

# JOINING OF THREE DISSIMILAR MATERIAL USING FRICTION STIR WELDING: A REVIEW

Deepak Sharma<sup>1</sup>, Dr. Hari Om<sup>2</sup>

<sup>1</sup>M.Tech student, J.C. BOSE UNIVERSITY OF SCIENCE AND TECHNOLOGY

<sup>2</sup>Professor, J.C. BOSE UNIVERSITY OF SCIENCE AND TECHNOLOGY.

. e-mail:-deepakrey0123@gmail.com

## Abstract

Friction stir welding is a new technique to weld materials. It has the capability to weld dissimilar materials too. In this welding technique, materials can be welded without melting of materials. So this is an advantage of this welding process. Materials of different physical and chemical properties can be welded using this process. This process reduces the welding defects which generally occur in conventional welding processes like porosity, formation of intermetallic compound, distortion, cracking etc. There are many research papers available about joining of two dissimilar materials/alloys using friction stir welding. The aim of this review mainly provides feasibility about the suitability of the FSW technique to join three dissimilar materials/alloys in a single pass.

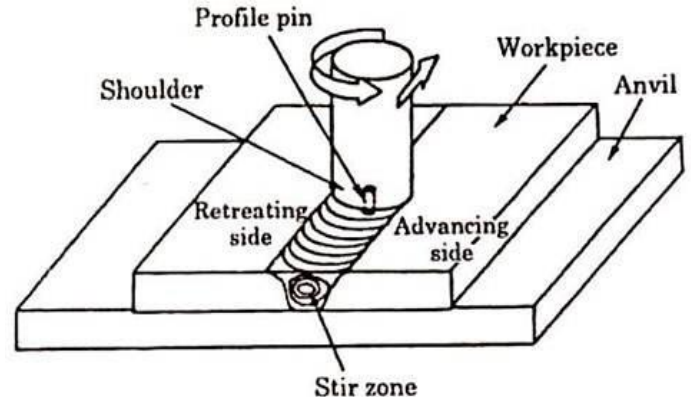
## 1. Introduction

Joining of dissimilar materials and alloys has importance in many industries like aerospace, shipbuilding industries, nuclear and power plant industries. Joining of two dissimilar materials is important because there is an advantage over here, we can use properties of different materials in a single hybrid structure. Hybrid materials are the materials which are made up of materials. For e.g. material made up of metal and ceramics. In today's trend, industries want to make a structure which has a high strength to weight ratio, so it can be done by joining of two different materials, one which has strength and the second one which has a light weight. For e.g. joining of aluminium and steel.

Joining of dissimilar materials cannot be done using conventional welding processes like MIG, TIG etc. Because these kinds of welding are fusion welding techniques, in these welding techniques, materials to be welded have to be melted first and cool afterward. As different materials have different melting points and this will lead to distortion, cracking etc. Also, different materials at high temperature can form

intermetallic compounds which are very hard and brittle.

To overcome this problem, a new method of joining of materials has been evolved, known as friction stir welding. In this method, there is no melting of materials. In this technique, materials are stirred together at the joining interface and materials mix together and materials join together. In this process, no melting of materials occurs; only plastic deformation of materials occurs. So this process reduces the welding defects which generally occur in conventional welding processes.



1.1 Schematic diagram of friction-stir-welding.

The diagram of the friction stir welding process is shown in the figure. As shown, the tool penetrates at the joining interface and advances along the joint interface. The materials to be welded mix up due to the tool and weld due to plastic deformation. There are two sides of the tool: the advancing side and the retreating side.

### 1.1 Thermophysical Properties of Some Pure Metals (Mills, 2002)

Metal	Density at 25°C (kg/m <sup>3</sup> )	Coefficient of Thermal Expansion (1/K) at 25°C	Heat Capacity (J/(K·kg)) at 25°C	Thermal Conductivity (W/(m·K)) at 25°C	Melting Point (°C)
Al	2702	28	905	91	660.2
Co	8862	16.7	425	100	1495
Cu	8930	19	380	400	1084.6
Fe	7874	14.5	450	73	1538
Mg	1710	30	103	157	650
Ni	8900	17.3	426	90	1455
Si	2330	3.8	712	140	1414
Ti	4540	11	525	21	1668
Zn	7140	30	390	120	419.4

### 1.2 Factors affecting quality of welding.

Weld quality of friction stir welding depends upon the various factors which should be considered before doing actual welding. There are various factors listed below.

1. Welding speed.
2. rotational speed of tool .
3. tool tilt angle.

4. Work piece and joint design.
  5. Tool geometry.
- These factors have been found out by different researchers.

Takehiko Watanabe et al (2006) successfully obtained a butt joint between aluminium alloy and steel and it has been found out that tensile strength of that joint is about 86% of aluminium base alloy.

Ghosh et al. (2010) welded A356 and 6061 aluminum alloys by friction stir welding under tool rotation speed of 1000-1400 rpm and transversing speed of 80-240 mm/min keeping other parameters same. In the investigation it was found that the joint fabricated using lowest tool transversing and rotational speed, exhibits superior mechanical properties with respect to other

Firouzdor and Kou (2009) were selected two materials 6061Al and AZ31Mg to join then using FSW and it has been found that position of AL and MG alloy with respect to tool greatly affect the quality of weld.

Amancio-Filho et al. (2008) done study on the mechanical property and microstructure of joining of two dissimilar material aluminium alloy (2024-T531) and 6056-T4 by varying rotational and welding speed kept other parameters constant. It was found that, good weld joints can be obtained with rotational speed of 800 rpm and welding speed 150 mm/min.

Duo Liu et al. (2011) done study on welding of dissimilar Mg alloys AZ31 and AZ80 and it was found that to obtain a good quality joint, alloy of high deformability should be at retreating side and alloy of low deformability should be at advancing side.

## 2. DESIGN OF TOOL FOR FRICTION STIR WELDING

Friction stir welding machine tool mainly has two parts, shoulder and probe. Probe is used to

stir and to generate localized heat between materials to be welded. Probe is connected to shoulder. The tool shoulder restricts metal from flowing out and applies forging pressure to consolidate the material right behind the moving pin (Mishra and Mahoney, 2007)

Tool designing is very important part of friction stir welding process because materials to be welded has different physical and chemical properties.

### 3. CONCLUSION

This study shows that there are many research paper are available which shows that joining of two dissimilar material can be made feasible by selecting appropriate parameters of friction stir welding.

### 4. SCOPE FOR FUTURE WORK

This study shows that joining of two dissimilar material can be made feasible by selecting proper parameters

Of FSW. So scope in this field is to design a friction stir welding setup and also a joint design for the joining of three dissimilar material in single pass using friction stir welding.

### 5. References

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