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RETRACTED: Analysis of Friction Stir Welding Tool Offset on the Bonding and Properties of Al–Mg–Si Alloy T-Joints

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Abstract: Research on T-configuration aluminum constructions effectively decreases fuel consumption, increases strength, and develops aerial structures. In this research, the effects of friction stir welding (FSW) tool offset (TO) on Al–Mg–Si alloy mixing and bonding in T-configurations is studied. The process is simulated by the computational fluid dynamic (CFD) technique to better understand the material mixing flow and the bonding between the skin and flange during FSW. According to the results, the best material flow can be only achieved at an appropriate TO. The appropriate TO generates enough material to fill the joint line and results in formation of the highest participation of the flange in the stir zone (SZ) area. The results show that, in the T-configuration, FSW joints provide raw materials from the retreating side (RS) of the flange that play a primary role in producing a sound mixing flow. The selected parameters were related to the geometric limitations of the raw sheets considered in this study. The failure point of all tensile samples was located on the flange. Surface tunneling is the primary defect in these joints, which is produced at high TOs. Among the analyzed cases, the most robust joint was made at +0.2 mm TO on the advancing side (AS), resulting in more than 60% strength of the base aluminum alloy being retained.

Keywords: friction stir welding tool offset; Al–Mg–Si alloy; T-joint; process modelling

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1. Introduction

In the transportation sector, weight reduction has become one of the most important goals for manufacturers, who seek to reduce structural engineering weight in order to optimize fuel usage [1–3]. Among various metallic materials, aluminum and its alloys significantly decrease the weight of engineering components and improve the structure's strength [4–6]. Al–Mg–Si aluminum alloys are suitable materials in lightweight frames due to their many benefits, such as good strength-to-weight ratio, corrosion resistance, and weldability [7–11]. T-joints have generally been constructed through the welding of two structural components, a horizontal sheet (skin) and a vertical sheet (stringer or flange) [12–17]. High-efficiency solid-state welding technologies like friction stir welding (FSW) have improved the mechanical and metallurgical properties of welded T-joints. The FSW process is also suitable for welding different types of materials and other geometries. It enables the retention of up to 90% of the mechanical properties of metallic materials like aluminum alloys after welding. Researchers have focused on FSW of regular butt joint configurations in the literature, while alternative joint designs like T-configurations and corner fillets have scarcely been considered [18–21].

FSW may be considered as a potential joining process to produce T-joints with high strength–weight ratios. In the available literature about FSW of T-joints, the most critical factor during the joining process is maximum mixing of skin and flange without any defect formation [22]. Kissing bond defects (KBs) and material explosion from joint line

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surface are significantly visible defects and directly affect the FSWed T-joints' strength. By minimizing these defects, the FSW process can retain 90% of the base metal strength after joint production [23,24].

In the FSW process many parameters can deteriorate or improve the weld's final strength, such as tool shoulder and tool pin profile, rotational speed and welding velocity, tool tilt angle and tool offset (TO) [25–27]. The purpose of using TO is to improve the joint strength by creating vibrations at the tool location during the welding process. It is well known that the maximum stress in the stringer panel is much higher than that in the skin plates, which are subject to bending loads [28]. Some studies showed that FSW could obtain a sound T-joint structure, from a manufacturing point of view, by increasing the welding speed ratio [29–31]. Both macro and microscale tests have shown that increasing the ratio of FSW tool rotational velocity to traverse velocity will produce a high-quality T-joint with fewer defects [32]. In comparison with the other joint configurations , researchers have found that FSW of T-joints has higher sensitivity to process parameters, such as FSW tool offset [14,33].

The previous studies mainly considered aspects related to heat input optimization, while ignoring the importance of TO effects on T-joint structural performance [34]. Eliminating defects due to TO, in order to control the mechanical properties and microstructural evolution of T-joints is critical [35–37]. A few simulation resources are available that deal with the understanding of temperature evaluation, strain rate, and void prediction during the FSW of T-joint configuration [38]. In fact, simulation or numerical methods such as the computational fluid dynamic (CFD) method have been applied as an effective alternative way to analyze heat generation, the flow of material, temperature distribution, and strain rates involved during the FSW process [39]. Up to now, most studies concerning the FSW of T-joints have been focused on the experimental regulation of the FSW tool rotational and traverse velocities. At the same time, there are limited numerical studies that consider the simulation of FSW of T-joints. The current study aims to carry out a 3D numerical study to investigate the effects of TO on the temperature, strain rate and material flow of an Al–Mg–Si lap T-joint configuration. Furthermore, a set of experiments was proposed and performed to validate the simulation.

2. Experimental Procedure

AA6068 aluminum alloy sheets of 4 mm thickness were cut to an appropriate size and friction stir welded by a modified milling machine (Tabriz TZ14/5). The mechanical properties and chemical composition of the aluminum alloy base material are presented in Tables 1 and 2. In the experimental process design, an aluminum plate is located at the top as skin, and another is placed in the middle of the skin as a flange. The fixtures used for positioning base metals during the welding process were made of steel. The base metals were fixed in place to ensure there was no movement during welding. Figure 1a shows a view of the sheet placement in the fixture. For conducting the experiments, a single factor experimental design was used, which means that one factor is varied through the levels while the other factors are kept constant in order to find the effect of a given parameter. For a better understanding of the effects of TO on the T-joint, the other process parameters were kept constant. Due to the sensitivity of TO, the amount of TO has been considered for both, advancing (AS) and retreating (RS) sides. A tungsten-carbide tool with a frustum pin profile was used for the welding procedure. The tool shoulder diameter, upper pin diameter, lower pin diameter, and pin length were 18 mm, 6 mm, 3 mm, and 4.5 mm, respectively. The tool size was selected according to the geometrical limitations of the raw materials and the joint configuration. Two K-type thermocouples (TC1 and TC2) were placed in the FSW tool to better analyze thermal changes in the stir zone. The placement of thermocouples in the FSW tool is depicted in Figure 1b. A total of six 0.8 mm K-type thermocouples (Omega engineering, Nork, CT, USA) were placed on the skin, and two thermocouples were used on the flange (Figure 1c) for monitoring the thermal history

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during welding. All thermocouples on the surface of both skin and flange are labeled "NT" in Figure 1c.

Table 1. Mechanical Properties of AA6068 aluminum alloy.

Parameter	Density	Melting Point	Thermal Conductivity	Ultimate Tensile Strength	Shear Strength	Yield Strength	Vickers Hardness
Units	kg/m^3	°C	W/m·k	MPa	MPa	MPa	HB
Value	2700	555	180	300	460	200	91

Table 2. Chemical composition of AA6068 aluminum alloy.

Element	Cu	Mg	Mn	Si	Fe	Cr	Zn	Al
wt.%	0.1	1.2	1	1.3	0.5	0.25	0.2	95.4

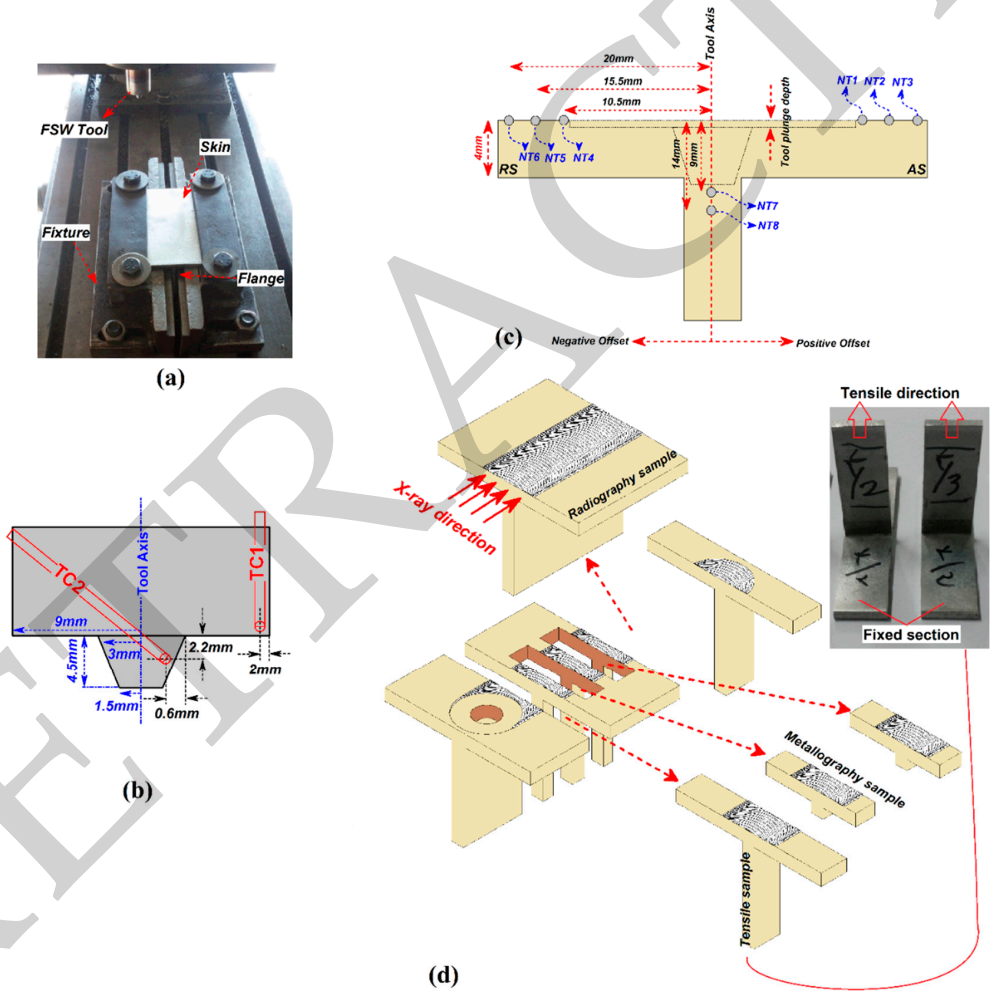


Figure 1. (**a**) Fixture of FSW. Schematic view of thermocouple placement in (**b**) FSW tool and (**c**) inside of workpieces. (**d**) Mechanical test samples.

Table 3 shows the process parameters used in the experimental procedure. Due to novelty in the joint configuration and the base metal used (AA6068 aluminum alloy), there is little in the literature about finding process parameters. Initial process parameters for the process were selected according to the Aghajani Derazkola et al. [40] and Guan et. al. [41]. After several trial-and-error tests, the tool rotational speed, welding speed, tool tilt angle,

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and tool plunge depth were selected, as well as the optimized values of the parameters reported in Table 3. The range of TO was selected according to the geometric limitations. In this study, a TO higher than +0.4 and −0.4 mm was not possible, because the FSW tool was located out of flange area. The metallographic investigation was done by optical microscopy (OM) (Olympus, Okaya, Japan), and scanning electron microscopy (SEM) (TESCAN, Brno, Czech Republic) was implemented for the fracture study. For a better understanding of void formation, non-destructive radiography tests were carried out. Three specimens were cut from each joint according to ASTM E8-M03 standard with a wire cutting machine to evaluate the mechanical properties. For each welding condition, the test was repeated three times and the average value of the tests was reported. In the tensile test, the skin was fixed in grips and the tensile direction was on the flange side. The direction of ray and mechanical test details are shown in Figure 1d. A micro-hardness test was performed to evaluate hardness changes along the joint line. For the investigation of the tensile properties of the aluminum alloy, a uniaxial tension test from 25 °C up to 500 °C was performed according to the ASTM E21 Standard (Figure 2a). Thermal conductivity and specific heat of AA6068 aluminum alloy were measured according to the ASTM E1461 (Figure 2b,c).

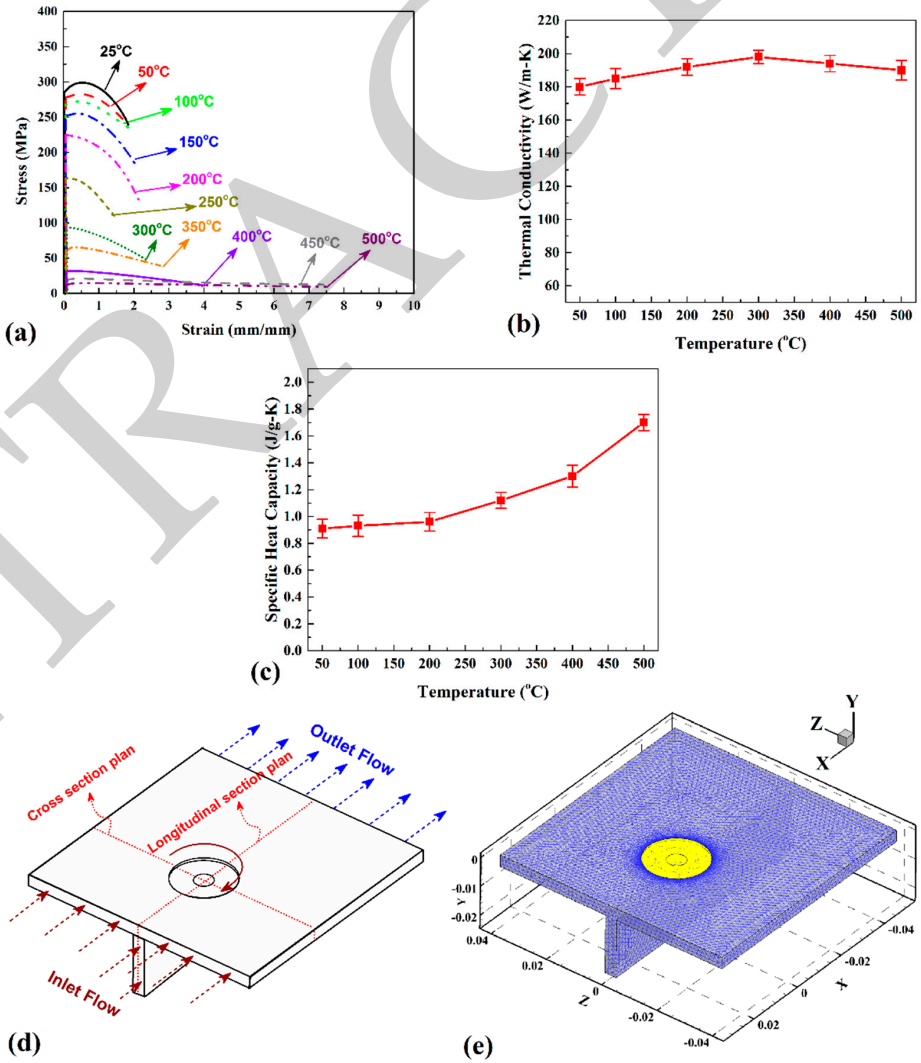


Figure 2. (**a**) Stress–strain graph of AA6068 aluminum alloy at various temperatures. (**b**) Thermal conductivity and (**c**) specific heat of AA6068 aluminum alloy at various temperatures. (**d**) Simulation domain and (**e**) meshed domain.

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Table 3. FSW process parameters.

Parameter	Tool Rotation Speed	Welding Speed	Tool Tilt Angle	Tool Plunge Depth	Tool Offset
Sample Number/Units	rpm	mm/min	Degree	mm	mm
1	1400	40	2	0.2	+0.4
2	1400	40	2	0.2	+0.2
3	1400	40	2	0.2	0
4	1400	40	2	0.2	−0.2
5	1400	40	2	0.2	−0.4

3. Process Modelling

The computational domain in this study includes the workpieces and the tool inserted inside the workpieces. The dimensions of the plates and the tool were selected according to the actual situation (experimental procedure). The FSW tool plunging and exit phases were neglected in this simulation, and the temperature and velocity fields were solved assuming steady-state behavior. During the simulation, three-dimensional plastic flow is represented by the momentum, energy, and plastic flow conservation. The momentum conservation equation in index notation, with i or j = 1, 2, and 3, which correspond to the x, y, and z directions, is given below [42–44]:

$$\rho\left(u_i u_j\right)_{,i} = -P_{,j} + \mu\left(u_{i,ij} + u_{j,ii}\right) - \rho U_1 u_{j,1} \tag{1}$$

In Equation (1), μ is the non-Newtonian viscosity that can be determined from the flow stress and effective strain rate as follows [45–51]:

$$\mu = \frac{\sigma_e}{3\dot{\varepsilon}} \tag{2}$$

The calculation of viscosity requires the local values of strain rate and temperature. In Equation (2), σ_e indicates the flow stress that can be defined as [52,53]:

$$\sigma_e = \frac{1}{\alpha} arcsinh\left(\frac{Z}{A}\right)^{\frac{1}{n}} \tag{3}$$

A, α, and n are material constants and Z is the Zener–Hollomon parameter. The Zener–Hollomon parameter (Z), represents the temperature compensated effective strain rate and is given by [54,55]:

$$Z = \dot{\varepsilon} exp^{\left(\frac{Q}{RT}\right)} \tag{4}$$

Q = 158.3 kJ/mol is the activation energy, R is the universal gas constant, $\dot{\varepsilon}$ is the effective strain rate, which is given by [55]:

$$\dot{\varepsilon} = \left(\frac{2}{3}\varepsilon_{ij}\varepsilon_{ij}\right)^{\frac{1}{2}} \tag{5}$$

where ε_{ij} is the strain rate tensor, defined as [56]:

$$\varepsilon_{ij} = \frac{1}{2}\left(\frac{\partial u_i}{\partial x_j} + \frac{\partial u_j}{\partial x_i}\right) \tag{6}$$

Due to the changes in the metal properties with temperature, the definition of a relationship between mechanical and thermal properties during FSW in the simulation procedure seems necessary. On this basis, in order to increase the accuracy of the simulations,

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the AA6068 aluminum alloy C_P (specific heat) and K (thermal conductivity) parameters are used according to the experimental tests (Figure 2b,c) and for the tungsten tool [57–59]:

$$C_p = 468.3 - 8.5T + 3.0 \times 10^{-4}T^2 + 1.8 \times 10^{-7}T^3 \quad (7)$$

$$K = 3.8 + 0.092T - 1.8 \times 10^{-4}T^2 + 7.8 \times 10^{-8}T^3 \quad (8)$$

The pressure field is obtained by solving the following continuity equation iteratively with the momentum equations for incompressible single-phase flow [14,60]:

$$\frac{\partial u_i}{\partial x_i} = 0 \quad (9)$$

where v_i is the plastic flow velocity. The steady state single phase momentum conservation equations attached to the heat source may be defined as [17]:

$$\rho C_p \frac{\partial (u_i T)}{\partial x_1} = -\rho C_p U_1 \frac{\partial T}{\partial x_1} + \frac{\partial}{\partial x_i}\left(k \frac{\partial T}{\partial x_i}\right) + Q_i + Q_b \quad (10)$$

The heat generation at the interface of the tool pin surfaces and the workpiece are calculated according to [61]:

$$Q_i = \left[(1-\delta)\eta\tau + \delta\mu_f P_N\right](\omega r - U_1 \sin\theta) \quad (11)$$

where θ is the angle with the x-axis, η is the mechanical efficiency, δ denotes the spatially variable fractional slip between the tool and the workpiece interface. In Equation (10), Q_b has been calculated as [62]:

$$Q_b = \frac{d\dot{\varepsilon}_p}{dV} = \beta\mu\lambda \quad (12)$$

in which λ is given by [62]:

$$\lambda = 2\sum_{i=1}^{3}\left(\frac{\partial u_i}{\partial x_i}\right)^2 + \left(\frac{\partial u_1}{\partial x_2} + \frac{\partial u_2}{\partial x_1}\right)^2 + \left(\frac{\partial u_1}{\partial x_3} + \frac{\partial u_3}{\partial x_1}\right)^2 + \left(\frac{\partial u_3}{\partial x_2} + \frac{\partial u_2}{\partial x_3}\right)^2 \quad (13)$$

In Equation (12), β is an arbitrary constant that indicates the extent of mixing on the atomic scale. The total heat generated at the shoulder/workpiece interface has been partitioned between the work piece and the tool according to the ratio given below [56]:

$$q = \frac{\left(\sqrt{k\rho C_p}\right)_{workpiece}}{\left(\sqrt{k\rho C_p}\right)_{tool} + \left(\sqrt{k\rho C_p}\right)_{workpiece}} \quad (14)$$

A heat flux continuity at the shoulder matrix interface yields [55]:

$$k\frac{\partial T}{\partial Z}\bigg|_{Top} = \frac{J_{workpiece}}{J_{workpiece} + J_{Tool}} q \quad (15)$$

where q represents the total rate of heat generation at the shoulder–workpiece interface. It is given by [54]:

$$q_1 = [\eta(1-\delta)\tau + \delta\mu_F P_H](\omega r - U_1 \sin\theta) \quad (16)$$

The value of heat transfer at the bottom of the workpiece was determined by [55]:

$$k\frac{\partial T}{\partial Z}\bigg|_{Bottom} = h_b(T - T_a) \quad (17)$$

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where h_b is the bottom heat transfer coefficient and T_a is the ambient temperature, which is defined as 298 K in this study. The heat transfer coefficient at the bottom face depends on the local temperature and is given by the following relation [55]:

$$h_b = h_{b0}(T - T_a)^{0.25} \tag{18}$$

where h_{b0} is the heat transfer parameter for the bottom surface. On the upper surface, the heat transfer is due to both convection and radiation and is given by [55]:

$$-k\left.\frac{\partial T}{\partial Z}\right|_{Top} = \mathrm{B}\epsilon\left(T^4 - T_a^4\right) + h_t(T - T_a) \tag{19}$$

The schematic view of the simulation domain and meshed sample are shown in Figure 2d,e, respectively. According to the FSW procedure, the tool passed three main steps from the start to the end of the joining procedure. The first step is called plunging, which means penetration of the joint line by the FSW tool. The second step is mixing of the base metals during forward motion of the FSW tool, and the last step is the exit of the FSW tool from the joint line. For simplicity, during this study the plunging and exit phases of the FSW tool have been ignored. During the simulation process, all parameters (tool geometry, tool rotational and traverse velocities, tool tilt angle and plunge depth) were selected according to the experimental procedure. The base metal is assumed to be a non-Newtonian fluid with thermally dependent visco-plastic behavior and density based on the AA6068 aluminum alloy. The Tetrahedral/Hybrid elements with a T-grid combination shape were used in the mesh generation of both tool and workpiece. The region close to the pin tool and the FSW tool required a much finer mesh to evaluate the heat transfer model and viscous flow. A sizing function on the tool and workpiece was used to generate the different volume sizes. The sizing function uses a start size, growth rate and maximum size. For the fine mesh pictured in Figure 2, the start size was 0.1 mm, the growth rate was 1.2 mm, and the maximum size was 1.3 mm. For this meshing scheme, the total number of volumes for the lateral case was 2,264,289 volumes. The welding equations were solved by ANSYS Fluent commercial software (ANSYS, Inc., Canonsburg, PA, USA). The simulation was tested several times (following a trial and error technique) to validate the results by experimental tests. As a result, the overall errors during the simulation were lower than 4%. Moreover, after running each phase, the results converged after 54 iterations in general.

4. Results and Discussion

4.1. Thermal Study

The frictional heat produced in the FSW process presents a direct effect on the mechanical properties of the final joints. The generated heat and temperature distribution are determined by material flow during welding, the formation of defects, microstructure changes, and the mechanical properties of the joint [5,63–65]. A minimum heat generation is required to obtain sufficient material flow. The heat generated in FSW is mainly produced by friction at tool–base metal interfaces but also by material plastic deformation. The heat generation by plastic deformation is related to the material's resistance to deformation, which creates internal frictional forces [38]. The heat distribution is not uniform around the SZ. The tool's thermal conductivity, FSW tool velocity, and the contact area between the fixture and the base metal affects the internal heat distribution. Figure 3a,b show both longitudinal and cross-section views, respectively, of the simulation results of cases 1, 3, and 5. The results show that the distribution of heat in the skin is more than in the flange.

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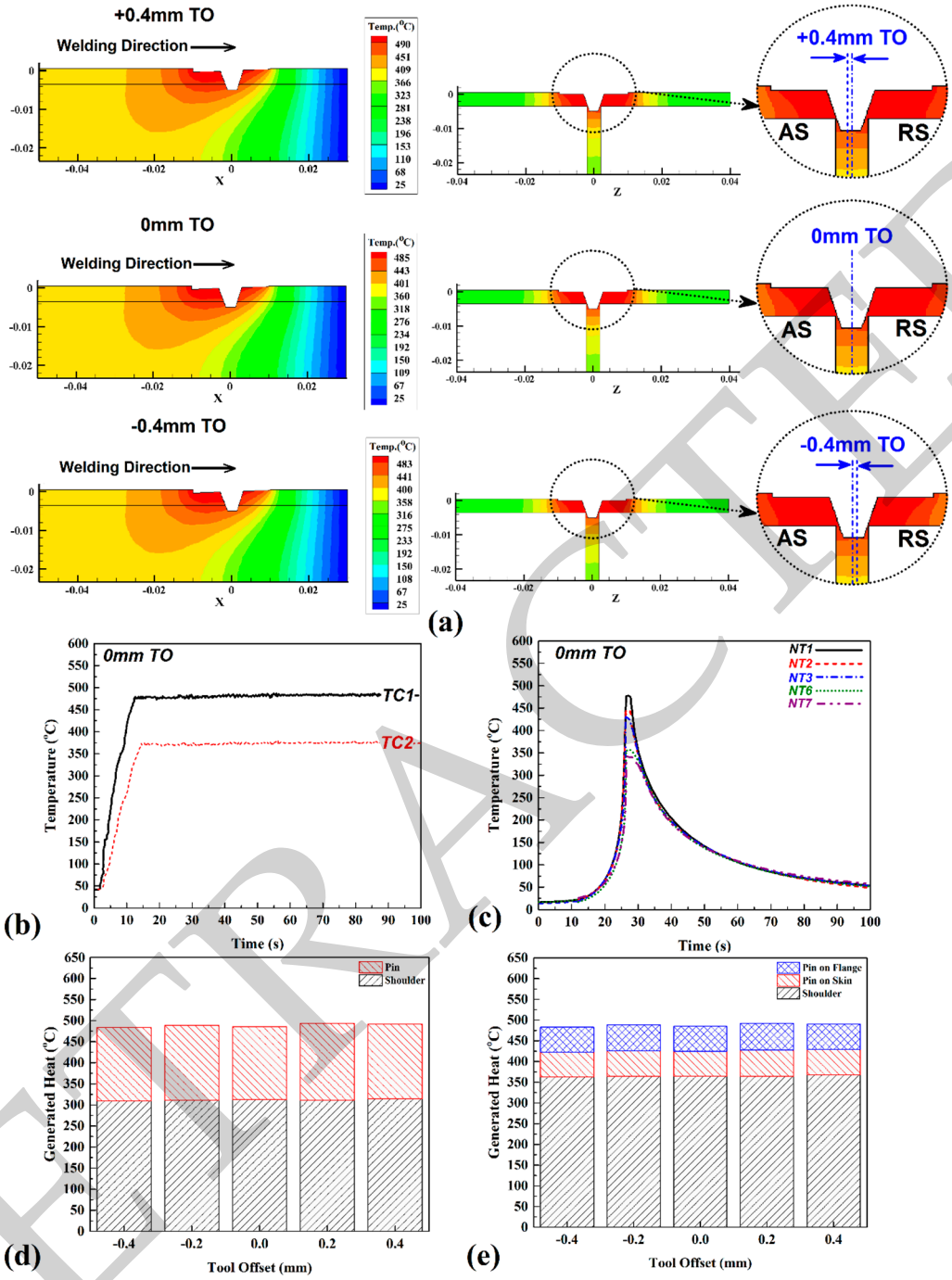


Figure 3. Simulation results of internal heat flow at (**a**) longitudinal and cross section of various TOs. (**b**) Recorded temperature by FSW tool. (**c**) Recorded temperature by thermocouples at surface of skin and flange. (**d**) Recorded temperature by thermocouples insides the FSW tool and (**e**) Simulation results of generated heat at various TOs.

On the other hand, the heat concentration in front of the pin, in the flange, is higher than that in the SZ of the skin. TC1 confirms this result; the maximum recorded temperature from simulation results were 483 °C, 488 °C, 485 °C, 492 °C, and 490 °C. There are noticeable differences between the temperatures recorded by TC2 and the simulation results corresponding to the pin side. This behavior can reflects that the TC2 data presents mixed heat produced at the pin side and diffused temperature from shoulder side. On the other hand, the heat produced by the part of the pin inserted in the flange (TF) also increased at the TO in AS. Among the selected TOs, case 3 shows the lowest heat generation compared to other cases. Due to constant process parameters, the generated heat is related

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to the materials flow direction and TOs [66]. The simulation results of surface heat flow in the various cases are shown in Figure 4a. As seen, the heat discussion in AS is more than in RS for all cases. The recorded temperatures from the thermocouples around the joint line on the skin, are presented in Figure 4b. The maximum recorded heat in cases 1, 2, 3, 4, and 5 were 444 °C, 448 °C, 441 °C, 439 °C, and 436 °C at AS, respectively. The simulation results showed good agreement with these numbers (approximately 2 degrees lower).

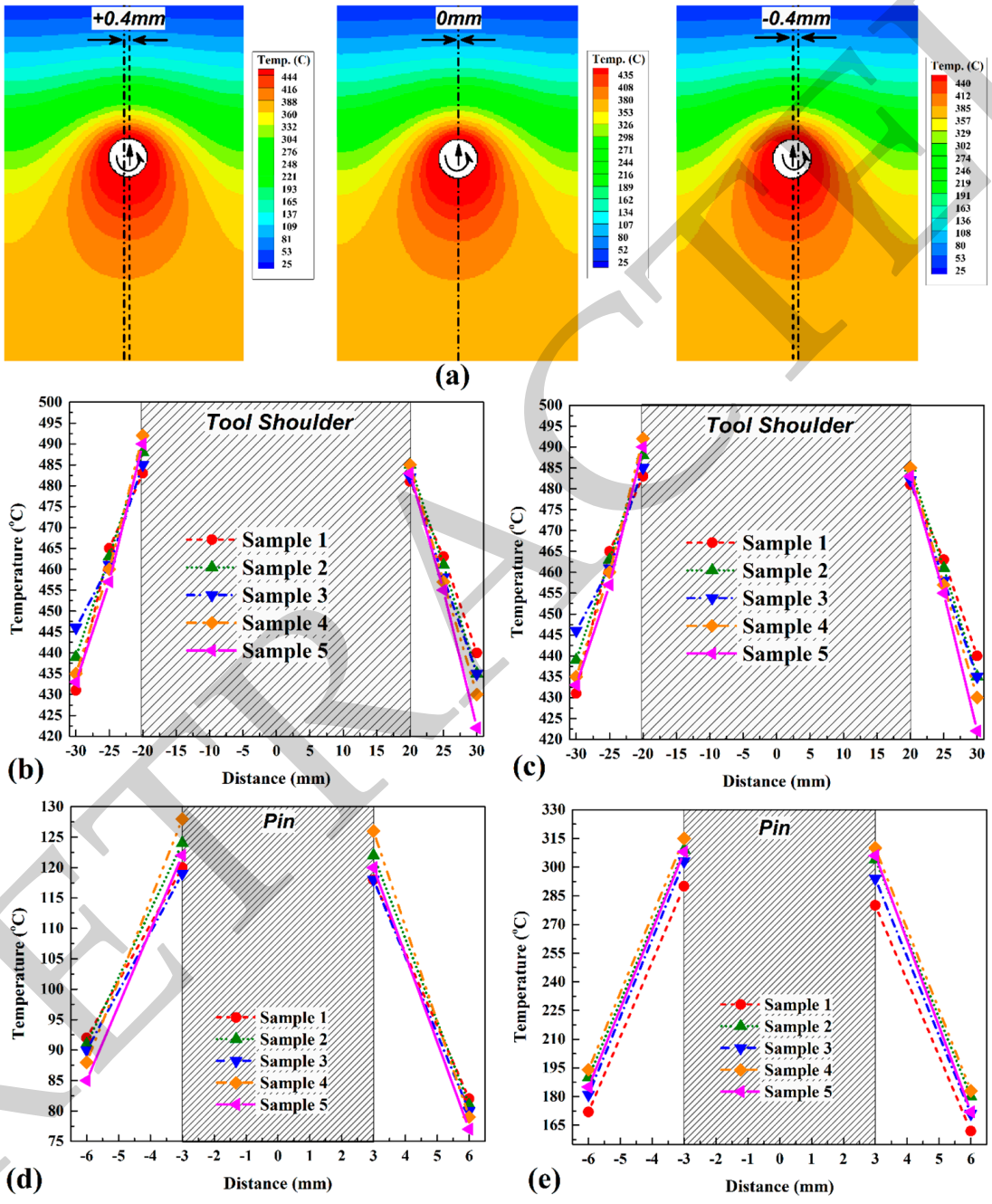


Figure 4. (**a**) Simulation results of surface heat flow at various cases. (**b**) Experimental and (**c**) simulation results of recorded maximum temperature and heat diffusion on skin. (**d**) Experimental and (**e**) simulation results of recorded maximum temperature and heat diffusion on flange.

The recorded temperature on the flange side (Figure 4d) reveals that the generated heat in lower SZ areas is significantly lower than SZ's upper area. Due to the direct contact of the shoulder with the skin (that leads to a higher contact area compared to the pin), the

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generation of heat in the upper area is increased. The critical issue is that, at the flange side, the heat flow gradient is higher than at the skin side. The maximum heat was recorded by thermocouples near the SZ (NT1, NT4, and NT5) and the other thermocouples recorded the heat diffused from SZ. They also indicate the cooling rate of SZ after passing the FSW tool. The difference between thermocouples placed at the flange shows that the heat diffusion in this area is faster than in the skin. However, the materials are similar and thus, the flange geometry, which is narrower and thinner than the skin's one, is responsible for the faster heat flux in the flange compared to that of the skin.

4.2. Material Velocity and Surface Flow

The material's velocity is related to the generated heat. Higher frictional heat generation diminishes base metal shear strength and, consequently, materials velocity in the SZ is increased. This phenomenon leads to the sitting and mixture of plasticized materials, which are closely related to the generated heat and materials velocity [35]. The results of materials velocity in the SZ of case 3 are shown in Figure 5a. The critical point is that in the T-configuration, the mixing of materials at the common area between the flange and the SZ (TF) should be sound. The flange and the skin share an amount of material for the formation of the final SZ. During the forward motion of the FSW tool, the FSW tool's rotational direction meets the forward direction. In this situation, the aluminum alloy is mainly subjected to the shearing action of the pin in the AS. At the RS, the FSW tool's rotation direction is the opposite of the tool's movement direction. In this case, the aluminum alloy is mainly subjected to the extrusion action induced by the FSW pin. Therefore, the level of stirring action on the AS is higher than that of the RS. The force of this behavior can be variable at different TOs. The material's internal velocity (internal flow) results from the difference between shearing and extrusion forces. Inequality of internal forces can lead to the formation of defects. The stirring action of the pin mainly forms the SZ. From this perspective, the FSW tool's center position determines the quality of the internal material velocity (internal material flow). When the TO is displaced, the center of the SZ moves [67]. The velocity of the internal material in both skin and flange, is affected by the surrounding materials of the AS or the RS. According to the simulation results presented in Figure 5b, the highest material velocity in the flange occurred in case 2. It can be seen that the TO on the AS side provides a better effect on material flow to produce more frictional heat and material velocity. The +0.4 and -0.4 mm TO have the lowest velocity. An overall view of the welded sample in case 2 is presented in Figure 5c. As shown by the statistic results in Figure 5d, incomplete joints are formed at +0.4 mm and −0.4 mm TOs. In addition, little voids are produced at −0.2 mm and 0 mm TO.

Previous research agreed that the TO has important effects on materials flow and FSW tool working life in dissimilar joints [68]. On the other hand, some studies indicated that the TO does not impact polymeric materials flow during FSW [60]. It seems that pulse tool rotational and traveling velocities, tool tilt angle, tool plunge depth, and the TO can affect the quality of the final similar joint in the T-configuration. The radiography image from samples with complete SZ is shown in Figure 6a. There are few defects detected in the RS of −0.2 mm and 0 mm TO pieces. The FSW tool rotation direction moves the materials from the RS to the AS. The desired amount of raw material has to be provided by both the skin and flange to form a complete SZ. Because the available materials in the flange are limited, unlike the skin, they provide plasticized aluminum alloy to fill the SZ, which is related to the availability of raw aluminum in the RS from the flange side. Materials were compressed in the AS and the primary inlet materials were provided from the RS. According to the experimental results, the FSW process sensitivity to changes in the TO is higher in the RS than in the AS. A sound joint in the T-configuration needs enough materials from the RS to achieve appropriate velocity and stirring action. This behavior does not exist in other joint configurations that have been reported until now [69]. Figure 6b shows the top view of the surface flow of joints with various TOs. As reported before, a big surface tunnel is formed in both cases welded with a 0.4 mm TO.

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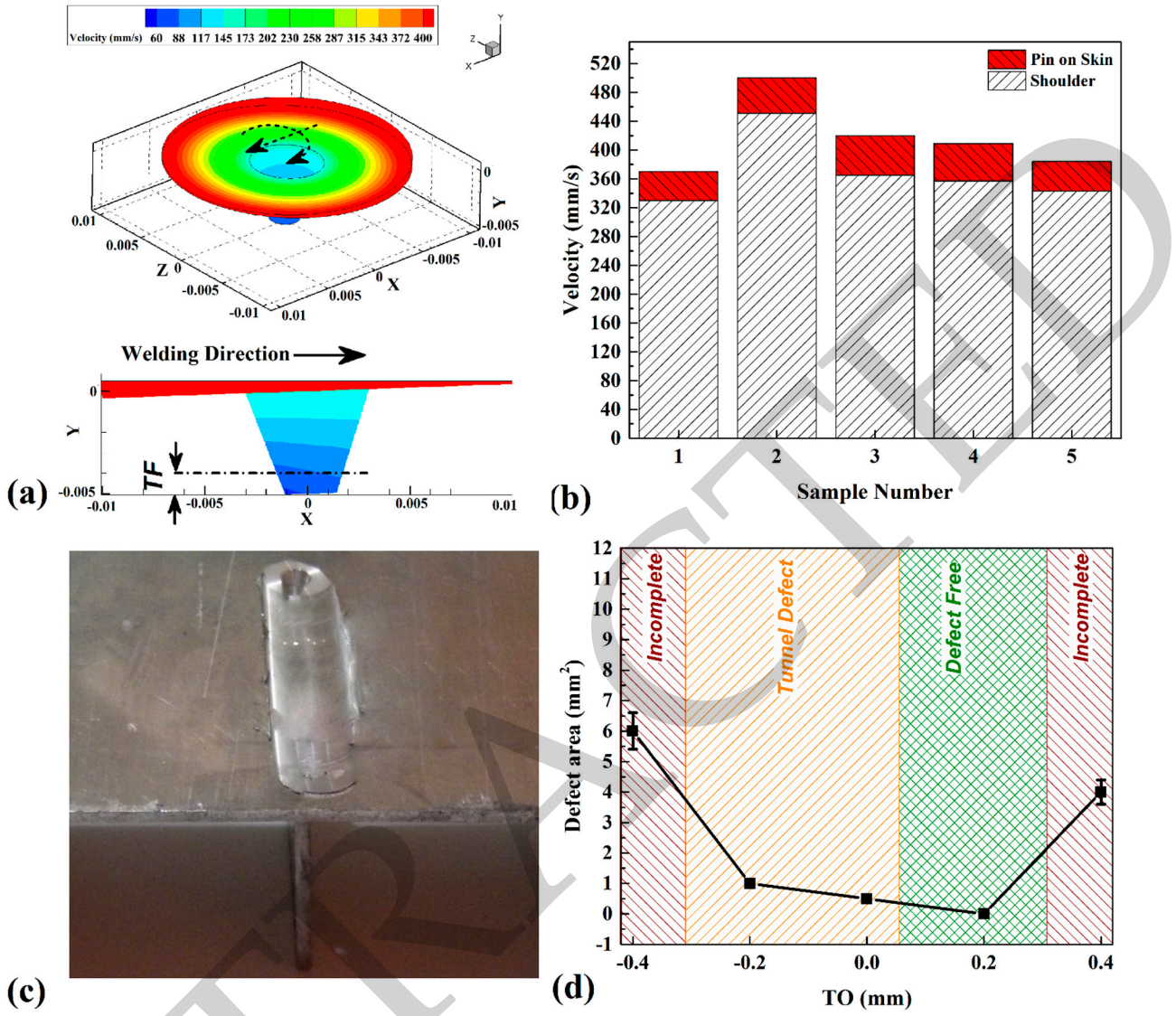


Figure 5. (**a**) Simulation results of materials velocity in SZ of case 3. (**b**) Simulation results of maximum materials velocity on skin and flange. (**c**) Welded sample case 2. (**d**) Relationship between TO and joint defects.

4.3. Strain Rate and Microstructure Changes

Figure 7a shows the top and cross-section views of the strain rate simulation results. As can be observed, the strain rate in the AS is higher than in the RS in all cases. As expected, this behavior is related to the materials flow induced by FSW tool direction. In the cross-section view, it can be seen that the strain rate is higher in the upper area of the joint. This region presents a higher contact area between the shoulder and the skin compared to the pin–flange contact area, which leads to this phenomenon. The results of the simulation predicted the maximum strain rate in case 2 with a value of 440 s^{-1}, while the lowest strain rate was predicted in case 5 with a value of 390 s^{-1}. The cross-section view of the joints indicates that the highest strain rates were predicted in the joint's upper areas. As expected, with increasing heat generation and materials velocity in cases with higher TOs at AS, the strain rate in +0.2 mm and +0.4 mm is higher than in the other cases. A higher value of strain rate indicates not only higher frictional heat generation, but also higher plastic deformation on the SZ. The core effect of strain rate is the determination of grain size in the SZ. The friction between the pin beneath and the SZ root's material during the rotation of the FSW tool resulted in the non-uniform strain rate distribution in this area.

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As shown in the results, the strain rate presents its maximum value at the upper area of SZ, while the strain rate on both the AS and the RS gradually decreases as the distance from the top of the SZ increases. The friction between the pin beneath and the base metals is proportional to the strain rate distribution and, consequently, increases pressure in this area [70].

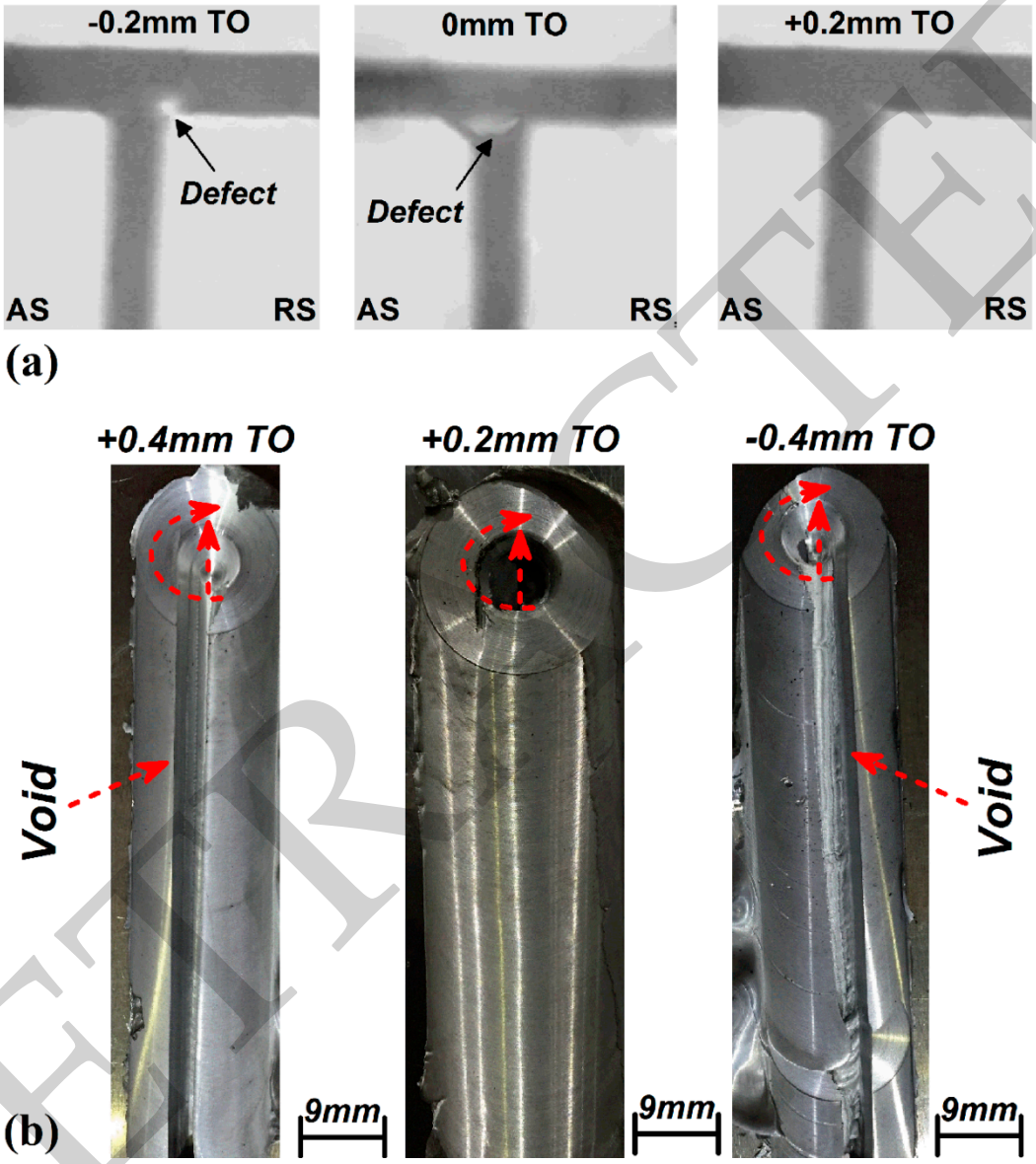


Figure 6. (**a**) Radiography image from welded samples. (**b**) Surface materials flow of various samples.

The Microstructure of the FSWed sample with +0.2 mm TO, is presented in Figure 7a. The thermomechanical affected zone (TMAZ) and heat affected zone (HAZ) is also indicated in Figure 7a. The statistical results of average grain size in various joints in both skin and flange, are depicted in Figure 7b. The fluctuation of grain size in +0.4 mm and −0.4 mm TOs is high in both flange and skin, due to the high stirring action and the uncomplete joint line. The inequality of grain structure in various parts of the SZ modifies the mechanical properties of the joint. The metallographic study shows the finest grain size in +0.2 mm TO. In this case, the flow of materials, heat generation, and materials velocity are appropriate and thus, the average size in both the skin and flange is homogenous. According to the results, the grain size of the SZ in cases 1, 2, 3, 4 and 5 was, respectively, 18 µm, 13 µm, 14 µm, 15 µm, and 16 µm.

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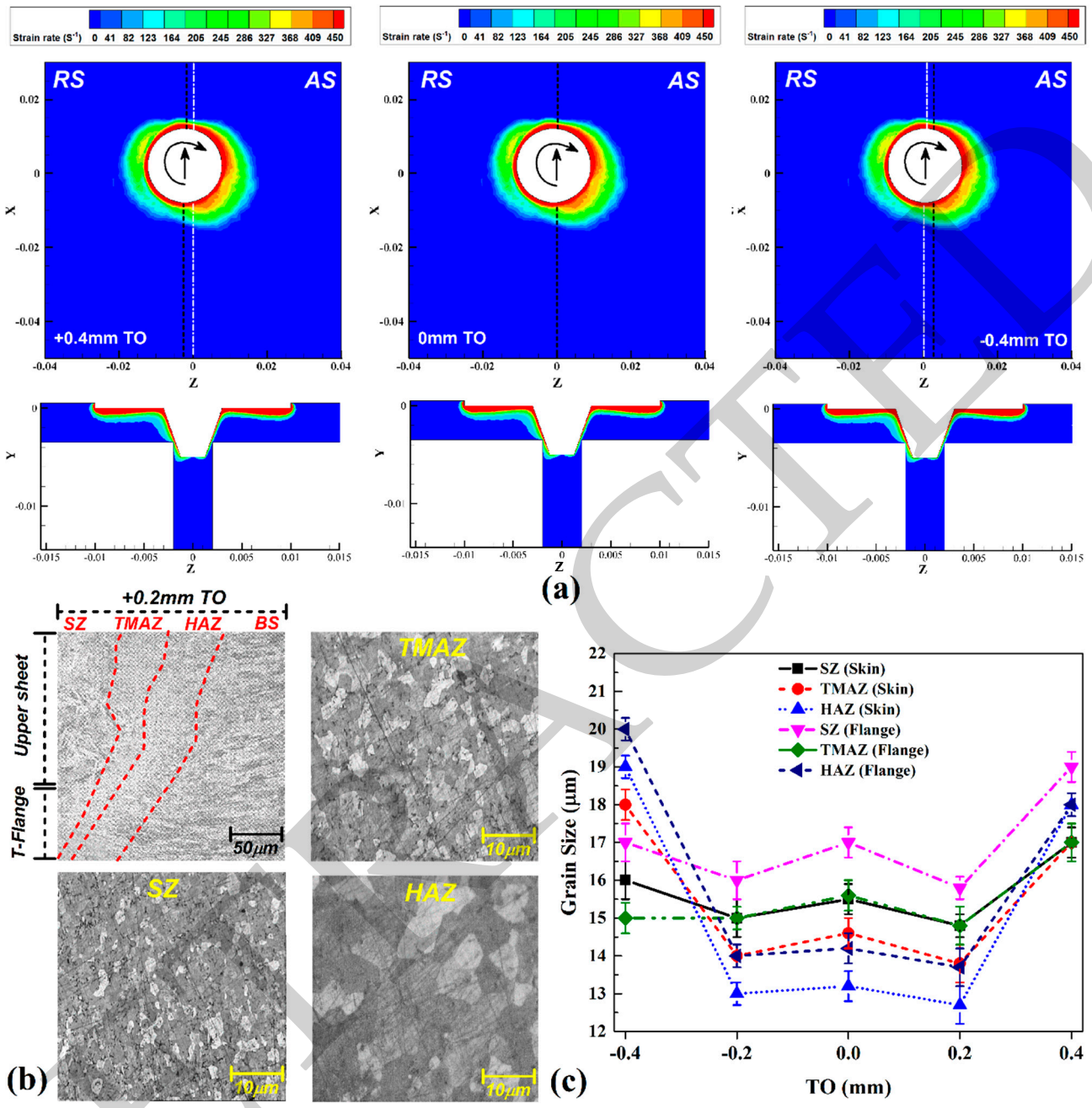


Figure 7. (**a**) Simulation results of Strain rate in various cases. (**b**) Microstructure of SZ in case 2. (**c**) Statistic results of grain size in skin and flange at different cases.

4.4. Tensile Strength and Micro-Hardness

The defects in the SZ root directly influence the fracture path and the load bearing of the joint. Figure 8a depicts a schematic view of the fracture path that was seen in all cases. Results show that the transition area between the SZ and the TMAZ was not broken, and all joints were broken from the skin–flange interface on the SZ. During the tensile test, stress concentration is overcome in the weakest region. Due to the tensile test setup detailed in the experimental section, the tensile load was applied to the flange. For this reason, the fracture occurred at this position. As discussed previously, the TO changes the stirring action of materials [71]. Due to lower the stirring action in the RS, this area would be weaker than the AS. For this reason, the fracture initiation during the tensile test started from the RS. A statistical analysis of tensile strength is presented in Figure 8b.

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As expected, appropriate heat generation, materials flow, and velocity lead to the joint in case 2 showing the highest strength. On the contrary, joints with the lowest strength correspond to cases 1 and 5. The incomplete joint lines with surface defects caused these joints to have the lowest tensile strength. According to the results, the strength in cases 1, 2, 3, 4, and 5 were 121 MPa, 181 MPa, 172 MPa, 164 MPa, and 106 MPa, respectively. The SEM image of the fracture surface of case 2 (sample with the highest strength) is depicted in Figure 8c. As can be observed from the SEM image, a semi-ductile fracture surface was detected. The micro-hardness distribution along a vertical line in the SZ at different TOs is presented in Figure 8d,e. From the results, it can be seen that the shape profile of the microhardness distribution is not uniform. Compared to the hardness of the BM, the SZ hardness decreased in all cases. Indeed, the hardness decreases gradually along the measuring line direction.

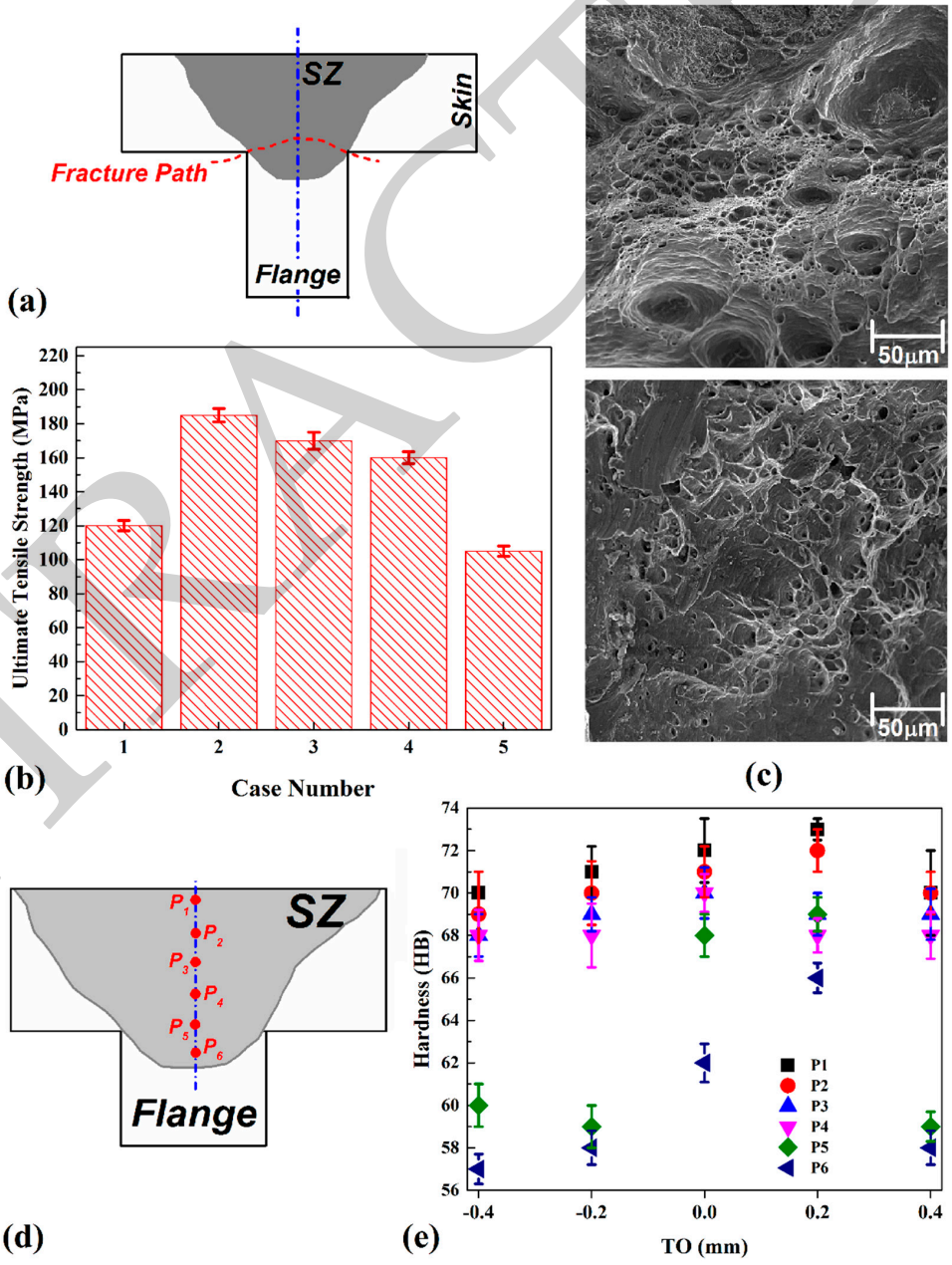


Figure 8. (**a**) Schematic view of fracture path during tensile test. (**b**) Tensile strength of joints. (**c**) SEM image of the fracture surface in case 2. (**d**) Schematic view of selected points for hardness test. (**e**) Hardness test results.

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On the other hand, the hardness of sound welds was slightly higher than others. Close examination revealed that from top to bottom, the upper area shows the highest hardness value. This behavior can be explained by the higher heat generation and more refined grain structure that is present in the upper area compared to the lower side. From these results, it can be seen that one reason for this issue is that the fracture path was on the interface of the skin and the flange on the SZ. This region presented the lowest hardness and also non-uniform hardness along SZ.

5. Conclusions

This research studied the FSW tool's effects on the mechanical strength and material flow in an Al–Mg–Si alloy. A thermomechanical model was proposed to predict the thermal history, strain rate, and materials velocity during the joining process. From the results and observations, the following conclusions can be drawn:

1. The maximum frictional heat was produced in Case 2 (~81% of the aluminium melting point) and the minimum frictional heat was produced in Case 5 (~77% of the aluminium melting point). The results show that at the optimum TO (in which mechanical properties are maximum), the heat generation by the tool pin in the flange side shows the highest value compared to other tool offsets.
2. Thermal history and temperatures recorded by thermocouples revealed that due to the flange's narrow area, the diffusion of heat is faster there than at the skin. For this reason, the stirring action of plasticized materials by the tool could be inconsistent at an inappropriate TO.
3. The best materials velocity that produced a sound joint with appropriate material flow was predicted (~480 mm/s in +0.2 mm TO), and this setup results in enough materials stirring being produced from plasticized aluminium in the RS of the flange.
4. The predicted strain rate in the AS was higher than at the RS in all analysed TOs. The higher strain rate leads to more stirring action and plastic flow. The best value was found in the case +0.2 mm of TO, which lead to a uniform grain size in all regions of the SZ. This behaviour results in a higher tensile strength.

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Nomenclature

Time	t
Coefficient of thermal conductivity	k
Mass-specific heat capacity	c
Density of the materials	ρ
Specific heat	ν
Yeild strength	τ

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Material yield stress	σy
Zener- hollomon Parameter	Z
Heat transfer coefficient	h_e
Initial temperature	T_a
Stefan–Boltzmann constant	B
Emissivity,	ε
Convective heat transfer coefficient	h_t
Velocity,	u
Welding speed	U_1
Angular velocity	ω
Pressure	P
Flow stress	σ_e
Effective strain rate	ε
Material Constants	$A = 5.18 \times 10^{10}\ S^{-1}$
Material Constants	$a = 1\ MPa^{-1}$
Material Constants	$n = 5.66$
Activation Energy	$Q = 158.3\ kJ/mol$

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