

EFFECT OF HEAT TREATMENT ON CORROSION BEHAVIOUR OF ALUMINIUM ALLOY 6061 BY FRICTION STIR WELDING

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CERTIFICATE

This is to certify that the work contained in this thesis titled “**EFFECT OF HEAT TREATMENT ON CORROSION BEHAVIOUR OF ALUMINIUM ALLOY 6061 BY FRICTION STIR WELDING**” has been carried out by **EJAJ HUSSAIN.G** under my supervision and has not been submitted elsewhere for a degree.

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ABSTRACT

Friction Stir Welding (FSW) is a solid state joining process that involves joining of metals without fusion or filler materials. FSW applications are shipbuilding, aerospace, railway, electrical, automobile industries etc. Hence samples are welded at four different speed such as 800rpm, 900rpm, 1000rpm & 1200rpm. Thus the purchased plates is fabricated in the dimensions of 100*50*6mm as per the fixture shape and plates are welded together by butt joint of FSW. Hence welded samples are subjected to Heat treatment for 3-4 hours at 200-250 °C.

Thus Corrosion behaviour study is carried out after welding. Hence welded samples are subjected to pitting corrosion due to welding at Nugget region and welded samples of Aluminium Alloy (AA) 6061 plate are subjected into corrosion study with a help of potentiodynamic polarization study. In this study, there are three (3) electrodes that should be integrated to undergo the testing. The electrodes which involved in electrochemical cell would be working electrode (WE), reference electrode (RE) and calomel electrode (CE). Electrochemical corrosion test by Tafel extrapolation method was carried out on all welded samples of base alloy weld region of AA6061 in sodium chloride solution of 3% NaCl to determine corrosion parameters, such as corrosion potential (E_{corr}) and corrosion current (I_{corr}). The corrosion rates of the material will depend on the corrosion current (I_{corr}).

Aluminium Alloy (AA) 6061 plate followed by Corrosion behaviour study is subjected to Microstructure examination. In order to examine the free defects from the surface of welding as well as to reveal the precipitation across the surface due to welding for all four samples and images are captured for precipitation as well as Micro-Hardness study Hence this microstructure study is examined with a help of Metallurgical microscope.

Finally Chemical composition of each welded samples are checked out in order to find out the nominal composition of most Aluminium percentage among all four samples. Chemical composition results gives the reason for corrosion rate influence for all welded samples. Chemical composition are checked with a help of Spectroscope machine.

TABLE OF CONTENTS

| CHAPTER NO. | TITLE | PAGE NO. |
|-------------|---|----------|
| | ABSTRACT | iv |
| | LIST OF FIGURES | ix |
| | LIST OF TABLES | xi |
| | NOMENCLATURE | xii |
| | ABBREVIATIONS | xiii |
| 1 | INTRODUCTION | 1 |
| | 1.1. HISTORY OF WELDING | 2 |
| | 1.2. CLASSIFICATION OF WELDING PROCESS | 3 |
| | 1.3. OBJECTIVES | 4 |
| | 1.4. PROBLEM IDENTIFICATION | 5 |
| | 1.5. SIGNIFICATION OF THE PROJECT | 5 |
| | 1.5.1. NEED FOR RESEARCH | 6 |
| | 1.5.1.1. COATING AND LINERS | 6 |
| | 1.5.1.2. CATHODIC PROTECTION | 6 |
| | 1.5.1.3. MATERIALS SELECTION | 6 |
| | 1.5.1.4. CORROSION INHIBITORS | 6 |
| 2 | LITERATURE REVIEW | 7 |
| | 2.1. CONCLUSION FROM LITERATURE | 9 |
| | 2.2. GAP ANALYSIS | 9 |
| 3 | METHODOLOGY | 10 |
| | 3.1. TASK WORK FLOW | 10 |
| | 3.2. MATERIAL SELECTION FOR WELDING & FSW | |
| | TOOL | 11 |
| | 3.2.1. COMPOSITION OF ALUMINIUM PLATE | 12 |
| | 3.2.2. SPECIFICATION OF AA6061 PLATE | 13 |

| | |
|---|----|
| 3.2.3. COMPOSITION OF TOOL | 13 |
| 3.2.4. TOOL PIN PROFILE | 14 |
| 3.2.5. SPECIFICATION OF TOOL | 14 |
| 3.3. THE IDEAS OF FRICTION STIR WELDING | 15 |
| 3.3.1. FRICTION STIR WELDING | 15 |
| 3.3.2. METALLURGICAL BENEFITS | 15 |
| 3.3.3. ADVANTAGES | 15 |
| 3.3.4. APPLICATIONS | 16 |
| 3.3.5. LIMITATION | 16 |
| 3.3.6. FRICTION STIR WELDING MICROSTRUCTURE ZONES | 16 |
| 3.4. FRICTION STIR WELDING MACHINE | 18 |
| 3.4.1. FSW SPECIFICATION | 19 |
| 3.4.2. FSW PROCESS PARAMETERS | 20 |
| 3.4.2.1. WELDING PARAMETERS | 20 |
| 3.4.2.2. TOOL PARAMETERS | 20 |
| 3.4.3. WELDED SAMPLES DIAGRAMS | 20 |
| 3.5. HEAT TREATMENT OF WELDED SAMPLES ON ALUMINIM ALLOY 6061 | 21 |
| 3.6. CORROSION MECHANISM | 22 |
| 3.6.1. PITTING CORROSION | 22 |
| 3.6.2. A CORROSION BEHAVIOR STUDY ON ALUMINUM ALLOY 6061 | 23 |
| 3.6.3. TAFEL POLARIZATION GRAPH | 23 |
| 3.6.4. CALCULATION OF CORROSION RATE FROM CORROSION CURRENT | 25 |
| 3.6.5. WELDED PIECES FOR CORROSION TEST & MICROSTRUCTURE | 26 |
| 3.7. SAMPLE PREPARATION FOR CORRSOION TEST | 27 |
| 3.7.1. ELECTROCHEMICAL CELL | 27 |
| 3.7.2. CORRODED WELDPICES | 28 |

| | |
|--|-----------|
| 3.8. AN EXAMINATION OF MICROSTRUCTURE | |
| ON ALUMINIUM ALLOY 6061 | 29 |
| 3.8.1. METALLURGICAL MICROSCOPE | 29 |
| 3.8.2. WORKING PRINCIPLE | 29 |
| 3.9. SAMPLE PREPARATION FOR MICROSTRUCTURE | |
| SCANNING | 30 |
| 3.9.1. SPECIMEN SIZING | 30 |
| 3.9.2. MOUNTING | 30 |
| 3.9.3. GRINDING & POLISHING | 30 |
| 3.9.4. ETCHING | 31 |
| 3.10. CHEMICAL COMPOSITION ON ALUMINUM | |
| ALLOY 6061 | 32 |
| 4 | |
| RESULTS AND DISCUSSION | 33 |
| 4.1. A CORROSION BEHAVIOR STUDY ON | |
| ALUMINUM ALLOY 6061 | 33 |
| 4.2. GRAPH FOR 800 RPM | 33 |
| 4.2.1. CYCLIC SWEEP GRAPH | 33 |
| 4.2.1. TAFEL POLARIZATION GRAPH | 33 |
| 4.2.3. RESULTS FROM GRAPH | 34 |
| 4.3. GRAPH FOR 900RPM | 35 |
| 4.3.1. CYCLIC SWEEP GRAPH | 35 |
| 4.3.2. TAFEL POLARIZATION GRAPH | 35 |
| 4.3.3. RESULTS FROM GRAPH | 36 |
| 4.4. GRAPH FOR 1000 RPM | 37 |
| 4.4.1. CYCLIC SWEEP GRAPH | 37 |
| 4.4.2. TAFEL POLARIZATION GRAPH | 37 |
| 4.4.3. RESULTS FROM GRAPH | 38 |
| 4.5. GRAPH FOR 1200 RPM | 39 |
| 4.5.1. CYCLIC SWEEP GRAPH | 39 |

| | |
|---|-----------|
| 4.5.2. TAFEL POLARIZATION GRAPH | 39 |
| 4.5.3. RESULTS FROM GRAPH | 40 |
| 4.6. COMBINED GRAPH FROM DIFFERENT SPEED | 41 |
| 4.6.1. CYCLIC SWEEP GRAPH | 41 |
| 4.6.2. COMBINED RESULTS FROM DIFFERENT SPEED | 42 |
| 4.7. AN EXAMINATION OF MICROSTRUCTURE ON ALUMINUM ALLOY 6061 | 43 |
| 4.7.1. MICROSTRUCTURE OF WELDED SPEED SAMPLES | 43 |
| 4.7.2. MICRO HARDNESS TEST | 44 |
| 4.8. CHECKING OF CHEMICAL COMPOSITION ON ALUMINUM ALLOY 6061 | 45 |
| 4.8.1. CHEMICAL COMPOSITION OF 800RPM | 45 |
| 4.8.2. CHEMICAL COMPOSITION OF 900RPM | 46 |
| 4.8.3. CHEMICAL COMPOSITION OF 1000RPM | 47 |
| 4.8.4. CHEMICAL COMPOSITION OF 1200RPM | 48 |
| 5 CONCLUSION AND FUTURE ENHANCEMENTS | 49 |
| 5.1. CONCLUSION | 49 |
| 5.2. FUTURE ENHANCEMENTS | 49 |
| REFERENCE | 50 |

LIST OF FIGURES

| FIGURE NO. | TITLE | PAGE NO. |
|-------------------|--|-----------------|
| 3.1.1. | TASK WORKFLOW OF THE PROCESS | 10 |
| 3.2.1. | IMAGE OF AA 6061 PLATE | 11 |
| 3.2.1.1. | IMAGE OF AA 6061 PLATE COMPOSITION | 12 |
| 3.2.4.1. | PRO-E DIAGRAM OF FSW TOOL | 14 |
| | | 17 |
| 3.4.1. | IMAGE OF FRICTION STIR WELDING MACHINE | 16 |
| 3.4.3.1. | IMAGE OF WELDED SAMPLES OF DIFFERENT SPEED | 16 |
| 3.4.6.1. | CROSS SECTIONAL AREA OF MATERIAL | 17 |
| 3.5.1. | IMAGE OF ELECTRIC FURNACE | 21 |
| 3.6.1.1. | GENERALIZED ILLUSTRATION OF PITTING CORROSION ON ALUMINIUM ALLOYS | 23 |
| 3.6.3.1. | CORROSION RATE DETERMINATION | 23 |
| 3.6.3.2. | MODEL TAFEL POLARIZATION GRAPH | 25 |
| 3.6.5.1. | IMAGE OF WELDED PIECES FOR CORROSION TEST & MICROSTRUCTURE | 26 |
| 3.7.1.1. | IMAGE OF AN ELECTROCHEMICAL CORROSION SETUP | 27 |
| 3.7.2.1. | IMAGES OF CORRODED PIECES | 28 |
| 3.8.2.1. | IMAGE OF METALLURGICAL MICROSCOPE | 29 |
| 3.9.3.1. | IMAGE OF POLISHING MACHINE | 30 |
| 3.9.4.1. | IMAGE OF MOUNTED PIECE SAMPLES FOR MICROSTRUCTURE | 31 |
| 3.10.1. | IMAGE OF SPECTRA MAX MACHINE | 32 |
| 4.2.1.1. | CYCLIC SWEEP GRAPH (800 RPM) | 33 |
| 4.2.2.1. | TAFEL POLARIZATION GRAPH (800 RPM) | 33 |
| 4.3.1.1. | CYCLIC SWEEP GRAPH (900 PRM) | 35 |

| | | |
|----------|---|----|
| 4.3.2.1. | TAFEL POLARIZATION GRAPH (900 RPM) | 35 |
| 4.4.1.1. | CYCLIC SWEEP GRAPH (1000 RPM) | 37 |
| 4.4.2.1. | TAFEL POLARIZATION GRAPH (1000 RPM) | 37 |
| 4.5.1.1. | CYCLIC SWEEP GRAPH (1200 RPM) | 39 |
| 4.5.2.1. | TAFEL POLARIZATION GRAPH (1200 RPM) | 39 |
| 4.6.1.1. | CYCLIC SWEEP GRAPH FOR DIFFERENT SPEED | 41 |
| 4.6.2.1. | GRAPH FOR CORROSION RATE AT DIFFERENT SPEED | 42 |
| 4.7.1.1. | IMAGES OF DIFFERENT SPEED SAMPLES | 43 |
| 4.7.2.1. | GRAPH OF VICKERS HARDNESS AT DIFFERENT SPEED | 44 |
| 4.8.1.1. | CHEMICAL COMPOSITION OF 800RPM | 45 |
| 4.8.2.1. | CHEMICAL COMPOSITION OF 900RPM | 46 |
| 4.8.3.1. | CHEMICAL COMPOSITION OF 1000RPM | 47 |
| 4.8.4.1. | CHEMICAL COMPOSITION OF 1200RPM | 48 |

LIST OF TABLES

| TABLE NO. | TITLE | PAGE NO. |
|------------------|---|-----------------|
| 3.2.1.1. | NOMINAL COMPOSITION OF AA 6061 | 13 |
| 3.2.2. | SPECIFICATION OF AA6061 PLATE | 13 |
| 3.2.3.1. | CHEMICAL COMPOSITION OF HCHCr STEEL TOOL | 13 |
| 3.2.5.1. | SPECIFICATION OF HCHCr STEEL TOOL | 14 |
| 3.4.2.1.1. | WELDING PARAMETERS | 20 |
| 3.7.1.1. | TYPES OF ELECTRODE USED IN CORROSION TESTS | 28 |
| 4.6.2.1. | VALUES OF VARIOUS PARAMETERS FOR DIFFERENT SPEED | 42 |

NOMENCLATURE

| | | |
|-------------------|---|--|
| E | - | Potential in Volt (V) |
| i | - | Current in Ampere (A) |
| R | - | Resistance in Ohm (Ω) |
| Q | - | Charge passed (coulombs) |
| N | - | Number of electrons involved in the electrochemical reaction |
| W | - | Weight of electroactive species (gr) |
| M | - | Molecular weight (gr) |
| C.R. (mpy) | - | Corrosion rate in milli-inches per year (mpy) |
| I_{corr} | - | Corrosion current density ($\mu\text{A}/\text{cm}^2$) |
| E.W | - | Equivalent weight of the corroding species (g) |
| D | - | Density of the corroding species (g/cm^3) |
| E_{stat} | - | Starting potential in Volt (V) |
| E_{end} | - | Final/End potential in Volt (V) |
| E_{corr} | - | Pitting potential in Volt (V) |
| I_{corr} | - | Pitting Current in (A/cm^2) |
| R_p | - | Linear Polarization Resistance in (Ohm) |
| b_a | - | Anodic Voltage in (V/dec) |
| b_c | - | Cathodic Voltage in (V/dec) |
| C. R | - | Corrosion Rate in (mm/y) |

ABBREVIATIONS

| | | |
|------------------|---|---------------------------------|
| FSW | - | FRICITION STIR WELDING |
| HT | - | HEAT TREATMENT |
| SEM | - | SCANNING ELECTRON MICROSCOPE |
| MM | - | METALLURGICAL MICROSCOPE |
| CP | - | CATHODIC PROTECTION |
| AA | - | ALUMINIUM ALLOY |
| HCHCr | - | HIGH CARBON HIGH CHROMIUM |
| GTAW | - | GAS TUNGSTEN ARC WELDING |
| GMAW | - | GAS METAL ARC WELDING |
| MIG | - | METAL INERT GAS |
| HAZ | - | HEAT AFFECTED ZONE |
| TMAZ | - | THERMO MECHANICAL AFFECTED ZONE |
| BM | - | BASE METAL |
| EDS | - | ELECTRO DISPERSIVE SPECTROSCOPY |
| OCV | - | OPEN CIRCUIT POTENTIAL |
| WE | - | WORKING ELECTRODE |
| RE | - | REFERENCE ELECTRODE |
| CE | - | CALOMEL ELECTRODE |
| RPM | - | REVOLUTION PER MINUTE |
| HCl | - | HYDROCHLORIC ACID |
| NaCl | - | SODIUM CHLORIDE |
| HNO ₃ | - | NITRIC ACID |
| HF | - | HYDROFLUORIC ACID |

VH - VICKERS HARDNESS