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# Mechanical Properties on Electron Beam Welds of Constructional High Tension Steels (Report IV) †

Yoshiaki ARATA\*, Fukuhisa MATSUDA\*\*, Yutaka SHIBATA\*\*\*, Yoshihisa ONO\*\*\*, Mitsuo TAMAOKI\*\*\* and Shouichiro FUJIHIRA\*\*\*\*

## Abstract

The effects of bead width and hardness difference between the electron-beam weld and the base metal on the transition temperature for fracture mode ( $T_{rm}$ ) in Charpy impact ductility test were studied in this investigation by using HT50 and 80 constructional high tensile steels. The remarkable conclusion are as follows:

- (1) The impact strength of the weld metal is not depended on the variation of  $\alpha_b$  parameter.
- (2) Moreover with an increase of weld heat input or notch depth for Charpy test specimen, the  $T_{rm}$  tends to be raised.
- (3) With an increase of the annealing temperature, the  $T_{rm}$  tends to be raised in general.
- (4) The impact strength for HT50 and 80 weld metals was not depended on the variation of the hardness of the weld metal except for the HT50 weld with 650°C annealing.
- (5) The  $T_{rm}$  tends to be raised with an increase of bead width ratio, or with a decrease of hardness difference ratio.
- (6) Isothermal lines for the  $T_{rm}$  more than 100°C were made clear by the two parameters of the bead width ratio and the hardness difference ratio.

## 1. Introduction

Some results of the mechanical properties of electron-beam welds such as hardness distribution, tensile-, bend-, impact- and fatigue-properties were reported in the two previous reports<sup>1),2)</sup>. Therefore the mechanical properties were almost made clear. However the authors had an attention concerning the impact properties of the weld metal whose bead width was narrower. That is to say, the impact values of these weld metals exceed those of the respective base metal in the temperature higher than the specific temperature.

Then the authors indicated in the previous report<sup>3)</sup> about the specific temperature that a transition phenomenon of the fracture mode occurred at the specific temperature, that is, the fracture occurred in the weld metal in the temperature lower than and crooked to the HAZ and/or the base metal in the temperature higher than. The authors called this specific temperature, at which the fracture mode in Charpy impact specimen changes, the transition temperature for fracture mode ( $T_{rm}$ ) in the previous report<sup>3)</sup>.

Moreover in the previous report<sup>3)</sup>, the effect of the weld heat input on the  $T_{rm}$  in Charpy impact test was partly clarified. As a result of the report, the  $T_{rm}$  is closely related to both the bead width and the difference in the hardness of base and weld metals, and has the tendency to rise with an increase of the bead width or

with a decrease of the hardness difference. Then, in this report, the authors have treated about the detailed behavior of the  $T_{rm}$  for impact properties by using HT50 and 80 steels. Namely, by the various combinations of the weld heat input and  $\alpha_b$  parameter, three different welding conditions were selected to have three different bead widths (narrow, middle and wide bead widths).

Moreover the effects of the notch depth and the weld heat input on the  $T_{rm}$  were systematically investigated. Moreover some of the welds were suitably heat-treated in order to reduce the hardness difference between base and weld metals, and the effects of the hardness variation of weld metal on the impact properties were studied. Furthermore, the behaviors of impact properties for the welds in various  $\alpha_b$  parameters were also examined. Finally, by the use of the two parameters (bead width and hardness difference ratio in the welds), the limit of the desirable  $T_{rm}$  which exceeds 100°C was fixed for the electron-beam welds of HT50 and 80 steels.

## 2. Experimental Procedure

### 2.1 Materials used

The materials used in this investigation are HT50 and 80 steels which are widely used in the constructional bridges and buildings. The former is not heat-treated, and the latter is quenched and tempered materials. The chemical compositions of these two types of high tension

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\* Professor

\*\* Associate Professor

\*\*\* Katayama Iron Works, Ltd.

\*\*\*\* Co-operative Researcher (1975), Katayama Iron Works, Ltd.

Table 1 Chemical compositions of HT50 and 80 steels used.

Composition		(wt%)									
Steel	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Ceq*
HT50	0.16	0.47	1.39	0.017	0.015	—	—	—	—	—	0.41
HT80	0.13	0.30	0.86	0.013	0.004	0.22	0.87	0.52	0.42	0.04	0.52

\*:  $C_{eq} = C + 1/6 Mn + 1/24 Si + 1/40 Ni + 1/5 Cr + 1/4 Mo + 1/14 V$  (JIS G 3106)

steels are listed in Table 1. The carbon equivalent (Ceq) of HT50 and 80 steels is 0.41 and 0.52, respectively. The plate thickness of these steels is 25mm.

## 2.2 Welding procedures and conditions

High vacuum type-EB welder, conventional low voltage type (30KV-500mA, 15KW in maximum), was employed in this investigation. Welding for all materials was performed with one pass bead-on-plate welding method. Any oxide and scale on plate surfaces was completely machined along welding direction and in advance of electron-beam welding, all of test plates were completely de-magnetized and plate surfaces were made clean with degreasing reagent.

In this experiment, all of welding were performed with 300mA or 400mA beam power. From the test results of the slope-welding method<sup>4)</sup>, the focal length ( $D_F$ ) of each beam power was fixed to be 257mm for 300mA and 244mm for 400mA. It is often observed that 25mm thick plates were burnt through due to the large weld heat input, in case of which welding was performed by means of the stacking of respective two plates.

There are two series of welding conditions adopted in

Table 2 Welding conditions in various  $\alpha_b$  parameters.

Beam power (KV-mA)	Welding speed (cm/min)	Weld heat input (KJ/cm)	$\alpha_b$ parameter ( $D_O/D_F$ ) ( $D_F = 257$ mm)
30-300 (9KW)	36	15	0.75, 0.9, 1.0
30-300 (9KW)	18	30	1.1, 1.2, 1.4

this investigation. Table 2 shows the one series of welding conditions in which  $\alpha_b$  parameter ( $D_O/D_F$ ,  $D_O$ : Objective distance,  $D_F$ : Focal length) is varied for the various six levels for two different weld heat inputs

Table 3 Welding conditions in various weld heat inputs.

Designation of welding condition	Beam-power (KV-mA)	Welding speed (cm/min)	Weld heat input (KJ/cm)	$\alpha_b$ parameter ( $D_O/D_F$ )
N	30-300 (9KW)	45	12	0.75 ( $D_F = 257$ mm)
M	30-300 (9KW)	18	30	1.0 (257)
W	30-400 (12KW)	18	40	1.2 (244)

(15 and 30KJ/cm). The specimen size in this case is 150mm in width and 500mm in length. Table 3 shows the other series of welding conditions in which the weld heat input is selected for the different three levels (12, 30 and 40 KJ/cm). In order to obtain the reasonable variation of weld bead width, the  $\alpha_b$  parameter to each weld heat input is determined to be 0.75, 1.0 and 1.2, respectively. Each designation of welding condition means that the respective bead width is narrow, middle and wide sizes. The specimen size in this case is 80mm in width and 500mm in length.

## 2.3 Heat treatment of weld metal

Two kinds of post heat treatment are given to some of plates welded with N-welding condition in Table 3 in order to reduce the hardness of weld metal. Namely, they are annealed with  $450^\circ\text{C} \times 1$  hr, or with  $650^\circ\text{C} \times 1$  hr.

## 2.4 Method for study of impact properties

Impact test was performed with Charpy V-notch specimen, the notch depth of which was successively changed, and the all specimens were notched at the center of the weld metal. The capacity of impact test machine was 50kg-m in maximum. Testing temperatures were firstly selected for six levels,  $-80$ ,  $-60$ ,  $-40$ ,  $-15$ ,  $0^\circ\text{C}$  and room temperature ( $15 \sim 30^\circ\text{C}$ ) in this examination to make the rough estimate of  $T_{Im}$ . Two test specimens were tested for each testing temperature. After that, the additional study was done in order to decide the exact temperature for the  $T_{Im}$ . For the welds with the welding conditions of Table 2 in which  $\alpha_b$  parameter was varied, the test specimens were machined from 3mm under the plate surface, and the impact tests were performed with standard Charpy 2mm V-notch specimens.

Nextly, in case of the welds with the welding conditions of Table 3, in which the weld heat input was varied for the three levels with respective constant  $\alpha_b$  parameter, the V-notch depth was successively changed from 1mm through 6mm to 10mm squared specimens. Moreover 15mm squared specimens were additionally made by way of trial in M-and W-welding conditions for

HT50 welds, the V-notch depth of which was 2 or 4mm. Furthermore, the V-notch depth in the heat treated specimens was selected to be 2, 4 or 5mm to 10mm squared. The combination between each welding condition and the test specimens prepared for various

Table 4 Combination between welding conditions and test specimens prepared for various notch depths to 10 mm square.

	V-notch depth to 10 mm squared specimen		
	12 (KJ/cm)	30 (KJ/cm)	40 (KJ/cm)
As weld	1, 2, 3, 4, 5, 6	1, 2, 3	1, 2
450°C annealing	2, 4, 5	—	—
650°C annealing	2, 4, 5 (mmV)	—	—

notch depths to 10mm square was shown in Table 4. The machined location for the test specimens for the N-, M- and W- welding conditions was 3, 4 and 5mm under plate surface, respectively. The respective machined location was determined in order to remove the snake head of electron-beam weld bead and to have parallel walled portion in bead within test specimens after macro-etching in cross-sectional welds.

### 3. Bead Shape and Hardness Examinations

All of the electron-beam welded joint of HT50 and 80 steels were X-ray inspected. As the result, very small porosity could be partly observed in them, however referring to Japan Industrial Standard Specification (JIS Z 3104-1968), most of them were allowable in the first class for synthetic grade.

Photo. 1 shows the macro-photographs for cross-sectional HT80 welds of 30KJ/cm weld heat input in various  $\alpha_b$  parameters. The penetration depth was about 27mm in maximum at  $\alpha_b = 0.9$ . With an increase of  $\alpha_b$  parameter, the bead width is gradually tended to turn from wedge shaped type to wine cup shaped type. These tendencies were irrespective of the difference of materials. The bead shapes of 15KJ/cm weld heat input was similarly varied to those of 30KJ/cm. Fig. 1 shows the variation of the bead width at 2,7 and 10mm inward depth from plate surface in various  $\alpha_b$  parameters for HT80 welds of 30KJ/cm weld heat input. In the bottom part of this figure the simple sketch of the bead and its penetration depth are shown. At 2mm inward depth, the bead width showed minimum width of about 7mm at  $\alpha_b = 1.0$ . Also in the variation at 7mm depth, it showed the discontinuous

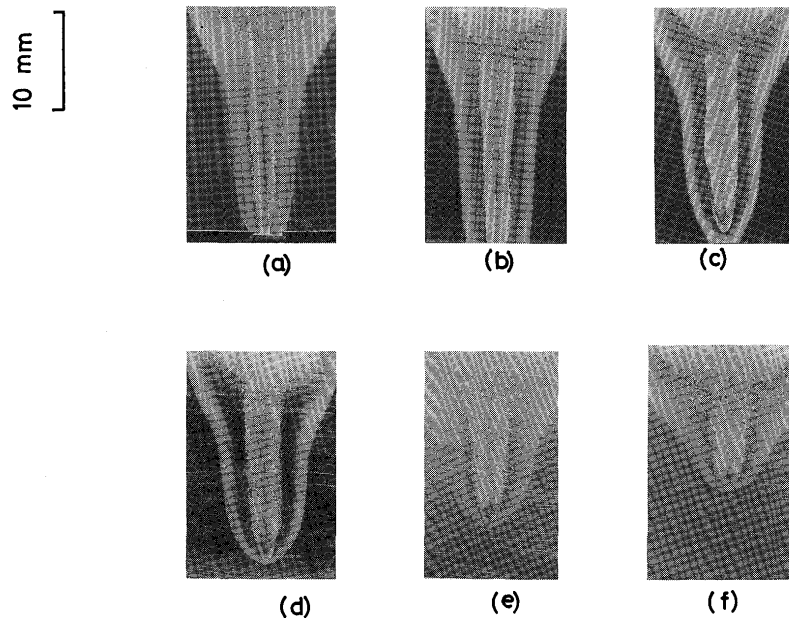


Photo. 1 Macro-photographs for cross-sectional HT80 welds of 30KJ/cm weld heat input in various  $\alpha_b$  parameters.

(a)  $\alpha_b=0.75$  (b) 0.9 (c) 1.0 (d) 1.1 (e) 1.2 (f) 1.4

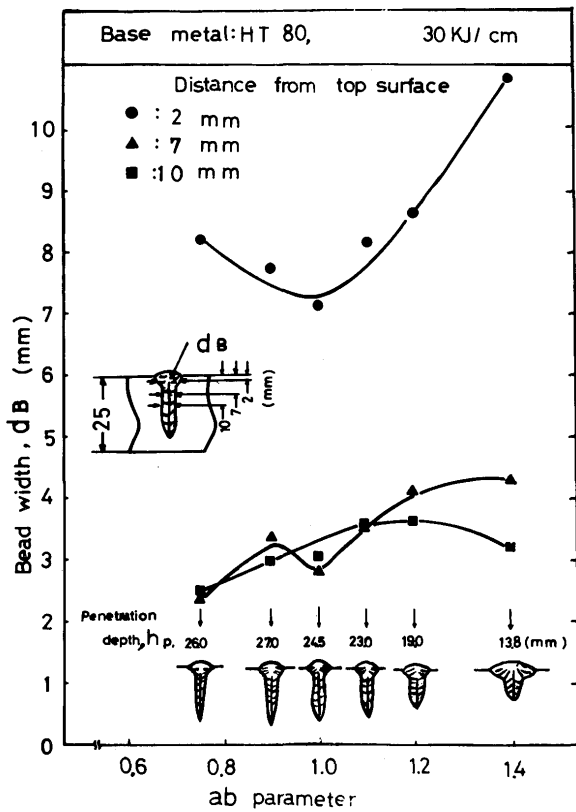


Fig. 1 Variation of bead width for HT80 welds of 30KJ/cm weld heat input in various  $a_b$  parameters.

variation at  $a_b = 1.0$ . It was caused by a little difference of bead shape. Namely, the bead shape at  $a_b = 1.0$  had the constricted part just at 7mm depth. Fig. 2 shows the relation between the  $a_b$  parameter and the average hardness of weld metal ( $H_w$ ) at 7mm inward from surface for HT50 and 80 welds. The hardness of welds was measured by using Vickers hardness tester with 10kg load.

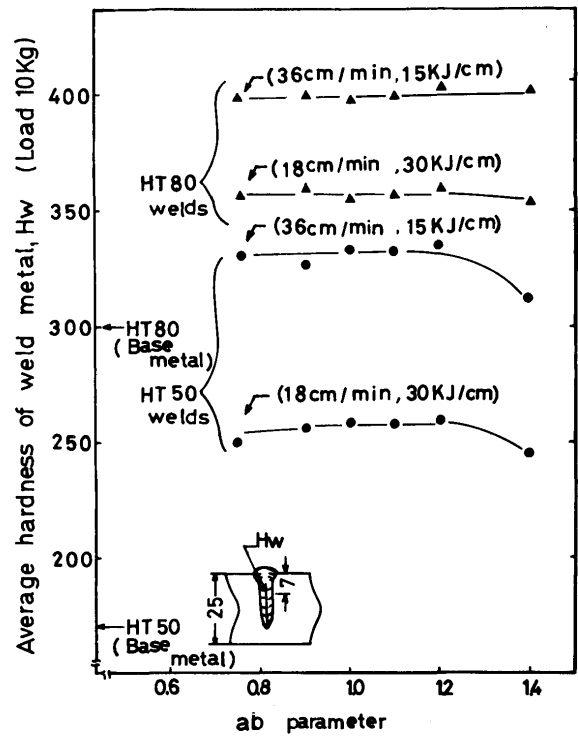


Fig. 2 Relation between  $a_b$  parameter and average hardness of weld metal ( $H_w$ ) for HT50 and 80 welds.

The hardnesses of the weld metal showed nearly constant value to the variation of  $a_b$  parameters. However, the hardnesses for  $a_b = 1.4$  in HT50 welds seems to be somewhat decreased as compared with those for the other  $a_b$  parameters. It seems mainly to be related to the variation of the vaporization of Mn element in the weld metal during electron-beam welding due to the difference in molten puddle shape.

Photo. 2 shows the typical example of HT50 welds for

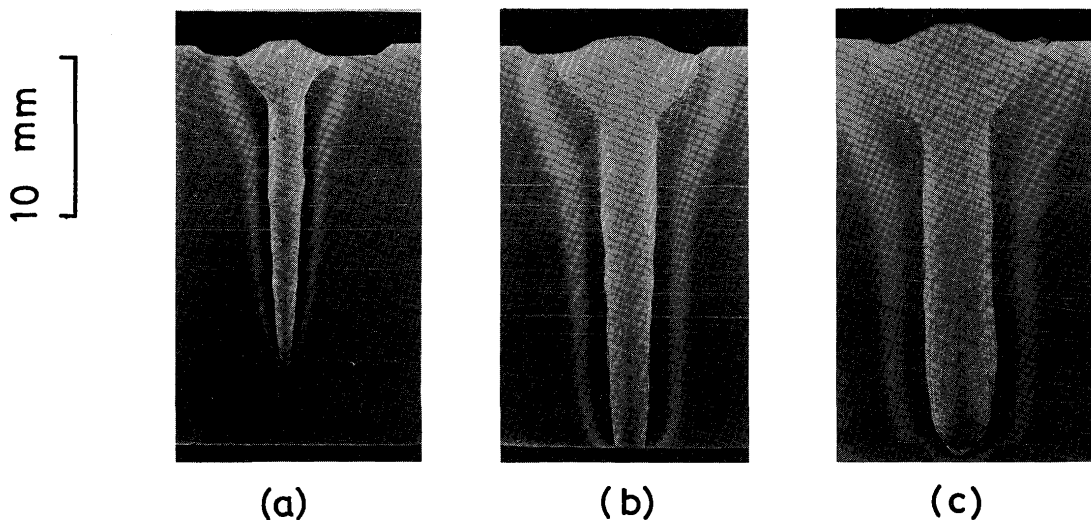


Photo. 2 Typical example of HT50 welds for different three weld heat inputs.

(a) 12KJ/cm,  $a_b = 0.75$  (b) 30KJ/cm,  $a_b = 1.0$  (c) 40KJ/cm,  $a_b = 1.2$

the different three weld heat inputs (12, 30 and 40KJ/cm), the bead width of which is varied to be narrow, middle and wide in size, respectively. The relations between the weld heat input and the penetration depth or the bead width are shown in Fig. 3. The measured point in the bead width for 12, 30 and 40KJ/cm weld heat inputs is at 8, 9

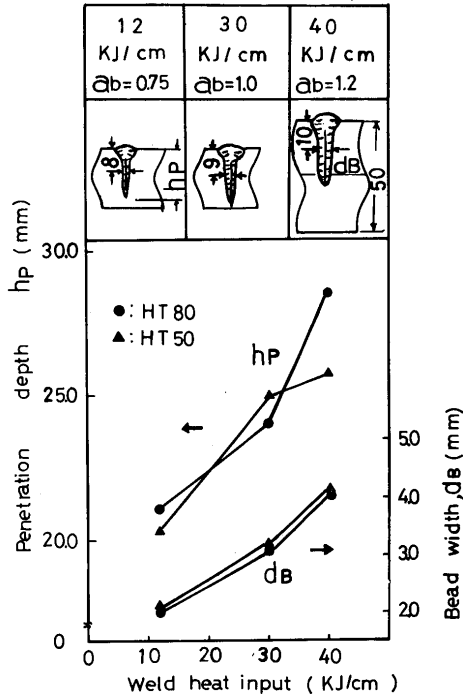


Fig. 3 Relation between weld heat input and penetration depth or bead width.

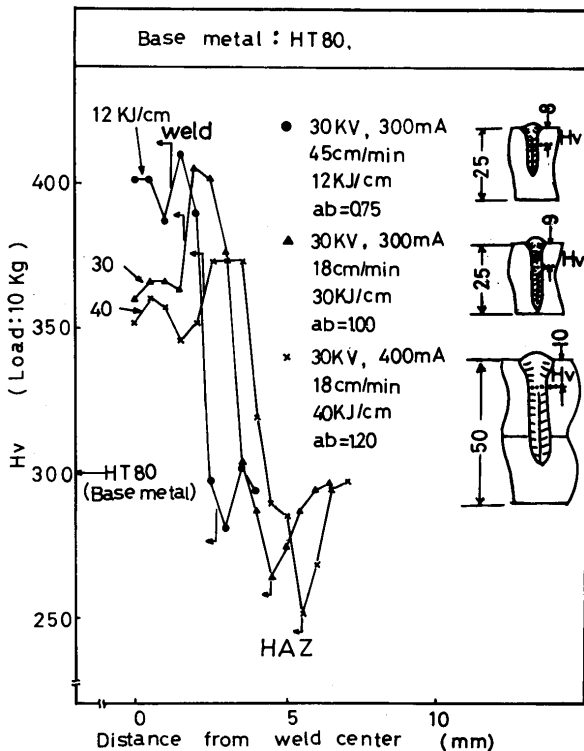


Fig. 4 Vickers hardness distributions of HT80 welds in various weld heat inputs.

and 10 mm inwards from plate surface, respectively. Each position corresponds to the center of Charpy specimens machined.

Fig. 4 shows the Vickers hardness distributions of HT80 welds in various weld heat inputs. The softened zones are observed in respective distribution. The minimum hardness of softened zone in 40KJ/cm weld heat input showed the lowest value of all of them. This difference of the minimum hardness is considered to be related to the cooling rate for respective weld heat input. Fig. 5 shows the relation between the weld heat input and

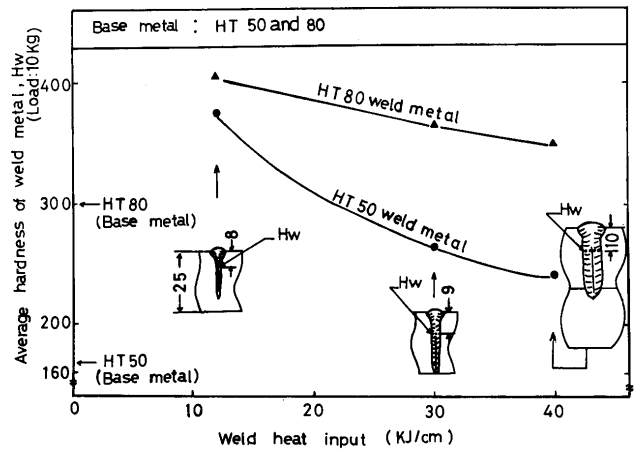


Fig. 5 Relation between weld heat input and average hardness of weld metal ( $H_w$ ).

the average hardness of weld metal ( $H_w$ ) for HT50 and 80 welds.  $H_w$  tends to be decreased with an increase of the weld heat input regardless of the difference of materials. Table 5 shows the variation of average hardness in the heat treated-base and -weld metals concerning the welds of 12KJ/cm weld heat input. In case of HT50, the hardness of as-received base metal tended to be a little decreased by the two heat treatments, and the hardness of the weld metal always showed higher value than that of respective base metal. However, in case of HT80, the hardnesses in base and weld metals were remarkably lowered by 650°C annealing, and they showed nearly equal.

Table 5 Variation of average hardness of heat treated-base and weld metals.

		(Load; 10 kg)			
		HT50		HT80	
		$H_w$	$H_B$	$H_w$	$H_B$
Weld heat input: 12 KJ/cm	As weld	375	170	405	300
	450°C annealing	300	165	330	300
	650°C annealing	200	145	206	208

$H_w$ ; Average hardness of weld metal (VHN)  
 $H_B$ ; Average hardness of base metal (VHN)

#### 4. Impact Properties

As stated previously, the value of impact strength usually showed the different levels even at the same testing temperature due to the difference in the fracture mode for Charpy specimens. Its specific testing temperature is named the transition temperature for fracture mode ( $T_{rm}$ ). The following is mentioned about the results of the study for the  $T_{rm}$  of HT50- and 80-welds.

##### 4.1 Effect of $a_b$ parameter on $T_{rm}$

As shown in Fig. 2, the hardnesses in the weld metal showed nearly constant regardless of the variation of  $a_b$  parameter. Then it is regarded as the variation of bead width. As an example, the transition temperature curves for HT50 welds of 15KJ/cm weld heat input in different three  $a_b$  parameters are shown in Fig. 6. The average hardness of weld metal ( $H_w$ ) in each weld is constant at about 335 (VHN).

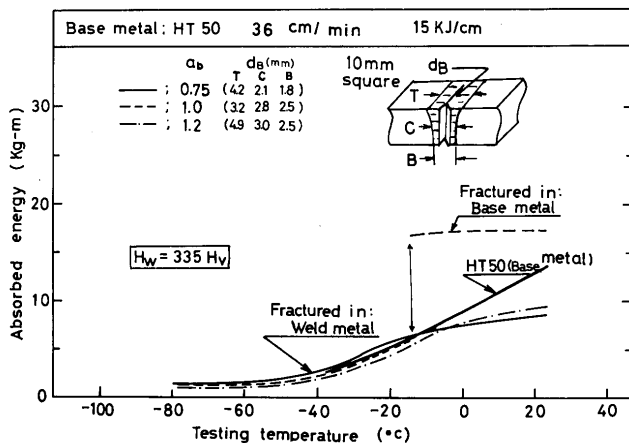


Fig. 6 Transition temperature curves for HT50 welds of 15KJ/cm weld heat input in different three  $a_b$  parameters.

The fracture mode separated into two types at  $-15^\circ\text{C}$  in case of  $a_b = 1.0$ , however it didn't separate even at  $25^\circ\text{C}$  in  $a_b = 0.75$  and  $1.2$ . Namely, the  $T_{rm}$  of the weld metal for  $a_b = 0.75, 1.0$  and  $1.2$  was  $>25, -15$  and  $>25^\circ\text{C}$ , respectively. The average bead widths at the top, center and bottom parts for each test specimen machined are also shown. Judging from this result, it is considered that the top bead width for test specimens has an important influence on the shift of  $T_{rm}$  for each weld metal.

Furthermore, the impact strength of the weld metal is little varied by the change of  $a_b$  parameters, and its value corresponds to that of base metal. Fig. 7 shows the transition temperature curves for HT50 welds of 30KJ/cm weld heat input in different three  $a_b$  parameters. In this case the fracture always occurred in weld metal even at  $100^\circ\text{C}$ . It is due to the increase in the bead width ( $d_b$ ) and the decrease in  $H_w$  in comparison with those of the

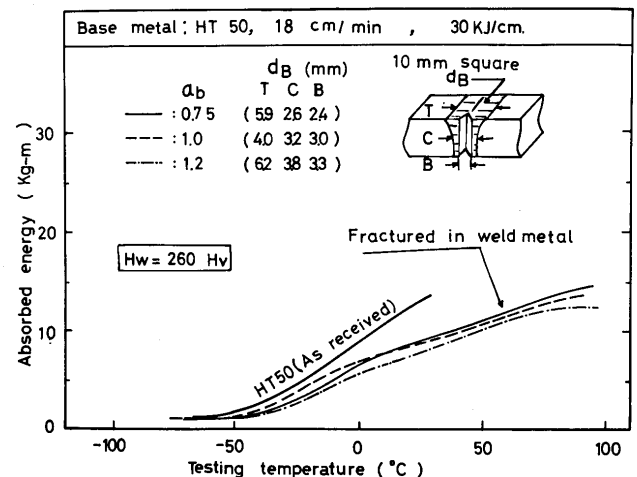


Fig. 7 Transition temperature curves for HT50 welds of 30KJ/cm weld heat input in different three  $a_b$  parameters.

welds of 15KJ/cm.

Moreover, the above-mentioned tendencies for HT80 welds were almost similar to those for HT50 welds. However in HT80 welds, the impact strength of weld metal seems to show lower value than that of base metal.

##### 4.2 Effects of weld heat input and notch depth on $T_{rm}$

Fig. 8 shows the transition temperature curves for

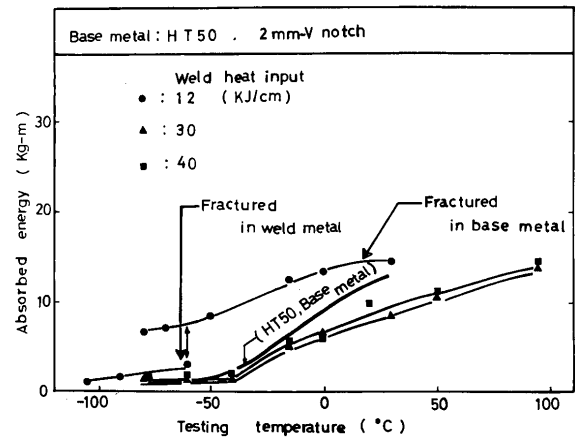


Fig. 8 Transition temperature curves for HT50 welds in 12, 30 and 40KJ/cm weld heat inputs for 2mm V notch to 10mm squared specimen.

HT50 welds for 12, 30 and 40KJ/cm weld heat inputs. The notch depth is 2 mm V to 10 mm squared specimen. The  $T_{rm}$  of the welds for 12, 30 and 40KJ/cm is  $-60, >100$  and  $>100^\circ\text{C}$ , respectively.  $T_{rm} >100^\circ\text{C}$  means that the fracture never deviates to base metal side even at  $100^\circ\text{C}$  testing temperature. With an increase of the weld heat input, all of each bead width at top, center and bottom for test specimens machined are increased and the hardness in weld metal is decreased, and therefore the fracture tends to occur within the weld metal easily. Namely, the  $T_{rm}$  of each weld is considered to have the tendency to rise with an increase of the weld heat input.

Furthermore, in case of the result for the 1 mm notch depth to 10 mm squared specimen, the  $T_{Rm}$  tended to rise with an increase of the weld heat input.

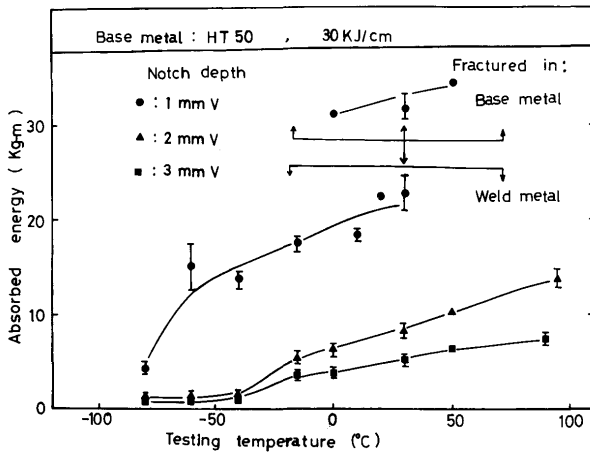


Fig. 9 Effect of notch depth variation to 10mm squared specimen on  $T_{Rm}$  shift for HT50 welds of 30KJ/cm weld heat input.

Nextly, Fig. 9 shows the effect of notch depth variation to 10 mm squared specimen on the shift of the  $T_{Rm}$  for HT50 welds of 30KJ/cm weld heat input. The  $T_{Rm}$  of the welds for 1,2 and 3mm V-notch depths was 30, > 100 and > 100°C, respectively. Namely, the  $T_{Rm}$  of each weld tended to shift to higher temperature with an increase of the notch depth, that is, with a decrease of the remained thickness in the notch bottom for Charpy specimen. Furthermore, the features on the  $T_{Rm}$ -shift of HT80 welds with the variation of weld heat input and notch depth are almost similar to those of HT50 welds. The relations between the notch depth to 10 mm squared specimen and the  $T_{Rm}$  for HT50 and 80 welds in various weld heat inputs are shown in Fig. 10. As stated in the above, it was found that the  $T_{Rm}$  for HT50 and 80 weld metal tended to be raised with an increase of the notch

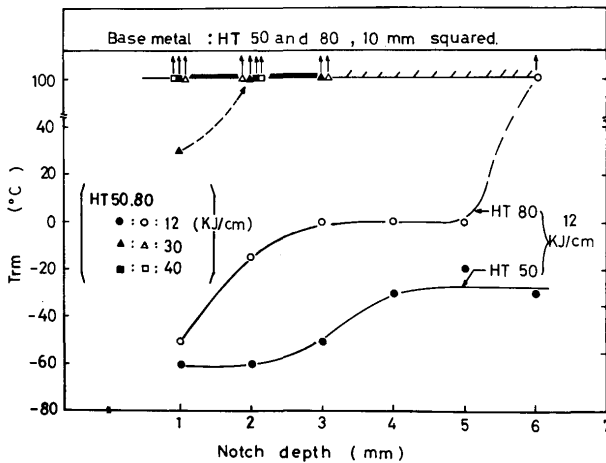


Fig. 10 Relation between notch depth to 10mm squared specimen and  $T_{Rm}$  for HT50 and 80 welds in various weld heat inputs.

depth or weld heat input. In case of 6mm V-notch to 10mm squared specimen, the  $T_{Rm}$  for HT50 and 80 welds of 12 KJ/cm weld heat input was -30 and > 100°C, respectively. This difference in  $T_{Rm}$  seems to be mainly caused by the respective hardness difference between the base and weld metals. Namely, as the hardness difference in HT50 welds is larger than that of HT80 welds, it is thought that the fracture of HT50 welds easily deviated to base metal side as compared with that of HT80 welds. Furthermore, by using the 15mm squared specimens, the notch depth of which is 2 or 4 mm, the impact tests were done concerning some of HT50 welds of 30 and 40KJ/cm weld heat inputs. As an example, Fig. 11 shows the effect of notch depth variation to 15 mm squared specimen on the  $T_{Rm}$ -shift for HT50 welds of 30KJ/cm weld heat input. The features on the  $T_{Rm}$ -shift for 15 mm squared specimen by the variation of weld heat input or notch depth are similar to those for 10 mm squared. As shown in Fig. 11, the  $T_{Rm}$  for the welds of 30KJ/cm in 2

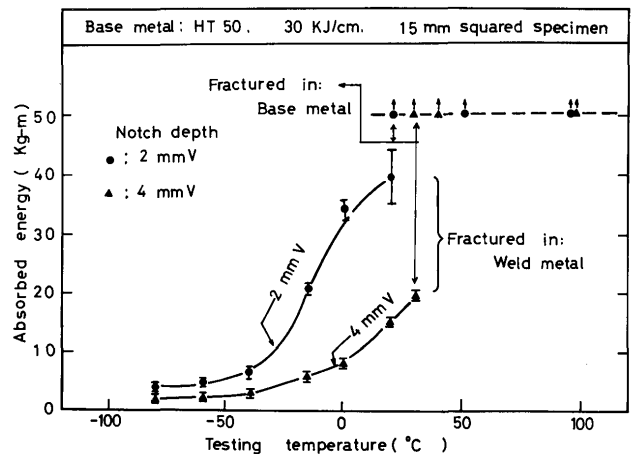


Fig. 11 Effect of notch depth variation to 15mm squared specimen on  $T_{Rm}$  shift for HT50 welds of 30KJ/cm weld heat input.

and 4 mm V notches was 20 and 30°C, respectively. Moreover the  $T_{Rm}$  for the welds of 40KJ/cm in 2 and 4 mm V-notches was > 100 and > 100°C, respectively. Furthermore, the  $T_{Rm}$  for 15 mm squared specimen seemed to show lower temperature than that for 10 mm squared at the same 2 mm notch depth in case of 30KJ/cm weld heat input.

### 4.3 Effect of heat treatment on $T_{Rm}$

Some of the welds of 12KJ/cm weld heat input were annealed with 450°C × 1 hr or with 650°C × 1 hr in order to reduce the hardness of weld metal. Then, Fig. 12 shows the comparison of the absorbed energy curves for HT80 welds without and with heat treatment for 2 mm V notch



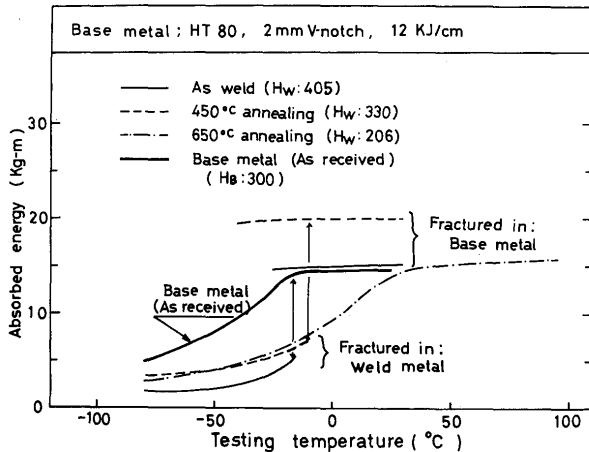


Fig. 12 Comparison of absorbed energy curves for HT80 welds without and with heat treatment for 2mm V notch to 10mm squared specimen.

to 10 mm squared specimen. The  $T_{Rm}$  for as-welds, 450°C and 650°C annealed welds is -15, -10 and >100°C, respectively. Namely, with an increase in the heat treatment temperature, that is, with a decrease in the hardness of weld metal, the  $T_{Rm}$  tended to be raised in general.

Also the respective impact strength of the weld metal always showed lower value than that of as-recieved base metal, however the impact strength at low testing temperature seems to be little raised by the heat treatments as compared with that of the as-welds. The tendencies for 4 and 5 mm notch depth specimen are almost similar to those in 2 mm notched. Furthermore, the features on the  $T_{Rm}$ -shift in HT50 welds with heat treatments had similar tendency to those in HT80 welds, however, the impact strength of weld metal for HT50 welds in case of 650°C annealing showed remarkably higher value than that of the as-weld for HT50.

#### 4.4 Relation between hardness and toughness in weld metal

Figs. 13 and 14 show the relations between the

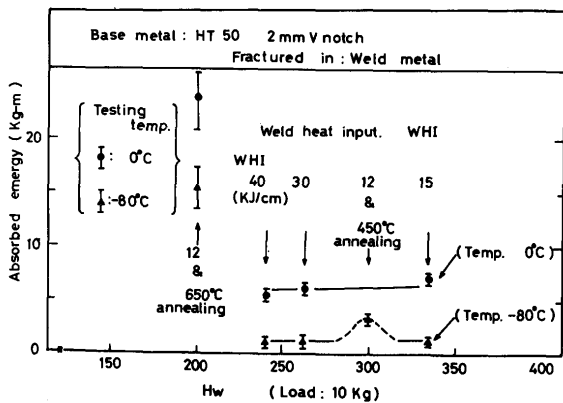


Fig. 13 Relation between average hardness and absorbed energy of weld metal for HT50 welds.

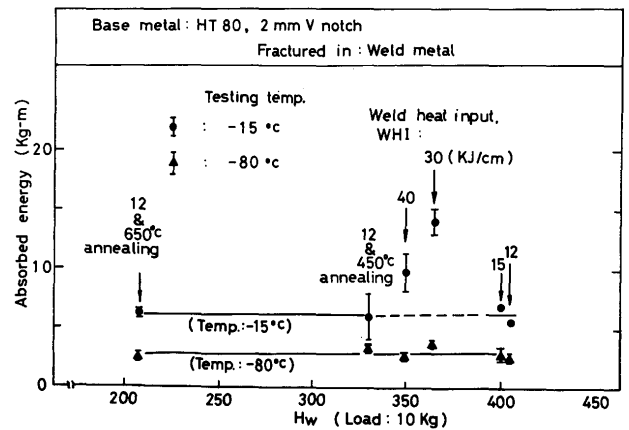


Fig. 14 Relation between average hardness and absorbed energy of weld metal for HT80 welds.

average hardness and the absorbed energy of the weld metal for HT50 and 80 welds by using the testing temperature as the parameter, respectively. The respective absorbed energy was shown in the value obtained by 2 mm V-notch specimen to 10 mm square, the fracture of which occurred within the weld metal. In HT50 welds (Fig. 13), the impact strength of the weld metal without heat treatments was not varied irrespective of the hardness variation, that is, the variation of weld heat input within the range of the authors' experiment. However, concerning the welds with heat treatments, the impact strength of the weld metal of 450°C annealed showed little higher value than that of the as-weld, and especially in 650°C annealed it showed remarkably high value. This will be due to a large change in microstructure of the weld by annealing. On the other hand, in HT80 welds (Fig. 14) the impact strength of the weld metal without and with heat treatments at the testing temperature, -80°C showed almost constant value regardless of the hardness variation of weld metal, according to a rough view. However, at -15°C testing temperature, the impact strength for the weld metal of 30 and 40KJ/cm weld heat inputs showed higher value than that for the others. This is due to the difference in the fracture propagation within the weld metal. Namely, in this case the fracture propagated along the notched location, but at the both sides of the notch for specimens it had a tendency to deviate partly to HAZ side. Therefore, it seems to show higher value. If there is no partial deviation to HAZ side at the both sides of notch, the impact strength is expected to show the similar value to that of the other welds.



fracture mode,  $T_{rm}$ , was made clear on the electron-beam welds for HT50 and 80 steels. The results obtained are as follows.

- (1) Effect of  $a_b$  parameter on the hardness of weld metal and the  $T_{rm}$ 
  - (a) The hardness of the weld metal showed a nearly constant value regardless of  $a_b$  parameter.
  - (b) The impact strength of the weld metal is irrespective of the variation of  $a_b$  parameter. The impact strength for HT50 welds corresponded to that for base metal, however in HT80 welds it showed lower value than that for base metal.
  - (c) The top bead width in Charpy test specimen showed an important influence on the  $T_{rm}$ -shift in case of the variation of  $a_b$ .
- (2) Effect of weld heat input or notch depth of Charpy test specimen on the  $T_{rm}$ .
  - (a) The  $T_{rm}$  has a tendency to be raised with an increase of weld heat input or notch depth of specimen.
  - (b) The  $T_{rm}$  for 15 mm squared Charpy test specimen showed lower temperature than that for 10 mm squared at the same notch depth.
- (3) Effect of heat treatment
  - (a) With an increase of the annealing temperature, that is, with a decrease of the hardness of the weld metal, the  $T_{rm}$  tended to be raised in general.
  - (b) The impact strength of the weld metal for HT50 welds with 650°C annealing showed remarkably higher value than that of the as-welded.
  - (c) Except for the HT50 welds with 650°C annealing, the impact strength for HT50 and 80 welds without and with heat treatment was not almost dependent on the hardness variation of the weld metal.
- (4) Limit of  $T_{rm}$  higher than 100°C
  - (a) Both of isothermal lines for the  $T_{rm} > 100^\circ\text{C}$  for the weld metal of HT50 and 80 steels were roughly

made clear by using the bead width to specimen size ratio and the hardness difference to base metal ratio.

- (b) The  $T_{rm}$  tends to be raised with an increase of the bead width ratio, or with a decrease of the hardness difference ratio.
- (c) The  $T_{rm}$  for the weld metal of HT80 steel showed in general lower temperature than that for HT50 weld metal at similar hardness difference ratio.
- (d) For the purpose of acquisition of the true ductility of the weld metal which has a narrow bead width and a high hardness. An attention should be paid for the decision in the size of Charpy test specimen. A criterion for decision in the size of Charpy specimen was established for the weld metal for HT50 and HT80 steels in this investigation.

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