

Effect of welding variables on mechanical properties of low carbon steel welded joint

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ABSTRACT

This paper discussed the effect of welding variables on the mechanical properties of welded 10 mm thick low carbon steel plate, welded using the Shielded Metal Arc Welding (SMAW) method. Welding current, arc voltage, welding speed and electrode diameter were the investigated welding parameters. The welded samples were cut and machined to standard configurations for tensile, impact toughness, and hardness tests. The results showed that the selected welding parameters had significant effects on the mechanical properties of the welded samples. Increases in the arc voltage and welding current resulted in increased hardness and decrease in yield strength, tensile strength and impact toughness. Increasing the welding speed from 40-66.67 mm/min caused an increase in the hardness characteristic of the welded samples. Initial decrease in tensile and yield strengths were observed which thereafter increased as the welding speed increased. An electrode diameter of 2.5 mm provided the best combination of mechanical properties when compared to the as received samples. This behaviour was attributed to the fact that increased current and voltage meant increased heat input which could create room for defect formation, thus the observed reduced mechanical properties.

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1. Introduction

Steel is an important engineering material. It has found applications in many areas such as vehicle parts, truck bed floors, automobile doors, domestic appliances etc. It is capable of presenting economically a very wide range of mechanical and other properties.

Traditionally mechanical components has been joined through fasteners, rivet joints etc. In order to reduce time for manufacturing, weight reduction and improvement in mechanical properties, welding process is usually adopted. Today, a variety of different welding processes are available, such that welding is extensively used as a fabrication process for joining materials in a wide range of compositions, part shapes and sizes. Welding is an important joining process because of high joint efficiency, simple set up, flexibility and low fabrication costs [1]. Welding is an efficient, dependable and economical process.

Welded joints are finding applications in critical components where failures are catastrophe. Hence, inspection methods and adherence to acceptable standards are increasing. These acceptance standards represent the minimum weld quality which is based upon test of welded specimen containing some discontinuities. Welding involves a wide range of variables such as time, temperature, electrode, pulse frequency, power input and welding speed that influence the

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Table of Contents Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel

1. Understanding the eBook Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - The Rise of Digital Reading Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - Advantages of eBooks Over Traditional Books
2. Identifying Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - User-Friendly Interface
4. Exploring eBook Recommendations from Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - Personalized Recommendations
 - Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel User Reviews and Ratings
 - Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel and Bestseller Lists
5. Accessing Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel Free and Paid eBooks
 - Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel Public Domain eBooks
 - Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel eBook Subscription Services

- Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel Budget-Friendly Options
- 6. Navigating Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel eBook Formats
 - ePub, PDF, MOBI, and More
 - Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel Compatibility with Devices
 - Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - Highlighting and Note-Taking Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - Interactive Elements Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
- 8. Staying Engaged with Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
- 9. Balancing eBooks and Physical Books Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - Setting Reading Goals Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Effects Of Melting And Processing Variables On The Mechanical Properties Of Steel
 - Fact-Checking eBook Content of Effects Of Melting And Processing Variables On The Mechanical Properties Of

Steel

- Distinguishing Credible Sources

13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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