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<th><strong>Title</strong></th>
<th>Quantitative Evaluation of Solidification Brittleness of Weld Metal during Solidification by In-Situ Observation and Measurement (Report IV): Effect of Grain-Boundary Sliding on Strain-Rate Dependence of Critical Strain Required for Solidification Crack Initiation (Materials, Metallurgy &amp; Weldability)</th>
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<td><strong>Author(s)</strong></td>
<td>Matsuda, Fukuhisa; Nakagawa, Hiroji; Tomita, Shogo</td>
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<tr>
<td><strong>Citation</strong></td>
<td>Transactions of JWRI. 16(2) P.317-P.323</td>
</tr>
<tr>
<td><strong>Issue Date</strong></td>
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<tr>
<td><strong>Text Version</strong></td>
<td>publisher</td>
</tr>
<tr>
<td><strong>URL</strong></td>
<td><a href="http://hdl.handle.net/11094/6337">http://hdl.handle.net/11094/6337</a></td>
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Quantitative Evaluation of Solidification Britteness of Weld Metal during Solidification by In-Situ Observation and Measurement (Report IV)†

— Effect of Grain-Boundary Sliding on Strain-Rate Dependence of Critical Strain Required for Solidification Crack Initiation —

Fukushia MATSUDA*, Hiroji NAKAGAWA**, Shogo TOMITA***

Abstract

Tensile hot cracking test, Trans-Farestraint cracking test and simulated hot ductility test have been carried out for stainless steels and Inconel alloy. The aim of this work is to investigate the next three phenomena from grain-boundary sliding. Namely: (1) the critical strain required for solidification crack initiation increases with an increase in strain rate, (2) the strain rate dependence increases with a decrease in crack susceptibility, and (3) the critical strain in the high strain rate is more sensitive to compare the crack susceptibilities among materials than that in the low strain rate.

Grain-boundary sliding has occurred at solidification grain-boundary of weld metal during solidification under the condition of low strain rate. Then, these phenomena in the above have been explained from the view point of contribution of grain-boundary sliding to total strain of weld metal.

KEY WORDS: (Solidification) (Hot Cracking) (Stainless Steel) (GTA Welding)

1. Introduction

The authors showed in the previous paper¹ that the critical strain required for the initiation of weld solidification crack increases with an increase in strain rate, and that the tendency is noticeable in materials of low crack susceptibility. Therefore, the cracking test with high strain rate was confirmed to be useful for the comparison of crack susceptibilities among materials¹, although the critical strain rate required for the initiation of the crack is alternative excellent criterion in the sense that the rate is as slow as that in actual welding fabrication. However, the reason for this strain rate dependence of the critical strain has not been clear.

In the field of hot workability, it is well known², ³) that flow stress and ductility increase with an increase in strain rate, and that generally grain-boundary sliding is one of major reasons for these strain rate dependences. Also in the field of creep, the importance of grain-boundary sliding is widely accepted. Moreover, one of the authors revealed concerning the ductility-dip cracking in welding of Fe-36%Ni alloy⁴) that grain-boundary sliding causes the formation of cavity at grain-boundary, and that high strain rate makes the ductility trough unclear because of the reduction of grain-boundary sliding. According to these references, the dependence of ductility on strain rate is considered to be directly correlated to the dependence of grain-boundary sliding on strain rate.

All these references above mentioned are concerned with the ductility below solidus temperature. However, there are a few reports⁵, ⁶) showing that flow stress increases with strain rate by compression test in solid-liquid coexistent temperature. However, study on the grain-boundary sliding in solid-liquid coexistent state has not been done until now.

Therefore, the purpose of this paper is to study whether grain-boundary sliding occurs or not within brittleness temperature range during weld solidification, and whether it has a strain-rate dependence or not if it occurs. In general, grain-boundary sliding is usually measured quantitatively by making marking line on the surface of specimen⁴).

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Transactions of JWRI is published by Welding Research Institute of Osaka University, Ibaraki, Osaka 567, Japan
However, it is impossible to make marking line on the surface of weld metal during solidification. Therefore, hot ductility test was done in solid-liquid coexistent temperature for the specimen with marking lines to assess the extent of grain-boundary sliding quantitatively.

2. Materials Used and Experimental Methods

2.1 Materials used

Commercial austenitic stainless steel (SUS310S) and Inconel alloy 600 were used, and their chemical compositions and thickness are shown in Table 1.

<table>
<thead>
<tr>
<th>Material</th>
<th>Item</th>
<th>Chemical composition (wt%)</th>
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<td></td>
<td></td>
<td>Cracking test.</td>
</tr>
</tbody>
</table>

*Designation follows Japanese Industrial Standard (JIS).

2.2 Tensile hot cracking test

The shape of the specimen used was the same as that in the previous paper, namely 300 x 1000 x 21 (mm). GTA welding was done without filler metal under the conditions of 70A, 12V (DCEN) and 0.83mm/s. Tensile deformation was applied perpendicular to the welding direction during the welding with the tensile hot cracking tester under the two kinds of crosshead speed (C.H.S.) of 0.1 and 20mm/s. Crosshead speed (C.H.S.) of 0.1mm/s was the same as that to evaluate the lower critical strain rate below which the crack can not occur as mentioned in the previous paper, and 20mm/s was maximum in the tester used. Strain and strain rate applied on the specimen are shown in Table 2. As soon as the tensile deformation was completed, welding was stopped and the specimen was immediately removed from the chuck to prevent grain-boundary sliding during cooling after solidification.

2.3 Trans-Varestraint cracking test

The size of the specimens used were 100 x 100 x 4.0 for SUS310S and 100 x 100 x 3.5 mm for Inconel 600. GTA welding was done without filler metal under the conditions of 100A, 15V (DCEN) and 2.5mm/s. The augmented strain evaluated by (t/2R) x 100(%) was set to 0.3, referred to 7 and 8, where t = thickness of specimen and R = radius of block. Two kinds of augmented strain rates shown in Table 2 were applied to the specimen by controlling the falling speed of yokes.

2.4 Simulated hot ductility test

It is difficult to measure the grain-boundary sliding in the tensile hot cracking test and the Trans-Varestraint cracking test, because any marking lines to measure the sliding can not be drawn on the surface of weld metal during solidification. Therefore, simulated hot ductility test was applied.

The shape and the size of specimen used in this test is shown in Fig. 1, where weld metal was located in the middle of specimen. The welding was done with GTAW under the conditions of 100A, 15V (DCEN) and 1.67mm/s with Ar gas back shielding. The bead width of top and back surfaces was about 5 ~ 6mm. The surface of specimen was polished electrolytically, and some ten straight marking lines to measure the grain-boundary sliding were scratched on the surface of weld metal by a razor. The test was done with high frequency induction heating system in
At atmosphere. The specimen was heated with the heating rate of about 44.7°C/s up to 1340°C, which was the liquation temperature of grain boundary in weld metal, and then tensile deformation was applied under keeping the temperature with two kinds of C.H.S., namely 0.06 and 6.07mm/s, shown in Table 2. Crosshead speed (C.H.S.) of 0.06mm/s was the same as that used to evaluate the lower critical strain rate in the tensile hot cracking test in the previous paper.\(^1\)

The deformation due to grain-boundary sliding and the total deformation of weld metal along the tensile direction was measured by optical microscope in X400 utilizing the marking lines. Figure 2 shows the fracture surface of specimen at the testing temperature. The fractograph showed a feature of smooth intergranular fracture caused by grain-boundary liquation.

![Fracture surface of weld metal after simulated hot ductility test (SUS316L, C.H.S. = 6.07mm/s, 1340°C).](image)

**Fig. 2** Fracture surface of weld metal after simulated hot ductility test (SUS316L, C.H.S. = 6.07mm/s, 1340°C).

3. **Experimental Results and Discussion**

3.1 **Observation of grain-boundary sliding in weld solidification cracking test**

Figure 3 shows the surface of weld metal within weld solidification brittleness temperature range (BTR) of Inconel alloy 600(A) tested by the tensile hot cracking test with C.H.S. = 0.1mm/s (strain rate = 1.2%/s). Columnar grain-boundaries at solidification, which is hereafter called solidification grain-boundary, is observed with solidification substructure and many slip bands after solidification. It is noticed that the surface of weld metal shows a difference in level at the solidification grain-boundary. This means grain-boundary sliding occurred at the solidification grain-boundary.

However, with the C.H.S. = 20mm/s (strain rate = 21%/s), such obvious difference in level on weld metal surface was not observed at solidification grain-boundary as shown in Fig. 4.

![Surface of weld metal of Inconel 600(A) with tensile hot cracking test under the condition of C.H.S. = 0.1mm/s.](image)

**(a) low magnification** (b) high magnification

**Fig. 3** Surface of weld metal of Inconel 600(A) with tensile hot cracking test under the condition of C.H.S. = 0.1mm/s.

![Surface of weld metal of Inconel 600(A) with tensile hot cracking test under the condition of C.H.S. = 20mm/s.](image)

**(a) low magnification** (b) high magnification

**Fig. 4** Surface of weld metal of Inconel 600(A) with tensile hot cracking test under the condition of C.H.S. = 20mm/s.
Figure 5 shows the surface of weld metal within BTR of SUS310S(A) tested by the Trans-Varestraint cracking test with the low strain rate (0.4%/s). A difference in level at the solidification grain-boundary was observed, namely solidification grain-boundary sliding occurred.

However, with the high strain rate (24.0%/s), such difference in level on weld metal surface was not observed obviously at solidification grain-boundary as shown in Fig. 6.

Therefore, it is confirmed that grain-boundary sliding occurs at solidification grain-boundary during solidification under the condition of low strain rate.

3.2 Quantification of grain-boundary sliding in grain-boundary liquation temperature

Figure 7 shows the surface of weld metal tested with C.H.S. = 0.06mm/s, where the straight lines are the scratches made to observe the grain-boundary sliding, and grain-boundary sliding is clearly observed as in (b). EDX analysis on this grain-boundary showed an increase of Cr content as seen in solidification grain-boundary, and thus confirms that this grain-boundary was liquated.

Figure 8 shows the surface of weld metal tested with C.H.S. = 6.07mm/s. Grain-boundary sliding hardly occurred.

Therefore, it is understood that the behavior of the grain-boundary sliding at the liquated grain-boundary is the same as that at solidification grain-boundary mentioned in 3.1.

Table 3 shows the contribution of grain-boundary sliding evaluated, where St means the total deformation of weld metal which was measured from the displacement of gauge length of 4.5mm, Sgb means the deformation due to grain-boundary sliding parallel to the tensile direction which was measured as the sum of the sliding at the all grain-boundary within the gauge length, and $\gamma$ means the contribution defined as Sgb/St. The value of $\gamma$ is 0.2 and less than 0.03 in C.H.S. of 0.06 and 6.07mm/s, respectively, and this strain rate dependence agrees with that in creep. By the may, the values of $\gamma$ are about 0.3 at 900°C in bicrystal of copper and about 0.5 at 100 ~ 300°C in Cu, Fe, Cd, Sn, Al and Al alloy. The value of $\gamma$ in the C.H.S. of 0.06mm/s in Table 3 is a little lower than these $\gamma$ values, but it may be regarded that the easiness of grain-boundary sliding is similar to that in creep, considering that the strain rate in this study is fairly higher than in creep.

3.3 Discussion of dependence of critical strain on strain rate

It is well known in the fields of creep and hot working
that (i) grain-boundary sliding is usually proportional to total strain\(^{12}\), (ii) the contribution of grain-boundary sliding to total strain decreases with stress\(^{10}\), and (iii) flow stress increases with strain rate\(^{13-15}\). Therefore, the relationship between grain-boundary sliding and total strain can be expressed follows:

\[ e_{gb} = \gamma (\dot{e}) \varepsilon_T \]  

(1)

where \( e_{gb} \) is the stress due to grain-boundary sliding, \( \varepsilon_T \) is total strain and \( \gamma (\dot{e}) \) is the proportional constant decreasing with strain rate \( \dot{e} \).

In the previous paper, the strain in the weld metal was measured by the MISO technique and the gauge length in the MISO technique was chosen from 0.9 \( \sim \) 1.7mm\(^{1}\).

\[
\begin{array}{|c|c|c|c|}
\hline
\text{C.H.S.} & \text{Total deformation} & \text{Deformation due to} & \text{Contribution of} \\
\text{(m/s)} & \text{(um)} & \text{grain-boundary sliding} & \text{Stg to St (Stg/St)} \\
\hline
0.06 & 140 & 28.1 & 0.2 \\
6.07 & >140 & <4.2 & <0.03 \\
\hline
\end{array}
\]

Table 3 Effect of strain rate on contribution of grain-boundary sliding to total deformation in solid-liquid region.

Generally, there are several grains in this gauge length as shown in Fig. 9. This means the strain measured by the MISO technique corresponds to \( \varepsilon_T \) in Eq. (1). Therefore, when solidification crack occurs, it is regarded \( \varepsilon_T \) in Eq. (1) has just become the critical strain required for crack initiation, \( \varepsilon_i \). And \( e_{gb} \) has just become the critical grain-boundary sliding, \( e_{gbc} \).

Therefore, just at the initiation of solidification crack, Eq. (1) is rewritten as follows:

\[ e_{gbc} = \gamma (\dot{e}) \varepsilon_i \]  

(2)

Namely, the critical strain, \( \varepsilon_i \) measured by the MISO technique is expressed as follows:

\[ \varepsilon_i = e_{gbc}/\gamma (\dot{e}) \]  

(2')

Equation (2') means that \( \varepsilon_i \) increases with an increase in \( \dot{e} \), because \( \gamma (\dot{e}) \) decreases with the increase in \( \dot{e} \).

Moreover, the reasons why the dependence of \( \varepsilon_i \) on strain rate increased with decreasing crack susceptibility and \( \varepsilon_i \) evaluated in high strain rate was more sensitive for the comparison of crack susceptibilities among materials.
than that in low strain rate can be explained as follows: The relationship between $\epsilon_{gbc}$ and $\epsilon_1$ is illustrated in Fig. 10, where a crack susceptible material having $\epsilon_{gbc1}$ and a crack insusceptible material having $\epsilon_{gbc2}$ are compared. Suppose that the two materials are tested with two strain rates, $\dot{\epsilon}_R$ and $\dot{\epsilon}_S$ (R: rapid, S: slow) to measure the critical strain $\epsilon_1$ by MISO technique. According to Eq. (2)', the gradient of $\epsilon_1$ vs $\epsilon_{gbc}$ in $\dot{\epsilon}_R$ is steeper than that in $\dot{\epsilon}_S$. That is, the difference between $\epsilon_{R2}$ and $\epsilon_{S2}$ is bigger than that between $\epsilon_{R1}$ and $\epsilon_{S1}$, meaning that the strain rate dependence of critical strain is noticeable in crack insusceptible material. Then, it is easily understood from Fig. 10 that the difference between $\epsilon_{R2}$ and $\epsilon_{R1}$ is bigger than that between $\epsilon_{S2}$ and $\epsilon_{S1}$, meaning that the critical strain measured in a high strain rate is more sensitive for the comparison of crack susceptibilities among materials.

Therefore, all the strain-rate dependence of solidification cracking can be explained from the viewpoint of the contribution of grain-boundary sliding to total strain of weld metal during welding.

4. Conclusion

Effect of grain-boundary sliding on strain-rate dependence of critical strain required for the initiation of weld solidification cracking was studied with the tensile hot cracking test, the Trans-Varestraint cracking test and the simulated hot ductility test for stainless steel and Inconel alloy. Main conclusions obtained are as follows:

(1) Under low strain rate condition, grain-boundary sliding occurs obviously within BTR. On the contrary, under high strain rate, it hardly occurs.

(2) The reasons why the critical strain increases with increasing the strain rate, the dependence of critical strain on strain rate increases with decreasing crack susceptibility, and the critical strain in high strain rate is more sensitive for the comparison of crack susceptibilities among materials than that in low strain rate can be explained from the view point of contribution of grain-boundary sliding to total strain of weld metal during welding.

Acknowledgement

The authors would like to thank Nippon Stainless Co., Ltd. for the offering of materials used.

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