

Contents

Preface *xvii*

List of Abbreviations and Symbols *xxix*

About the Authors *xxiii*

1 Introduction 1

2 Principles of X-ray Spectrometry 7

2.1 Analytical Performance 7

2.2 X-ray Radiation and Their Interaction 11

2.2.1 Parts of an X-ray Spectrum 11

2.2.2 Intensity of the Characteristic Radiation 13

2.2.3 Nomenclature of X-ray Lines 15

2.2.4 Interaction of X-rays with Matter 15

2.2.4.1 Absorption 16

2.2.4.2 Scattering 17

2.2.5 Detection of X-ray Spectra 20

2.3 The Development of X-ray Spectrometry 21

2.4 Carrying Out an Analysis 26

2.4.1 Analysis Method 26

2.4.2 Sequence of an Analysis 27

2.4.2.1 Quality of the Sample Material 27

2.4.2.2 Sample Preparation 27

2.4.2.3 Analysis Task 28

2.4.2.4 Measurement and Evaluation of the Measurement Data 28

2.4.2.5 Creation of an Analysis Report 29

3 Sample Preparation 31

3.1 Objectives of Sample Preparation 31

3.2 Preparation Techniques 32

3.2.1 Preparation Techniques for Solid Samples 32

3.2.2 Information Depth and Analyzed Volume 32

3.2.3 Infinite Thickness 36

3.2.4 Contaminations 37

3.2.5 Homogeneity 38

3.3	Preparation of Compact and Homogeneous Materials	39
3.3.1	Metals	39
3.3.2	Glasses	40
3.4	Small Parts Materials	41
3.4.1	Grinding of Small Parts Material	42
3.4.2	Preparation by Pouring Loose Powder into a Sample Cup	43
3.4.3	Preparation of the Measurement Sample by Pressing into a Pellet	44
3.4.4	Preparation of the Sample by Fusion Beads	48
3.4.4.1	Improving the Quality of the Analysis	48
3.4.4.2	Steps for the Production of Fusion Beads	49
3.4.4.3	Loss of Ignition	53
3.4.4.4	Quality Criteria for Fusion Beads	53
3.4.4.5	Preparation of Special Materials	54
3.5	Liquid Samples	55
3.5.1	Direct Measurement of Liquids	55
3.5.2	Special Processing Procedures for Liquid Samples	58
3.6	Biological Materials	58
3.7	Small Particles, Dust, and Aerosols	59
4	XRF Instrument Types	61
4.1	General Design of an X-ray Spectrometer	61
4.2	Comparison of Wavelength- and Energy-Dispersive X-Ray Spectrometers	63
4.2.1	Data Acquisition	63
4.2.2	Resolution	64
4.2.2.1	Comparison of Wavelength- and Energy-Dispersive Spectrometry	64
4.2.2.2	Resolution of WDS Instruments	66
4.2.2.3	Resolution of EDS Instruments	68
4.2.3	Detection Efficiency	70
4.2.4	Count Rate Capability	71
4.2.4.1	Optimum Throughput in ED Spectrometers	71
4.2.4.2	Saturation Effects in WDSs	72
4.2.4.3	Optimal Sensitivity of ED Spectrometers	73
4.2.4.4	Effect of the Pulse Throughput on the Measuring Time	74
4.2.5	Radiation Flux	75
4.2.6	Spectra Artifacts	76
4.2.6.1	Escape Peaks	76
4.2.6.2	Pile-Up Peak	77
4.2.6.3	Diffraction Peaks	77
4.2.6.4	Shelf and Tail	79
4.2.7	Mechanical Design and Operating Costs	79
4.2.8	Setting Parameters	80
4.3	Type of Instruments	80
4.3.1	ED Instruments	81
4.3.1.1	Handheld Instruments	82
4.3.1.2	Portable Instruments	83

4.3.1.3	Tabletop Instruments	84
4.3.2	Wavelength-Dispersive Instruments	85
4.3.2.1	Sequential Spectrometers	85
4.3.2.2	Multichannel Spectrometers	87
4.3.3	Special Type X-Ray Spectrometers	87
4.3.3.1	Total Reflection Instruments	88
4.3.3.2	Excitation by Monoenergetic Radiation	90
4.3.3.3	Excitation with Polarized Radiation	91
4.3.3.4	Instruments for Position-Sensitive Analysis	93
4.3.3.5	Macro X-Ray Fluorescence Spectrometer	94
4.3.3.6	Micro X-Ray Fluorescence with Confocal Geometry	95
4.3.3.7	High-Resolution X-Ray Spectrometers	96
4.3.3.8	Angle Resolved Spectroscopy – Grazing Incidence and Grazing Exit	96
4.4	Commercially Available Instrument Types	98
5	Measurement and Evaluation of X-ray Spectra	99
5.1	Information Content of the Spectra	99
5.2	Procedural Steps to Execute a Measurement	101
5.3	Selecting the Measurement Conditions	102
5.3.1	Optimization Criteria for the Measurement	102
5.3.2	Tube Parameters	103
5.3.2.1	Target Material	103
5.3.2.2	Excitation Conditions	104
5.3.2.3	Influencing the Energy Distribution of the Primary Spectrum	105
5.3.3	Measurement Medium	107
5.3.4	Measurement Time	108
5.3.4.1	Measurement Time and Statistical Error	108
5.3.4.2	Measurement Strategies	108
5.3.4.3	Real and Live Time	109
5.3.5	X-ray Lines	110
5.4	Determination of Peak Intensity	112
5.4.1	Intensity Data	112
5.4.2	Treatment of Peak Overlaps	112
5.4.3	Spectral Background	114
5.5	Quantification Models	117
5.5.1	General Remarks	117
5.5.2	Conventional Calibration Models	118
5.5.3	Fundamental Parameter Models	121
5.5.4	Monte Carlo Quantifications	124
5.5.5	Highly Precise Quantification by Reconstitution	124
5.5.6	Evaluation of an Analytical Method	126
5.5.6.1	Degree of Determination	126
5.5.6.2	Working Range, Limits of Detection (LOD) and of Quantification	127
5.5.6.3	Figure of Merit	129
5.5.7	Comparison of the Various Quantification Models	129

5.5.8	Available Reference Materials	131
5.5.9	Obtainable Accuracies	132
5.6	Characterization of Layered Materials	133
5.6.1	General Form of the Calibration Curve	133
5.6.2	Basic Conditions for Layer Analysis	135
5.6.3	Quantification Models for the Analysis of Layers	138
5.7	Chemometric Methods for Material Characterization	140
5.7.1	Spectra Matching and Material Identification	141
5.7.2	Phase Analysis	141
5.7.3	Regression Methods	143
5.8	Creation of an Application	143
5.8.1	Analysis of Unknown Sample Qualities	143
5.8.2	Repeated Analyses on Known Samples	144
6	Analytical Errors	149
6.1	General Considerations	149
6.1.1	Precision of a Measurement	151
6.1.2	Long-Term Stability of the Measurements	153
6.1.3	Precision and Process Capability	154
6.1.4	Trueness of the Result	156
6.2	Types of Errors	156
6.2.1	Randomly Distributed Errors	157
6.2.2	Systematic Errors	158
6.3	Accounting for Systematic Errors	159
6.3.1	The Concept of Measurement Uncertainties	159
6.3.2	Error Propagation	160
6.3.3	Determination of Measurement Uncertainties	161
6.3.3.1	Bottom-Up Method	161
6.3.3.2	Top-Down Method	162
6.4	Recording of Error Information	164
7	Other Element Analytical Methods	167
7.1	Overview	167
7.2	Atomic Absorption Spectrometry (AAS)	168
7.3	Optical Emission Spectrometry	169
7.3.1	Excitation with a Spark Discharge (OES)	169
7.3.2	Excitation in an Inductively Coupled Plasma (ICP-OES)	170
7.3.3	Laser-Induced Breakdown Spectroscopy (LIBS)	171
7.4	Mass Spectrometry (MS)	172
7.5	X-Ray Spectrometry by Particle Excitation (SEM-EDS, PIXE)	173
7.6	Comparison of Methods	175
8	Radiation Protection	177
8.1	Basic Principles	177
8.2	Effects of Ionizing Radiation on Human Tissue	178
8.3	Natural Radiation Exposure	179

8.4	Radiation Protection Regulations	181
8.4.1	Legal Regulations	181
9	Analysis of Homogeneous Solid Samples	183
9.1	Iron Alloys	183
9.1.1	Analytical Problem and Sample Preparation	183
9.1.2	Analysis of Pig and Cast Iron	184
9.1.3	Analysis of Low-Alloy Steel	185
9.1.4	Analysis of High-Alloy Steel	187
9.2	Ni–Fe–Co Alloys	188
9.3	Copper Alloys	189
9.3.1	Analytical Task	189
9.3.2	Analysis of Compact Samples	189
9.3.3	Analysis of Dissolved Samples	189
9.4	Aluminum Alloys	191
9.5	Special Metals	192
9.5.1	Refractories	192
9.5.1.1	Analytical Problem	192
9.5.1.2	Sample Preparation of Hard Metals	192
9.5.1.3	Analysis of Hard Metals	193
9.5.2	Titanium Alloys	194
9.5.3	Solder Alloys	194
9.6	Precious Metals	195
9.6.1	Analysis of Precious Metal Jewelry	195
9.6.1.1	Analytical Task	195
9.6.1.2	Sample Shape and Preparation	196
9.6.1.3	Analytical Equipment	197
9.6.1.4	Accuracy of the Analysis	198
9.6.2	Analysis of Pure Elements	198
9.7	Glass Material	199
9.7.1	Analytical Task	199
9.7.2	Sample Preparation	200
9.7.3	Measurement Equipment	202
9.7.4	Achievable Accuracies	202
9.8	Polymers	203
9.8.1	Analytical Task	203
9.8.2	Sample Preparation	204
9.8.3	Instruments	205
9.8.4	Quantification Procedures	205
9.8.4.1	Standard-Based Methods	205
9.8.4.2	Chemometric Methods	206
9.9	Abrasion Analysis	209
10	Analysis of Powder Samples	213
10.1	Geological Samples	213

10.1.1	Analytical Task	213
10.1.2	Sample Preparation	214
10.1.3	Measurement Technique	215
10.1.4	Detection Limits and Trueness	215
10.2	Ores	216
10.2.1	Analytical Task	216
10.2.2	Iron Ores	216
10.2.3	Mn, Co, Ni, Cu, Zn, and Pb Ores	217
10.2.4	Bauxite and Alumina	218
10.2.5	Ores of Precious Metals and Rare Earths	219
10.3	Soils and Sewage Sludges	221
10.3.1	Analytical Task	221
10.3.2	Sample Preparation	221
10.3.3	Measurement Technology and Analytical Performance	222
10.4	Quartz Sand	223
10.5	Cement	223
10.5.1	Analytical Task	223
10.5.2	Sample Preparation	224
10.5.3	Measurement Technology	225
10.5.4	Analytical Performance	226
10.5.5	Determination of Free Lime in Clinker	227
10.6	Coal and Coke	227
10.6.1	Analytical Task	227
10.6.2	Sample Preparation	228
10.6.3	Measurement Technology and Analytical Performance	229
10.7	Ferroalloys	230
10.7.1	Analytical Task	230
10.7.2	Sample Preparation	230
10.7.3	Analysis Technology	232
10.7.4	Analytical Performance	234
10.8	Slags	235
10.8.1	Analytical Task	235
10.8.2	Sample Preparation	235
10.8.3	Measurement Technology and Analytical Accuracy	236
10.9	Ceramics and Refractory Materials	237
10.9.1	Analytical Task	237
10.9.2	Sample Preparation	237
10.9.3	Measurement Technology and Analytical Performance	238
10.10	Dusts	239
10.10.1	Analytical Problem and Dust Collection	239
10.10.2	Measurement	242
10.11	Food	242
10.11.1	Analytical Task	242
10.11.2	Monitoring of Animal Feed	243
10.11.3	Control of Infant Food	244
10.12	Pharmaceuticals	245
10.12.1	Analytical Task	245

10.12.2	Sample Preparation and Analysis Method	245
10.13	Secondary Fuels	246
10.13.1	Analytical Task	246
10.13.2	Sample Preparation	247
10.13.2.1	Solid Secondary Raw Materials	247
10.13.2.2	Liquid Secondary Raw Materials	249
10.13.3	Instrumentation and Measurement Conditions	250
10.13.4	Measurement Uncertainties in the Analysis of Solid Secondary Raw Materials	251
10.13.5	Measurement Uncertainties for the Analysis of Liquid Secondary Raw Materials	252
11	Analysis of Liquids	253
11.1	Multielement Analysis of Liquids	254
11.1.1	Analytical Task	254
11.1.2	Sample Preparation	254
11.1.3	Measurement Technology	254
11.1.4	Quantification	255
11.2	Fuels and Oils	255
11.2.1	Analysis of Toxic Elements in Fuels	256
11.2.1.1	Measurement Technology	256
11.2.1.2	Analytical Performance	258
11.2.2	Analysis of Additives in Lubricating Oils	258
11.2.3	Identification of Abrasive Particles in Used Lubricants	260
11.3	Trace Analysis in Liquids	261
11.3.1	Analytical Task	261
11.3.2	Preparation by Drying	261
11.3.3	Quantification	262
11.4	Special Preparation Techniques for Liquid Samples	263
11.4.1	Determination of Light Elements in Liquids	263
11.4.2	Enrichment Through Absorption and Complex Formation	264
12	Trace Analysis Using Total Reflection X-Ray Fluorescence	267
12.1	Special Features of TXRF	267
12.2	Sample Preparation for TXRF	269
12.3	Evaluation of the Spectra	271
12.3.1	Spectrum Preparation and Quantification	271
12.3.2	Conditions for Neglecting the Matrix Interaction	272
12.3.3	Limits of Detection	273
12.4	Typical Applications of the TXRF	274
12.4.1	Analysis of Aqueous Solutions	274
12.4.1.1	Analytical Problem and Preparation Possibilities	274
12.4.1.2	Example: Analysis of a Fresh Water Standard Sample	275
12.4.1.3	Example: Detection of Mercury in Water	277
12.4.2	Analysis of the Smallest Sample Quantities	278
12.4.2.1	Example: Pigment Analysis	278

12.4.2.2	Example: Aerosol Analysis	279
12.4.2.3	Example: Analysis of Nanoparticles	279
12.4.3	Trace Element Analysis on Human Organs	280
12.4.3.1	Example: Analysis of Blood and Blood Serum	280
12.4.3.2	Example: Analysis of Trace Elements in Body Tissue	282
12.4.4	Trace Analysis of Inorganic and Organic Chemical Products	283
12.4.5	Analysis of Semiconductor Electronics	284
12.4.5.1	Ultra-Trace Analysis on Si Wafers with VPD	284
12.4.5.2	Depth Profile Analysis by Etching	285
13	Nonhomogeneous Samples	287
13.1	Measurement Modes	287
13.2	Instrument Requirements	288
13.3	Data Evaluation	290
14	Coating Analysis	291
14.1	Analytical Task	291
14.2	Sample Handling	292
14.3	Measurement Technology	293
14.4	The Analysis Examples of Coated Samples	294
14.4.1	Single-Layer Systems: Emission Mode	294
14.4.2	Single-Layer Systems: Absorption Mode	297
14.4.3	Single-Layer Systems: Relative Mode	298
14.4.3.1	Analytical Problem	298
14.4.3.2	Variation of the Specified Working Distance	298
14.4.3.3	Sample Size and Spot Size Mismatch	299
14.4.3.4	Non-detectable Elements in the Layer: NiP Layers	300
14.4.4	Characterization of Ultrathin Layers	302
14.4.5	Multilayer Systems	304
14.4.5.1	Layer Systems	304
14.4.5.2	Measurement Technology	305
14.4.5.3	Example: Analysis of CIGS Solar Cells	305
14.4.5.4	Example: Analysis of Solder Structures	306
14.4.6	Samples with Unknown Coating Systems	307
14.4.6.1	Preparation of Cross Sections	308
14.4.6.2	Excitation at Grazing Incidence with Varying Angles	309
14.4.6.3	Measurement in Confocal Geometry	311
15	Spot Analyses	313
15.1	Particle Analyses	313
15.1.1	Analytical Task	313
15.1.2	Sample Preparation	314
15.1.3	Analysis Technology	315
15.1.4	Application Example: Wear Particles in Used Oil	315
15.1.5	Application Example: Identification of Glass Particles by Chemometrics	316
15.2	Identification of Inclusions	318

15.3	Material Identification with Handheld Instruments	318
15.3.1	Analytical Tasks	318
15.3.2	Analysis Technology	319
15.3.3	Sample Preparation and Test Conditions	320
15.3.4	Analytical Accuracy	320
15.3.5	Application Examples	321
15.3.5.1	Example: Lead in Paint	321
15.3.5.2	Example: Scrap Sorting	321
15.3.5.3	Example: Material Inspection and Sorting	322
15.3.5.4	Example: Precious Metal Analysis	322
15.3.5.5	Example: Prospecting and Screening in Geology	323
15.3.5.6	Example: Investigation of Works of Art	323
15.4	Determination of Toxic Elements in Consumer Products: RoHS Monitoring	324
15.4.1	Analytical Task	324
15.4.2	Analysis Technology	325
15.4.3	Analysis Accuracy	327
15.5	Toxic Elements in Toys: Toys Standard	328
15.5.1	Analytical Task	328
15.5.2	Sample Preparation	328
15.5.3	Analysis Technology	330
16	Analysis of Element Distributions	331
16.1	General Remarks	331
16.2	Measurement Conditions	332
16.3	Geology	333
16.3.1	Samples Types	333
16.3.2	Sample Preparation and Positioning	333
16.3.3	Measurements on Compact Rock Samples	334
16.3.3.1	Sum Spectrum and Element Distributions	334
16.3.3.2	Object Spectra	335
16.3.3.3	Treatment of Line Overlaps	336
16.3.3.4	Maximum Pixel Spectrum	339
16.3.4	Thin Sections of Geological Samples	340
16.4	Electronics	342
16.5	Archeometric Investigations	344
16.5.1	Analytical Tasks	344
16.5.2	Selection of an Appropriate Spectrometer	346
16.5.3	Investigations of Coins	347
16.5.4	Investigations of Painting Pigments	349
16.6	Homogeneity Tests	350
16.6.1	Analytical Task	350
16.6.2	Homogeneity Studies Using Distribution Analysis	351
16.6.3	Homogeneity Studies Using Multi-point Measurements	352
17	Special Applications of the XRF	355
17.1	High-Throughput Screening and Combinatorial Analysis	355

17.1.1	High-Throughput Screening	355
17.1.2	Combinatorial Analysis for Drug Development	357
17.2	Chemometric Spectral Evaluation	358
17.3	High-Resolution Spectroscopy for Speciation Analysis	361
17.3.1	Analytical Task	361
17.3.2	Instrument Technology	361
17.3.3	Application Examples	362
17.3.3.1	Analysis of Different Sulfur Compounds	362
17.3.3.2	Speciation of Aluminum Inclusions in Steel	363
17.3.3.3	Determination of SiO ₂ in SiC	365
18	Process Control and Automation	367
18.1	General Objectives	367
18.2	Off-Line and At-Line Analysis	369
18.2.1	Sample Supply and Analysis	369
18.2.2	Automated Sample Preparation	371
18.3	In-Line and On-Line Analysis	376
19	Quality Management and Validation	379
19.1	Motivation	379
19.2	Validation	380
19.2.1	Parameters	384
19.2.2	Uncertainty	385

Appendix A Tables 387

Appendix B Important Information 419

B.1	Coordinates of Main Manufacturers of Instruments and Preparation Tools	419
B.2	Main Suppliers of Standard Materials	422
B.2.1	Geological Materials and Metals	422
B.2.2	Stratified Materials	423
B.2.3	Polymer Standards	424
B.2.4	High Purity Materials	424
B.2.5	Precious Metal Alloys	425
B.3	Important Websites	425
B.3.1	Information About X-Ray Analytics and Fundamental Parameters	425
B.3.2	Information About Reference Materials	426
B.3.3	Scientific Journals	427
B.4	Laws and Acts, Which Are Important for X-Ray Fluorescence	427
B.4.1	Radiation Protection	427
B.4.2	Regulations for Environmental Control	428
B.4.3	Regulations for Performing Analysis	428
B.4.4	Use of X-ray Fluorescence for the Chemical Analysis	428
B.4.4.1	General Regulations	428

- B.4.4.2 Analysis of Minerals 429
- B.4.4.3 Analysis of Oils, Liquid Fuels, Grease 430
- B.4.4.4 Analysis of Solid Fuels 432
- B.4.4.5 Coating Analysis 433
- B.4.4.6 Metallurgy 433
- B.4.4.7 Analysis of Electronic Components 434

References 435

Index 453