

Table of Content

1. Introduction	1
1.1. Objectives	2
1.2. Motivation	3
1.3. Scope of work	3
2. Background	4
2.1. FSW	4
2.2. Background literature	5
2.3. Coupled model for friction stir welding	6
2.3.1. List of symbols	6
2.4. Scaling of the coupled thermal and mechanical problem	8
2.4.1. Heat conduction in the shear layer	8
2.4.2. Heat generation in the shear layer	10
2.4.3. Constitutive equation in the shear layer	11
2.4.4. Heat conduction outside the shear layer	12
2.4.5. Solutions of the system of scaled equations	13
2.5. Material Properties	14
2.5.1. Thermal and Mechanical Properties	14
2.5.2. Zenner-Hollomon law constants	15
3. Materials and methods	17
3.1. Methodology	17
3.2. Experiment selection	18
3.2.1. Data Base	18
3.2.2. Measurement Forms	18
3.3. Resources	19
4. Adjustment of coupled model for FSW	20
4.1. Influence of the heat loss through the plate	20
4.2. Modification of the coupled model for FSW	21
5. Results	22
5.1. Ratio of measurement and numerical results to estimations	22
5.1.1. Estimation of maximum temperature	23
5.1.2. Estimation of torque	28
5.1.3. Estimation of shear layer thickness	33
5.1.4. Correlation between the estimated and measured maximum temperature, torque and shear layer thickness	38

5.1.5. Incorporation of the fifth assumption	42
5.2. Error and Correction factors	44
6. Discussion	45
7. Conclusions	50
7.1. Future work	51
Bibliography	52
Annexed A. Measured of pin and shoulder for Colgrove Al7075	56
Annexed B. Summary of data compiled from literature without accounting for surface heat losses	57
Annexed C. Summary of data compiled from literature accounting for sur- face heat losses	63
Annexed D. Summary of data compiled of θ and ϕ.	69