

Contents

Preface *vii*

List of Abbreviations *ix*

1	Aluminum Alloys: Fundamentals of Welding Metallurgy	1
1.1	Introduction	1
1.1.1	Aluminum–Copper Alloys	4
1.1.2	Aluminum–Zinc–Magnesium Alloys	4
1.1.3	Aluminum–Magnesium–Silicium	4
1.1.4	Aluminum–Lithium Alloys	5
1.2	Weldability	5
1.2.1	Aluminum Oxide	6
1.2.2	Hydrogen and Pore Formation	7
1.2.2.1	Effects of Porosity on the Mechanical Behavior	10
1.2.3	Hot Cracking	10
1.3	Thermal Cycle and Its Effect on the Weld Zone	23
1.4	Welding of Aluminum to Other Metals	30
	References	31
2	Arc Welding Processes	37
2.1	Introduction	37
2.2	Processes	38
2.2.1	TIG Welding	38
2.2.2	Plasma Arc Welding	39
2.2.3	MIG Welding	40
2.3	Modifications to the Processes	42
2.3.1	Negative-Pole and Positive-Pole TIG Welding	42
2.3.2	Keyhole TIG (K-TIG) Welding	42
2.3.3	Activated-Flux TIG (A-TIG) Welding	44
2.3.4	Double-Wire MIG Welding	44
2.3.5	Indirect Electric Arc	46
2.3.6	Cold Metal Transfer (CMT) Welding	47
2.3.7	Positive-Pole Plasma Welding	47
2.3.8	Hyperbaric Welding	48
2.4	Hybrid Welding	48
2.4.1	Plasma-MIG Welding	49
2.4.2	TIG-MIG Welding	51
2.5	Protective Gases	52
2.6	Filler Material	53
2.7	Grain Refinement in the Weld	53
2.8	Grain Structure	59

2.9	Defects During Arc Welding	60
2.9.1	Segregation	60
2.9.2	Smut	61
2.9.3	Pores	62
2.9.4	Hot Cracking	62
2.10	Welding of Dissimilar Metals	64
2.11	Simulation of the Arc Welding Processes	67
	References	72
3	Beam Welding Processes	83
3.1	Introduction	83
3.2	Laser Systems	87
3.3	Defects Formation During Laser Welding of Al Alloys	88
3.3.1	Mechanism of Pore Formation	88
3.3.2	Hot Cracking in Laser Welding	93
3.4	Shielding Gases in Laser Welding	96
3.5	Modifications to Laser Welding of Al	98
3.5.1	Multi-spot Laser Beam Welding	98
3.5.2	Micro-laser Welding	99
3.5.3	Pulsed Laser Beam Welding	99
3.5.4	Hybrid Laser Welding	103
3.5.5	Oscillation Laser Beam Welding	104
3.5.6	Vibration-Assisted Laser Beam Welding	105
3.5.7	Hot-Wire Laser Welding	106
3.6	Special Cases of Al Welding	107
3.6.1	Additive Manufacturing	107
3.6.2	Cast Aluminum	107
3.6.3	Welding of Aluminum to Dissimilar Materials	108
3.7	Simulation of Laser Welding	109
	References	115
4	Resistance Welding Process	125
4.1	Introduction	125
4.2	Weld Zones	131
4.2.1	Nugget Zone	131
4.2.2	Thermo-Mechanically Affected Zone (TMAZ)	133
4.3	Defects During RSW of Al Alloys	135
4.4	RSW of Dissimilar Aluminum Alloys	137
4.5	RSW of Al to Dissimilar Metals	139
4.6	Modifications to RSW for Welding Al Alloys	144
4.7	Simulation of the Process	149
4.8	Evaluation of the Joints	152
	References	155
5	Solid-State Welding Process	163
5.1	Introduction	163
5.2	FSW of Al Alloys	164
5.3	FSW of Al-Matrix Composites	172
5.4	FSW of Al to Dissimilar Materials	175
5.5	Joint Design	180
5.6	Simulation of the Process	184
	References	186
	Index	193