

Brass-texture induced grain structure evolution in room temperature rolled ODS copper

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Abstract

Currently, advanced ODS copper alloy is under study as a potential fusion material providing good mechanical properties. In this work, in order to develop a high performance ODS copper containing 0.5wt% Y₂O₃ oxide particles, the effect of room temperature rolling and subsequent annealing on the grain structure evolution, texture development and tensile properties are studied using EBSD, TEM and tensile tests. Microstructure evolution studies show the grain structure coarsens by enhancing the Brass texture during increase of rolling reduction and a unique single crystal-like brass-texture deformed structure is achieved after 80% rolling reduction. We found the deformation mechanism of partial slip by $\frac{a}{6}\langle 211 \rangle$ dislocations facilitated by the pinning of $\frac{a}{2}\langle 101 \rangle$ perfect dislocations through fine oxide particles is responsible for formation of Brass texture during room temperature rolling. Furthermore, the recrystallization of ODS copper retards to high temperature of ~700°C and shows a fine-grained microstructure with different orientations of Goss, Brass, S and Copper. Evaluation of microstructure-mechanical properties of the recrystallized samples expresses that the bimodal grain size distribution at 800°C for 30 min offers a good tensile strength-ductility (UTS: 491 MPa, el_t: 19%) at ambient temperature.

Keywords: ODS copper; Grain structure; Brass texture; Tensile properties; Rolling and Recrystallization

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1 **1. Introduction**

2 Advanced oxide dispersion strengthened (ODS) materials are attractive category of
3 metallic alloys especially for the neutron irradiation environments due to the good mechanical
4 properties and radiation resistance by suppression of irradiation defects using fine dispersion
5 of Y-based oxide particles in the microstructure. During the recent decades, different types of
6 ODS steels have been developed successfully for application in the nuclear fission reactors [1].
7 Recent attention to fusion energy as infinite source of energy has been a strong motivation for
8 a broader area of structural materials research like new ODS copper alloys for high heat flux
9 applications in some fusion reactor components such as divertor [2, 3]. In this way, the control
10 of microstructure offering good mechanical properties at low to intermediate temperature is of
11 paramount importance.

12 It is well known that plastic deformation by cold rolling and subsequent recrystallization
13 is an effective way of microstructure control to improve mechanical properties. In recent years,
14 this processing especially at cryogenic temperatures attracted a considerable attention [4, 5].
15 During such processing of metallic alloys, the evolution of grain size and preferred texture are
16 two important microstructural parameters of materials which strongly affect different
17 mechanical/physical properties such as tensile strength, strain hardening, ductility and also
18 thermal conductivity [6-8]. It has been well documented that by plastic deformation of metallic
19 alloys at low temperature, the density of defects rises up, i.e. dislocations pile-up and increase

1 in grain boundaries through change in grain shape results in deformation induced grain
2 refinement [9, 10]. In other side, literature review shows that the effect of primary grain size
3 on the evolution of texture is considerable [11-14]. In a new paper, Gu et al. [6] achieved a
4 brass-type texture in the ultrafine grained copper, while a copper-type texture was obtained in
5 the coarse-grained copper after the same rolling condition and concluded that the deformation
6 texture in severe rolled copper is strongly grain size dependent.

7 It has been observed generally that fcc materials develop two different types of rolling
8 texture depending on material parameters especially stacking fault energy (SFE): α -fiber or
9 brass-type texture in low SFE materials and β -fiber or copper-type texture in medium to high
10 SFE materials. The α -fiber is described by a combination of the brass orientation ($\{110\}\langle 2\bar{1}1\rangle$)
11 and the Goss orientation ($\{110\}\langle 100\rangle$) while the β -fiber is obtained by the main orientations
12 of copper ($\{112\}\langle 111\rangle$) and S ($\{123\}\langle 634\rangle$). It is widely accepted that copper type texture is
13 developed by homogenous deformation of polycrystal with straight-forward $\{111\}\langle 110\rangle$ slip
14 based on the Taylor model, but still the underlying mechanisms related to the formation of brass
15 type texture is a controversial subject. Leffers and Ray [15] in a recent review paper explained
16 the current understanding on main parameters affecting on the brass-type texture development.
17 It is believed that deformation twinning has a decisive effect on development of the brass-type
18 texture via overshooting/latent hardening introduced by the closely spaced twin lamellae. In
19 addition, shear bands have been observed to provide a predominant contribution during the late

1 stages of the development of the brass-type texture [5,16]. Recently, some researchers have
2 investigated the effect of deformation mechanism on development of Brass-type texture [17,
3 18]. Gu et al. [18] discussed the deformation mechanism of brass-type texture in rolling of
4 ultrafine-grained copper associated with the activation of partial $\{111\}\langle 11\bar{2}\rangle$ slip in addition
5 to usual $\{111\}\langle 110\rangle$ slip and with a reduced quantity of geometrically necessary dislocations
6 using the viscoplastic self-consistent polycrystal model.

7 The distribution of second phase particles in the metallic matrix has been observed to be
8 an effective factor on the deformation microstructure and texture. Hansen and Leffer [19] have
9 reviewed the role of small and large particles in fcc materials during deformation and pointed
10 out that presence of oxide particles leads to higher dislocation density and smaller subgrain
11 size in a given strain. For small volume fractions of particles, the texture strengthening has
12 been reported in some studies. Even though in recent years many researches have tried to
13 understand the microstructure evolution of pure copper during rolling deformation, the
14 information on the evolution of microstructure and texture of oxide dispersion strengthened
15 copper is quite low. The objective of this work is to specify the crystallographic texture of ODS
16 copper and its effect on the grain structure evolution during rolling deformation at room
17 temperature and subsequent recrystallization annealing and assess underlying deformation
18 mechanism and related tensile properties by experimental evaluations.

19 **2. Experimental**

1 In this study, ODS copper material with a nominal composition of Cu-0.5wt% Y₂O₃ was
2 prepared. A high purity (99.9%) copper powder with the mean particle size of 50 μm and Y₂O₃
3 nanopowder with the mean particle size of 50 nm were used as raw materials. The powder
4 mixture was mechanically alloyed (MA) by using Fritch-P6 planetary ball mill with optimum
5 amount of 1wt% stearic acid as process control agent in Ar gas atmosphere. The ball milling
6 was performed for 48 hours with ball to powder ratio of 10:1 and rotation speed of 470 rpm.
7 The chemical composition of MA powder has been shown elsewhere [20]. Then, the MA
8 powder was consolidated by spark plasma sintering (SPS) in a graphite die at 900°C/45min
9 under a load of 800 kg and a vacuum of 10 Pa. After the consolidation, a sintered ODS copper
10 with a cylindrical shape of ~ 15 mm (diameter) × 10 mm (height) was obtained and a sample
11 with a thickness of 3 mm was cut from the center part normal to the radial direction for
12 subsequent rolling and microstructural analysis.

13 Cold rolling process was performed on the sintered ODS copper sample at room
14 temperature with a total thickness reduction of 80% and a low thickness reduction of 0.01 mm
15 per pass using a two-rolling mill with the roll diameter of 160 mm. For comparison, a sintered
16 pure copper sample without Y₂O₃ oxide particles was cold rolled with the same conditions. The
17 Evolution of microstructure and rolling texture during deformation was evaluated by stopping
18 the cold rolling process at different thickness reductions of 20%, 40%, 60% and 80%. Then the
19 annealing was done on 80% cold rolled samples in temperature range of 100-900°C for 30 min

1 to evaluate the recrystallization temperature.

2 X-ray diffraction was conducted by means of $Cu - K_{\alpha}$ radiation with a Philips X'Pert
3 PRO to measure the dislocation density according to Ref. [20]. The analysis was performed on
4 the surface of polished 80% rolled plates with an acceleration voltage of 40 kV and the current
5 of 40 mA in the 2θ range of 20° - 100° with a step size of 0.02° . The microstructure of specimens
6 was observed by electron backscatter diffraction (EBSD) equipment attached to a field
7 emission scanning electron microscope (JEOL JSM-6500F) operating at 15 kV. The
8 observations were made on the rolling plane containing rolling direction (RD) and transverse
9 direction (TD) in the mid-thickness section of the samples with a step size depending on the
10 grain size as low as 20 nm. Sample preparation for EBSD was done by grinding with SiC paper
11 up to 2000 grit and then polishing with 1 μ m diamond paste and final polishing with Struers
12 colloidal silica suspension. To attain EBSD data, TSL-OIM software was used for different
13 analyses of inverse pole figure (IPF) maps, image quality (IQ) map, orientation distribution
14 functions (ODF) and grain size measurements. To improve the reliability of the EBSD data,
15 small grains comprising three or fewer pixels were automatically removed from the maps using
16 the grain-dilation option in the software. Furthermore, a lower limit boundary-misorientation
17 cutoff of 2° was used and a 15° criterion was employed to differentiate low-angle boundaries
18 (LABs) and high-angle boundaries (HABs). Grain size was quantified by the determination of
19 the area of each grain and the calculation of its circle-equivalent diameter. To evaluate the

1 texture, ODF related to three different sections in $\varphi_2 = 0^\circ, 45^\circ, 65^\circ$ were studied based on the
2 typical orientations of fcc structure.

3 A JEOL JEM-2010 transmission electron microscopy was used with a voltage of 200 kV
4 to study the microstructures of rolled samples in high magnification. To study the dislocations
5 in the microstructures, the sample tilted in four different g-vectors near to [011] zone axis.
6 Furthermore, a FEI-Titan scanning transmission electron microscope (300 kV) was used to
7 analyze fine oxide particles. The thin foil for TEM observation was prepared by focused ion
8 beam (FIB) (JEOL JIB-4600F) and the thinning was accomplished up to the thickness of ~100
9 nm. For evaluation of oxide particle distribution, the average particle size and the number
10 density of oxide particles was derived in thin foil based on TEM images using the convergent-
11 beam technique [20,21]. The volume fraction of twin bundles was estimated based on different
12 TEM images taken in different areas. Considering the same thickness in the TEM images, the
13 volume fraction of twin bundles was evaluated.

14 To specify the recrystallization temperature, Vickers microhardness data of the rolled and
15 annealed samples were obtained by a HMV-Micro Hardness Tester-SHIMADZU, under a load
16 of 980 mN and dwell time of 30 s with 5 times measurements. The average Vickers
17 microhardness values were reported, and the maximum and minimum values were shown as
18 error bar. In order to evaluate mechanical properties, uniaxial tensile tests were performed
19 parallel to the rolling direction at ambient temperature under a strain rate of $1.0 \times 10^{-3} \text{ s}^{-1}$

1 using Shimadzu, SSL-1KN tensile machine. For each condition, two miniaturized size
2 specimens were prepared with a gauge dimension of 5 mm in length, 1.2 mm in width and 0.5
3 mm in thickness using an electro-discharge processing machine.

4 **3. Results**

5 **3.1. Microstructure characterization after sintering and rolling of 80% reduction**

6 Fig. 1 shows the EBSD results of sintered ODS copper by SPS at 900°C/45 min. IPF map
7 of sintered ODS copper (Fig. 1(a)) exhibits mainly submicron sized grains (~80% area fraction)
8 in combination with some larger micron sized grains were formed in the microstructure. The
9 misorientation distribution of grain boundaries (Fig. 1(b)) shows that about 40% area fraction
10 of boundaries are LABs of $<15^\circ$ and 60% are HABs with a peak around 60° related to twin
11 boundaries. The related ODF (Fig. 1(c)) at $\varphi_2 = 0^\circ$ indicates that a main texture of α -fiber
12 with the maximum intensity of 2.7 was developed in sintered microstructure from Goss
13 ($\{011\}\langle 100 \rangle$) to around Brass orientation ($\{011\}\langle 2\bar{1}1 \rangle$) together with weaker texture near to
14 β -fiber (including copper $\{112\}\langle 111 \rangle$ and S $\{123\}\langle 634 \rangle$) and Y orientation ($\{111\}\langle 2\bar{1}1 \rangle$).
15 Formation of this texture in the sintered ODS copper after SPS is in contrast to random texture
16 reported for sintered pure copper [22]. However, after rolling with 80% reduction, the IPF map
17 of rolling plane in Fig. 2(a) reveals the formation of an unexpected microstructure of large
18 green grain with some fine grains distributed inside the matrix. The related image quality (IQ)
19 map in Fig. 2(b) expresses low IQ values attributed to high stored energy in the large green

1 grain. The supplementary results indicate formation of a large grain in three dimensions of
2 rolling, transverse and normal directions. The texture determined by the ODF in $\varphi_2 = 0^\circ$ (Fig.
3 2(c)) demonstrates concentration of strong Brass orientation ($\{011\}\langle 2\bar{1}1\rangle$) with a high
4 maximum intensity of 143 times than random which was confirmed by strong peak of $\{022\}$
5 plane in X-ray measurement (not shown here). Fig. 2 (d) shows the grain boundary map of the
6 same frame of the IPF map in Fig. 2 (a) as the HABs are shown in black line and the LABs of
7 $2-5^\circ$ and $5-15^\circ$ are shown with red and green lines, respectively. It clearly expresses that the
8 large green grain is covered mainly by many fine subgrains with approximate size of 100 nm
9 via arrangement of LABs of $<5^\circ$ in the curved shape in addition to some grains delineated by
10 HABs with a size in the range of 100 nm-5 μm . The misorientation distribution of grain
11 boundaries in Fig. 2 (e) illustrates that 74% area fraction is belonged to the LABs of $<5^\circ$ which
12 increased considerably after cold rolling. In comparison, in the work by Gu et al. [18], sub-
13 micrometer grains with a brass-type texture including 11.2% copper, 39% S and 34% Brass
14 orientations was accomplished after high strain rolling of ultrafine-grained copper.

15 Fig. 3(a) shows the bright-field (BF) TEM image of ODS copper sintered around 900°C
16 before cold rolling with 80% reduction. It can be seen many fine submicron sized grains are
17 distributed in the microstructure of sintered ODS copper as confirmed by inset diffraction
18 pattern with a relatively high dislocation density remained in the microstructure after the
19 sintering. Another important microstructural property illustrated by diffraction pattern and BF-

1 STEM image in Fig. 3(b) is fine distribution of Y_2O_3 oxide particles in the microstructure of
2 the sintered ODS copper. Based on this figure, fringe patterns appear in the interface of oxide
3 particles with copper matrix, suggesting semicoherent interface of oxide particles. The fringe
4 contrast has been discussed for oxide particles in literature to be formed by the misfit
5 dislocations [20, 23]. Number density of oxide particles was estimated in the order of
6 $1.62 \times 10^{22} \text{ m}^{-3}$ with an average diameter of $\sim 10 \text{ nm}$. This high distribution of fine oxide
7 particles has a strong effect on capturing the irradiation defects at the interface of oxides-matrix
8 and contributing to irradiation resistance [1]. TEM observations from the microstructure of
9 80% rolled ODS copper in Fig. 3(c) suggests the fine nanosized subgrains or grains as shown
10 by arrows with a size of $\sim 100 \text{ nm}$ have been distributed in the matrix as confirmed by the inset
11 diffraction pattern from $[211]$ zone axis. Some nanoscale deformation twin bundles [24] with
12 lenticular shape can be seen in Fig. 3(d) spreading in various high strain areas which was
13 estimated to be about 6% of area fraction. Furthermore, a high dislocation density was
14 accumulated in the whole microstructure which was calculated to be $1.00 \times 10^{15} \text{ m}^{-2}$, one
15 order of magnitude higher in compared to the value of $1.82 \times 10^{14} \text{ m}^{-2}$ for the 80% reduction
16 rolled pure copper without oxide particles. The TEM results are consistent with EBSD results
17 in Fig. 2, showing the formation of many fine subgrains inside the matrix of large Brass-texture
18 grain by arrangement of dislocation boundaries discussed previously for different cold rolled
19 fcc metals [25-27], and indicating a unique deformed structure was developed in heavily cold

1 rolled ODS copper.

2 **3.2. Evolution of grain structure and texture during cold rolling**

3 To evaluate the evolution of grain structure and crystallographic texture during cold rolling
4 of ODS copper, the rolling plane microstructure was analyzed by EBSD in different thickness
5 reductions of 20%, 40%, 60% and 80%, respectively (Fig. 4). Based on the IPF maps, the grains
6 after 20% reduction are in fine submicron size with the distribution of some green grains of
7 $\{110\}$ rolling plane (Fig. 4a), then by increasing the reduction to 40% and 60%, the density of
8 green grains increase with simultaneous growth of the grain size especially after 60% to micron
9 size (Fig. 4b, c). Surprisingly, after 80% reduction (Fig. 4d), one green grain overspread in the
10 whole microstructure and a single crystal-like structure formed in the final cold rolled ODS
11 copper material. It should be noted that the analysis was done in the lowest feasible
12 magnification with a 1 mm scale to show the magnitude of the single grain. As observed in the
13 ODF (Fig. 4(e-h)), the crystallographic texture of Brass orientation ($((110)[2\bar{1}1])$) is dominant
14 in all reductions. While in deformation textures up to 60% reduction, some scattering of texture
15 around Brass orientation is also available related to the grains with other orientations, the
16 texture of 80% rolled sample was converged completely around Brass orientation with much
17 higher intensity. Formation of such a microstructure is in contrast to the usual cold rolled
18 microstructures in pure copper [28] and demonstrates an extraordinary deformed structure
19 based on our literature survey.

1 Fig. 5 depicts the change in grain size, grain boundary length fraction and Brass-texture
2 intensity (defined as the ratio of weight at Brass orientation relative to its weight in a random
3 texture) versus different rolling reductions based on the EBSD results of Fig. 4. As shown in
4 Fig. 5(a), the primary sub-micron sized grains, by starting cold rolling to 20% reduction
5 remains in ultrafine grain size of $0.25\pm 0.21\ \mu\text{m}$, then by increasing rolling reduction the grain
6 size start to grow slowly and reaches to $0.27\pm 0.21\ \mu\text{m}$ and $0.31\pm 0.31\ \mu\text{m}$ after 40% and 60%
7 reductions, respectively. By progress of rolling to more heavy deformation, the trend of grain
8 growth accelerates and after final 80% reduction, an interestingly single grain with a several
9 millimeter-sized grain forms in the microstructure. Furthermore, analysis of grain boundary
10 length fractions of LABs ($2-15^\circ$) and HABs ($>15^\circ$) taken from the equivalent area in Fig. 5(b)
11 determines a consistent result with a stable ratio of about 40% LABs and 60% HABs up to 60%
12 reductions and then the fraction of the LABs increase significantly to $\sim 83\%$ with remaining
13 17% LABs as seen in Fig. 2(d). The progress of the intensity of Brass texture during rolling
14 reductions up to 80% can be observed in Fig. 5(c). This curve shows the intensity of Brass
15 texture is incrementing slowly from 2.7 times in primary sample to 14.5 times in 60%
16 reductions, then by increase of rolling to 80% reduction, the intensity rose considerably up to
17 143 times. In comparison to the change of grain size, this curve shows the same evolution
18 during rolling and expresses the dependency of grain growth to texture intensity during heavy
19 deformation by cold rolling.

3.3. Evolution of grain structure and texture during annealing and related mechanical properties

To study subsequent recrystallized microstructures, the Vickers microhardness ($HV_{0.1}$) of cold rolled ODS copper samples were analyzed after annealing at different temperatures of 100-900°C for 30 min (Fig. 6). In the figure, there is a little drop from microhardness of 80% rolled condition ($171 \pm 3 HV_{0.1}$) by annealing at low temperatures up to around 600°C probably due to thermally activated recovery processes. However, at temperature range of ~700-800 °C, the microhardness showed a high drop to the value of $123 \pm 1 HV_{0.1}$ and $106 \pm 5 HV_{0.1}$ at 700°C and 800 °C, respectively, suggesting the occurrence of static recrystallization phenomena [29].

Fig. 7 (a,b) shows the EBSD results of recrystallized ODS copper at 700 °C and 800 °C for 30 min after 80% reduction rolling. The microstructure of recrystallized ODS copper at 700°C/30 min in the IPF map (Fig. 7a) exhibits formation of fine new grains in the wide range of submicron to micron sized grains with average grain size of $\sim 0.46 \mu\text{m}$. The related ODF at $\varphi_2 = 0^\circ, 45^\circ, 65^\circ$ indicate that the new grains have different orientations in α -fiber including Goss ($\{011\}\langle 100 \rangle$) and Brass ($\{011\}\langle 2\bar{1}1 \rangle$) orientations and also β -fiber including S ($\{123\}\langle 634 \rangle$) and copper ($\{112\}\langle 111 \rangle$) orientations. By increasing recrystallization to 800°C/30 min (Fig. 7b), a larger average grain size of $0.53 \mu\text{m}$ formed in the sample and some abnormal grain growth can be observed in the micrometer sized grains in combination to the ultrafine grains in the IPF map, however the texture still remained in the α -fiber and β -fiber

1 including the main orientations of Goss, Brass, S and copper with the higher texture intensity
2 of 12.4 in compared to recrystallization at 700°C.

3 Fig. 8 shows the engineering tensile stress-strain curves of 80% reduction rolled ODS
4 copper and subsequent recrystallized ODS copper at 700°C and 800°C for 30 min, evaluated
5 at ambient temperature. The related values of mechanical properties including yield strength
6 ($\sigma_{0.2}$), ultimate strength (σ_u), uniform elongation (el_u) and total elongation (el_t) can be seen in
7 Table 1. As observed clearly in the figure, the room temperature rolled sample has the highest
8 ultimate tensile strength (UTS) of 550 MPa, but the lowest ductility with a total elongation of
9 3.2%. However, after recrystallization at both 700°C and 800°C, the ductility improved
10 significantly to amounts of 13% and 19% in expense of little reduced tensile strength,
11 respectively. The UTS level of recrystallized ODS copper at 800°C after room temperature
12 rolling is superior to tensile strength of coarse grained pure copper (200 MPa) and also the
13 recrystallized pure copper even after cryogenic rolling (~400 MPa) [4] and comparable with
14 the precipitation strengthened CuCrZr (σ_y : 500 MPa) [3]. The high ductility in the recrystallized
15 ODS copper at 800°C with a total elongation of 19% is attributed to the bimodal grain size
16 distribution discussed previously in Ref. [4], consisting of ultrafine grains in combination to
17 some micron sized grains as observed in the IPF map of Fig. 7 (b).

18 **3.4. Deformation mechanism of ODS copper during rolling deformation**

19 Investigation of the deformation mechanism was performed on the cold rolled ODS copper

1 deformed with 20% reduction by transmission electron microscope imaging. Based on the
2 bright field TEM images in Fig. 9, one grain with a width of about 250 nm was selected to
3 observe in four different g-vectors of $[31\bar{1}]$, $[200]$, $[\bar{1}\bar{1}1]$ and $[\bar{1}1\bar{1}]$ near to $[011]$ zone
4 axis as shown in each selected area diffraction pattern. According to Table 2, the visibility
5 criteria ($|\vec{g} \cdot \vec{b}|$ values) was used for the evaluation of perfect dislocations and partial dislocations
6 with the burgers vectors of $b_1 = \frac{a}{2}\langle 011 \rangle$ and $b_2 = \frac{a}{6}\langle 211 \rangle$, respectively. The detailed analysis of
7 the four figures showed that the dislocation lines of three burgers vectors of $\frac{a}{2}[\bar{1}01]$, $\frac{a}{2}[0\bar{1}1]$,
8 $\frac{a}{2}[1\bar{1}0]$ can be observed in these figures as shown by red arrows. In upper part of the images,
9 a dislocation line between the grain boundary and an oxide particle with $\frac{a}{2}[1\bar{1}0]$ burgers
10 vector is visible in all the figures except $g = [\bar{1}\bar{1}1]$. In the center part of the images, a zigzag
11 dislocation line is located between some oxide particles with a length of ~ 100 nm which is
12 invisible in the TEM image corresponding to $g = [200]$, possessing burgers vector of $\frac{a}{2}[0\bar{1}1]$.
13 Furthermore, it was found different pieces of dislocations in the curved shape were in the lower
14 part of the images which were realized to be a mixture of partial and perfect dislocations based
15 on the visibility criteria. Except one perfect dislocation piece with $\frac{a}{2}[\bar{1}01]$ burgers vector
16 shown by red arrows in other images, other segments can be distinguished more clearly in the
17 image with g-vector of $[\bar{1}\bar{1}1]$. Moreover, a number of fine oxide particles can be distinguished
18 around dislocation lines in this image. In other side, two finer pieces of dislocations with size
19 of less than 20 nm (in $g(200)$ image) was found as the partial dislocations with $\frac{a}{6}[\bar{1}2\bar{1}]$

1 burgers vectors as shown by the yellow arrows.

2 Due to difficulty in observation of more partial dislocations in Fig. 9, the square area (in
3 the $g(200)$ image), was evaluated in higher magnification in the same g -vectors in Fig. 10. In
4 the $g(31\bar{1})$ and $g(200)$ (Fig. 10-a, b), a number of small blocks of stacking faults (SFs) were
5 found with the length of 8 nm or less, marked by the red arrows as observed previously in the
6 literature for the fcc Al [30]. In addition to the block-type stacking faults, in the two other
7 images of $g(\bar{1}\bar{1}1)$ and $g(\bar{1}1\bar{1})$ (Fig. 10-c,d), numerous SF ribbons can be realized with a
8 contrast of Moiré fringe patterns [31] as indicated by the yellow arrows. The shape of these
9 fringe patterns is completely distinctive from the fringe contrast of oxide particles in spherical
10 shape which has reported previously for oxide dispersion strengthened alloys [23]. These fringe
11 patterns are the result of misfit dislocations in the interface of SF observed in appropriate
12 diffraction condition, i.e, in $g=\langle 111 \rangle$ in our case. The formation of both types of ribbon and
13 blocky SFs are indication in substantial existence of Shockley partial dislocations bearing
14 burgers vector of $\frac{a}{6}\langle 211 \rangle$. By measurement of more than seventy SF ribbons in the images, a
15 wide range of 1.7-14 nm was obtained experimentally for the width of observed SFs while 90%
16 of the SF ribbons have a size of less than 7nm.

17 **4. Discussion**

18 The results of grain structure evolution during cold rolling and recrystallization have been
19 summarized in the schematic presentation of Fig. 11. As shown in this figure, during early

1 stages of cold rolling around 20% thickness reduction, the primary submicron sized grains with
2 α -fiber texture (Fig. 11(a)) refine to fine grain size of $\sim 0.25 \mu\text{m}$ with increasing dislocation
3 density and intensity of brass texture grains enhances in expense of other orientations (Fig.
4 11(b)). Progress of rolling up to 60% thickness reduction lead to gradual promotion of the grain
5 size in simultaneous to reorientation of different texture grains to higher fraction of brass
6 texture grains (Fig. 11(c)). The rate of change in microstructure and texture development from
7 60% to 80% thickness reduction amplify wonderfully based on the results presented in Fig. 5
8 and leads to formation of a heavily deformed single-crystal brass texture grain inside the whole
9 80% rolled sample as the matrix including many ultrafine subgrains developed by high density
10 low angle dislocation boundaries (Fig. 11(d)). During annealing of 80% rolled sample, again
11 ultrafine grains with an average grain size of $1 \mu\text{m}$ formed inside the microstructure (Fig. 11(e)).
12 The cold rolled microstructure showed a retardation in nucleation of new recrystallized grains
13 and according to the microhardness results (Fig. 6), it shifts to high recrystallization regime of
14 around $700^\circ\text{C}/30 \text{ min}$. This temperature is far from the typical recrystallization temperature
15 reported for cold rolled pure copper to be around 200°C for a few minutes [4,5]. The large
16 difference between recrystallization temperature of ODS copper and pure copper can be
17 interpreted with respect to distribution of fine nanosized oxide particles and obtained grain
18 structure. Fine distribution of oxide particles are effective barriers against recrystallization
19 based on the Zener pinning force per unit area (P) in the following relation [32]:

1
$$P = 3f\gamma/2r \tag{4-1}$$

2 where, f and r are the volume fraction (~ 0.0075) and radius of oxide particles (~ 5 nm) and
3 γ is the grain boundaries energy (~ 1 J/m²). So, there is a pinning energy of ~ 1.8 MJ by oxide
4 particles. Furthermore, formation of large millimeter-sized grain in 80% cold rolled ODS
5 copper reduced the fraction of HABs significantly. As the HABs are favored sites for nucleation
6 during recrystallization [28,33], the recrystallization retards to much higher temperatures.

7 According to Fig. 9, existence of two types of perfect dislocations with $\frac{a}{2}[1\bar{1}0]$ burgers
8 vector and Shockley partial dislocations of $\frac{a}{6}[\bar{1}2\bar{1}]$ burgers vectors proved in 20% reduction
9 rolled ODS copper by TEM imaging. Based on the observations, the perfect dislocations had a
10 higher length of typical 100 nm in a ragged arrangement caused through pinning of dislocation
11 lines by fine oxide particles. The repulsive interaction of dislocations by oxide particles has
12 been established before by Scattergood and Bacon [34] based on the Orowan mechanism and
13 results in strengthening effect especially at high temperatures [1]. Such a strong pinning of
14 perfect dislocation lines can be observed in 80% rolled ODS copper with a higher dislocation
15 density in TEM image of Fig. 12(a), which demonstrates looping of dislocations around fine
16 oxide particles in different locations indicated by arrows. Therefore, a pinned perfect
17 dislocation with $\frac{a}{2}[10\bar{1}]$ burgers vector dissociates into two finer partial dislocations of
18 $\frac{a}{6}[11\bar{2}]$ and $\frac{a}{6}[2\bar{1}1]$ burgers vectors by the following reaction leaving a SF in (111) plane
19 according to Fig. 12(b):

$$1 \quad \vec{b}_1 \rightarrow \vec{b}_2 + \vec{b}_3 \quad (4-2)$$

$$2 \quad \frac{a}{2}[10\bar{1}] \rightarrow \frac{a}{6}[11\bar{2}] + \frac{a}{6}[2\bar{1}1] \quad (4-3)$$

3 Entity of a high number of nanosized SFs in the microstructure (Fig. 10) suggests extensive
 4 dissociation of perfect dislocations into a high density of Shockley partial dislocations during
 5 deformation of ODS copper.

6 Up to now, two main factors have been proposed for Brass texture evolution in copper
 7 alloys: twinning [15] and shear bands [5,16]. In this study on ODS copper, the fraction of
 8 nanotwins is about 6% limited to very small high strain areas without observation of shear
 9 bands. Recently, Gu et al. [18] proposed a different deformation mechanism using simulation
 10 approach in ultrafine-grained copper associated with the activation of partial $\{110\}\langle 11\bar{2}\rangle$ slip
 11 in addition to usual $\{111\}\langle 110\rangle$ slip. In our theory in accordance with Fig 12(c), the primary
 12 submicrometer grains with wide orientations of Goss to Brass deform during room temperature
 13 rolling by mechanism of partial slip of $\frac{a}{6}\langle 211\rangle$ burgers dislocations in a random approach in
 14 four $\{111\}$ slip planes of fcc copper structure. The glide of partial dislocations in either two
 15 slip planes of (111) and $(11\bar{1})$ or $(1\bar{1}1)$ and $(1\bar{1}\bar{1})$ in each grain gives an outcome
 16 deformation in $\{110\}$ plane with $\langle 211\rangle$ direction, i.e. “Brass orientation”. In parallel,
 17 moving of some partial dislocations in the neighboring planes results in formation of nanoscale
 18 twins. Hence, by increasing the rolling reduction or deformation strain and as a result higher
 19 activity of partial dislocations, the grains tend to rotate into the stronger Brass orientation.

1 Based on the grain structure evolution in Fig. 4 and 5(a), while the grain structure is still in
2 micrometer scale until 60% thickness reduction, higher deformation up to 80% reduction leads
3 to coarsening of individual Brass-oriented grains and final formation of single grain Brass-
4 oriented deformed structure.

5 **Conclusions**

6 In this study, the grain structure, texture evolution and tensile properties of ODS copper
7 after room temperature cold rolling and subsequent recrystallization was investigated and the
8 below conclusions were obtained:

9 1. The fine grain structure coarsened during room temperature rolling in simultaneous to
10 development of Brass texture especially after 60% reduction and finally, a single millimeter
11 sized brass texture deformed grain was evolved in 80% reduction room temperature rolled ODS
12 copper.

13 2. Recrystallization of ODS copper retarded to the high temperature of $\sim 700^\circ\text{C}$ mainly
14 due to Zener pinning force of fine oxide particles. A fine-grained microstructure with the new
15 textures of α and β -fiber including Goss, Brass, S and copper components were developed in
16 the recrystallized condition.

17 3. Pinning of perfect dislocations with burgers vector of $\frac{a}{2}\langle 101 \rangle$ happened by
18 distribution of fine oxide particles and deformation mechanism was controlled via high activity
19 of partial dislocations with burgers vector of $\frac{a}{6}\langle 211 \rangle$ in a random approach.

20 4. Tensile properties of recrystallized ODS copper at 800°C for 30 min showed a high
21 UTS of 491 MPa with a good ductility of 19% at ambient temperature. This combined high
22 tensile strength-ductility was attributed to bimodal grain size distribution including ultrafine
23 grained together with micron sized grained structure.

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1 List of Figures

2 Fig.1- EBSD results of sintered ODS copper at 900°C/45 min including a) IPF map and b) Misorientation
3 distribution of boundaries c) ODF (at $\varphi_2 = 0^\circ, 45^\circ$ and 65°)

4 Fig. 2-EBSD results of rolled ODS copper with 80% thickness reduction including a) IPF map, b) IQ map, c)
5 ODF (at $\varphi_2 = 0^\circ$), d) grain boundary map including HABs of $>15^\circ$ (black line) and LABs of $2-5^\circ$ (red lines) and
6 $5-15^\circ$ (green line), and e) Misorientation distribution of boundaries. All the figures are corresponded to rolling
7 plane (RD-TD) section.

8 Fig. 3-a) BF-TEM image of sintered ODS copper and inset selected area diffraction pattern showing ultrafine
9 grained microstructure, b) BF-STEM image of fine semicoherent Y_2O_3 oxide particles with fringe contrast
10 distributed in ODS copper c) BF-TEM image of the microstructure of 80% reduction rolled ODS copper and inset
11 selected area diffraction pattern showing fine nanosized grains indicated by arrows distributed in the large grain,
12 d) lenticular shaped deformation twin bundle distributed in the microstructure as shown by arrows with
13 accumulation of high dislocation density

14 Fig. 4-(a-d) Evolution of rolling plane microstructure (IPF maps) and (e-h) crystallographic texture (ODF at $\varphi_2 =$
15 0°) of rolled ODS copper after different thickness reductions of 20%, 40%, 60%, and 80%, respectively.

16 Fig. 5 - Change of a) grain size, b) boundary length fraction (%) for LABs ($2-15^\circ$) and HABs ($>15^\circ$), and c) Brass-
17 texture intensity, versus different rolling reductions up to 80%

18 Fig. 6- Vickers microhardness ($HV_{0.1}$) of 80% rolled ODS copper after annealing at temperature range of 100-
19 $900^\circ C/30$ min

20 Fig. 7-EBSD results including IPF maps and ODF (at $\varphi_2 = 0^\circ, 45^\circ, 65^\circ$) of recrystallized ODS copper at a)700
21 $^\circ C /30$ min and b) 800 $^\circ C /30$ min

22 Fig. 8- Engineering tensile stress-strain curves of room temperature rolled (80%Re) (black curve) and subsequent
23 recrystallized ODS copper at 700 $^\circ C/30$ min (red curve) and 800 $^\circ C/30$ min (blue curve).

24 Fig. 9- BF-TEM images of 20% rolled ODS copper showing perfect and partial dislocations in four different g-
25 vectors of a) $[31\bar{1}]$, b) $[200]$, c) $[\bar{1}\bar{1}1]$ and d) $[\bar{1}1\bar{1}]$,

26 Fig. 10- BF-TEM images of 20% rolled ODS copper showing block type and ribbon type SFs in four different g-
27 vectors of a) $[31\bar{1}]$, b) $[200]$, c) $[\bar{1}\bar{1}1]$ and d) $[\bar{1}1\bar{1}]$,

28 Fig. 11-Microstructure development during room temperature rolling and recrystallization of ODS copper

29 Fig. 12- a) TEM image of 80% reduction suggesting pinning of dislocations (shown by arrows) by fine nanosized
30 oxide particles; b) schematic of dissociation of perfect pinned dislocation with $b_1 = \frac{a}{2}[10\bar{1}]$ into two Shockley
31 partial dislocations of $b_2 = \frac{a}{6}[11\bar{2}]$ and $b_3 = \frac{a}{6}[2\bar{1}1]$ leaving a stacking fault; c) schematic of deformation
32 mechanism of individual grains by partial slip and formation of single Brass-oriented deformed grain after 80%
33 reduction

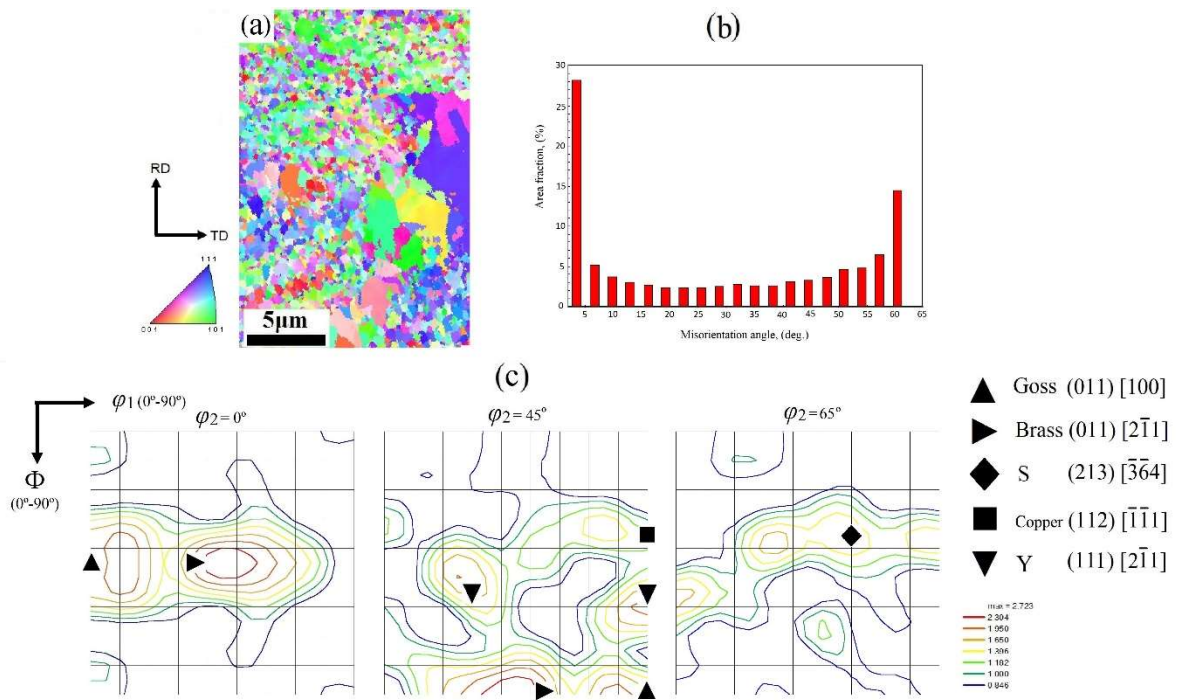
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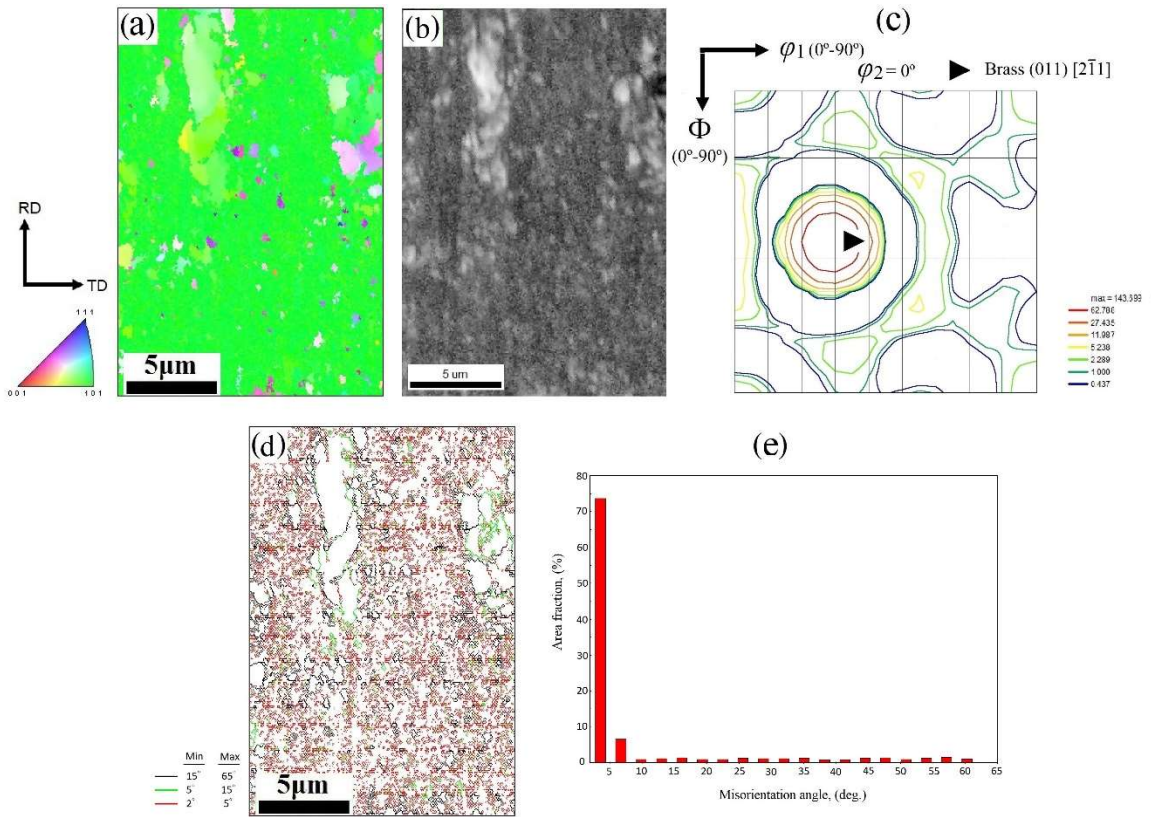
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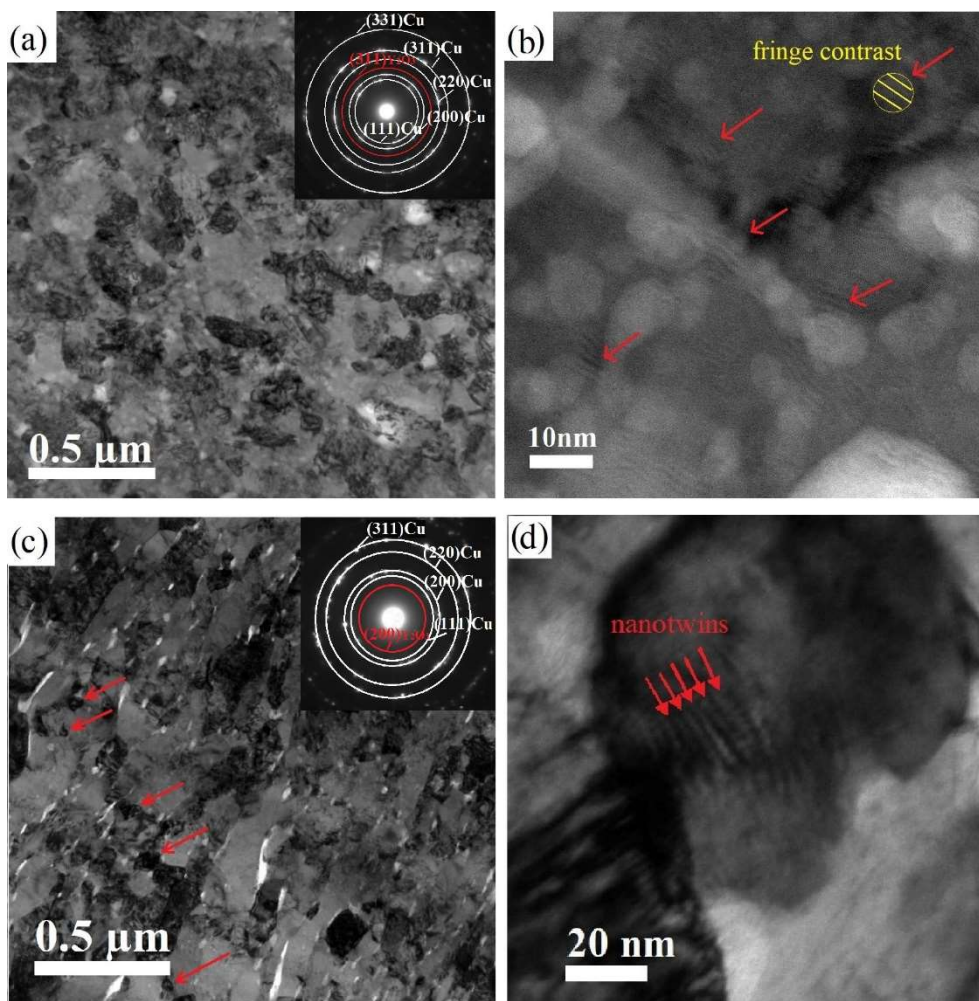
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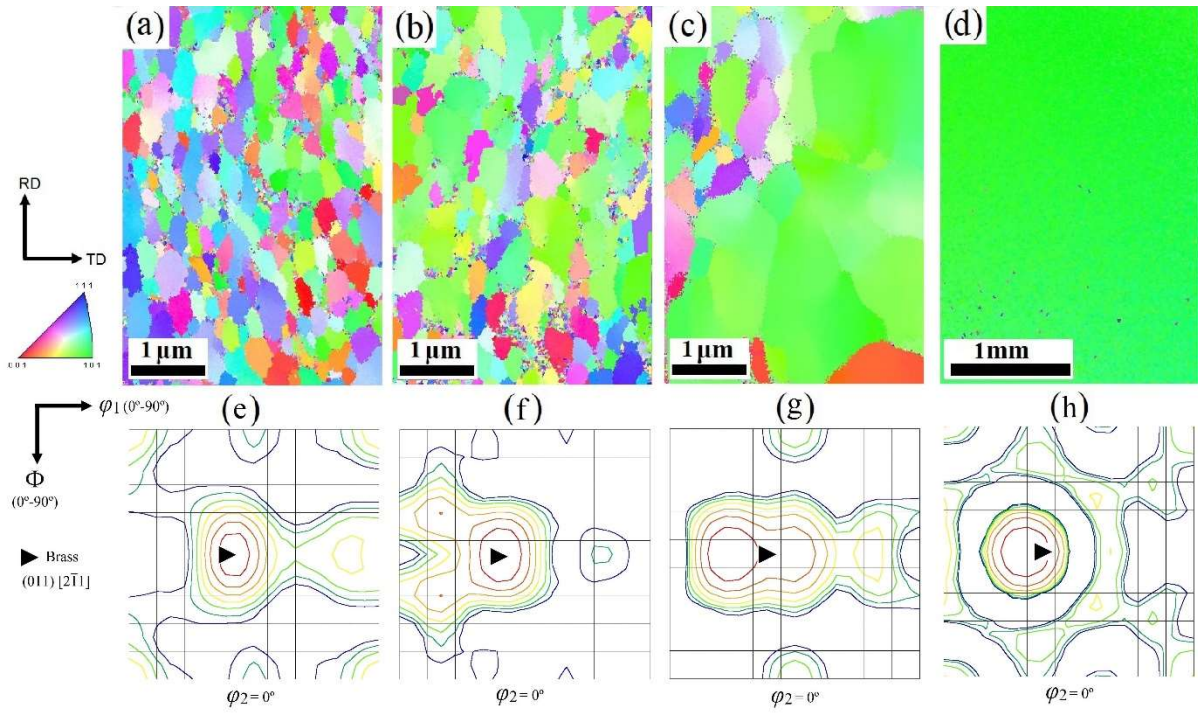
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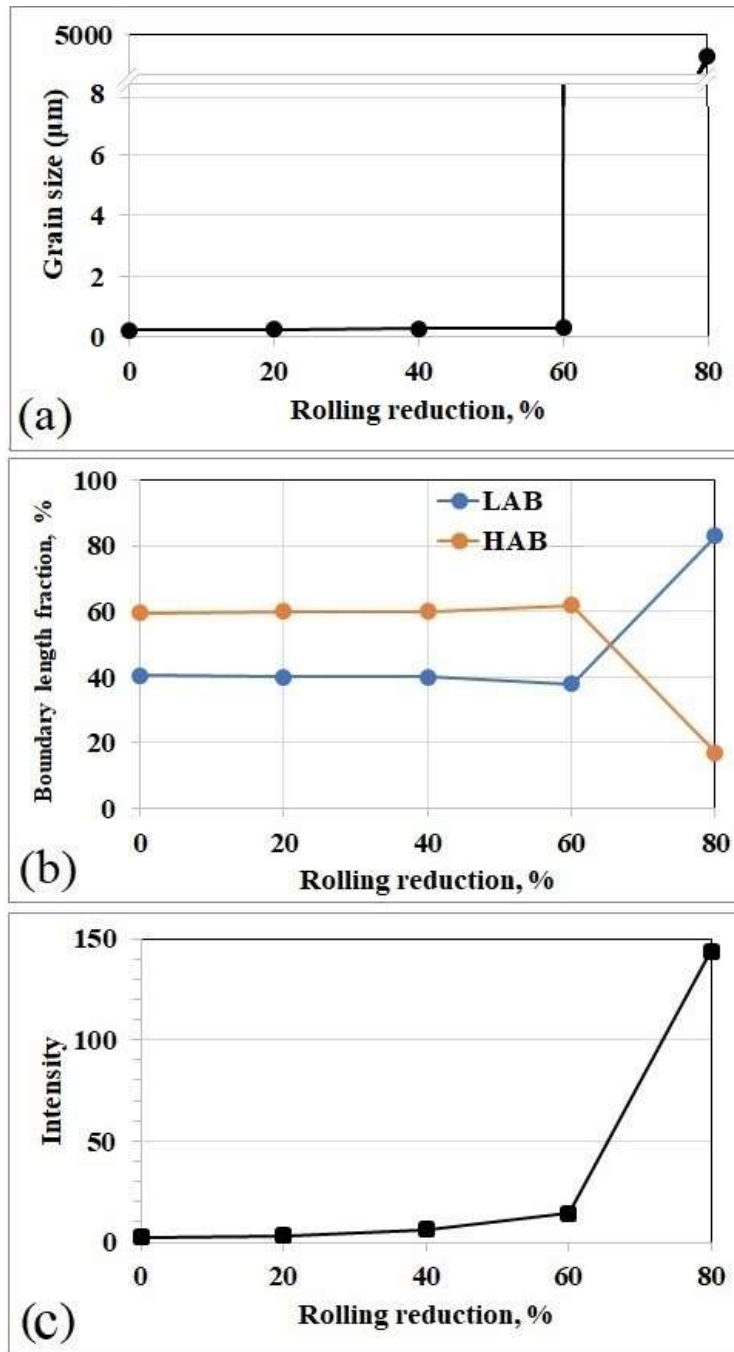
Fig. 4



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Fig. 5

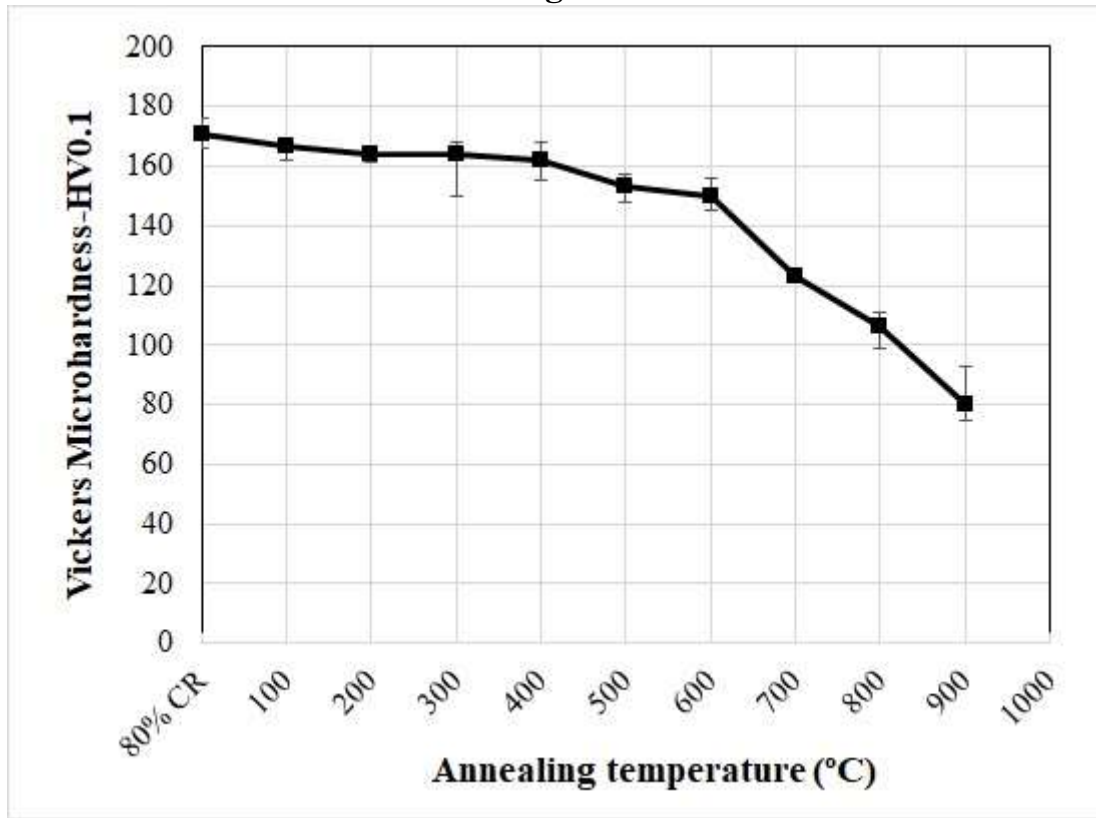


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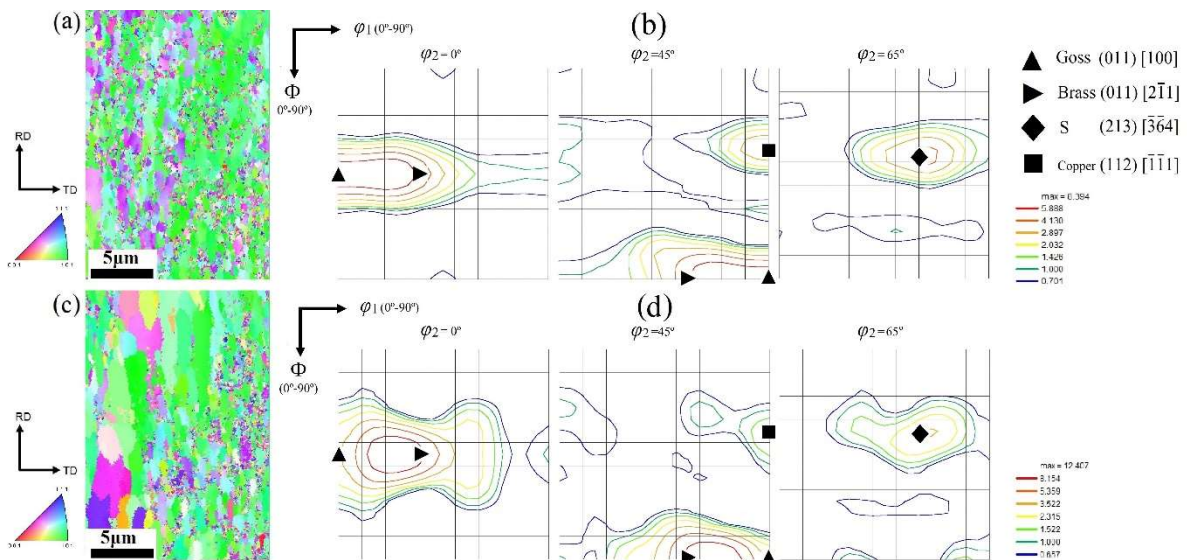
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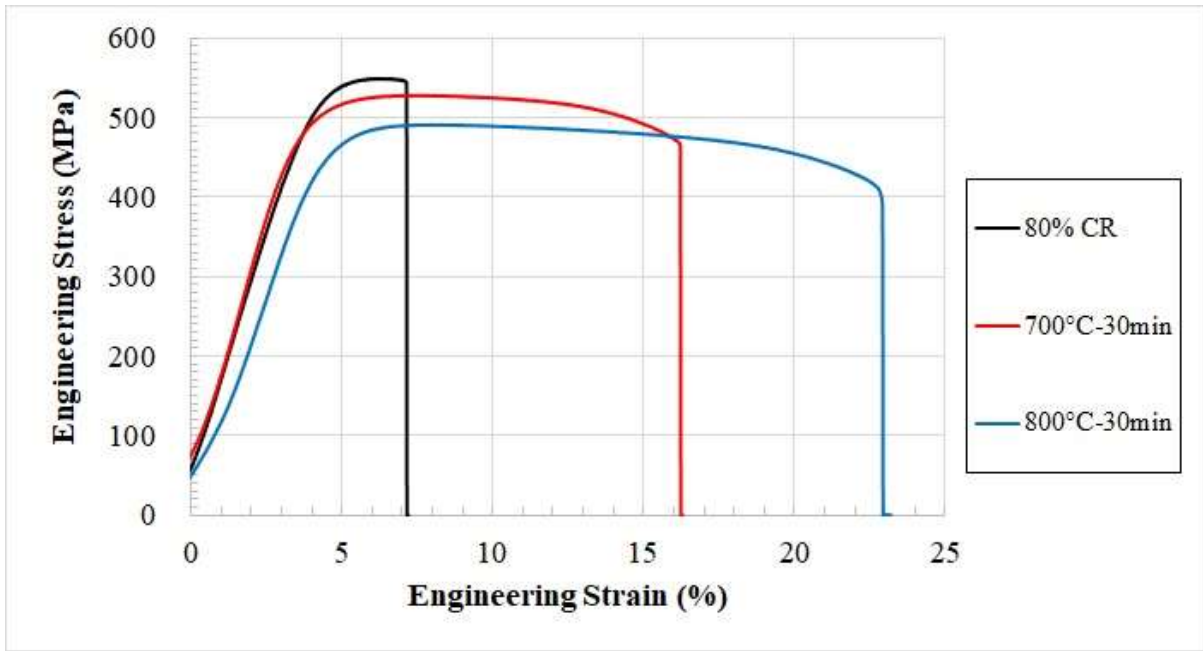


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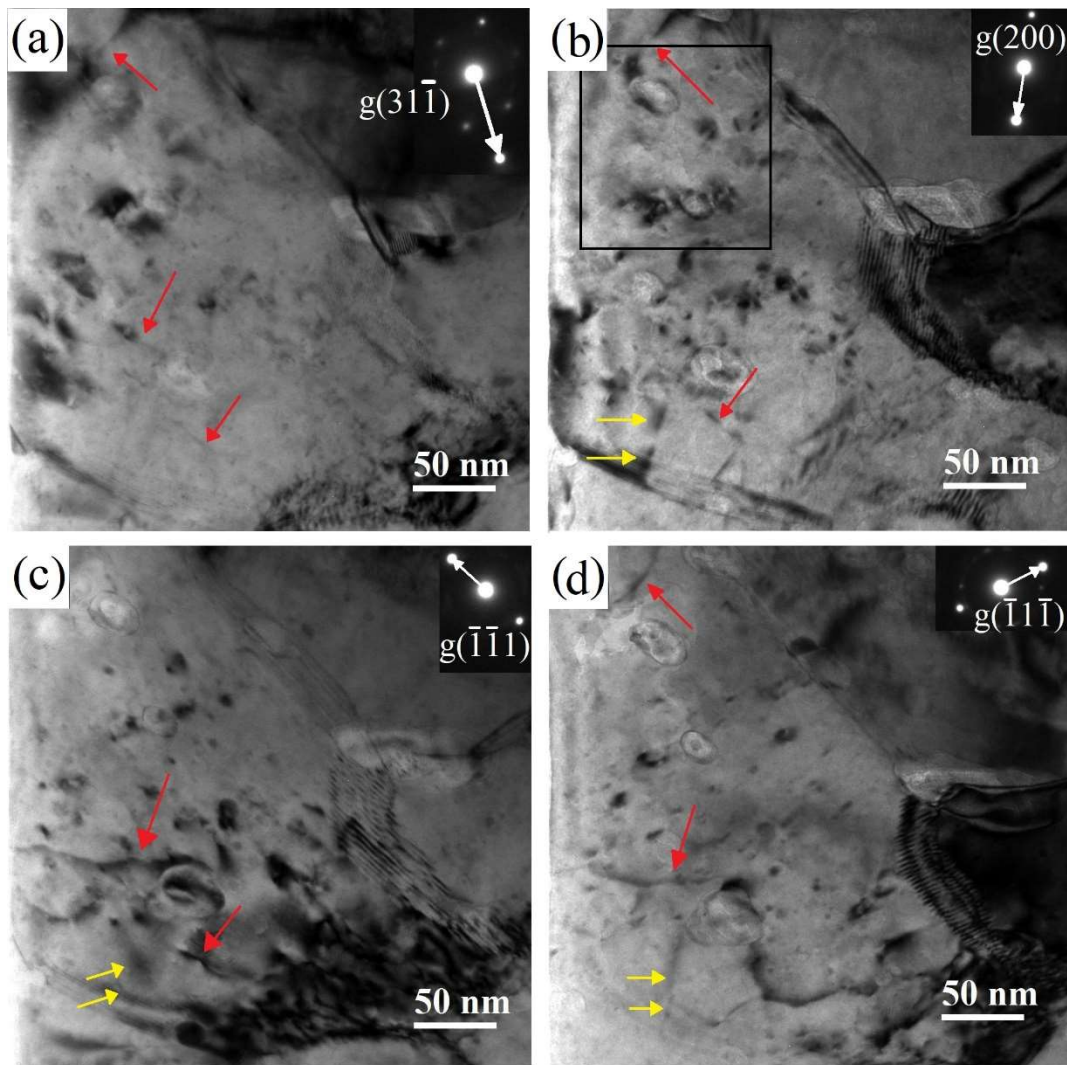


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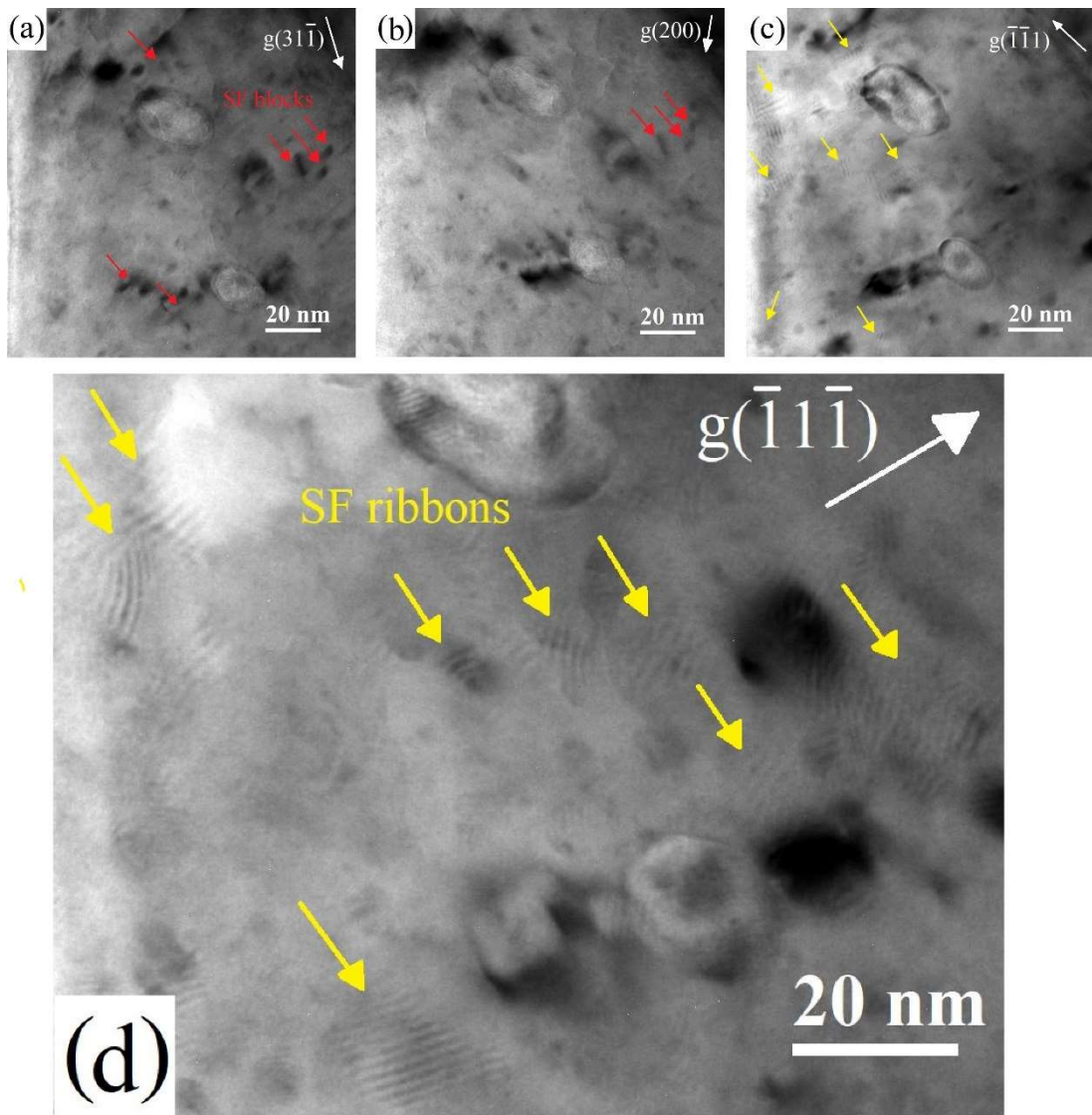


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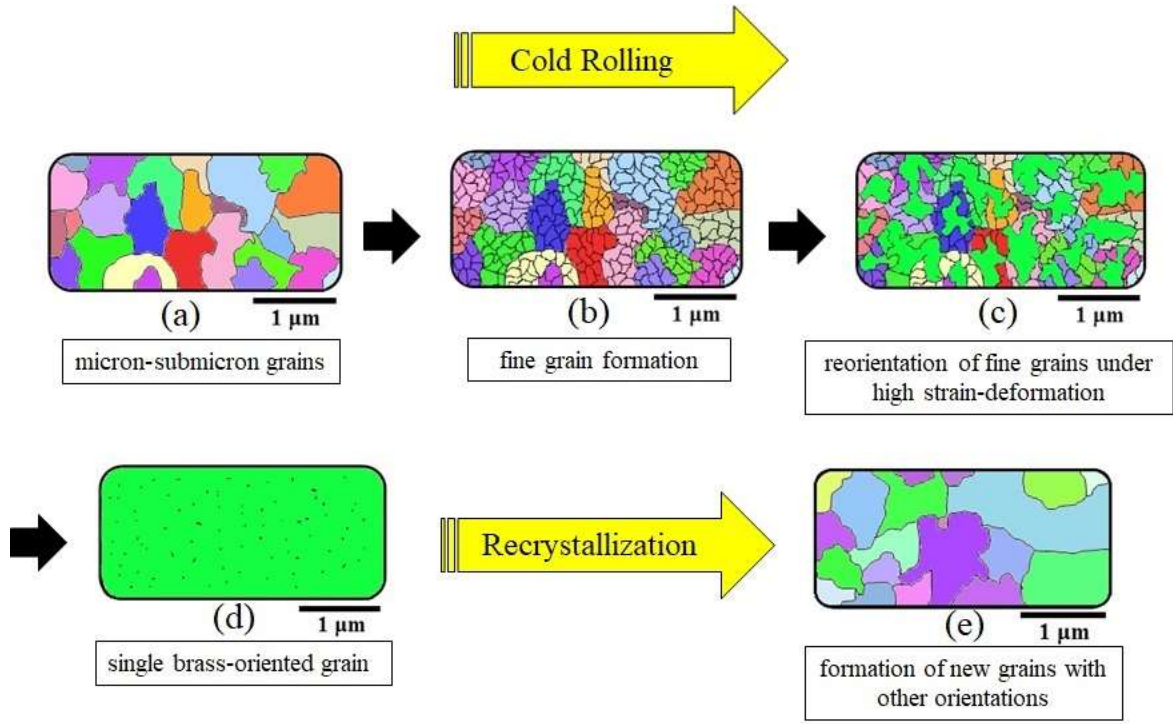
Fig. 10



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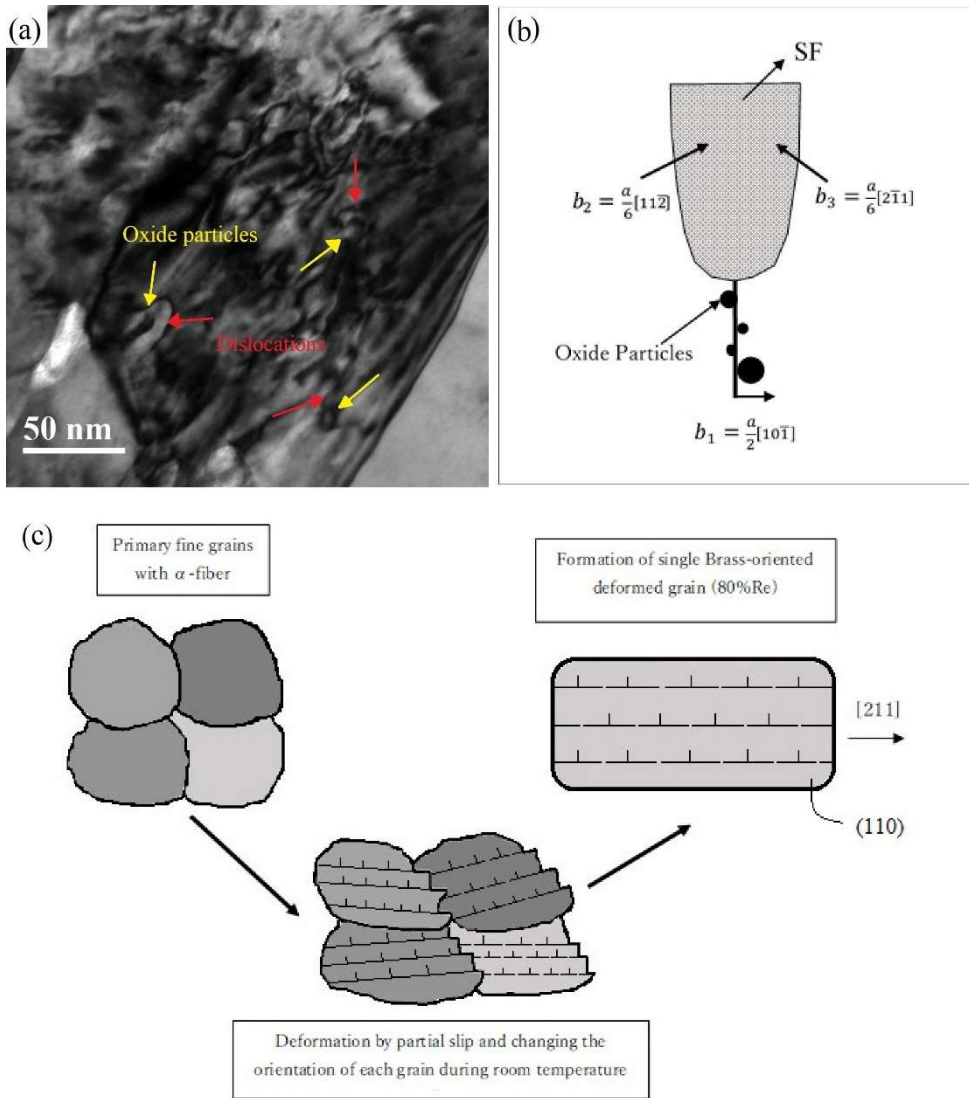


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Fig. 12



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1 **List of Tables**

2

3 Table 1. Values of mechanical properties of 80% reduction room temperature rolled and subsequent recrystallized

4 ODS copper at 700°C and 800°C for 30 min.

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Table 1

Sample	$\sigma_{0.2}$	σ_u	e_{lu} (%)	e_{lt} (%)
Roll. 80% Re.	480	550	2.3	3.2
Rec. 700°C/30	460	528	4.2	13
Rec. 800°C/30	422	491	3	19

8

9 Table 2. $|\vec{g} \cdot \vec{b}|$ value for different g-vectors near to [011] zone axis

10

11

Table 2

$\vec{g} \backslash \vec{b}$	$1/6[11-2]$	$1/6[-12-1]$	$1/6[2-1-1]$	$1/2[-101]$	$1/2[0-11]$	$1/2[1-10]$
(31-1)	1	0	1	-2	-1	1
(200)	1/3	-1/3	2/3	-1	0	1
(-1-11)	-2/3	-1/3	-1/3	1	1	0
(-11-1)	1/3	2/3	-1/3	0	-1	-1

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