

Welding Handbook

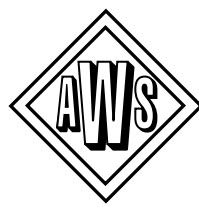
Ninth Edition

Volume 1

WELDING SCIENCE AND TECHNOLOGY

Prepared under the direction of the
Welding Handbook Committee

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ISO9001
Registered Organization

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Welding Handbook, Ninth Edition

Volume 1 *Welding Science and Technology*

Volume 2 *Welding Processes—Part 1*

Volume 3 *Welding Processes—Part 2*

Volume 4 *Materials and Applications—Part 1*

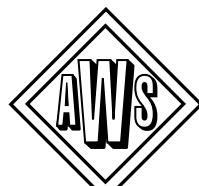
Volume 5 *Materials and Applications—Part 2*

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Volume 1

WELDING SCIENCE AND TECHNOLOGY



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CONTENTS

PREFACE	xi
ACKNOWLEDGEMENTS	xii
CONTRIBUTORS	xiii
CHAPTER 1—SURVEY OF JOINING, CUTTING, AND ALLIED PROCESSES	1
Introduction	2
Joining Processes	3
Cutting Processes.....	42
Thermal Spraying	47
Conclusion	49
Bibliography	49
Supplementary Reading List	50
CHAPTER 2—PHYSICS OF WELDING AND CUTTING	51
Introduction	52
Fusion and Solid-State Welding	52
Energy Sources for Welding	57
Arc Characteristics	67
Metal Transfer.....	73
Melting Rates	78
Physical Properties of Metals and Shielding Gases.....	81
Conclusion	84
Bibliography	84
Supplementary Reading List	84
CHAPTER 3—HEAT FLOW IN WELDING	87
Introduction	88
Heat Flow Fundamentals.....	88
Quantitative Calculation of Heat Transfer in Fusion Welding	95
Conduction of Heat during Fusion Welding	97
Convective Heat Transfer in the Weld Pool	105
Relative Importance of Conduction and Convection	108
Conclusion	111
Bibliography	112
Supplementary Reading List	113
CHAPTER 4—WELDING METALLURGY	115
Introduction	116
Physical Metallurgy	116
Metallurgy of Welding.....	130
Weldability of Commercial Alloys	140
Corrosion in Weldments.....	149
The Braze or Soldered Joint	151
Corrosion in Braze and Soldered Joints	154
Conclusion	154
Bibliography	155
Supplementary Reading List	155
CHAPTER 5—DESIGN FOR WELDING	157
Introduction	158
Properties of Metals	158
Weldment Design Program	166
Welded Design Considerations	170

Design of Welded Joints	182
Selection of Weld Type	193
Sizing of Steel Welds.....	196
Tubular Connections	216
Aluminum Structures	226
Conclusion	236
Bibliography.....	237
Supplementary Reading List	237
CHAPTER 6—TEST METHODS FOR EVALUATING WELDED JOINTS	239
Introduction	240
Testing for Strength	241
Hardness Tests	256
Bend Tests	260
Fracture Toughness Testing	261
Fatigue Testing	272
Corrosion Testing.....	277
Creep and Rupture Testing.....	280
Testing of Thermal Spray Applications.....	281
Weldability Testing.....	284
Conclusion	292
Bibliography.....	292
Supplementary Reading List	294
CHAPTER 7—RESIDUAL STRESS AND DISTORTION.....	297
Introduction	298
Fundamentals.....	298
Nature and Causes of Residual Stress.....	300
Effects of Residual Stress.....	308
Measurement of Residual Stress	313
Residual Stress Distribution Patterns.....	318
Effects of Specimen Size and Weight.....	322
Effects of Welding Sequence	325
Residual Stress in Welds Made with Different Welding Processes	326
Weld Distortion	328
Reducing or Controlling Residual Stress and Distortion.....	351
Conclusion	354
Bibliography.....	354
Supplementary Reading List	356
CHAPTER 8—SYMBOLS FOR JOINING AND INSPECTION.....	359
Introduction	360
Fundamentals.....	361
Welding Symbols	361
Welding Symbols for Specific Weld Types	373
Brazing Symbols.....	381
Soldering Symbols	382
Inspection Symbols.....	385
Conclusion	393
Bibliography.....	393
Supplementary Reading List	393
CHAPTER 9—WELDMENT TOOLING AND POSITIONING.....	395
Introduction	396
Fixtures	396

Positioners	403
Conclusion	419
Bibliography	419
Supplementary Reading List	419
CHAPTER 10—MONITORING AND CONTROL OF WELDING AND JOINING PROCESSES	421
Introduction	422
Principles of Monitoring and Control.....	422
Sensing Devices	423
Process Instrumentation	428
Process Monitoring Systems	429
Process Control Systems	429
Monitoring and Control Systems.....	431
Conclusion	448
Bibliography	448
Supplementary Reading List	448
CHAPTER 11—MECHANIZED, AUTOMATED, AND ROBOTIC WELDING	451
Introduction	452
Mechanized Welding	453
Automated Welding.....	458
Robotic Welding.....	467
Planning for Automated and Robotic Welding	474
Conclusion	482
Bibliography	482
Supplementary Reading List	482
CHAPTER 12—ECONOMICS OF WELDING AND CUTTING	483
Introduction	484
The Cost Estimate	484
Economics of Welding	485
Automated and Robotic Systems	498
Economics of Resistance Spot Welding	510
Capital Investment in Welding Automation and Robotics	514
Control of Welding Costs	517
Economics of Brazing and Soldering.....	523
Economics of Thermal Cutting.....	530
Conclusion	531
Bibliography	531
Supplementary Reading List	531
CHAPTER 13—WELD QUALITY	533
Introduction	534
Defining Weld Quality	534
Overview of Weld Discontinuities.....	536
Discontinuities Associated with Fusion Welding	538
Discontinuities Associated with Resistance Welding	562
Discontinuities Associated with the Solid-State Welding Processes.....	567
Discontinuities in Braze and Soldered Joints	569
Significance of Weld Discontinuities	572
Conclusion	575
Bibliography	576
Supplementary Reading List	576

CHAPTER 14—WELDING INSPECTION AND NONDESTRUCTIVE EXAMINATION.....	579
Introduction	580
Personnel Qualifications.....	581
The Inspection Plan.....	583
Nondestructive Examination.....	584
Metallographic Examination Methods.....	633
Inspection of Brazed and Soldered Joints.....	634
Conclusion	634
Bibliography.....	634
Supplementary Reading List.....	636
CHAPTER 15—QUALIFICATION AND CERTIFICATION.....	637
Introduction	638
Welding and Brazing Procedure Specifications.....	640
Qualification of Welding and Brazing Procedures.....	655
Performance Qualification.....	668
Standardization of Qualification Requirements	678
Conclusion	679
Bibliography.....	679
Supplementary Reading List.....	680
CHAPTER 16—CODES AND OTHER STANDARDS	683
Introduction	684
Types of Regulatory Documents.....	684
Standards-Developing Organizations and Welding-Related Publications.....	685
Guidelines for Participating in International Standards Activities.....	708
Conclusion	708
Supplementary Reading List.....	709
CHAPTER 17—SAFE PRACTICES	711
Introduction	712
Safety Management.....	712
Protection of the Work Area	714
Personal Protective Equipment	719
Protection against Fumes and Gases.....	724
Safe Handling of Compressed Gases	733
Protection against Electromagnetic Radiation	738
Electrical Safety.....	738
Fire Prevention	741
Explosion Prevention	743
Process-Specific Safety Considerations	743
Safety in Robotic Operations	753
Conclusion	754
Bibliography.....	754
Supplementary Reading List.....	757
APPENDIX A—TERMS AND DEFINITIONS	759
APPENDIX B—METRIC PRACTICE GUIDE FOR THE WELDING INDUSTRY	849
INDEX OF MAJOR SUBJECTS:	
Eighth Edition and Ninth Edition, Volume 1	873
INDEX OF NINTH EDITION, Volume 1	891

CHAPTER 1

SURVEY OF JOINING, CUTTING, AND ALLIED PROCESSES



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Contents

Introduction	2
Joining Processes	3
Cutting Processes	42
Thermal Spraying	47
Conclusion	49
Bibliography	49
Supplementary Reading List	50

CHAPTER 1

SURVEY OF JOINING, CUTTING, AND ALLIED PROCESSES

INTRODUCTION

This chapter introduces the conventional and more widely known joining, cutting, and thermal spraying processes. The distinguishing features of the various processes are summarized and compared to one another. Among the joining processes reviewed are the arc, resistance, and solid-state welding processes as well as brazing, soldering, and adhesive bonding. The cutting processes examined include thermal and non-thermal methods. The thermal spraying processes considered include flame and plasma arc spraying as well as arc and detonation flame spraying.

With respect to process selection, as several processes may be applicable for a particular job, the challenge lies in selecting the process that is most suitable in terms of fitness for service and cost. However, these factors may not be compatible, thus forcing a compromise. The selection of a process ultimately depends on several criteria. These include the number of components to be fabricated, capital equipment costs, joint location, structural mass, and the desired performance of the product. The adaptability of the process to the location of the operation, the type of shop, and the experience and skill levels of the employees may also have an impact on the final selection. These criteria are examined as they relate to the various joining, cutting, and thermal spraying processes.

As this chapter is intended to serve merely as a survey of the most common joining, cutting, and thermal

spraying processes,¹ the reader is encouraged to conduct a thorough investigation of the processes that appear to have the best potential for the intended applications. This investigation should take into account safety and health considerations such as those presented in the American National Standard *Safety in Welding, Cutting, and Allied Processes*, ANSI Z49.1,^{2,3} and the information provided in the manufacturers' material safety data sheets (MSDSs). Additional sources of information about the joining, cutting, and allied processes are listed in the Bibliography and Supplementary Reading List at the end of this chapter. In particular, *Welding Processes*,⁴ Volume 2 of the American Welding Society's *Welding Handbook*, 8th edition, presents in-

1. For further information on the categorization of the welding, joining, cutting, and allied processes, see Appendix A.

2. At the time of the preparation of this chapter, the referenced codes and other standards were valid. If a code or other standard is cited without a date of publication, it is understood that the latest edition of the document referred to applies. If a code or other standard is cited with the date of publication, the citation refers to that edition only, and it is understood that any future revisions or amendments to the code or standard are not included; however, as codes and standards undergo frequent revision, the reader is encouraged to consult the most recent edition.

3. American National Standards Institute (ANSI) Committee Z49 on Safety in Welding and Cutting, *Safety in Welding, Cutting, and Allied Processes*, ANSI Z49.1, Miami: American Welding Society.

4. O'Brien, R. L., ed., 1991, *Welding Processes*, Vol. 2 of *Welding Handbook*, 8th ed., Miami: American Welding Society.

depth coverage of each of the welding, cutting, and allied processes.

JOINING PROCESSES

The goal of the joining processes is to cause diverse pieces of material to become a unified whole. In the case of two pieces of metal, when the atoms at the edge of one piece come close enough to the atoms at the edge of another piece for interatomic attraction to develop, the two pieces become one. Although this concept is easy to describe, it is not simple to effect. Surface roughness, impurities, fitting imperfections, and the varied properties of the materials being joined complicate the joining process. Welding processes and procedures have been developed to overcome these difficulties by incorporating the use of heat or pressure, or both. Though portions of this description do not apply to brazing, soldering, and adhesive bonding, an explanation will be given when these processes are described later in the chapter.

Barring a few exceptions, most welding processes apply significant heat to the base material. This heat is only a means to bring the atoms at the edge of one piece of material close enough to the atoms of another piece for interatomic attraction. However, this heat is detrimental to the microstructure of the materials being joined. As hot metal tends to oxidize, sufficient protection from oxidation must be provided by the welding process to prevent this detrimental reaction with ambient oxygen. Some metals are far more sensitive than others, in which case protection from oxidation becomes more demanding. Thus, while examining each welding process, the reader should consider whether heat is produced by the process and, if so, the manner in which it is produced. The means by which sufficient protection against oxidation is provided by the process should then be identified.

The selection of an appropriate joining and cutting process for a given task involves a number of considerations. These include the following:

1. Availability and fitness for service;
2. Skill requirements;
3. Weldability of the base metal alloy with respect to type and thickness;
4. Availability of suitable welding consumables;
5. Weld joint design;
6. Heat input requirements;
7. Demands of the welding position;
8. Cost of the process, including capital expenditures, materials, and labor;
9. Number of components being fabricated;

10. Applicable code requirements; and
11. Safety concerns.

The overview of the joining processes featured in Table 1.1 presents an initial reference guide to the capabilities of various joining processes with respect to a variety of ferrous and nonferrous metals. This table indicates the processes, materials, and material thickness combinations that are usually compatible. The columns on the left list various engineering materials and four arbitrary thickness ranges. The processes most commonly used in industry are listed across the top.

It should be noted that additional information such as the considerations listed above must be taken into account before process selections are finalized. Nonetheless, Table 1.1 serves as a useful tool in providing general guidelines for the screening and selection process.

ARC WELDING

The term *arc welding* applies to a large, diversified group of welding processes that use an electric arc as the source of heat. The creation of a weld between metals using these processes does not usually involve pressure but may utilize a filler metal. The arc is struck between the workpiece and the tip of the electrode. The intense heat produced by the arc quickly melts a portion of the base metal, resulting in the formation of a weld. The arc welding processes may be moved along the joint to produce the weld or held stationary while the workpiece is moved under the process.

Arc welding operations are performed by conducting the welding current through consumable electrodes, which take the form of a wire or rod, or nonconsumable electrodes, consisting of carbon or tungsten rods. Metal arc processes utilize consumable electrodes that combine electrode filler metal with the molten base metal to create the weld. They may also produce a slag covering to protect the molten metal from oxidation. The nonconsumable arc processes can generate a weld by melting the base metal only, resulting in what is termed an *autogenous weld*. If filler metal is required in a nonconsumable process, it may be fed either manually or mechanically into the molten weld pool. In this case, the nonconsumable electrode serves only to sustain the arc.

Shielded Metal Arc Welding

Illustrated in Figure 1.1, shielded metal arc welding (SMAW) is a basic, versatile process used to weld ferrous and some nonferrous metals. The most widely known of the arc welding processes, shielded metal arc welding is sometimes referred to colloquially as *stick*

