

Example 1

The power source in a particular welding setup generates 3500W that can be transferred to the work surface with a heat transfer factor = 0.7. The metal to be welded is low carbon steel, whose melting temperature is 1760K. The melting factor in the operation is 0.5. A continuous fillet weld is to be made with a cross-sectional area = 20mm². Determine the travel speed at which the welding operation can be accomplished.

Sol:

Let us first find the unit energy required to melt the metal U_m from Eq. (18.1)

$$U_m = 3.33(10^{-6}) \times 1760^2 = 10.3 \text{ J/mm}^3$$

Rearranging Eq. (18.4) to solve for travel velocity, we have $v = \eta_1 \eta_2 R_p / U_m A_w$; and solving for the conditions of the problem

$$v = \frac{0.7 (0.5) (3500)}{10.3 (20)} = 5.95 \text{ mm/s.}$$

Lecture Notes Physical Principles In Welding Engineering

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