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The effect of (Ti+Al):V ratio on the structure and oxidation behaviour of TiAlN/VN nano-scale multilayer coatings

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Abstract: Nano-scaled multilayered TiAlN/VN coatings have been grown on stainless steel and M2 high speed steel substrates at $U_B = -85$ V in an industrial, four target, Hauzer HTC 1000 coater using combined cathodic steered arc etching/unbalanced magnetron sputtering. X-ray diffraction (XRD) has been used to investigate the effects of process parameters (Target Power) on texture evolution (using texture parameter T^*), development of residual stress ($\sin^2 \psi$ method) and nano-scale multilayer period. The composition of the coating was determined using energy dispersive X-ray analysis. The thermal behaviour of the coatings in air was studied using thermo-gravimetric analysis, XRD and scanning electron microscopy. The bi-layer period varied between 2.8 and 3.1 nm and in all cases a $\{1\ 1\ 0\}$ texture developed with a maximum value $T^* = 4.9$. The residual stress varied between -5.2 and -7.4 GPa. The onset of rapid oxidation occurred between 62° and 645 °C depending on the (Ti+Al):V ratio. After oxidation in air at 550 °C AlVO₄, TiO₂ and V₂O₅ phases were identified by XRD with the AlVO₄, TiO₂ being the major phases. The formation of AlVO₄ appears to disrupt the formation of Al₂O₃ which imparts oxidation resistance to TiAlN based coatings. Increasing the temperature to 600 and 640 °C led to a dramatic increase in the formation of V₂O₅ which was highly oriented (001) with a plate-like morphology. At 640 °C there was no evidence of the coating on XRD. Increasing the temperature to 670°C led to further formation of AlVO₄ and a dramatic reduction in V₂O₅.

Keywords: Nano-scale multilayers; TiAlN/VN coatings; Oxidation; X-ray diffraction; Scanning electron microscopy

1. Introduction

TiAlN/CrN, TiAlN/VN and CrN/NbN nano-scaled multilayered coatings with typical periods λ between 3 and 4 nm have been successfully produced economically under production conditions in industrially sized coating equipment [1]. TiAlN/CrN [2,3] exhibits excellent high temperature wear resistance and oxidation resistance, whereas CrN/NbN [4,5], has excellent anti-corrosion performance. Nano-scaled, multilayered TiAlN/VN coatings exhibit at room temperature, low coefficients of friction, $\mu = 0.4\text{--}0.5$ and low sliding wear coefficients of $1.2\text{--}10^{-17} \text{ m}^3\text{N}^{-1}\text{m}^{-1}$ which is two orders of magnitude lower compared to TiAlN/CrN ($\mu = 0.7$, $K = 2.38 \times 10^{-16} \text{ m}^3\text{N}^{-1}\text{m}^{-1}$) and CrN/NbN ($\mu = 0.69$, $K = 2.1 \times 10^{-15} \text{ m}^3\text{N}^{-1}\text{m}^{-1}$) systems. The lowest value of the coefficient of friction is due to the formation of a vanadium oxide (V_2O_5), which acts as a V_2O_5 dry lubricant [1]. At temperatures above 640°C the VN component in the multilayer is completely oxidised to V_2O_5 and at temperatures above 670°C , the V_2O_5 starts to melt resulting in loss of coating integrity making them unsuitable in higher temperature applications. However, one important area where the low coefficient of friction can be utilised is in the coating of M2 HSS cutting tools which have a maximum operating temperature of typically approximately 550°C . The lower coefficient of friction of these coatings may, therefore be particularly beneficial in the high speed machining of softer materials, e.g. Al alloys, Inconel alloys, where friction between work piece material and tool is of particular importance. This paper summarises results on the effect of (Ti+Al):V ratio on the structure and oxidation behaviour of TiAlN/VN nano-scale multilayer coatings.

2. Experimental details

TiAlN/VN coatings investigated were deposited by reactive unbalanced magnetron sputtering in a Hauzer Techno Coating HTC 1000-4 using the arc bond sputter process [6]. In all the processes 2 x V targets (99.9%) and 2 x Ti:Al (50:50) targets were used and the power applied to each target is given in Table 1. The coatings were deposited at bias voltages of $U_B = -75 \text{ V}$ for 1.5h and $U_B = -85 \text{ V}$ for 1.5 h using the target powers shown in Table 1. All the coatings were deposited at a constant temperature of 450°C on to stainless steel and M2 HSS substrates in a common Ar+N₂ atmosphere at a total pressure of $4.5 \times 10^{-3} \text{ mbar}$. A more detailed description of the process parameters used is described elsewhere [1,7–10].

The textures present in the as-deposited coatings were determined by the Harris inverse pole figure method (Texture T*) [11]. The bi-layer period of the nano-scale multilayer, D , was measured directly in the low angle region from the standard Bragg's equation [9]. Glancing angle parallel

Table 1 Target configuration, analysis and bi-layer thickness

Sample	Power to target (kW)				Al (at.%)	Ti (at.%)	V (at.%)	(Ti + Al):V	Bi-layer thickness (nm)
	Ti-Al	Ti-Al	V	V					
1	10	10	5.5	5.5	32.5	30.9	36.6	1.73	2.8
2	10	10	7	7	28.5	27.8	43.7	1.29	3.0
3	10	10	8	8	26.9	26.3	46.8	1.14	3.0
4	11.5	11.5	7	7	32.2	29.2	38.6	1.59	3.1

beam geometry was used to determine the state of residual stress present in the coatings [12]. The products which formed on the coatings surface after oxidation were identified by X-ray diffraction (XRD) using glancing angle (1° incidence) and $\theta/2\theta$ geometries. The morphology of the oxidized surfaces was investigated using a FEI environmental scanning electron microscope. The atomic percentage of the metallic elements in each coating was determined using a ZAF 4 corrected energy dispersive X-ray (EDX) analysis. A Cahn TG 121 microbalance was used for the thermo-gravimetry work. The hardness was measured using a Knoop indenter, $(HK)_{0.025}$. Pin-on-disc measurements were made in dry sliding wear conditions using Al_2O_3 balls, a 5 N load at a linear speed of 0.1 ms^{-1} .

3. Results and discussion

3.1. Coating characterisation

3.1.1. Composition

Elemental analyses of the metallic elements in the coatings under investigation are shown in Table 1. A scan be predicted from the deposition parameters the (Ti+Al):V ratio decreases as the power to the pure V targets was increased, see Table 1.

3.1.2. Structural analysis

Low angle XRD was used to determine the bi-layer periods, D of the nano-scale multilayers, which were in the range of 2.8–3.1 nm, see Table 1. Texture measurements using the Harris inverse pole figure method for the four specimens under investigation are given in Table 2. In all cases the films developed with a pronounced $\{110\}$ texture where the intensity of the texture increased with increasing vanadium content. Pronounced $\{110\}$ textures have been observed when similar films were deposited at $U_B = -75 \text{ V}$ [13]. In fact strong $\{110\}$ textures are present in magnetron sputtered monolithically grown VN [14] films grown under similar bias voltage conditions indicating that under the deposition conditions used increasing the vanadium content favours the development of a $\{110\}$ texture. This texture is in contrast to similar films which developed a pronounced $\{111\}$ texture when deposited under similar conditions of bias voltage (i.e. $U_B = -85 \text{ V}$), but at a lower total pressure, P of $3.8 \times 10^{-3} \text{ mbar}$ T [13]. At the same bias voltage increasing the total gas pressure P_T decreases the energy of the bombarding ions and therefore, has a similar influence on texture formation as reducing the bias voltage. Therefore, the texture developed at $U_B = -85 \text{ V}$ using a total pressure $P_T = 5 \times 10^{-3} \text{ mbar}$ is similar to that developed at $U_B = -75 \text{ V}$ using a total pressure $P = 3.8 \times 10^{-3} \text{ mbar}$ that is a T $\{110\}$ texture in both cases.

3.1.3. Residual stress hardness, sliding wear, coefficient of friction (μ) and adhesion

Residual stress, hardness, sliding wear, coefficient of friction (μ) and adhesion values for the four coatings under investigation are shown in Table 2. All the coatings investigated exhibited residual compressive stress states. The stresses varied between -5.2 GPa for sample 1 and -7.4 GPa for sample 3. The hardness values mirror those of the residual stresses with minimum and maximum

Table 2 Texture coefficient T^* , sliding wear, coefficient of friction, μ , hardness, adhesion and residual stress

Sample	Texture coefficient, T^*			Sliding wear ($\text{m}^3 \text{N}^{-1} \text{m}^{-1}$)	μ	Hardness Knoop ($\text{HK}_{0.25}$)	Adhesion critical load N (L_c)	Residual stress (GPa)
	(1 1 1)	(2 0 0)	(2 2 0)					
1	0.2	1.7	4.1	$4.5\text{E}-17$	0.59	3377	55	-5.2
2	0.3	1.1	4.3	$2.8\text{E}-17$	0.52	3378	42	-6.4
3	0.3	0.9	4.9	$5.8\text{E}-17$	0.64	3752	55	-7.4
4	0.3	0.9	4.5	$1.76\text{E}-16$	0.57	3451	49	-6.6

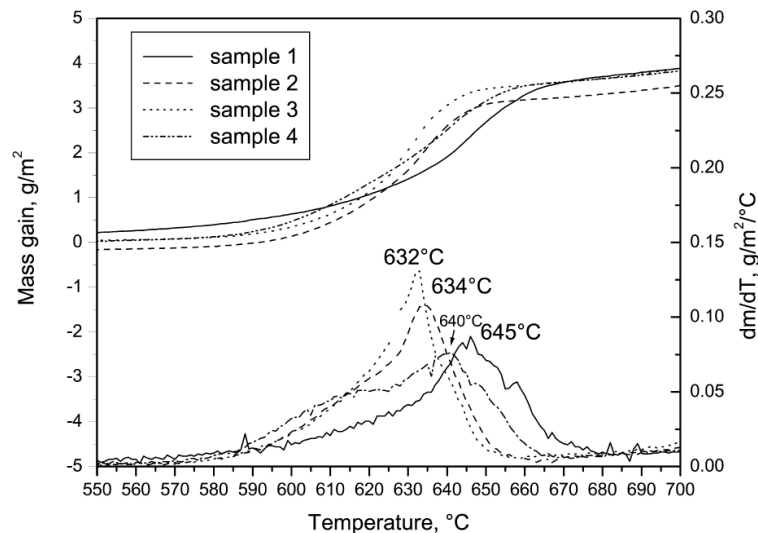


Fig. 1. Thermo-gravimetric oxidation measurement in air using a linear ramp of $1^\circ \text{C min}^{-1}$ from 400 to 1000 $^\circ \text{C}$ for samples 1–4.

hardness values for samples 1 and 3, respectively. The sliding wear varied between 1.76×10^{-16} and $2.8 \times 10^{-17} \text{ m}^3 \text{N}^{-1} \text{m}^{-1}$, whilst the μ varied between 0.52 and 0.64 with no clear trend of (Ti+Al):V ratio.

3.2. Oxidation studies

3.2.1. Thermal gravimetric analysis

Fig. 1 plots thermal gravimetric analysis (TGA) oxidation rate measurements for TiAlN/VN coatings (coupons from samples 1 to 4) deposited on stainless steel substrates. The measurements were dynamic TGA using a linear temperature ramp ($400\text{--}1000^\circ \text{C}$ at $1^\circ \text{C min}^{-1}$). The differentiated mass gains as a function of temperature are also displayed. Significant increases in mass gain (onset of rapid oxidation) occurred between 632 and 645 $^\circ \text{C}$ for all the coatings, which is in contrast to monolithic TiAlN coatings where the onset of rapid oxidation

occurred above 800 °C [15]. The temperature at which the onset of rapid oxidation occurred was also dependent on the (Ti+Al):V ratio in the coating, see Table 1. The higher the (Ti+Al):V ratio the higher the temperature at which rapid oxidation occurred, for example for sample 3 ((Ti+Al):V ratio 1.14) the onset of rapid oxidation was 632 °C whereas for sample 1 ((Ti+Al):V ratio 1.73) the onset of rapid oxidation was 645°C.

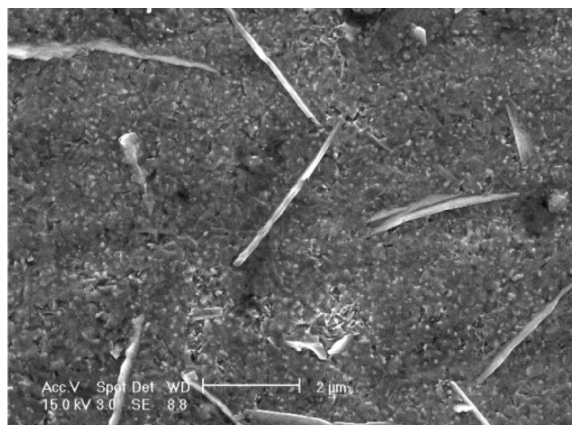


Fig. 2. A SEM of the surface of an oxidised TiAlN/VN coating sample 1, heat treated in air at 550 °C for 1 h.

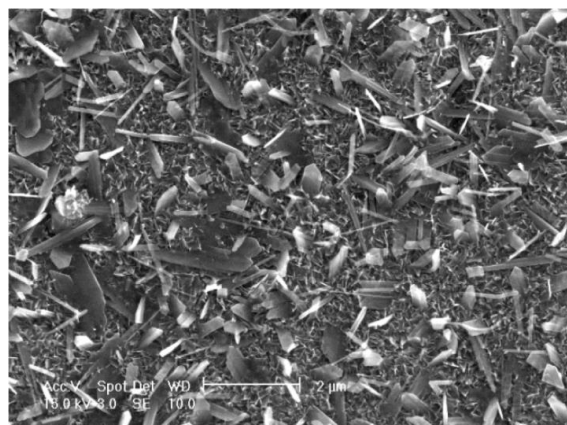


Fig. 3. A SEM of the surface of an oxidised TiAlN/VN coating sample 3, heat treated in air at 550 °C for 1 h.

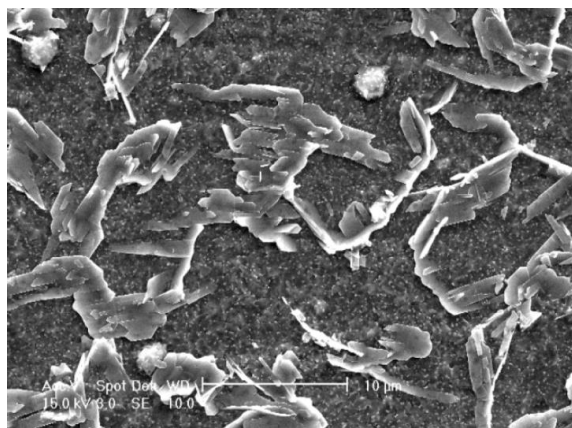


Fig. 4. A SEM of the surface of an oxidised TiAlN/VN coating, sample 1, heat treated in air at 600 °C for 1 h.

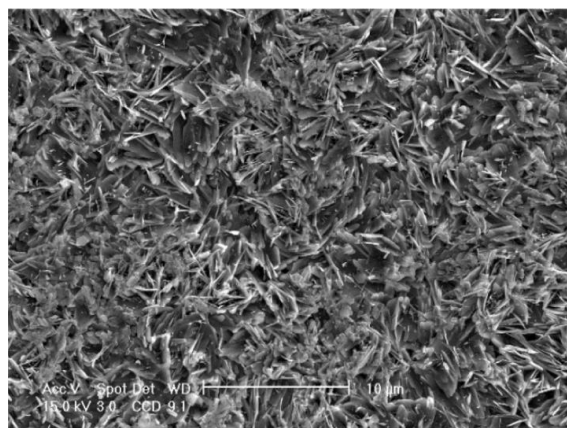


Fig. 5. A SEM of the surface of an oxidised TiAlN/VN coating, sample 3, heat treated in air at 600 °C for 1 h.

3.2.2. Scanning electron microscopy

Scanning electron micrographs (SEM) typical of the surfaces of samples 1–4 oxidised for 1 h in air at 550, 600, 640 and 670 °C are shown, respectively, in Figs. 2–8. After oxidation at 550 °C samples 1 and 4 exhibit an almost uniformly oxidised surface containing only a few needle-like particles, see Fig. 2. In contrast, samples 2 and 3 showed numerous needle-like particles at the surface, see Fig. 3. EDX analysis showed that the needle-like particles were rich in vanadium, i.e. V_2O_5 . Increasing the heat treatment temperature to 600 °C resulted in the development of platelet type morphology at the surface in all four specimens. The volume

fraction of the platelets at the surface was the greatest in sample 3 (compare Figs. 4 and 5), i.e. the coating containing the highest V content. EDX analysis showed the particles with platelet type morphology were richer in V than the surrounding regions thus leading one to the conclusion that they are V_2O_5 . With the exception of sample 3 increasing the heat treatment temperature to 640 °C resulted in more extensive development of the plate-like morphology of the V_2O_5 phase, (compare Figs. 6 and 7). This supports the evidence from the XRD patterns which show increasing intensity of the

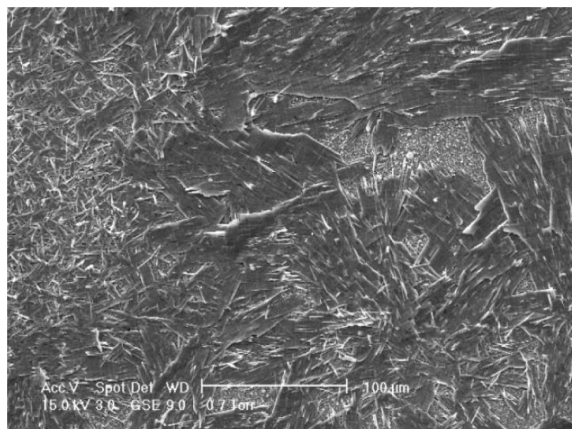


Fig. 6. A SEM of the surface of an oxidised TiAlN/VN coating, sample 1, heat treated in air at 640 °C for 1 h.

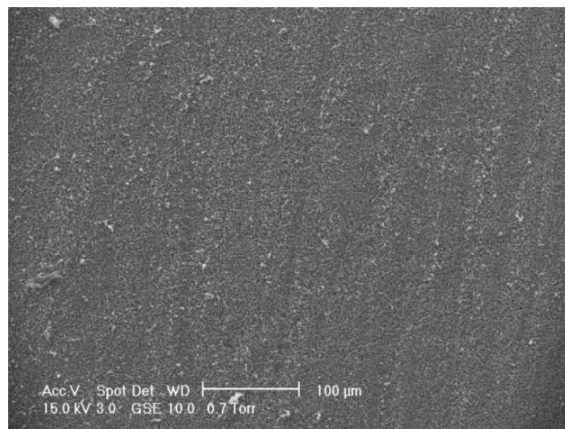


Fig. 7. A SEM of the surface of an oxidised TiAlN/VN coating, sample 3, heat treated in air at 640 °C for 1 h.

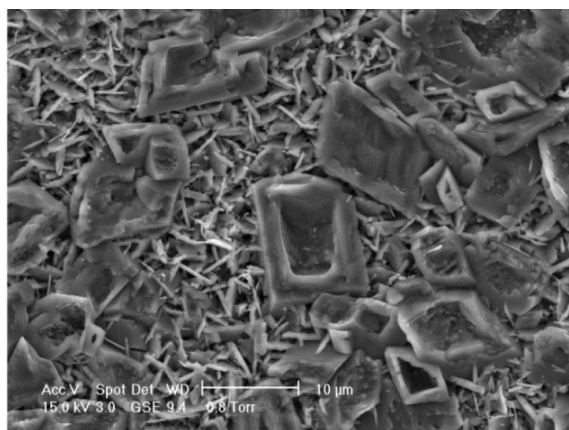


Fig. 8. A SEM of the surface of an oxidised TiAlN/VN coating, sample 1, heat treated in air at 670 °C for 1 h.

(001) texture of V_2O_5 for all coatings except sample 3 as the heat treatment temperature was increased to 640 °C. When the coatings were heat treated in air at 670 °C the plate like morphology completely disappeared to be replaced by regions with either blocky or needle like morphologies but there was no evidence of localised melting, see Fig. 8. EDX analysis showed the needle-like regions contained mainly Ti whilst the blocky regions contained both the elements Al and V.

3.2.3. X-ray diffraction

Glancing angle X-ray diffraction patterns (GAXRD, 1° incidence) of samples 1–4 heated in air at 550 °C are shown in Fig. 9. The following phases could be identified, V_2O_5 (41-

1426), TiO_2 (21-1276) and AlVO_4 (31-0034), together with the $\{1\ 1\ 1\}$ and $\{200\}$ (not shown in figure) reflections from the coating. However, when one compares the intensity of the (001) reflection for V_2O_5 in the GAXRD patterns it is clear that samples 1 and 4 contained relatively small amounts of V_2O_5 when compared with samples 2 and 3, the latter containing the highest intensity for the (001) reflection. The presence of coating peaks in the GAXRD pattern at 1° incidence clearly indicates an extremely thin oxide layer at the surface. A total oxide layer thickness of $\sim 0.08\ \mu\text{m}$ was calculated based on attenuation measurements of the $\{111\}$ reflection from the coating. In

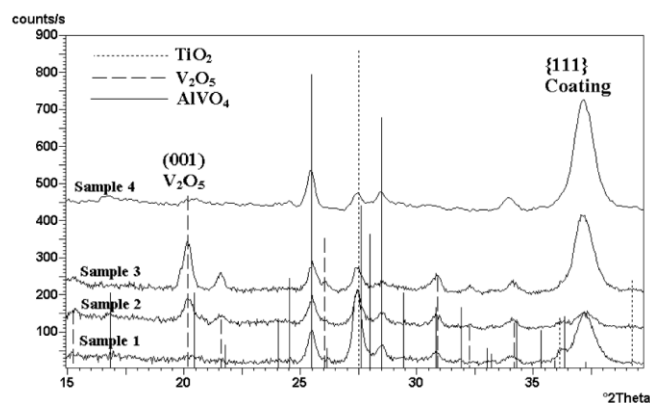


Fig. 9. GAXRD patterns of oxidised TiAlN/VN coating surfaces, heat treated in air at 550°C for 1 h.

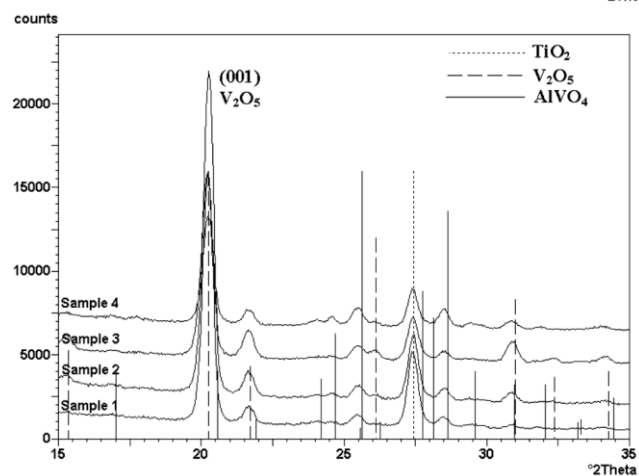


Fig. 10. $\theta/2\theta$ XRD patterns of oxidised TiAlN/VN coating surfaces, heat treated in air at 600°C for 1 h.

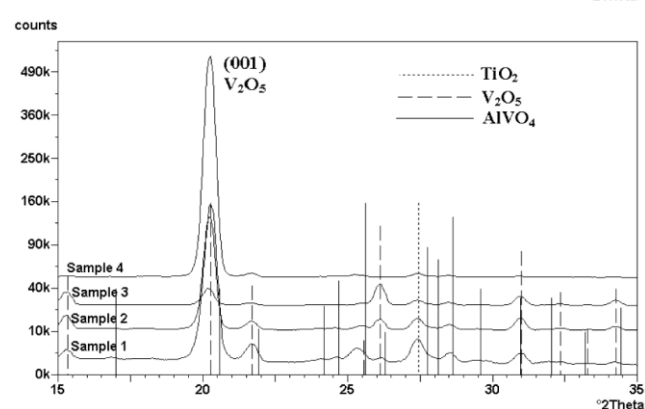


Fig. 11. $\theta/2\theta$ XRD patterns of oxidised TiAlN/VN coating surfaces, heat treated in air at 640°C for 1 h.

samples 1 and 4 where the Al:V ratio was almost unity the majority of any V_2O_5 formed was reduced to AlVO_4 . In contrast, in samples 2 and 3 where the Al:V ratio was much less than

unity, more free V_2O_5 was present. XRD patterns ($\theta/2\theta$) of coatings heated in air for 1 h at 600 °C are shown in Fig. 10. In all cases the patterns contained the same phases as were present at 550 °C, i.e. V_2O_5 , TiO_2 and $AlVO_4$. However, there was a dramatic increase in V_2O_5 relative to the other phases present. Furthermore, the V_2O_5 phase which formed was highly oriented with the majority of grain shaving their (001) planes parallel to the coating surface. The highly oriented (001) V_2O_5 phase identified in the $\theta/2\theta$ XRD patterns is consistent with the plate like morphology observed in the SEM images. However, there was still evidence of reflections from the coating (not shown in

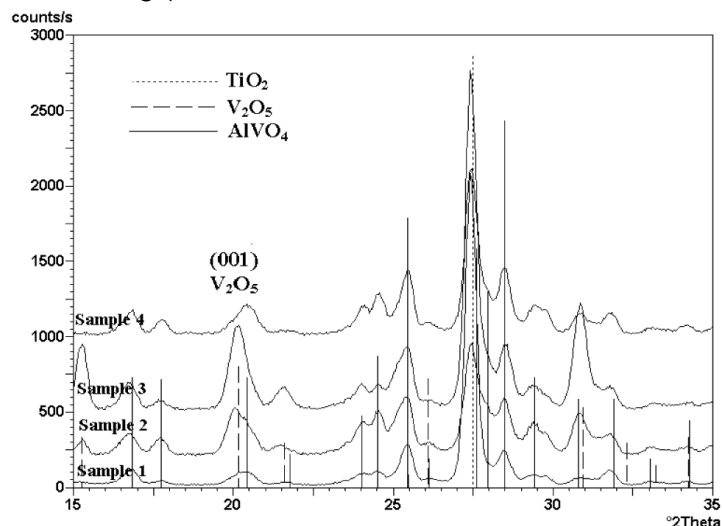
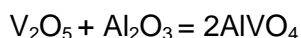


Fig. 12. $\theta/2\theta$ XRD patterns of oxidised TiAlN/VN coating surfaces, heat treated in air at 670 °C for 1 h.

figure) thus indicating that the coating was still intact. Increasing the heat treatment further to a temperature of 640 °C resulted, with the exception of sample 3, in further increases in the intensity of the (001) texture in the V_2O_5 , Fig. 11 and is clearly consistent with the increased plate like morphology observed in the SEM images. Reflections from the coating have now disappeared indicating that the coating (not shown in figure) was almost completely oxidised.

Further increases in temperature to 670 °C, Fig. 12 resulted in a dramatic decrease in the intensity of the V_2O_5 and corresponding increase in the intensity of the $AlVO_4$. The strong (001) texture present in samples 1, 2 and 4 after heat treating in air at 640 °C had completely disappeared. Thus, the V_2O_5 which had formed at the lower temperature was reduced by the formation of $AlVO_4$. This was clearly consistent with SEM observations which showed completely different surface morphologies after heating for 1 h in air at 670 °C. Thus, the oxides present were mainly TiO_2 (rutile) and $AlVO_4$ and indeed SEM and EDX analysis showed two phases one Ti rich and one Al and V rich.

$AlVO_4$ phase forms from a solid state reaction between V_2O_5 and Al_2O_3 of the following type [16–18].



However, according to Refs. [16–18] the reaction between V_2O_5 and Al_2O_3 to form $AlVO_4$ requires prolonged heating between 600 and 650 °C to go to completion. In the current work $AlVO_4$ phase could be identified at temperatures as low as 550 °C, which is much lower than

previously observed. One possible explanation is that at 550 °C the reaction is occurring mainly at the surface where diffusion rates are at least an order of magnitude faster than in the bulk. It is well established that the onset of rapid oxidation of TiN to form rutile takes place at 550 °C [19,20]. In TiAlN coatings the onset of rapid oxidation takes place above 800 °C [15]. TiAlN oxidises to form a stable passive oxide double layer [19,20], the upper one Al rich and the lower one Ti rich which increases the oxidation resistance of TiAlN base coatings. Oxidation in TiAlN proceeds by the simultaneous diffusion of Al to the oxide/vapour interface and inward diffusion of O to the oxide/nitride interface. Thus, the oxidation resistance of TiAlN is conferred by the presence of a continuous Al₂O₃ rich layer at the surface. In TiAlN/VN coatings oxidised at 550 °C the presence of major reflections from the AlVO₄ phase and only minor amounts of V₂O₅ (particularly in samples 1 and 4) would suggest that any Al₂O₃ which formed at the surface reacted with V₂O₅ to form AlVO₄. Therefore, the reaction of Al₂O₃ with V₂O₅ disrupts the protective Al₂O₃ layer from TiAlN/VN coatings. In the absence of a protective Al₂O₃ layer increasing the oxidation temperature to 600 or 640 °C results in rapid oxidation of the TiAlN/VN coatings (Fig. 1) to produce V₂O₅, TiO₂ and possibly Al₂O₃ although no crystalline phase of Al₂O₃ has been identified. No further significant increases in AlVO₄ were observed indicating little or no further reaction between V₂O₅ and Al₂O₃ in the bulk at these temperatures. This is consistent with the SEM images which show penetration of the surface by platelets of V₂O₅ at 600 and 640 °C, see Figs. 4–6. Increasing the temperature to 670 °C results in the formation of AlVO₄ that was clearly identified by both XRD and EDX analysis. Therefore, at 670 °C the temperature is sufficiently high for the reaction of V₂O₅ with Al₂O₃ to proceed in the bulk to form AlVO₄ [16–18]. The formation of V₂O₅ is believed to be critical to the low friction behaviour of these coatings. At 550 °C the oxidation of V appears to be dominated by the formation of AlVO₄. Only at temperatures of 600 and 640 °C significant quantities of V₂O₅ are formed leading one to the conclusion that these temperatures must be generated locally before low friction conditions prevail.

4. Conclusions

- 1) The onset of rapid oxidation in these coatings takes place at temperatures between 632 and 645 °C, which is ~150 °C lower than for monolithic TiAlN coatings. The higher the (Ti+Al):V ratio the higher the temperature of onset of rapid oxidation.
- 2) A reaction which occurs between Al₂O₃ and V₂O₅ to form AlVO₄ was responsible for disrupting the formation of Al₂O₃ which imparts oxidation resistance on TiAlN based coatings. This reaction lowers the oxidation resistance of TiAlN/VN nano-scale multilayer coatings when compared with monolithic TiAlN based coatings.
- 3) The relative amounts of V₂O₅ which formed was observed to depend on the (Ti+Al):V ratio.
- 4) The V₂O₅ phase with a plate like morphology was oriented with the (001) plane parallel to the coating surface.

Acknowledgments

Financial support from Engineering and Physical Science Research Council (EPSRC), UK, Grant No GR/N23998y01 is acknowledged.

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