



Faculty of Manufacturing Engineering

**CLADDING PROCESS USING GAS METAL ARC WELDING AS A
HEAT SOURCE AND 308L STAINLESS STEEL WIRE AS
FEEDSTOCK**

Nur Fawwaz Binti Asri

Master of Science

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NUR FAWWAZ BINTI ASRI

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ABSTRACT

Cladding technology in parts of manufacturing and repairing has been applied in many areas such as aerospace and automotive industries. One of the purposes of this technology is to prevent metallic surface from corrosion and wear. In order to reduce cost in tools and dies, layer-by-layer deposition technique in cladding process was formed by Gas Metal Arc Welding (GMAW) as a heat source. Stainless steel wire of 308L was used as a feedstock in which deposited on carbon steel substrate. The stainless steel wire was used to build the overlapped cladding for its known potential advantages. The 308L stainless steel clad was deposited directly by using a GMAW robotic welding to give a pore and crack free structure. The study was divided into two parts namely the investigation for stainless steel single bead clad and overlapped cladding (30% and 50% overlapped). The microstructure and microhardness behaviour of the 308L stainless steel structure was studied and solidification of 308L stainless steel during cladding process leads to dendritic formations which influence mechanical properties of the clad structure. Heat flow was studied to understand microstructure and microhardness variations of the clad material. The study also analysed corrosion behaviour of 308L stainless steel clad after cladding process. Design of Experiment (DOE) was employed in generated process parameter using Response Surface Methodology (RSM) method. Furthermore, the microstructural evolutions of 308L stainless steel cladding were investigated and the clad deposits were characterised by optical microscope, elemental mapping, Energy Dispersive X-ray (EDX), Vickers microhardness testing and electrochemical analysis. Results from the microstructural and microhardness properties was relate to the heat flow from the cladding process. The corrosion behaviour using Tafel extrapolation method was analysed in measuring the corrosion level of 308L stainless steel. Finding results indicated sample 12 (19.5V, 200 A and 35 cm/min) shows low corrosion rate behavior for 30% overlapped cladding.

ABSTRAK

Teknologi pelapisan dalam pembuatan dan pembaikan komponen telah diaplikasikan dalam pelbagai industri. Tujuan aplikasi pelapisan adalah untuk meningkatkan sifat permukaan logam daripada hakisan dan kehausan. Dalam usaha untuk mengurangkan kos bagi proses mengubah alat dan acuan, teknik lapisan demi lapisan dalam proses pelapisan telah dibuat dengan menggunakan Kimpalan Arka Logam Gas (GMAW) sebagai sumber haba. Dawai keluli tahan karat 308L telah digunakan sebagai bahan mentah dalam membaiki komponen yang rosak pada plat keluli karbon. Dawai keluli tahan karat menawarkan kelebihan yang berpotensi dan telah digunakan dalam kajian ini bagi membina pelapisan bertindih. Keluli tahan karat 308L telah dilapis terus dengan menggunakan robot Kimpalan Arka Logam Gas untuk memberi struktur yang tiada liang dan retak. Kajian penyelidikan dibahagikan kepada dua bahagian bagi mengkaji keluli tahan karat pelapisan tunggal dan pelapisan bertindih (30% dan 50% bertindih). Memahami mikrostruktur dan sifat kekerasan mikro untuk 308L struktur keluli tahan karat, pemejalan 308L keluli tahan karat semasa proses pelapisan membawa kepada pembentukan dendrit yang mempengaruhi sifat mekanikal struktur lapis. Aliran haba dianggap mengubah mikrostruktur dan mempertingkatkan kekerasan bahan. Kajian penyelidikan dijalankan dengan kakisan lapis keluli tahan karat 308L selepas proses pelapisan. Dalam tesis ini, Rekabentuk Ujikaji (DOE) telah digunakan dalam proses perolehan parameter menggunakan Kaedah Tindak Balas Permukaan (RSM). Di samping itu, evolusi mikrostruktur 308L keluli tahan karat pelapisan telah dikaji dan pelapisan dicirikan oleh mikroskop optik, pemetaan unsur, tenaga penyebaran x-ray, ujian kekerasan mikro Vickers dan analisa elektrokimia. Keputusan mikrostruktur dan kekerasan mikro bahan dihubungkan dengan aliran haba daripada proses pelapisan. Sifat kakisan menggunakan kaedah ekstrapolasi Tafel telah dikaji untuk mengukur kadar hakisan 308L keluli tahan karat. Keputusan kajian sampel 12 (19.5V, 200 A and 35 cm/min) menghasilkan kadar pengurangan yang rendah untuk 30% pelapisan bertindih.

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APPROVAL

This thesis is submitted to the Centre for Graduate Studies of UTeM as a partial fulfilment of the requirements for the Master of Science in Manufacturing Engineering. The member of the supervisory committee is as follow:

.....

Supervisor

.....

Co-supervisor

DECLARATION

I declare that this thesis entitle “Cladding Process Using Gas Metal Arc Welding as a Heat Source and 308L Stainless Steel Wire as Feedstock” is the result of my own research except as cited in the references. The thesis has not been accepted for any degree and is not concurrently submitted in candidature of any other degree.

Signature :

Name :

Date :

DEDICATION

To my parents, for their care, patience and teaching.

To Shahzrin Sabri

For his support, understanding and concern.

To my brother and sister

Fellow friends, course mates and Universiti Teknikal Malaysia Melaka as a whole.

LIST OF TABLES

TABLE	TITLE	PAGE
3.1	Nominal composition of ER 308L SS wire for cladding process.	33
3.2	The level of variable parameters in GMAW processes.	36
3.3	Cladding parameters generated using RSM method.	36
4.1	The 308L SS width, height and DOP of clad macrostructure.	45
4.2	The average HAZ width and maximum HAZ depth of 308L SS.	49
4.3	The size measurement of dendrite arm spacing 308L SS.	61
4.4	Weight percentage (wt%) of element in 308L SS mapping distribution.	63
4.5	The microhardness values of 15 samples produced.	65
4.6	The heat input values of 15 samples parameter.	72
4.7	The measurement clad dimension model and experimental generated by Smartweld software.	74
4.8	The measurement data of width clad changes for 50% and 30% overlapped cladding.	82
4.9	The theoretical and experimental measurement data of overlapping step length for 50% and 30% overlapped cladding.	83
4.10	Weight percentage (wt%) of element in 50% and 30% overlapped.	92
4.11	Microhardness values for overlapping 50% and 30% overlapped.	93
4.12	Corrosion rate values of experimental and theoretical 308L SS single bead clad with heat input 672 kJ/mm.	100
4.13	Corrosion rates value of experimental and theoretical 308L SS single bead clad with different heat input.	103
4.14	Corrosion rate values of experimental and theoretical of 50% and 30% overlapped cladding.	106

LIST OF FIGURES

FIGURE	TITLE	PAGE
2.1	Connecting rod produced from the HLM process.	8
2.2	Fe-C binary phase diagram for solidification in carbon steel and stainless steel welds.	10
2.3	Solidification in Fe-Cr-Ni welds.	12
2.4	Laser cladding deposit layer-by-layer on the shaft.	14
2.5	Laser cladding with powder injection clad onto substrate.	15
2.6	Laser cladding with wire feeding as a heat source deposited onto metal substrate.	16
2.7	The complete deposition processes through the macrostructure of weld beads.	17
2.8	Cladding of the inside of workpieces with nickel base alloy.	19
2.9	Alabama Laser uses several techniques.	20
2.10	The shaft wears after extended life used in FGD.	21
2.11	The Developed Repair Process for tapered fit section and seal surface Atomizer Shaft.	21
2.12	The thermal cycles and temperature distribution.	26
2.13	Schematic of welding path and welding thermal cycle.	27
2.14	Tafel extrapolation result from typical polarization test.	29
3.1	A cladding process using GMAW as a heat source and 308L SS wire as feedstock.	32
3.2	Isometric view for carbon steel plate dimension.	33
3.3	Electrochemical test setup.	39
4.1	308L SS single bead clad deposited on carbon steel substrate.	41
4.2	The optical micrographs of 308L SS clad measurement.	43
4.3	The effect of parameter on clad bead geometry.	44
4.4	Relationship between parameters and clad width of 308L SS.	46

4.5	Relationship between parameters and clad height of 308L SS.	47
4.6	Relationship between parameters and DOP of 308L SS.	47
4.7	Relationship between parameters and HAZ width of 308L SS.	50
4.8	Relationship between parameters and HAZ depth of 308L SS.	50
4.9	The cross section optical micrograph microstructure changes of a 308L clad layer.	53
4.10	The cross sectional microstructure in SS single bead clad.	54
4.11	Solidification in stainless steel 308L single bead clad.	55
4.12	HAZ solidification.	57
4.13	Carbon steel base plate.	58
4.14	Schematic diagram for the measurement of the primary dendrite arm length and secondary dendrite arm spacing.	60
4.15	Relationship between parameters and PDAS.	61
4.16	Relationship between parameters and SDAS.	62
4.17	Elemental distribution of SS 308L single bead clad from FZ to HAZ.	64
4.18	Microhardness distribution in 308L SS single bead clad.	66
4.19	Vickers Microhardness profile of stainless steel single bead clad	67
4.20	Relationship between parameters and FZ hardness.	68
4.21	Relationship between the arc current, arc voltage and traverse speed.	69
4.22	Relationship between parameters and microhardness.	69
4.23	Smartweld Rosenthal's steady state 3D for the thermal cycles.	71
4.24	Smartweld Rosenthal's steady state 3D weld parameter.	73
4.25	Overlapped of five layers of stainless steel 308L in 'zig-zag' direction.	80
4.26	Theoretical of 'zig-zag' direction applied on overlapped cladding.	80
4.27	Cross section schematic measurement of overlapping ratio in stainless steel deposit.	82
4.28	The cross sectional macrostructure of overlapped cladding.	84
4.29	The cladding section of 308L SS on carbon steel substrate at 50% overlapping ratio.	86

4.30	The cladding section of 308L SS on carbon steel substrate at 30% overlapping ratio.	87
4.31	Solidification phase in stainless steel 308L cladding overlapped.	88
4.32	Solidification mode of primary ferrite.	89
4.33	The overlapped cladding process of stainless steel 308L deposits.	90
4.34	The optical micrographs of overlapping microstructure.	91
4.35	Microhardness distribution in overlapped cladding 50% and 30% of 308L stainless steel wire.	93
4.36	Horizontal microhardness profiles of 308L SS with 50% overlapped ratio.	94
4.37	Tafel curves of tested samples with heat input 672 kJ/mm.	102
4.38	Tafel curves of tested samples with different heat input.	104
4.39	Relationship of the heat input and traverse speed with CR.	105
4.40	Tafel curves of overlapped cladding 308L SS for 50% and 30% overlapping ratio.	107

LIST OF ABBREVIATIONS

Ar	-	Argon
ASTM	-	American Society for Testing and Materials
BM	-	Base metal
C	-	Carbon
CAD	-	Computer Aided Design
cm/min	-	Centimetre per minute
CO ₂	-	Carbon dioxide
CR	-	Corrosion rate
Cr	-	Chromium
Cu	-	Copper
CZ	-	Clad zone
DMD	-	Direct metal deposition
DOE	-	Design of Experiment
DOP	-	Depth of penetration
DSPC	-	Direct shell production casting
E _{corr}	-	Voltage potential
EDX	-	Energy Dispersive X-ray
Fe	-	Ferum / iron
FGD	-	Flue Gas Desulfurization
FPI	-	Flourescent penetrant inspection
FZ	-	Fusion zone
GMAW/MIG	-	Gas metal arc welding/ metal inert gas
GTAW/TIG	-	Gas tungsten arc welding/ tungsten inert gas
HAZ	-	Heat affected zone
HCl	-	Hydrogen chloride acid
HLM	-	Hybrid layered manufacturing
I _{corr}	-	Current density

kJ/mm	-	Kilojoule/milimeter
mm/yr	-	Milimeter per year
Mn	-	Manganese
Mo	-	Molybdenum
NaCl	-	Natrium chloride
NC	-	Numerical codes
Ni	-	Nickel
OM	-	Optical microscope
P	-	Phosphorus
PAW	-	Plasma arc welding
PDAS	-	Primary dendrite arm spacing
RM	-	Rapid manufacturing
RP	-	Rapid prototyping
RSM	-	Research Surface Methodology
S	-	Sulfur
SDAS	-	Secondary dendrite arm spacing
Si	-	Silicon
SiC	-	Silicon carbide
SAW	-	Submerged arc welding
SEM	-	Scanning electron microscopy
TS	-	Traverse speed
XRD	-	X-ray diffraction

LIST OF SYMBOLS

A	-	Step length point
A	-	Thermal diffusivity (m^2s^{-1})
B	-	Interdendritic ferrite and austenite
Γ	-	Austenite
$\Gamma\delta$	-	Primary austenite with second phase ferrite
Δ	-	Ferrite
$\Delta\gamma$	-	Primary ferrite with second phase austenite
H	-	Efficiency
Ξ	-	Distance from the moving source measured along the positive x-axis ($\xi = x-vt$)
Λ	-	Thermal conductivity ($\text{Wm}^{-1}\text{K}^{-1}$)
λ_1	-	PDAS
μ	-	Micron
$\rho(T)$	-	Density of the metal as the function of the temperature (g/mm^3)
C	-	Carbon
$^{\circ}\text{C}$	-	Degree celcius
A	-	Arc current/current density
A	-	Area
$C(T)$	-	Specific heat of the metal as a function of temperature ($\text{J}/\text{g}^{-1}\text{K}^{-1}$)
EW	-	Equivalent weight
HV	-	Vickers hardness test
K	-	Overlapping ratio
$k(T)$	-	Thermal conductivity of the metal
M	-	Mole
N	-	Number of primary cells
Q	-	Rate of any internal heat generation (W/mm^3) / heat transfer
R	-	Rosenthal's radial distance from the heat source

T	-	Temperature of the weldment (K)
T	-	Time
V	-	Velocity
V	-	Arc voltage/voltage potential
V_x, V_y, V_z		Components of velocity
W	-	Watts
W	-	Width of single clad track (mm)
wt%	-	Weight percentage
X	-	Overlapping step length (mm)
X	-	Coordinate in the direction of welding
Y	-	Coordinate transverse to the welding direction
Z	-	Coordinate normal to weldment surface

TABLE OF CONTENT

	PAGE
ABSTRACT	ii
ABSTRAK	iii
ACKNOWLEDGMENT	iv
APPROVAL	v
DECLARATION	vi
DEDICATION	vii
LIST OF TABLES	ix
LIST OF FIGURES	x
LIST OF ABBREVIATIONS	xii
LIST OF SYMBOLS	xiv
CHAPTER 1	1
1. INTRODUCTION	1
1.0 Background of the Study	1
1.1 Problem Statement	3
1.2 Objectives	3
1.3 Scope of Study	4
CHAPTER 2	5
2. LITERATURE REVIEW	5
2.0 Introduction	5
2.1 Rapid Prototyping and Manufacturing	6
2.2 Deposition Process	7
2.2.1 GMAW as a Heat Source	7
2.2.2 Application Using GMAW In Manufacturing Industry	8
2.2.3 Direct Metal Deposition (DMD)	9
2.3 Metallurgy of Material	10
2.3.1 Carbon Steel	10
2.3.2 Stainless Steel	11
2.4 Cladding Process	12
2.4.1 Processing Involving a Powder	14
2.4.2 Processing Involving a Wire	15
2.4.3 Application of Cladding Technology in Industry	17
2.5 Measurement of Thermal Conditions in Direct Metal Deposition	22
2.5.1 Heat Flow	22
2.5.2 Rosenthal's Three Dimensional	24
2.5.3 The Welding Thermal Cycle	26
2.6 Cladding Metallurgy of Stainless Steel Deposited Affected by Parameter	27
2.7 Corrosion Resistance	28
2.8 Summary	30
CHAPTER 3	31
3. METHODOLOGY	31
3.0 Introduction	31
3.1 Research Methodology	31
3.2 Sample Preparation	33
3.2.1 Base Plate	33

3.2.2	Wire Electrode	33
3.2.3	Mounting	34
3.2.4	Grinding and Polishing	34
3.2.5	Etching	35
3.3	Process Experimental	35
3.3.1	Design of Experiment	35
3.4	Sample Testing	37
3.4.1	Scanning Electron Microscopy	37
3.4.1.1	Energy Dispersive X-ray (EDX)	37
3.4.1.2	Elemental Mapping	37
3.4.2	Optical Microscope (OM)	37
3.4.3	Microhardness	38
3.4.4	Electrochemical Analysis	38
3.5	Data Analysis	39

CHAPTER 4 40

4. RESULTS AND DISCUSSION – SINGLE BEAD CLAD 40

4.0	Introduction	40
4.1	Single Bead Clad	41
4.1.1	Macrostructure of the Claddings	41
4.1.2	Measurement of the Clad Dimension	43
4.1.3	Effect of Arc Voltage, Arc Current and Traverse Speed to the Clad	44
4.1.4	Effect of Parameter to the Width, Height and DOP Clad Measurement	45
4.1.5	Effect of Parameter to the HAZ Clad Measurement	49
4.1.6	Microstructure of the Claddings	52
4.1.6.1	Fusion Zone (FZ)	54
4.1.6.2	Heat Affected Zone (HAZ)	57
4.1.6.3	Base Plate of Carbon Steel (CS)	58
4.1.6.4	Dendrite Arm Spacing Measurement	59
4.1.7	Elemental Mapping	63
4.1.7.1	Elemental Distribution in 308L SS Clad Bead	63
4.1.8	Microhardness in 308L SS Single Bead Clad	65
4.1.8.1	Microhardness profile of 308L Single Bead Clad	66
4.1.8.2	Optimization of Parameter	68
	Heat Flow	70
4.1.9.1	Smartweld Result	72
4.1.9.2	Dimension of Clad Based on Model	73
4.1.10	Discussion (Single Bead Clad)	75
4.1.10.1	Comparison between Model and Measured Clad Dimension	75
4.1.10.2	Effect of Parameter on Clad Dimension	76
4.1.10.3	Mechanism of Microstructure Formation	77
4.1.10.4	Relationship of Heat Flow on Microstructure Formation	78
4.1.10.5	Microhardness Variation	78
4.2	Overlapped Clad	80
4.2.1	Cladding Processes	80

4.2.1.1	Overlapping Ratio	81
4.2.1.2	Effect of Parameter to the Clad Layer	83
4.2.2	Overlapping Macrostructure	84
4.2.2.1	Overlapping Ratio	85
4.2.3	Overlapping Microstructure	88
4.2.3.1	Overlapping Cladded Samples	90
4.2.4	Elemental Mapping of Overlapped Samples	91
4.2.5	Microhardness	92
4.2.5.1		94
	Effect of Overlapped Parameter on Microhardness	
4.2.6	Discussion (Overlapped Clad)	95
4.2.6.1	Effect of Overlapping Ratio on Clad Layer	95
4.2.6.2	Cladding Path	96
4.2.6.3	Solidification Layer	97
4.2.6.4	Microhardness Variation of the Cladding Layer	98
4.3	Electrochemical Analysis	99
4.3.1	Analysis of 308L SS Single Bead Clad	99
4.3.2	Relationship between Heat Input and Traverse speed to the Corrosion Rates Measurement 308L SS Single Bead Clad	104
4.3.3	Analysis of 308L SS Overlapped Cladding	105
4.3.4	Discussion (Electrochemical Analysis)	107
4.3.4.1	Effect of Heat Input and Traverse Speed to the Corrosion Rate 308L SS Single Bead Clad	107
4.3.4.2	Effect of Overlapped Ratio to the Corrosion Rate 308L SS Overlapped Cladding	108
4.4	Summary	110
CHAPTER 5		111
5.	CONCLUSION AND RECOMMENDATIONS	111
5.1	Conclusions	111
5.2	Recommendations for Future Research	113
REFERENCES		114
APPENDICES		124

CHAPTER 1

INTRODUCTION

1.0 Background Study

Layer-by-layer process is one of the techniques used to fabricate a thin layer of high resistant material onto substrate. Akula *et. al.* (2006) used this technique by applying hybrid layered manufacturing. In addition, the similar technique has been developed to cover the required area of the substrate called cladding. Komvopoulos *et. al.* (1990) was claimed that the added material is fused onto the substrate which creates different metallurgical properties after a cladding process. As the process partially melts the added material onto the substrate, it creates a very thin layer to attain a metallurgical bonding with minimal dilution. The added material sustains the original properties of coating material once melted with the substrate.

At present, most of the cladding process is performed by using laser as a heat source and either powder or wire is used as a feedstock. For example, Leunda *et.al.* (2011) was used vanadium carbide tool steel powders for die repair while Cottam *et. al.* (2011) was used titanium alloys powder in repairing aircraft components. Meanwhile, Palani *et. al.* (2006) use wire as an added material in cladding stainless steel (SS). The cladding studies have shown the properties of microhardness increased at the clad material.

Carbon steel components used as substrate are exposed to wear due to several times of services. Anjos *et. al.* (1997) states that carbon steel tends to corrode and damage during a long exposure in seawater. The layer-by-layer deposit is applied to repair the damaged parts of the carbon steel. Amado *et. al.* (2011) and Anjos *et. al.* (1997) repairs the damaged parts using layer-by-layer techniques. Therefore, austenitic 308L SS is used as the added material onto the carbon steel substrate in this focused research. In order to prevent carbon steel from corrosion in many industrial applications (Anjos *et. al.*, 1997), SS is commonly used as clad material (Palani *et. al.*, 2006).

Currently, cladding process has used quite a number of different techniques such as gas tungsten arc welding (GTAW), submerged arc welding (SAW), plasma arc welding (PAW) and gas metal arc welding (GMAW). In order to attract the interest of manufacturing industries, the GMAW was used as the heat source for this research study. The study of cladding process using GMAW was investigated using SS wire as the feedstock. The study was carried out by the automatic feeding of a continuous consumable electrode and robot welding.

The cladding process is an addition of material based on the rapid prototyping (RP) technology. Akula *et. al.* (2006) claim that the shape and dimensions of the clad bead are very important in the use of 3D deposit as an RP system for the layer manufacturing processes. Furthermore, by the use of arc cladding process, it is possible to deposit different material between 308L SS on carbon steel substrate (Anjos *et. al.*, 1997 and Hussein *et. al.*, 2011). In order to understand the cladding process using the automated robotic GMAW, the 308L SS wire was deposited layer-by-layer on carbon steel substrate. This process would improve the understanding of microstructural evolution and microhardness of material due to the cladding process.

1.1 Problem Statement

At present, high corrosion resistance and good performance of materials are essential for a long term reliability service in manufacturing environment. However, a part has a certain life time before it is damaged. Fabricating new part to replace the damaged part incur cost. Thus, repair was a better option. GMAW is one of the alternatives used to repair the damaged parts as it is more economical for repairing purposes (Sreeraj *et. al.*, 2013). Extensive research has been carried out by researchers on the cladding process using GMAW. The common filler materials used were titanium (Carvalho *et. al.*, 2011), stellite (Madadi *et. al.*, 2009 and Gupta *et. al.*, 2010) and nickel (Gupta *et. al.*, 2011). However, the cost of those filler materials is not economical for bulk repairing process. SS wire is one of the alternatives used as it is more economical compared to other filler materials. However, there is a lack of study on the effect of GMAW cladding process using 308L SS wire. The main aim of this research, then, is to study the effect of GMAW cladding using 308L SS wire on the mechanical properties and corrosion resistance of the cladded metal. The 308L SS is better for high temperature application and better creep resistance onto carbon steel substrate (Vitek *et. al.*, 1992 and Lincoln, 2010).

1.2 Objectives

The overall aim of this research is to get an insight of the process characteristics in an attempt to understand the property, structure and process interaction associated with the shape metal deposition using GMAW as the heat source on a metal. The objectives of the research are to:

- i. Study on the stainless steel used can be cladded directly by using gas metal arc welding (GMAW) as the heat source to give a pore and crack free structure.
- ii. Analyse the effect of process parameters on microstructural evolution and mechanical behavior of the cladding material.
- iii. Evaluate microstructural evolution and mechanical behavior with the heat flow during the cladding process.
- iv. Evaluate the corrosion behavior of the cladded substrate.

1.3 Scope of the Study

This research focused primarily was used GMAW as a heat source on improving properties of 308L SS onto carbon steel substrate using cladding process. The variables parameter evaluated were arc voltage, arc current and traverse speed. The experimental were carried out using DOE by RSM method.

Microhardness properties of clad were examined using Vickers microhardness in accordance with ASTM E92. For microstructure observation, optical microscope was used. A sample preparation for microstructural evolution was based on ASTM E3-01. While other aspect such as clad dimension was measured. Fusion zone (FZ), heat affected zone (HAZ), depth of penetration (DOP) and heat flow of the cladding process was simulated using Smartweld software.

The general corrosion test was included using a typical test method known as electrochemical testing (Tafel). A comparison of the corrosion behaviour of variables parameter used (arc voltage, arc current and traverse speed) and heat input during cladding was included to prove that 308L SS can prevent and improve the corrosion resistant onto carbon steel substrate using GMAW. The mechanical properties caused by the corrosion were not covered in this study.

CHAPTER 2

LITERATURE REVIEW

2.0 Introduction

This chapter reviews techniques to overcome problems such as resistance against wear and corrosion besides several thermal surface treatments that are currently available. Cladding is widely used to improve the surface properties of metallic parts. Various industries use cladding process to enhance material surface properties from corrosion and wear, repair worn parts and form near net shaped structures (Penn, 2008). Lim *et. al.* (2008) state that the cladding process develops new properties of material as well as improves damaged surface. In addition, Pinkerton *et. al.* (2008) also states that the cladding of SS and superalloy materials onto low alloy substrates has a potential for industrial application when a good corrosion or wear resistance is required. The arc fusion processes such as shielded metal arc welding (SMAW), gas metal arc welding (GMAW), submerged arc welding (SAW), gas tungsten arc welding (GTAW) and plasma arc welding (PAW) are widely used for the cladding operations.. This is supported by Schneider's (1998) study whereby the flame spraying, plasma spraying and arc welding are established techniques for cladding. In the study of cladding using GMAW as heat source and SS wire as feedstock, the cladding process comprises a formation of a new surface layer made up of 308L SS on top of corrosive such as carbon steel substrate. The new surface layer and properties are formed during heating and cooling section during layer-by-layer cladding process occurred.