

#### Example4

A fillet weld is used to join 2 medium carbon steel plates each having a thickness of 5.0 mm. The plates are joined at a 90° angle using an inside fillet corner joint.  $T_m = 1700^\circ\text{K}$ , The velocity of the welding head is 6 mm/sec. Assume the cross section of the weld bead approximates a right isosceles triangle with a leg length of 4.5 mm, the heat transfer factor is 0.80, and the melting factor is 0.58. Determine the rate of heat generation required at the welding source to accomplish the weld.

**Sol:**

$$A_w = bh/2 = 4.5(4.5)/2 = 10.125 \text{ mm}^2$$

$$U_m = 3.33 \times 10^{-6} (1700)^2 = 9.62 \text{ J/mm}^3$$

$$R_H = U_m A_w v / (f_1 f_2) = 9.62(10.125)(6.0) / (0.8 \times 0.58) = 1260 \text{ J/sec} = 1260 \text{ W.}$$

# Lecture Notes Physical Principles In Welding Engineering

**JE Gale**



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