

# Contents

<b>List of Abbreviations.....</b>	<b>IX</b>
<b>List of Symbols .....</b>	<b>XI</b>
<b>1 Introduction.....</b>	<b>1</b>
<b>2 Physical vapour deposition technology .....</b>	<b>3</b>
2.1 Magnetron sputtering.....	3
2.2 High power impulse magnetron sputtering .....	5
2.3 Cathodic arc evaporation .....	6
<b>3 Ti-Al-N coatings .....</b>	<b>11</b>
3.1 The Ti-Al-N system .....	12
3.2 Review of Ti-Al-N coatings deposited by CAE.....	13
3.2.1 Influence of the Al content on the microstructure and properties of Ti-Al-N coatings deposited by CAE .....	13
3.2.2 Influence of the bias voltage on the microstructure and properties of Ti-Al-N coatings deposited by CAE .....	16
3.2.2.1 Influence of $U_B$ on the Al content in the Ti-Al-N coatings deposited by CAE.....	16
3.2.2.2 Influence of $U_B$ on the residual stress in Ti-Al-N coatings deposited by CAE.....	18
3.2.2.3 Influence of $U_B$ on lattice parameter of fcc-(Ti,Al)N in CAE coatings .....	21
3.2.2.4 Influence of $U_B$ on the hardness of Ti-Al-N coatings deposited by CAE .....	21
3.3 Thermal stability of Ti-Al-N coatings .....	22
<b>4 Ti-Al-Ru-N coatings .....</b>	<b>25</b>
4.1 Properties of Ti-Al-Ru-N coatings deposited by CAE .....	25
4.2 Thermal stability of Ti-Al-Ru-N coatings deposited by CAE .....	26
<b>5 Cr-Al-Si-N coatings.....</b>	<b>27</b>
5.1 The Cr-Al-(Si)-N system.....	27
5.2 Magnetic ordering in CrN.....	28

<b>6</b>	<b>Characterisation techniques.....</b>	<b>31</b>
6.1	<b>Chemical Analysis .....</b>	<b>31</b>
6.1.1	Electron probe microanalysis .....	31
6.1.2	Glow discharge optical emission spectroscopy .....	31
6.2	<b>X-ray diffraction.....</b>	<b>32</b>
6.2.1	Glancing angle X-ray diffraction.....	32
6.2.1.1	Determination of stress-free lattice parameter and residual stress .....	33
6.2.1.2	Crystal anisotropy of the lattice deformation .....	37
6.2.2	<i>In situ</i> synchrotron HT-GAXRD .....	40
6.2.3	Pole figure measurements.....	41
6.2.4	Reciprocal space maps and XRD rocking curves .....	42
6.3	<b>Transmission electron microscopy.....</b>	<b>44</b>
6.3.1	Imaging using TEM.....	44
6.3.2	Determination of the local orientation.....	45
6.3.3	Analytical TEM.....	48
6.3.3.1	Energy dispersive spectroscopy .....	48
6.3.3.2	Electron energy loss spectroscopy.....	50
6.4	<b>Thermal treatment .....</b>	<b>58</b>
6.5	<b>Calotest.....</b>	<b>58</b>
6.6	<b>Nanoindentation .....</b>	<b>59</b>
<b>7</b>	<b>Results and discussion.....</b>	<b>63</b>
7.1	<b>Ti-Al-N coatings deposited by CAE.....</b>	<b>63</b>
7.1.1	Deposition of CAE Ti-Al-N monolayer coatings .....	63
7.1.2	Chemical and phase composition of as-deposited $Ti_{1-x}Al_xN$ coatings.....	64
7.1.3	Macroscopic lattice strain and residual stress of as-deposited $Ti_{1-x}Al_xN$ coatings.....	70
7.1.4	Crystallite size of as-deposited $Ti_{1-x}Al_xN$ coatings.....	71
7.1.5	Interfaces between fcc-(Ti,Al)N and w-AlN .....	73
7.1.6	Hardness of as-deposited $Ti_{1-x}Al_xN$ coatings.....	77
7.1.7	Thermal stability of $Ti_{1-x}Al_xN$ coatings .....	79
7.1.7.1	Thermally activated microstructure changes in the $Ti_{0.62}Al_{0.38}N$ coatings ....	80
7.1.7.2	Effect of the bias voltage and chemical composition on the phase composition of annealed $Ti_{1-x}Al_xN$ coatings .....	87

7.1.7.3	Apparent microstrain as an indicator of local concentration fluctuations in fcc-(Ti,Al)N .....	89
<b>7.2</b>	<b>Ti-Al-N / Al-Ti-(Ru)-N multilayers deposited by CAE.....</b>	<b>93</b>
7.2.1	Deposition of CAE Ti-Al-N / Al-Ti-(Ru)-N multilayer coatings .....	93
7.2.2	Chemical and phase composition of as-deposited Ti-Al-N / Al-Ti-(Ru)-N multilayers .....	94
7.2.3	Multilayer architecture of the Ti-Al-N / Al-Ti-(Ru)-N multilayer coatings .....	98
7.2.4	Residual stress in the as-deposited Ti-Al-N / Al-Ti-(Ru)-N multilayer coatings.....	105
7.2.5	Hardness of the as-deposited Ti-Al-N / Al-Ti-(Ru)-N multilayer coatings .....	106
7.2.6	Preferred orientation of the fcc-(Ti,Al)N crystallites .....	107
7.2.7	Thermal stability of Ti-Al-N / Al-Ti-(Ru)-N multilayers .....	113
7.2.7.1	Thermally activated microstructure changes in the Ti-Al-N / Al-Ti-(Ru)-N multilayer coatings .....	113
7.2.7.2	Thermally activated microstructure changes in the Ru-rich Ti-Al-N / Al-Ti-Ru-N multilayer coating deposited at $U_B = -80$ V as seen by analytical TEM .....	120
7.2.7.3	Interfaces between fcc and wurtzite phase after thermal treatment .....	126
<b>7.3</b>	<b>Heteroepitaxial TiN / AlN / TiN layers deposited by MS .....</b>	<b>130</b>
7.3.1	Preparation of TiN / AlN / TiN layer stacks.....	131
7.3.2	Internal interfaces studied by heteroepitaxial growth.....	133
7.3.2.1	Wurtzite AlN grown on $(1\bar{1}0)_{fcc}$ oriented fcc-TiN .....	135
7.3.2.2	Wurtzite AlN grown on $(00\bar{1})_{fcc}$ oriented fcc-TiN .....	150
<b>7.4</b>	<b>Cr-Al-Si-N coatings deposited by UBM and HIPIMS .....</b>	<b>167</b>
7.4.1	Deposition of Cr-Al-Si-N coatings using UBM, HIPIMS and CAE.....	167
7.4.2	Ionized species in the UBM and HIPIMS plasma .....	170
7.4.3	Phase composition of the Cr-Al-Si-N coatings deposited by UBM and HIPIMS and crystal anisotropy of the lattice deformation.....	173
7.4.4	Stress-free lattice parameter of the fcc-(Cr,Al,Si)N phase .....	176
7.4.5	Influence of the deposition mode on the microstructure of Cr-Al-Si-N coatings .....	179
<b>8</b>	<b>Conclusions .....</b>	<b>185</b>
	<b>Appendix .....</b>	<b>189</b>
	<b>Bibliography .....</b>	<b>201</b>