cv_{:});

% Plot this fit
h_ = plot(cf_1112_123,'fit',0.95);
set(h_(1),'Color',[0 0 1],...
     'LineStyle','-','LineWidth',2,...
     'Marker','none','MarkerSize',6);
% Turn off legend created by plot method.
legend off;
% Store line handle and fit name for legend.
leg_h(end+1) = h_(1);
leg_t(end+1) = 'fit_1112_123';

% --- Create fit "fit_1112_138"
fo_ = fitoptions('method','NonlinearLeastSquares','Lower',[-Inf -Inf 0]);
ok_ = isfinite(LSTRAIN_1112_138) & isfinite(LTIME_1112_138);
if ~all(ok_)
    warning('GenerateMFile:IgnoringNansAndInfs',...
           'Ignoring NaNs and Infs in data. ');
end
st_ = [0.98267510959976456 0.28338102803366083 0.54523096157345863 ];
set(fo_,'Startpoint',st_);
ft_ = fittype('(log(17.8915309+1)+B)/(1+(x/xo)^p)-B',...
             'dependent',{'y'},'independent',{'x'},...
             'coefficients',{'B','p','xo'});

% Fit this model using new data
[cf_1112_138,goodness_1112_138] = fit(LSTRAIN_1112_138(ok_),LTIME_1112_138(ok_),ft_,fo_);
% Alternatively uncomment the following lines to use coefficients from the
% original fit. You can use this choice to plot the original fit against new
% data.
%   cv_ = { -0.080047271143669232, -2.7500993673603986, 0.7017611055550429};
%   cf_ = cfit(ft_,cv_{:});

% Plot this fit
h_ = plot(cf_1112_138,'fit',0.95);
set(h_(1),'Color',[0.666667 0.333333 0],...
     'LineStyle','-','LineWidth',2,...
     'Marker','none','MarkerSize',6);
% Turn off legend created by plot method.
legend off;
% Store line handle and fit name for legend.
leg_h(end+1) = h_(1);
leg_t(end+1) = 'fit_1112_138';

```

```

% --- Create fit "fit_1292_58"
fo_ = fitoptions('method','NonlinearLeastSquares','Lower',[-Inf -Inf 0]);
ok_ = isfinite(LSTRAIN_1292_58) & isfinite(LTIME_1292_58);
if ~all( ok_ )
    warning( 'GenerateMFile:IgnoringNansAndInfs',...
            'Ignoring NaNs and Infs in data.' );
end
st_ = [0.1451932177560965 0.26068783435660436 0.65562326224249745 ];
set(fo_,'Startpoint',st_);
ft_ = fittype(' (log(288.444272+1)+B)/(1+(x/xo)^p)-B',...
            'dependent',{'y'},'independent',{'x'},...
            'coefficients',{'B', 'p', 'xo'});

% Fit this model using new data
[cf_1292_58,goodness_1292_58] = fit(LSTRAIN_1292_58(ok_),LTIME_1292_58(ok_),ft_,fo_);
% Alternatively uncomment the following lines to use coefficients from the
% original fit. You can use this choice to plot the original fit against new
% data.
% cv_ = { 0.14930276002735685, -2.3380045132701355, 0.34240097228279215};
% cf_ = cfit(ft_,cv_{:});

% Plot this fit
h_ = plot(cf_1292_58,'fit',0.95);
set(h_(1),'Color',[0.333333 0.333333 0.333333],...
    'LineStyle','-','LineWidth',2,...
    'Marker','none','MarkerSize',6);
% Turn off legend created by plot method.
legend off;
% Store line handle and fit name for legend.
legh_(end+1) = h_(1);
legt_{end+1} = 'fit_1292_58';

% --- Create fit "fit_1292_65"
fo_ = fitoptions('method','NonlinearLeastSquares','Lower',[-Inf -Inf 0]);

ok_ = isfinite(LSTRAIN_1292_65) & isfinite(LTIME_1292_65);
if ~all( ok_ )
    warning( 'GenerateMFile:IgnoringNansAndInfs',...
            'Ignoring NaNs and Infs in data.' );
end
st_ = [0.8299866357708845 0.24932267896815952 0.22706078593610923 ];
set(fo_,'Startpoint',st_);
ft_ = fittype(' (log(92.8542652+1)+B)/(1+(x/xo)^p)-B',...
            'dependent',{'y'},'independent',{'x'},...
            'coefficients',{'B', 'p', 'xo'});

```

```

% Fit this model using new data
[cf_1292_65,goodness_1292_65] = fit(LSTRAIN_1292_65(ok_),LTIME_1292_65(ok_),ft_,fo_);
% Alternatively uncomment the following lines to use coefficients from the
% original fit. You can use this choice to plot the original fit against new
% data.
%   cv_ = { 0.011808430583981951, -2.6126463628227352, 0.44951376496647949};
%   cf_ = cfit(ft_,cv_{:});

% Plot this fit
h_ = plot(cf_1292_65,'fit',0.95);
set(h_(1),'Color',[1 0 1],...
    'LineStyle','-','LineWidth',2,...
    'Marker','none','MarkerSize',6);
% Turn off legend created by plot method.
legend off;
% Store line handle and fit name for legend.
legh_(end+1) = h_(1);
legt_{end+1} = 'fit_1292_65';

% --- Create fit "fit_1292_80"
fo_ = fitoptions('method','NonlinearLeastSquares','Robust','On');
ok_ = isfinite(LSTRAIN_1292_80) & isfinite(LTIME_1292_80);
if ~all( ok_ )
    warning( 'GenerateMFile:IgnoringNansAndInfs',...
        'Ignoring NaNs and Infs in data.' );
end
st_ = [0.89051471139509319 0.64711766344406096 0.47195974656784689 ];
set(fo_,'Startpoint',st_);
ft_ = fittype('(log(26.7451219+1)+B)/(1+(x/xo)^p)-B',...
    'dependent',{'y'},'independent',{'x'},...
    'coefficients',{'B','p','xo'});

% Fit this model using new data
[cf_1292_80,goodness_1292_80] = fit(LSTRAIN_1292_80(ok_),LTIME_1292_80(ok_),ft_,fo_);
% Alternatively uncomment the following lines to use coefficients from the
% original fit. You can use this choice to plot the original fit against new
% data.
%   cv_ = { 0.0075841017567688596, -2.0076214226418543, 0.53012354573903464};
%   cf_ = cfit(ft_,cv_{:});

% Plot this fit
h_ = plot(cf_1292_80,'fit',0.95);
set(h_(1),'Color',[1 0 0],...
    'LineStyle','-','LineWidth',2,...
    'Marker','none','MarkerSize',6);
% Turn off legend created by plot method.
legend off;
% Store line handle and fit name for legend.
legh_(end+1) = h_(1);
legt_{end+1} = 'fit_1292_80';

```

```
% --- Finished fitting and plotting data. Clean up.
hold off;
% Display legend
leginfo_ = {'Orientation', 'vertical', 'Location', 'NorthEast'};
h_ = legend(ax_, legh_, legt_, leginfo_{:});
set(h_, 'Interpreter', 'none');
% Remove labels from x- and y-axes.
xlabel(ax_, '');
ylabel(ax_, '');
```

REFERENCES

1. *Energy Materials: Robust prediction of full creep curves from minimal data and time to rupture model.* **Holmstrom, S. and Auerkari, P.** 4, Kemistintie : Institute of Materials, Minerals and Mining and W. S. Maney & Son Ltd, 2006, Vol. 1.
2. **Boresi, P. Arthur.** *Advanced Mechanics of Materials Sixth Edition.* Hoboken : John Wiley & Sons, Inc, 2003. 0-471-43881-2.
3. *Journal Of Materials Science: Review, Mathematical description of the mechanical behaviour of metallic materials under creep conditions.* **Batsoulas, N. D.** 10, Patras : Chapman & Hall, 1997, Vol. 32. 0022-2461.
4. **Betten, Josef.** *Creep Mechanics.* Berlin : Springer-Verlag Berlin Heidelberg, 2008.
5. *Computational Materials Science: Benchmarks for finite element analysis of creep continuum damage mechanics.* **Becker, A. A., et al.** pg. 34-41, Nottingham : Elsevier Science B. V., 2002, Vol. 25.
6. *On the Viscous Flow in Metals and Allied Phenomena.* **C., Andrade E. N. DA.** London : The Royal Society of London, 1910.
7. *Computational Materials Science: Benchmarks for finite element analysis of creep continuum damage mechanics.* **Becker, A. A., et al.** pg. 34-41, Nottingham : Elsevier Science B. V., 2002, Vol. 25. 0927-0256.
8. *ECCC Recommendations and Guidance for the assessment of Creep Strain Data.* **Holdsworth, S. R.** 5, United Kingdom : ECCC (European Creep Collaborative Committee), 2003, Vol. 5.
9. *International Journal of Damage Mechanics: A Damage Mechanics Model for Creep and Oxygen Embrittlement in Metals.* **Deng, Xiaomin, Ma, Fashang and Sutton, A. Michael.** Columbia : Sage Publications, 2005, Vol. 14. 1056-7895.
10. *Energy Materials; Robust prediction of full creep curves from minimal data and time to rupture model.* **Holmstrom, S. and Auerkari, P.** 4, Kemistintie : Maney Publishing, 2006, Vol. 1. 1748-9245.
11. *Materials Science and Engineering A: Time-independent formulation for creep damage modeling in metals based on void and crack evolution.* **Esposito, Luca and Bonora, Nicola.** 15, s.l. : Elsevier, 2009, Vols. 510 - 511. 0921-5093.
12. *Uniaxial high-temperature creep property predictions made by CDM and MPC omega techniques for ASME SA 455 steel.* **Manu, C. C., Birk, A. M. and Y., Kim I.** 4, Tarrytown : Pergamon, 2009, Vol. 16. 1350-6307.
13. *Nuclear Engineering and Design: A review of creep analysis and design under multi-axial stress states.* **Yao, Hua-Tang, et al.** s.l. : Elsevier, 2007, Vol. 237. 0029-5493.
14. **Jadaan, M. Osama.** *Deterministic Multiaxial Creep and Creep Rupture Enhancements for CARES/Creep Integrated Design Code.* s.l. : National Aeronautics and Space Administration (NASA), 1968.
15. *Journal of Materials Engineering and Performance; Creep Constitutive Model and Component Lifetime Estimation: The Case of Niobium-Modified 9Cr-1Mo Steel Weldments.* **Lewis, Gladius and Shaw, M. Kevin.** New York : Springer, 2010, Vol. Online First. 1059-9495.
16. *International Journal of Pressure Vessels and Piping.* **Law, M., Payten, W. and Snowden, K.** Northern Ireland : Elsevier Science Ltd., 1998, Vol. 75. 0308-0161.
17. *International Journal of Pressure Vessels & Piping: Creep damage simulation of thick-walled tubes using the θ projection concept.* **Loghman, A. and Wahad, M. A.** Northern Ireland : Elsevier, 1996, Vol. 67. 0308-0161.
18. *Metals and Materials International: Creep Strain and Creep-Life Prediction for Alloy 718 Using the Omega Method.* **Yeom, Jong-Taek, et al.** 6, Seoul : Springer, 2003, Vol. 9.
19. **Imaoka, Sheldon.** User Creep Subroutine. s.l. : ANSYS Inc, 2007. Memo Number: STI074A.
20. *Guide to ANSYS User Programmable Features, ANSYS Release 10.0.* Canonsburg : ANSYS, Inc, 2005.
21. **Klopp, D. William.** Ni-4100:IN718 (Code 4103). *Aerospace Structural Metals Handbook.* West Lafayette : Purdue Research Foundation, 1995.
22. **Cullen, T.M. and Freeman, J.W.** *Nasa Contractor Report (NASA CR-268): The Mechanical Properties of Inconel 718 Sheet Alloy at 800, 1000, and 1200.* Washington, D.C. : National Aeronautics and Space Administration, 1965.
23. High Temp Metals 800-500-2141 - Inconel 718 Technical Data. *High Temp Metals.* [Online] High Temp Metals, Inc., July 29, 2011. [Cited: February 15, 2011.] <http://www.hightempmetals.com/techdata/hitempInconel718data.php>.
24. Programmer's Manual for ANSYS Release 12.0. s.l. : SAS IP Inc, 2009.

25. *Developing an ANSYS Creep Model for Polypropylene from Experimental Data. Proceedings of International ANSYS Conference.* **Dropik, M., Johnson, D. and Roth, D.** s.l. : N/A, 2002.
26. **Shults, Carlos.** Implicit Delayed Norton Creep Implementd. s.l. : PADT Inc.
27. *Nuclear Engineering and Design; Long-term creep rupture behavior of smoothed and notched bar specimens of low-carbon nitrogen-controlled 316 stainless steel (316FR) and their evaluation.* **Takahashi, Yukio, Hiroshi, Shibamoto and Kazuhiko, Inoue.** s.l. : Elsevier, 2008, Vol. 238. 0029-5493.
28. *Materials Science and Engineering A.* **Yu, Q. M., et al.** s.l. : Elsevier, 2009, Vol. 520. 0921-5093.
29. **Inouye, F. T., et al.** *Application of Alloy 718 in M-1 Engine Components.* Washington : National Aeronautics and Space Administration (NASA), 1967.
30. *Notch effects on creep behaviour of CMSX-4 superalloy single crystals.* **Lukas, P., Prelik, P. and Cadek, J.** s.l. : Elsevier, 2001, Vol. 298. 0921-5093.
31. *International Journal of Pressure Vessels and Piping: A comparison of creep models for nickel base alloys advanced energy systems.* **Swindeman, R.W. and Swindeman, M.J.** Lancaster : Elsevier, 2008, Vol. 85. 0308-0161.
32. *Transactions of The Indian Institute of Metals: A Stochastic model for evolution of creep damage in engineering materials.* **Roy, N., Ghosh, R.N. and Bose, S.C.** 2-3, Jamshedpur : TIIM, 2010, Vol. 63.
33. *Engineering Failure Analysis: Uniaxial High-Temperature creep property predictions made by CDM and MPC omega techniques for ASME SA 455 Steel.* **Manu, C.C., Birk, A.M. and Kim, I.Y.** s.l. : Elsevier, 2009, Vol. 16. 1350-6307.
34. *Metallurgical and Materials Transactions A: Creep-Behavior Modeling of the Single-Crystal Superalloy CMSX-4.* **MacLachlan, D. W. and Knowles, D. M.** Cambridge : TMS and ASM International, 2000, Vol. 31A.
35. *ACTA PHYSICA SINICA: A STATISTICAL THEORY OF CREEP FRACTURE.* **HUI-YING, Xu and XIU, XING.** 8, Beijing : National Natural Science Foundation of China, 1997, Vol. 6.
36. *Materials Letters: Study of standard heat treatment on mechanical properties of Inconel 718 using ball indentation technique.* **Ghosh, Sabita, Yadav, Sandip and Goutam, Das.** s.l. : Elsevier, 2008, Vol. 62. 2619-2622.
37. *Strain: An Advanced Creep Model Allowing for Hardening and Damage Effects.* **Calı, C., Cricrı, G. and Perrella, M.** s.l. : Blackwell Publishing Ltd., 2010, Vol. 46.
38. *Ansys Element Reference 12.1.* Canonsburg : SAS IP, Inc., 2009.