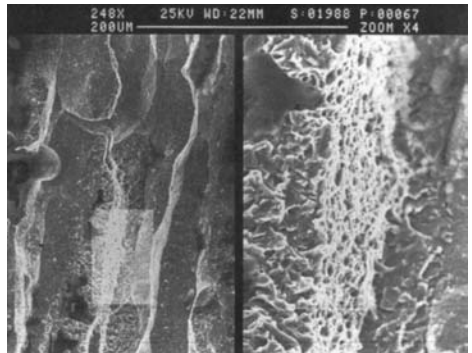
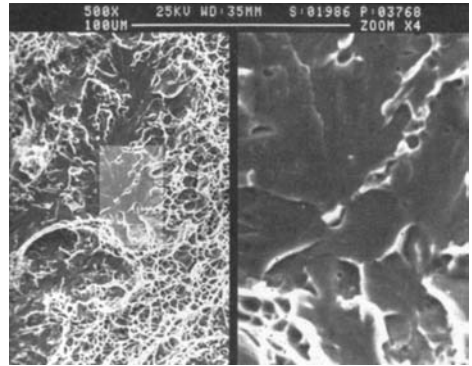
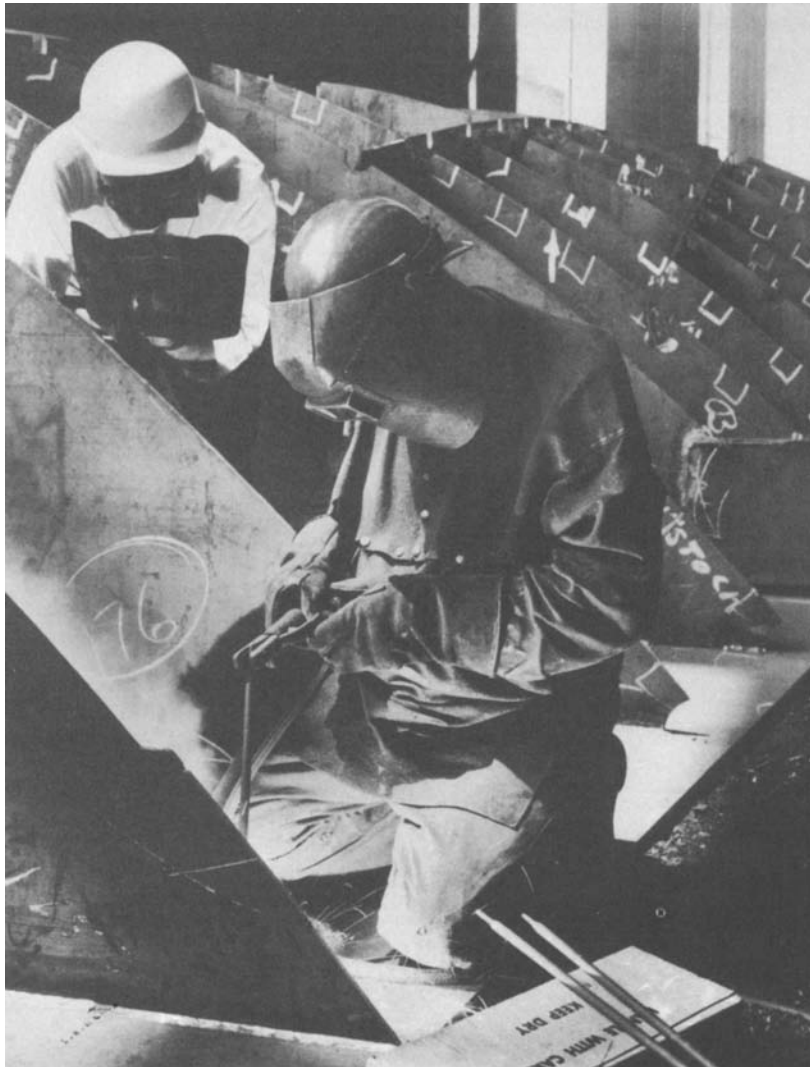




Guide to Weldability



Carbon and Low Alloy Steels

GUIDE TO WELDABILITY: CARBON and LOW ALLOY STEELS

How to get the needed results and stay out of trouble

Written by
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INTRODUCTION

You are responsible for the operation of an independent fabrication shop, a similar facility within a manufacturing organization, or a maintenance facility in a factory of any type. "Things" are brought to you to fabricate or repair. This guide is intended to help you ask the right questions, and from the answers, select the method, materials, and procedures that will produce the result desired from your "customer," or direct you to more comprehensive guidance that may be needed to produce the desired results.

ACKNOWLEDGMENTS

Most of the information in this reference guide is condensed from information in the current edition of *The Welding Handbook* and *Welding Metallurgy*, Linnert Volume 1, both published by The American Welding Society. Additional sources include AWS D1.1/D1.1M:2004, *Structural Welding Code—Steel*, Jefferson's *Welding Encyclopedia*, 18th Edition, The Lincoln Electric Company *Procedure Handbook of Arc Welding*, and the *ASM Handbook, Volume VI*.

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TABLE OF CONTENTS

	Page No.
CHAPTER 1—The Questions (you need to ask)	1
What is the product and how will it be used?	1
What is the material?	1
What specifications or codes apply to the welding rods or electrodes (wires), and to the finished product, if any?	1
Are there welding procedure requirements? Make sure you understand what is required!	1
What are the postweld requirements?	1
CHAPTER 2—Key Background Information	3
What is Steel?	3
Why is Steel a Unique Structural Material?	3
Common Steels You May Encounter	6
What if no information or identification is available?	6
Properties of Steel—What the “Numbers” Mean	6
Some Additional Important Terms	6
Alloying Elements in Steels	11
Weldability—What is it?	14
CHAPTER 3—What Happens When You Weld	19
Where Does the Welding Heat Go?	19
The Weld Zones	19
Shrinkage, Residual Stresses, and Distortion	20
Restraint, Preheat and Interpass Temperatures, and Hydrogen Control	21
Other Effects of Welding	22
CHAPTER 4—Selection of Proper Welding Filler Metal (Rods, Electrodes, etc.)	29
CHAPTER 5—Metallurgically-Related Weld Discontinuities (Defects) and Typical Causes	31
Cracking	31
Porosity	31
Inclusions	34
CHAPTER 6—Weld Examination and Testing	35
The Weld Cross Section	35
Mechanical Tests—What They Can Tell You	35
CHAPTER 7—Postweld Treatments	39
CHAPTER 8—Good Practice Reminders	41
A Basic Welding Procedure Worksheet	41
A Qualified Procedure Should be Used by a Qualified Welder	41
CHAPTER 9—Additional Information and Guidance	43
APPENDIX 1—Alternative Methods for Determining Preheat (and Preventing Cracking)	45
APPENDIX 2—Additional Filler Metal Recommendations	51

LIST OF TABLES

Table	Page No.
2.1	Composition and Strength Requirements of Typical ASTM Carbon Steels.....7
2.2	Typical SAE–AISI Compositions8
2.3	ASTM Specifications for High-Strength Low-Alloy Structural Steels9
2.4	ASTM Specifications for High-Strength Low-Alloy Steels for Pressure-Vessel Plate10
2.5	Composition of Selected Heat-Treatable Low-Alloy (HTLA) Steel.....11
2.6	Properties for Steel and/or Welds.....12
2.7	Effects of Common Alloying Elements at Levels Used in Carbon and Low-Alloy Steels12
2.8	Carbon Equivalent of Some Steels from Tables 2.1–2.5.....17
3.1	Prequalified Minimum Preheat and Interpass Temperature23
3.2	Minimum Preheat and Interpass Temperature for Three Levels of Restraint26
4.1	Recommended Base Metal–Filler Metal Combinations for Matching Electrode Tensile Strengths Nominally of 70 ksi (483 MPa) Minimum.....30
5.1	Common Causes and Potential Solutions to Cracking.....33
5.2	Common Causes of and Remedies for Porosity33
A2.1	Recommended Base Metal–Filler Metal Combinations for Matching Electrode Tensile Strengths Nominally of 80–90 ksi (552–620 MPa) Minimum.....51
A2.2	Recommended Base Metal–Filler Metal Combinations for Steels with Tensile Strengths Nominally of 100 ksi (689 MPa) Minimum52
A2.3	Suggested Welding Filler Metals for Exposed Applications of ASTM A 242 and A 588 Steels53

LIST OF FIGURES

Figure	Page No.
2.1	Structural changes in low carbon steel weld metal on cooling from liquid4
2.2	Pattern of dendritic growth from a crystal during solidification.....4
2.3	Grain size and shape in solidified metal are determined by the manner in which the branches of dendrites meet5
2.4	Weld cross section showing grains.....5
2.5	Schematic illustration of (A) Substitutional and (B) Interstitial solid solutions5
2.7	Typical tensile specimens: (A) Rectangular and (B) Round.....13
2.8	Typical tensile test specimen before and after testing to failure, showing maximum elongation13
2.9	Stress/strain diagram for complete history of a metal tension test specimen from the start of loading and carried to the breaking point14
2.10	Charpy V-notch impact specimen15
3.1	Schematic showing the different discrete regions present in a single-pass weld.....19
3.2	Effect of weld geometry and relative plate thickness on heat flow characteristics.....20
3.3	Multi-pass weld in C-Mn steel plate 1-1/2 in. (40 mm) thick showing positions of individual weld beads and their heat-affected zones lying both in weld metal and in base metal.....20
3.4	Longitudinal shrinkage in a butt joint (distribution of longitudinal residual stress, s_x , is also shown).....21
3.5	Types of distortion22
5.1	Crack types of weld related cracking32
6.1	Specimen and test orientation of the guided bend test36
6.2	Schematic illustration of typical guided bend test fixtures.....36
6.3	Typical tension test specimens for the evaluation of welded joints37
8.1	Basic Welding Procedure Worksheet42

CHAPTER 1

The Questions (you need to ask)

What is the product and how will it be used?

In other words, what does the product do? Is the weld a simple connection that bears a light static (non-fluctuating) load, or are the welds subject to highly fluctuating loads so that a small defect could grow into a crack and cause a catastrophic failure? Will it be subjected to low temperatures, e.g., winters in the north where temperatures well below 0°F can be encountered? (Some steels become brittle at such temperatures.)

What is the material?

Find out what specification is used to purchase the steel. Some of the more common types of steel are discussed in Chapter 2. If there is no specification, ask if the material is "plain carbon steel" or "mild steel," or (at the other extreme) "tool steel." In most cases, the former materials are relatively easy to weld and somewhat "forgiving." The latter materials require extreme care if they are to be welded satisfactorily.

There are some simple tests to help determine the general class of material that you have, but there is no substitute for the actual composition or the purchasing specification.

What specifications or codes apply to the welding rods or electrodes (wires), and to the finished product, if any?

Most general fabrication is covered by agreement between the customer and the fabricator, with applicable specifications on drawings and related notes. However, you need to know if the work is covered by a code or specification that has legal standing and/or requires approval of a third party, which may require qualification of procedures, operators, materials, or other factors. Examples are the AWS D1.1/D1.1M:2004, *Structural Welding Code*—

Steel, the American Society of Mechanical Engineers (ASME) *Pressure Vessel Code*, various U.S. Military Standards, and others. If you see reference to such codes and standards on drawings, notes, or specifications, you and your customer need to reach an agreement on how these requirements will be handled. Certification, qualification, or conformance to such "third party" requirements is covered in detail by each code, and is outside the scope of this guide.

Are there welding procedure requirements? Make sure you understand what is required!

Your customer may require the use of:

- a specific welding process,
- a specific welding material (type and perhaps even the brand or manufacturer),
- a specific range of welding conditions,
- "qualified" welding operators (qualified by whom and to what standard?),
- a written welding procedure subject to the customer's approval.

NOTE: Even if your customer does not require a formal procedure, you should consider preparing one. Then, test your operators to ensure that they can produce satisfactory welds using the procedure. A sample form for preparing an internal record or "control document" is included in Part 8 of this guide. Such a record has many benefits, especially if the job is to be repeated. The control document can be particularly useful if there are problems with the finished product on inspection or in service.

What are the postweld requirements?

Postweld requirements are as follows:

- Specific inspection and/or testing of the finished product,
- A specific post-weld heat treatment, e.g., stress relief,
- Painting, plating, or other surface treatment.