Effect of Tool Pin Profile and Friction Stir Welding Speed on Tensile & Hardness Properties of Friction Stir Welded Joints of AA6082 & A319 Aluminium Alloy

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Abstract - Fusion welding of aluminium alloys results in solidification cracking, porosity etc. which affects the properties of the weldment. FSW which is broadly used in welding of aluminium alloys. It overcomes the defects of fusion welding process in improving the properties of the joints. The current paper focus on studying the tensile properties of the disparate FSW of aluminium alloys AA6082 and A319. Three dissimilar tool profiles (square, hexagonal and cylindrical) with three welding speeds (25, 30, 35 mm/min) and three tool rotational speeds (800, 1000 and 1300 rpm) have been used in studying the joint properties of the weld. Higher tensile strength was obtained for the parameters of square tool profile, 30 mm/min and 1300 rpm.

Key words: Aluminium alloys, FSW, welding speed, rotational speed, tensile strength, hardness.

I. INTRODUCTION

Aluminium alloys are broadly worn in the automobiles, marine and aerospace wherever more strength to weight ratio is a concern. But the joining of aluminium alloys by fusion welding always poses a problem of solidification cracking, porosity, intermetallic components etc affects the joint properties of the weld by reducing its strength. Also while joining dissimilar materials, the problems like variation in thermal and mechanical properties have negative impact on the potency of the disparate joints. FSW procedure is a solid phase welding method and it posses more advantage over fusion welding due to lower processing temperature and grain refinement which results in the decrease of weld defects, less distortion and less solidification cracking due to brittleness. FSW does not involve any flux or external material and the process is called environmental friendly welding process or green energy process. Also FSW has the advantage over fusion welding with its ability to weld unlike materials like Al-Cu, Al-Mg, and Al-steel has placed its use a prominent one in the ship building, aircraft panels, train bodies, automobile parts etc [2]. FSW method involves a non consumable revolving tool having a cylindrical carrier over which protrudes a pin of suitable profile. The pin aides in the stirring of the material from the joint interface as it rotate. The rule of thumb is that the head diameter should be three times of the pin diameter. The shoulder aides in transferring the material from one end to the other side and hold the material by the downward axial force. The success of the dissimilar FSW depends upon vigilant conclusion with reference to material position, FSW tool positioning and FSW process parameters varying upon the material to be joined[3],[4]. The FSW welding process parameters are welding speed, axial load, tool rotational speed, and tool profiles. Regarding the positioning of the base metals especially in case of dissimilar FSW, two options were viable i.e. placing which of the base metal in the advancing side (AS) or retreating side (RS). Advancing side is the side where the tool rotation coincides with the path the translation of the welding tool. Retreating side is the one where the tool rotation motion and translation motion counteracts each other [5]. Lee et.al has reported in their studies on friction stir welding of AA6061 to A356 aluminium alloy create that the stir zone is subject by the metals sited in the retreating side [6]. In the present investigation, FSW between dissimilar aluminium alloys of AA6082 and A319 were conducted using three tool pin profiles, three welding speeds and three tool rotational speeds.

II. EXPERIMENTAL PROCEDURE

The base metal, A319 cast aluminium alloy was procured as ingot from the supplier and cut into required dimensions for welding as 100x50x6 mm plates using milling machine and power hacksaw tool. Another base metal AA6082-T6, wrought aluminium alloy was obtained as rolled plates. Three unlike tools varying pin profiles as round, hexagon and square made from high speed steel without draft were used for FSW process (see Fig.2).
The welded plates were then cut for tensile tests as per (ASTM E8-M04). From each specimen two tensile tests were primed for mechanical testing. Tensile test were done on the universal testing machine (Make FIE Bluestar, India; Model: UNITEK-94100) where the specimen was weighed down at 100 KN/min. Vickers microhardness test was conducted at various locations of the FSW zones for all the nine specimens using Vickers microhardness tester of Model: MMT-X7 Matzusawa. A load of 0.5 kg was applied for 10s for the microhardness test.

### III.RESULTS AND DISCUSSION

#### III.1 Tensile Strength

The tensile results shows that the highest failures were originate to happening at the advancing side of A319 (see Fig. 3). Among the tool profiles square profile shows the highest tensile strength for all the other working functions (see Fig. 4). The tensile strength for round profile was calculated to be lowest. Hexagonal tool pin profile shows the moderate value of the tensile strength. The welding speed at 25 mm/min yields higher tensile results and the welding speed of 35mm/min yields the smallest. In case of tool rotational speed, 1300 rpm gives the maximum tensile strength. In case of unlike welding, when there is a variation in tensile and hardness properties, the malfunction of the tensile specimen will at all times take place at the lighter of the two metals.

The ultimate tensile strength of support metal A319 is of 180 MPa while AA6082-T6 was of 255 MPa. Also the presence of precast defects in A319 also acting a prominent role in disturbing the tensile strength of the specimen. Higher welding speed outcome in inadequate heat supply and faster cooling rate will affect the plastic flow rate of the material during stirring which results as kissing defect. But the lesser welding speed consequences in more heat supply per unit length distressing the perpendicular motion of the material [7]. On the contrary Ericsson and Sandstrom has reported that lower welding speed is further preferable than higher welding speed as the creation of the weld will be effective with proper metal flow [8]. Enhance in tool rotational speed fallout in pin hole with piping defect with the increase in turbulence of the plasticized material with high tool rotation speed [9]. Lower tool rotational speeds results in tunnel deficiency due to inadequate heat production during friction and thus insufficient metal transfer. Therefore for the present problem the progression array which satisfy the welding circumstances of the wrought (AA6082-T6) and cast (A319) aluminium alloys be preferred.

### Table I: Composition of AA6063-T6 and A319

| Composition | Base Metals |
|-------------|-------------|
| AA6082      | A319        |
| Si          | 1.1         | 6          |
| Cu          | 0.1         | 3.4        |
| Mg          | 0.9         | 0.1        |
| Mn          | 0.6         | 0.5        |
| Ti          | 0.1         | 0.2        |
| Zn          | 0.2         | 0.1        |
| Fe          | 0.5         | 0.1        |
| Al          | Bal         | Bal        |

Each tool shoulder diameter and pin diameter used is 18 mm and 3mm respectively. The tool pin length was maintained at 5.6 mm in length. The FSW tools were machined using CNC turning centre. To get the precise profile of the pin a wire cut EDM was used. Further the tool hardiness is improved to 65 Hrc by hardening process. FSW was conducted on an FSW machine supplied by R.V. Machine Tools, Coimbatore, India (see Fig. 1). It is a modified vertical end milling machine with a horizontal table which can move in the X and Y axes. It also has vertical guide ways for axial loading. The table has special provisions for mechanical fixture which holds the base material rigidly. The pin was to be found at the interface of the joint line. The process parameters chosen were given in table III. The experimental setup consists of FSW of the different materials which have been recognized using the progression parameters selected. A319 was kept at the advancing side whereas AA6082 was kept in the retreating side. FSW was conducted using three different welding speeds, three different rpm using three different tool profiles. A total of nine experiments were conducted. The joints when inspected where free for any exterior welding defects.

### Table II: FSW Process Parameters

| Process Parameters | Values       |
|--------------------|--------------|
| Tool Pin Profile   | Round, Hexagon, Square |
| Welding Speed (mm/min) | 25,30,35   |
| Tool Rotation Speed (rpm) | 800,1000,1300 |

### Table III: Mechanical Properties of AA6082 and A319 Aluminium Alloys

| Mechanical Properties | Base Metals |
|-----------------------|-------------|
|                        | AA6082      | A319        |
| UTS(MPa)               | 248         | 186         |
|YS(MPa)                | 219         | 124         |
| %ELONGATION           | 2.8         | 12          |
| HARDNESS              | 90          | 85          |
The result of tool pin profile in determining the tensile strength can be seen from the high difference between round pin profile and square pin profile. The joint effectiveness for the weldment is of 92% of tensile strength of A319 alloy and 72% of the tensile strength of AA6082-T6 alloy.

III.2 Microhardness Results

Microhardness values were measured the length of the mid-thickness of the welded joint (see Fig. 6). The rigidity distribution of the SZ is found to be superior than that of the base metals. In the absence of the external defects, the tensile properties always follow the lowest hardness distribution. The fracture zones are identified in Table IV. Failure has in most place on the minimum hardness zone at the advancing side of A319 side. Fracture locations can be seen to be distributed at the Weld zone, TMAZ and HAZ of A319 side [10]. Ren et al. has measured the hardness across the thickness for the AA6061 alloy and correlated that fracture path with the lowest hardness distribution [11].

![Figure 5: Effect of welding speed on tool pin profiles](image)

![Figure 6: LHZ Distribution for Various Tool Pin Profiles](image)

In the current investigation the hardness distribution has been taken for all the specimens by measuring the Vickers Microhardness beside the cross section of the FSW joint for every 0.5mm interval. The fracture locations were found to be reliable with the lower hardness sharing profile. All the specimens failed at the advancing side.

IV. CONCLUSIONS

In the current investigation the combined properties of the unalike fsd on cast aluminium alloy A319 to wrought aluminium alloy AA6082 were calculated by changing the working parameters of tool rotational speed, tool pin profile, and welding speed. Of the three dissimilar pin profiles, square tool pin profile shows highest tensile strength of 168 MPa at the welding speed of 25mm/min and at the tool rotational speed of 1300 rpm. Microhardness distribution profile revealed that the fracture points of the joints were in coherent with the lowest hardness values. All the specimens futille at the advancing side of the A319 wherever a lower hardness value was measured.
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