

Table of Contents

	General introduction	XV
1	Crystal Chemistry of Mullite and Related Phases	1
1.1	The Mullite-type Family of Crystal Structures	1
	<i>R. X. Fischer, H. Schneider</i>	
1.1.1	Introductory Remarks	1
1.1.2	The Derivation of Mullite-type Crystal Structures	4
1.1.3	Members of the Mullite-type Family of Crystal Structures	12
1.1.3.1	Introduction	12
1.1.3.2	MUL-II.1, $P4_2/mbc$: Schafarzikite Group	13
1.1.3.3	MUL-VI.11, $P4_2/mbc$: Apuanite Group	15
1.1.3.4	MUL-IV.12, $Pbam$: $Bi_2M_4O_9$ Group	16
1.1.3.5	MUL-VIII.12, $Pbam$: Versiliaite Group	18
1.1.3.6	MUL-VIII.2, $Pbnm$: Grandidierite Group	19
1.1.3.7	MUL-II.3, $Pbam$: Mullite Group	20
1.1.3.8	MUL-IV.31, $Pnmm$: Andalusite Group	33
1.1.3.9	MUL-VIII.31, $P2_1/n11$: Olivenite Group	35
1.1.3.10	MUL-IV.32, $Pbnm$: Sillimanite Group	35
1.1.3.11	MUL-VIII.33, $A2_1am$: A_9B_2 Boron Aluminates	37
1.1.3.12	MUL-IV.34, $P2_12_12$: $Al_5Ge_{0.972}Pb_{0.2}O_{9.71}$ Phase	40
1.1.3.13	MUL-VIII.34, $P2_12_12_1$: Mozartite Group	40
1.1.3.14	MUL-XVI.351, $A112/m$: Boralsilite Group	42
1.1.3.15	MUL-XXXII.352, $P\bar{1}$: Werdingite Group	46
1.2	The Real Structure of Mullite	46
	<i>S. Rahman, S. Freimann</i>	
1.2.1	Introduction	46
1.2.2	High-resolution Electron Microscopy	47
1.2.3	X-ray Investigation	54
1.2.4	Real-structure Determination Using Videographic Reconstruction and Simulation Techniques	56
1.2.4.1	The Videographic Method	57
1.2.4.2	Structure Variants of Mullite	60
1.2.4.3	Two-dimensional Videographic Reconstructions	62

1.2.4.4	Three-dimensional Videographic Simulations for 2/1-and 3/2-mullite	64
1.2.4.5	Conclusions	68
1.3	Foreign Cation Incorporation in Mullite	70
	<i>H. Schneider</i>	
1.3.1	Transition Metal Incorporation	70
1.3.1.1	Titanium Incorporation	74
1.3.1.2	Vanadium Incorporation	76
1.3.1.3	Chromium Incorporation	77
1.3.1.4	Manganese Incorporation	81
1.3.1.5	Iron Incorporation	83
1.3.1.6	Cobalt Incorporation	89
1.3.1.7	General Remarks on Transition Metal Incorporation	89
1.3.2	Other Foreign Cation Incorporation	90
1.4	Mullite-type Gels and Glasses	93
	<i>M. Schmücker, H. Schneider</i>	
1.4.1	Type I (Single Phase) Mullite Precursors and Glasses	94
1.4.1.1	Preparation of Type I Mullite Precursors and Glasses	94
1.4.1.2	Temperature-induced Structural Evolution of Type I Mullite Precursors and Glasses	97
1.4.1.3	Mechanisms of Mullite formation From Type I Precursors and Glasses	103
1.4.2	Type II (Diphasic) Mullite Precursors	105
1.4.2.1	Synthesis of Type II Mullite Precursors	105
1.4.2.2	Temperature-induced Structural Evolution of Type II Mullite Precursors	106
1.4.3	Type III (Single Phase/Diphasic) Mullite Precursors	114
1.4.3.1	Synthesis of Type III Mullite Precursors	115
1.4.3.2	Temperature-induced Structural Evolution of Type III Mullite Precursors	115
1.4.3.3	Mechanisms of Mullite Formation From Type III Mullite Precursors	117
1.4.4	General Remarks on the Structure and Crystallization Behavior of Mullite Precursors and Glasses	117
1.4.4.1	Mullite Precursors: Similarities and Differences	117
1.4.4.2	The Coordination of Aluminum in Mullite Precursors and Glasses	120
1.4.4.3	The Origins of Mullite Crystallization	125
	References	128
2	Basic Properties of Mullite	141
2.1	Mechanical Properties of Mullite	141
	<i>H. Schneider</i>	
2.1.1	Strength, Toughness and Creep	141
2.1.2	Elastic Moduli and Compressibility	142

2.1.3	Microhardness of Mullite	146
2.1.4	Mechanical Response to Dynamic Stress	149
2.2	Thermal Properties of Mullite	149
	<i>H. Schneider</i>	
2.2.1	Thermochemical Data	149
2.2.1.1	Enthalpy, Gibbs Energy and Entropy	149
2.2.1.2	Heat Capacity	152
2.2.2	Thermal Expansion	152
2.2.3	Thermal Conductivity	155
2.2.4	Atomic Diffusion	156
2.2.4.1	Oxygen Diffusion	156
2.2.4.2	Silicon Diffusion	158
2.2.4.3	Aluminum Diffusion	159
2.2.5	Grain Growth	160
2.2.6	Wetting Behavior	162
2.3	Miscellaneous Properties	164
	<i>H. Schneider</i>	
2.3.1	Optical and Infrared Properties	164
2.3.2	Electrical Properties	165
2.4	Structure-controlled Formation and Decomposition of Mullite	167
	<i>H. Schneider, M. Schmücker</i>	
2.4.1	Temperature-induced Formation	167
2.4.1.1	Formation from Kaolinite and Related Minerals	167
2.4.1.2	Formation from Andalusite and Sillimanite	172
2.4.1.3	Formation from X-sialon	178
2.4.1.4	General Remarks	178
2.4.2	Pressure-induced Decomposition	179
2.4.2.1	Decomposition to Sillimanite	179
2.4.2.2	Decomposition to γ -Alumina plus silica	180
2.5	Mullite-mullite Phase Transformations	180
	<i>H. Schneider, M. Schmücker</i>	
2.5.1	Compositional Transformations	180
2.5.2	Structural Transformations	186
2.5.2.1	Transformation at about 450 °C	186
2.5.2.2	Transformation above 1000 °C	186
2.6	Spectroscopy of Mullite and Compounds with Mullite-related Structures	189
	<i>K.J.D. MacKenzie</i>	
2.6.1	Solid-state Nuclear Magnetic Resonance (NMR) Spectroscopy	190
2.6.1.1	Brief Principles of Solid-state NMR Spectroscopy	190
2.6.1.2	NMR Spectroscopic Structural Studies of Aluminosilicate Mullite	191
2.6.1.3	NMR Spectroscopic Studies of Amorphous Materials of Mullite Composition	195
2.6.1.4	NMR Spectroscopic Studies of Mullite Formation from Minerals	198

2.6.1.5	NMR Spectroscopic Studies of Other Compounds with Mullite Structure	199
2.6.2	Electron Paramagnetic Resonance (EPR) Spectroscopy	204
2.6.3	Infrared (IR), Fourier-transform Infrared (FTIR) and Raman Spectroscopy	207
2.6.3.1	The IR Spectrum of Mullite	207
2.6.3.2	IR Spectroscopic Studies of Mullite Formation	208
2.6.4	Mössbauer Spectroscopy	210
	References	215
3	Phase Equilibria and Stability of Mullite	227
3.1	The Al ₂ O ₃ –SiO ₂ Phase Diagram	227
	<i>J. A. Pask, H. Schneider</i>	
3.1.1	Experimental Observations	227
3.1.2	Processing Parameters and Reaction Mechanisms	230
3.1.3	Solid-solution Range of Mullite	234
3.1.4	Melting Behavior of Mullite	234
3.1.5	Simulations of the Al ₂ O ₃ –SiO ₂ Phase Diagram	234
3.1.6	General remarks	235
3.2	Influence of Environmental Conditions on the Stability of Mullite	235
	<i>H. Schneider</i>	
3.2.1	Interactions with Reducing Environments	236
3.2.2	Interaction with Water Vapor-rich Environments	239
3.2.3	Interactions with Molten Sodium Salts	241
3.2.4	Interactions with Fluorine Salt Environments	242
3.3	Ternary X–Al ₂ O ₃ –SiO ₂ Phase-equilibrium Diagrams	243
	<i>H. Schneider</i>	
3.3.1	Alkaline Oxide–Al ₂ O ₃ –SiO ₂	243
3.3.2	Iron Oxide–Al ₂ O ₃ –SiO ₂	244
3.3.3	Alkaline Earth Oxide–Al ₂ O ₃ –SiO ₂	245
3.3.4	MnO–Al ₂ O ₃ –SiO ₂	245
3.3.5	TiO ₂ –Al ₂ O ₃ –SiO ₂	245
3.4	Multicomponent Systems	246
	<i>H. Schneider</i>	
	References	246
4	Mullite Synthesis and Processing	251
4.1	Mullite Synthesis	251
	<i>S. Komarneni, H. Schneider, K. Okada</i>	
4.1.1	Solid-state-derived Mullite	251
4.1.1.1	Formation from Kaolinite and Related Phases	251
4.1.1.2	Formation from Kyanite, Andalusite and Sillimanite	252
4.1.1.3	Formation from Staurolite and Topaz	252
4.1.1.4	Reaction Sintering of Alumina and Silica	253

4.1.1.5	Effects of Mineralizers, Reaction Atmosphere and Structural Defects	254
4.1.1.6	Commercial Production (Sinter-mullite)	256
4.1.2	Liquid-state-derived Mullite	259
4.1.2.1	Crystal Growth Techniques	259
4.1.2.2	Commercial Production (Fused-mullite)	260
4.1.3	Solution-sol-gel-derived Mullite	262
4.1.3.1	Solution-plus-solution Process	263
4.1.3.2	Solution-plus-sol Process	272
4.1.3.3	Sol-plus-sol Process	275
4.1.4	Spray Pyrolysis Approach	277
4.1.5	Hydrothermally Produced Mullite	281
4.1.6	Vapor-state-derived Mullite	283
4.1.7	Mullite Produced by Miscellaneous Methods	283
4.1.8	General Remarks on the Different Chemical Synthesis Methods of Mullite	284
4.2	Processing of Mullite Ceramics	286
	<i>S. Komarneni, H. Schneider</i>	
4.2.1	General Sintering Characteristics	286
4.2.2	Sintering of Powder Compacts	288
4.2.3	Reaction Sintering of Alumina and Silica	291
4.2.4	Reaction Bonding from Different Starting Materials	298
4.2.5	Reaction Sintering of Chemically Produced Mullite Precursors	299
4.2.6	Transient Viscous Sintering of Composite Powders	306
4.3	Mechanical Properties of Mullite Ceramics	307
	<i>K. Okada, H. Schneider</i>	
4.3.1	Mechanical Strength and Fracture Toughness	308
4.3.1.1	Mechanical Strength and Fracture Toughness at Room Temperature	308
4.3.1.2	Mechanical Strength and Fracture Toughness at High Temperatures	310
4.3.2	Elastic Modulus	312
4.3.3	Hardness	314
4.3.4	Thermal Shock Resistance	315
4.3.5	Wear Resistance	316
4.3.6	Fatigue Behavior	316
4.3.7	Creep Resistance	317
4.4	Thermal Properties of Mullite Ceramics	321
	<i>K. Okada, H. Schneider</i>	
4.4.1	Thermal Conductivity	322
4.4.2	Thermal Expansion	322
4.5	Miscellaneous Properties of Mullite Ceramics	323
	<i>K. Okada, H. Schneider</i>	
4.5.1	Electrical Properties	323
4.5.2	Optical Properties	324

4.5.3	Chemical Corrosion Behavior	324
4.6	Application of Mullite Ceramics	327
	<i>K. Okada, H. Schneider</i>	
4.6.1	Engineering Materials	327
4.6.1.1	Refractory Materials	327
4.6.1.2	High Temperature Engineering Materials	328
4.6.1.3	Materials for Heat Exchangers	329
4.6.1.4	Structural Materials	331
4.6.2	Electronic Packaging Materials	331
4.6.3	Optical Materials	333
4.6.4	Tribological Materials	334
4.6.5	Porous Materials for Filters and Catalyst Supports	335
4.6.6	Materials for Miscellaneous Applications	336
	References	337
5	Mullite Coatings	349
5.1	Chemical Vapor-deposited Coatings (CVD Coatings)	350
	<i>S. Basu, V.K. Sarin</i>	
5.1.1	Thermodynamics of Chemical Vapor-deposited Coatings	350
5.1.2	Growth Kinetics of Chemical Vapor-deposited Coatings	352
5.1.3	Microstructure of Chemical Vapor-deposited Coatings	353
5.1.4	The Structure of Chemical Vapor-deposited Al ₂ O ₃ -rich Mullite	358
5.1.5	High Temperature Phase Transformations in Chemically Chemical Vapor-deposited Mullite	359
5.1.6	Oxidation, Hot Corrosion and Recession Protection of Chemical Vapor-deposited Mullite	364
5.2	Plasma- and Flame-sprayed Coatings	367
	<i>S. Basu, V.K. Sarin</i>	
5.2.1	Microstructural Characteristics and Stability of Coatings	367
5.2.2	Plasma-sprayed Environmental Barrier Coatings (EBCs)	370
5.2.3	Plasma-sprayed Thermal Barrier Coatings (TBCs)	372
5.3	Deposition of Mullite Coatings by Miscellaneous Techniques	373
	<i>S. Basu, V.K. Sarin</i>	
	References	374
6	Mullite Fibers	377
6.1	Mullite Whiskers	377
	<i>H. Schneider</i>	
6.1.1	Whisker Formation From Melts	377
6.1.2	Whisker Formation via Gas-transport Reactions	378
6.2	Sol-gel-derived Continuous Mullite Fibers	381
	<i>H. Schneider</i>	
6.2.1	Laboratory Produced Fibers	381
6.2.2	Commercially Produced Fibers	384
6.2.2.1	Altex Fibers (Sumitomo Chemicals, Japan)	384

6.2.2.2	Nivity Fibers (Denka-Nivity, Japan)	385
6.2.2.3	Nextel Fibers (3M Company, U.S.A.)	385
6.3	Continuous Melt-grown Mullite Fibers	391
	<i>H. Schneider</i>	
6.4	Application of Mullite Fibers	393
	<i>H. Schneider</i>	
	References	394
7	Mullite Matrix Composites	397
7.1	Whisker-reinforced Mullite Matrix Composites	398
	<i>H. Schneider</i>	
7.1.1	Fabrication Routes	399
7.1.2	Mechanical Properties	399
7.1.3	Thermal Properties	402
7.1.4	Miscellaneous Properties	403
7.2	Continuous Fiber-reinforced Mullite Matrix Composites	403
	<i>H. Schneider</i>	
7.2.1	Fabrication Routes	403
7.2.1.1	Non-oxide Fiber-reinforced Composites	407
7.2.1.2	Oxide Fiber-reinforced Composites	409
7.2.2	Mechanical Properties	421
7.2.2.1	Non-oxide Fiber-reinforced Composites	423
7.2.2.2	Oxide Fiber-reinforced Composites	425
7.2.3	Thermal Properties	434
7.2.3.1	Thermal Expansion	434
7.2.3.2	Thermal Conductivity	435
7.2.4	Miscellaneous Properties	435
7.2.5	The Role of the Fiber/Matrix Interphase	436
7.2.5.1	Easy-cleavage Interphases	437
7.2.5.2	Low-toughness Interphases	438
7.2.5.3	Porous or Gap-producing Interphases	438
7.2.6	Applications	440
7.2.6.1	Spacecraft Applications	440
7.2.6.2	Aircraft Engine and Powerplant Applications	440
7.2.6.3	Other Industrial Applications	442
7.3	Platelet- and Particle-reinforced Mullite Matrix Composites	443
	<i>H. Schneider, K. Okada</i>	
7.3.1	Basic Principles	443
7.3.1.1	Transformation Toughening	443
7.3.1.2	Crack-deflection Toughening	444
7.3.1.3	Toughening by Modulus Load Transfer	444
7.3.1.4	Nanoparticle Toughening	445
7.3.2	Zirconia Particle-reinforced Composites	445
7.3.2.1	Fabrication Routes	445
7.3.2.2	Mechanical Properties	453

XIV | Table of Contents

7.3.2.3	Thermal Properties	455
7.3.3	Silicon Carbide Platelet- or Particle-reinforced Composites	455
7.3.3.1	Fabrication Routes	456
7.3.3.2	Mechanical Properties	459
7.3.4	Miscellaneous Oxide Particle-reinforced Composites	461
7.4	Metal-reinforced Mullite Matrix Composites	463
	<i>H. Schneider</i>	
7.4.1	Aluminum Metal-reinforced Composites	463
7.4.2	Molybdenum Metal-reinforced Composites	466
	References	467
	Index	477