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Date: 29 June 1962

INVESTIGATION OF ALUMINUM ALLOY 6061 T4-T6
WELDED AND UNWELDED

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BELL AEROSYSTEMS COMPANY
DIVISION OF BELL AEROSPACE CORPORATION

BELL AEROSYSTEMS COMPANY
DIVISION OF BELL AIRSPACE CORPORATION

Engineering Laboratories

Bell Laboratory Report

BLR 61-40 (M)

Revision A

INVESTIGATION OF ALUMINUM ALLOY 6061 T4-T6

WELDED AND UNWELDED

Contract: Company R&D

Project: R&D Lab No. 14

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Model _____	BELL AEROSYSTEMS COMPANY DIVISION OF BELL AIRSPACE CORPORATION	Page _____
Date _____		Report BLR 61-40 (H)

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Model _____	CELL APPROVED VERIFICATION CONTRACT DIVISION OF CELL DEVELOPMENT CORPORATION	Page <u>1</u>
Date <u>12-29-61</u>		Report <u>HLR 61-10 (M)</u>

TABLE OF CONTENTS

	<u>Page</u>
I INTRODUCTION	1
II TEST PROCEDURE	4
A. Mismatch	4
B. Weld Repair	8
C. Mechanical Properties	16
D. Bulge Test	64
III METALLURGY AND HEAT TREATMENT OF 6061	69
IV DISCUSSION OF RESULTS	70
V FUTURE WORK	72

Model _____	BELL AEROSPACE SYSTEMS COMPANY DIVISION OF BELL AEROSPACE CORPORATION	Page <u>11</u>
Date <u>12-29-61</u>		Report <u>BLR 61-40 (H)</u>

LIST OF ILLUSTRATIONS

<u>Figure</u>		<u>Page</u>
1.	Photomicrograph showing various percentages of mismatch.	7
2.	Stress vs Strain Curves for 6061-T4 - Transverse Direction - gage .064"	35
3.	Stress vs Strain Curves for 6061-T4 - Longitudinal Direction - gage .064"	36
4.	Stress vs Strain Curves for 6061-T4 - Transverse Direction - Heliarc Welded - Filler 4043 - Gage .064"	37
5.	Stress vs Strain Curves for 6061-T4 - Longitudinal Direction - Heliarc Welded - Filler 4043 - gage .064"	38
6.	Stress vs Strain Curves for 6061-T6 - Transverse Direction - gage .064"	39
7.	Stress vs Strain Curves for 6061-T6 - Longitudinal Direction - gage .064"	40
8.	Stress vs Strain Curves for 6061-T6 - Transverse Direction - Heliarc Welded Filler 4043 - gage .064"	41
9.	Stress vs Strain Curves for 6061-T6 - Longitudinal Direction - Heliarc Welded Filler 4043 - gage .064"	42
10.	Stress vs Strain Curves for 6061-T4 - Transverse Direction - gage .125"	43
11.	Stress vs Strain Curves for 6061-T4 - Longitudinal Direction - gage .125"	44
12.	Stress vs Strain Curves for 6061-T4 - Transverse Direction - Heliarc Welded - Filler 4043 - gage .125"	45
13.	Stress vs Strain Curves for 6061-T4 - Longitudinal Direction - Heliarc Welded Filler 4043 - gage .125"	46

Model _____	BELL AEROSPACE COMPANY DIVISION OF BELL AIRCRAFT CORPORATION	Page 111
Date 12-29-61		Report BLR 61-40 (M)

LIST OF ILLUSTRATIONS (continued)

<u>Figure</u>		<u>Page</u>
14.	Stress vs Strain Curves for 6061-T6 Transverse Direction - Gage .125"	47
15.	Stress vs Strain Curves for 6061-T6 Longitudinal Direction - gage .125"	48
16.	Stress vs Strain Curves for 6061-T6 Transverse Direction - Heliarc Welded Filler 4043 - gage .125"	49
17.	Stress vs Strain Curves for 6061-T6 Longitudinal Direction - Heliarc Welded Filler 4043 - gage .125"	50
18.	Stress vs Strain Curves for 6061-T6 at -320°F - gage .125"	51
19.	Stress vs Strain Curves for 6061-T6 at -320°F - gage .064"	52
20.	Stress vs Strain Curves for 6061-T6 at -320°F - gage .125"	53
21.	Stress vs Strain Curves for 6061-T6 at -320°F - gage .064"	54
22.	Stress vs Strain Curves for Heliarc Welded 6061-T6 at -320°F filler 4043 gage .125" . . .	55
23.	Stress vs Strain Curves for 6061-T6 Transverse Direction - Heliarc Welded Filler 4043 - 50% mismatch	56
24.	Stress vs Strain Curves for 6061-T6 Transverse Direction - Heliarc Welded Filler 4043 - 100% mismatch gage .064" . . .	57
25.	Stress vs Strain Curves for 6061-T6 Heliarc Welded - Filler 4043 -320°F gage .064"	58
26.	Stress vs Strain Curves for 6061-T6 Transverse Direction - Heliarc Welded Filler 4043 - 100% mismatch gage .125"	59
27.	Stress vs Strain Curves for 6061-T6 Heliarc Welded - Filler 4043 -320°F gage .125"	60

Model _____	BELL AEROSYSTEMS COMPANY DIVISION OF BELL AEROSPACE CORPORATION	Page <u>iv</u>
Date <u>12-29-51</u>		Report <u>DIM-41-450 (H)</u>

LIST OF ILLUSTRATIONS (continued)

<u>Figure</u>		
28.	Stress vs Strain Curves for 6061-T6 Heliarc Welded .4043 40-30-30 gage .031"	61
29.	Stress vs Strain Curves for 6061-T6 Transverse Direction - Heliarc Welded Filler 4043 25% mismatch - gage .125"	62
30.	Stress vs Strain Curves for 6061-T6 Transverse Direction - Heliarc Welded Filler 4043 - 50% mismatch - gage .125" . . .	63
31.	Bulge Diaphragm Test Fixture.	65
32.	Bulge Test Fixture	66
33.	Bulge Test Fixture Disassembled	66
34.	Radius of Curvature Calculation	67

Model _____
Date 12-29-61

HELL AEROSYSTEMS COMPANY
DIVISION OF BELL AEROSPACE CORPORATION

Page Y
Report ELR 61-40 (H)

LIST OF TABLES

<u>Table</u>		<u>Page</u>
I	Physical Properties of 6061 Aluminum Alloy	2
II	Guarantee Minimums for Aluminum Alloy 6061	3
III	Room Temperature Mechanical Properties of 6061T6 Heliarc Butt Welds (.124" Thick Material)	5
IV	Room Temperature Mechanical Properties of 6061T6 Heliarc Butt Welds (.064" Thick Material)	6
V	6061T4 Manual Weld and Aged to T6	9
VI	6061T4 Automatic Weld and Aged to T6	10
VII	6061T4 Automatic Weld and (one) Repair Aged to T6	11
VIII	6061T4 Automatic Weld and (two) Repairs Aged to T6	12
IX	6061T4 Sigma Weld and Aged to T6	13
X	6061T4 Sigma Weld and (one) Repair Aged to T6	14
XI	6061T4 Sigma Weld and (two) Repairs Aged to T6	15
XII	Unwelded 6061T4 Transverse Properties	17
XIII	Unwelded 6061T4 Longitudinal Properties	18
XIV	As-Welded 6061T4 (Transverse Properties of Sheet)	19
XV	As-Welded 6061T4 (Longitudinal Properties of Sheet)	20
XVI	Unwelded Notched 6061T4 Transverse Properties	21
XVII	Unwelded Notched 6061T4 Longitudinal Properties	22
XVIII	As-Welded and Notched 6061T4 (Transverse Properties of Sheet)	23
XIX	As-Welded and Notched 6061T4 (Longitudinal Properties of Sheet)	24
XX	Unwelded 6061T6 Transverse Properties	25
XXI	Unwelded 6061T6 Longitudinal Properties	27

Model _____
Date 12-29-61

BELL AEROSYSTEMS COMPANY
DIVISION OF BELL AIRCRAFT CORPORATION

Page VI
Report ELR 61-40 (M)

LIST OF TABLES (continued)

<u>Table</u>	<u>Page</u>
XXII 6061T4 Welded and Aged (Transverse Properties of Sheet)	29
XXIII Welded and Aged 6061T4 (Longitudinal Properties of Sheet)	30
XXIV Unwelded Notched 6061T6 Transverse Properties	31
XIV Unwelded Notched 6061T6 Longitudinal Properties	32
XIVI 6061T4 Welded and Aged, Notched (Transverse Properties of Sheet).	33
XIVII 6061T4 Welded and Aged, Notched (Longitudinal Properties of Sheet).	34
XIVIII Bulge Test Data	68

Model _____	BELL AEROSYSTEMS COMPANY DIVISION OF BELL TELEPHONE CORPORATION	Page <u>1</u>
Date <u>29 June 1962</u>		Report <u>BIR 61-10(N) Rev. A</u>

I. INTRODUCTION

The fusion welding of the aluminum alloy 6061 has been a part of fabrication development at Bell Aerosystems since the construction of the Rascal missile. New designs involving performance in or with new environments have necessitated the generation of design data not required previously such as mechanical property data at various cryogenic temperatures. For the most part, data available in the literature due to differences in welding techniques is not applicable. Bell Aerosystems' welding techniques have developed to a state that allows Bell designers to use higher values than those found in the literature and published by other companies.

Aluminum alloy 6061 was studied from practical welding considerations. Every effort was made throughout the program to duplicate in-shop welding and heat treatment conditions. Areas of concern to the design and metallurgical engineering departments in regard to tank fabrication, including mismatch due to improper line up of various degrees (25, 50 and 100%), effect of weld repairs, hand versus machine, effect of aging, and the effect of low temperatures on the mechanical properties of welded and unwelded, notched and unnotched, solution treated and solution treated and aged material, were studied.

For clarity of presentation, each phase of the program will be reported on separately. However, the interaction of the various parameters reported on must be considered in any end item to be constructed.

Mismatch is encountered in hardware fabrication as the result of poor line up or warpage of one piece of material in respect to another prior to welding. The designer is in need of this information to arrive at sound engineering safety factors.

Weld repairs are a part of the daily routine of any airframe welding shop. However, the variety of conditions encountered make it difficult to assess the deterioration of weld joint strength. Hand repairs or welded parts fabricated with machine welds in which a precise degree of control over speed is exercised are detrimental.

Model	29 June 1962	BELL AEROSYSTEMS COMPANY DIVISION OF BELL AEROSPACE CORPORATION	Page 2
Date			Report BLR 61-10(1) cv. A

Cryogenic temperatures are to be encountered in the storage of missile propellant fuels. Liquid gases for the above application result in temperatures from -150 F to -423 F. Specialists in this cryogenic field maintain that face-centered cubic metals are superior to the body-centered metals. Aluminum and its alloys are face-centered cubic but performance within this group varies. Ductility of the aluminum alloys suffers as temperatures approach absolute zero (-460 F). Welded structures of aluminum are more subject to fatigue failure at the low temperatures despite the increase in yield and tensile strength that results from such an environment. It has been the purpose in this program to determine (1) the strength of the material (6061T6) unwelded and welded at -150 F and -320 F, (2) the effect of a "V" notch on welded and unwelded material, (3) the total elongation occurring at temperature, (4) the strain magnitude encountered at the apex of the "V" notch so that a relationship might be arrived at for elongation as reported in a standard two inch uniform cross sectional area specimen and a two inch "V" notch elongation where the cross sectional area is non-uniform due to the presence of the notch.

Heat treatment of aluminum alloys has been and will continue to be a shop practice requiring rigid controls on the equipment used and personnel performing the operations. Heat treatable aluminum alloys such as 6061 develop their properties by solution heat treatment and quenching, which suspends a precipitate (the result of alloying) in the aluminum matrix, followed by either natural or artificial aging, which promotes the growth of the precipitate resulting in a strengthened atomic lattice.

The physical properties of interest of the 6061 aluminum alloy studied herein are given in Table I.

TABLE I

Physical Properties of 6061 Aluminum Alloy

Density	.098 lb/in ³
Melting range (F)	1080-1200
Coeff. of Thermal Expansion (in/in/F x 10 ⁻⁶) 68-212 F	13.1
Thermal Conductivity BTU/in/ft ² /F/hr at 77 F	1070 (T6)

Model _____	BELL AEROSYSTEMS COMPANY DIVISION OF BELL AIRCRAFT CORPORATION	Page <u>3</u>
Date <u>12-29-61</u>		Report <u>BLR 61-40 (H)</u>

The guarantee minimums for 6061T4 and T6 set forth in Military Handbook 5 are given in Table II.

TABLE II
Guarantee Minimums for Aluminum Alloy 6061

	<u>T4 Condition</u>	<u>T6 Condition</u>
Tensile Ultimate	30,000	42,000
Yield Strength (0.2% offset)	16,000	35,000
% Elongation in 2 inches	16	10

Model _____	BELL AEROSYSTEMS COMPANY DIVISION OF BELL TELEPHONE CORPORATION	Page <u>1</u>
Date <u>29 June 1962</u>		Report <u>BLR 61-49(M) Rev. A</u>

II. TEST PROCEDURE

A. Mismatch

In this phase a group of tensile specimens was deliberately misaligned to obtain 25, 50 and 100% mismatch with 0.125 inch thick material and 50 and 100% mismatch with 0.064 inch material. The 25% mismatch was not run on the 0.064 inch material. On the thinner material this degree of mismatch was very small, approximately 0.016 of an inch. The mismatch is expressed as percentage of total sheet thickness. Butt joints were made in 4 inch by 12 inch plates. These plates yielded nine tensile specimens per plate. The bars were tested at room temperature under uniaxial load conditions (shims were used to maintain alignment).

Figure 1 shows a typical grouping of the samples. Samples marked A are representative of 100% mismatch, B samples 50% and the C sample 25%. The excess weld metal shown in the pictures of the 0.125 inch samples A and B was not ground off for it has no effect on the mechanical properties.

The mechanical properties of the specimens tested are summarized in Tables III and IV. All specimens were welded in the T condition and aged to the T6 temper after welding.

Model _____		BELL AEROSYSTEMS COMPANY		Page <u>2</u>	
Date <u>12-2-61</u>		DIVISION OF BELL TELEPHONE CORPORATION		Report <u>BLR 01-40 (H)</u>	

Table III

Room Temperature Mechanical Properties of 6061 T6 Heliarc Butt Welds
(.125" Thick Material)

After various percentages of mismatch, material welded in T₄ condition 20 ipm and aged to T₆.

Specimen Number	Spec. Thick inches	% Mismatch	Tensile Str. (psi)	Yield Str. (psi)	Elong. % in 2"	Fracture Area
1.	.125	25	37,300	36,400	4	Base Metal
2.	.125	25	36,900	35,000	4	Base Metal
3.	.125	25	39,700	34,600	4	Base Metal
AVG.			37,966	35,333	4	
1.	.125	50	42,100	32,900	2	Edge Weld
2.	.125	50	39,800	33,000	2	Edge Weld
3.	.125	50	40,200	33,400	2	Edge Weld
AVG.			40,700	32,966	2	
1.	.145	100	33,800	26,400	2	Edge Weld
2.	.125	100	33,700	25,200	1	Edge Weld
3.	.125	100	36,600	26,600	2	Edge Weld
AVG.			34,700	26,066	1.67	

Model _____	DELL AEROSPACE COMPANY DIVISION OF DELL AEROSPACE CORPORATION	Page <u>6</u>
Date <u>12-29-61</u>		Report <u>BLR 61-40 (M)</u>

TABLE IV
Room Temperature Mechanical Properties of 6061T6 Heliarc Butt Welds
(.064" Thick Material)

After various percentages of mismatch, material welded in T₄ condition 20 ipm and aged to T₆.

Specimen Number	Spec. Thick. inches	% Mismatch	Tensile Str. (psi)	Yield Str. (psi)	Elong. % in 2"	Fracture Area
1.	.064	50	42,000	"	2	Edge Weld
2.	.064	50	42,100	32,700	2	Edge Weld
3.	.064	50	40,600	30,800	2	Edge Weld
AVG.			4,566	31,700	2	
1.	.064	100	32,300	31,600	.5	Edge Weld
2.	.064	100	34,700	33,800	.5	Edge Weld
3.	.064	100	32,700	32,600	.5	Edge Weld
AVG.			33,233	32,666	0.5	

Model _____	BELL AEROSPACE TENSILE COMPANY DIVISION OF BELL TELEPHONE CORPORATION	Page <u>7</u>
Date <u>12-29-61</u>		Report <u>BLR 61-40 (4)</u>

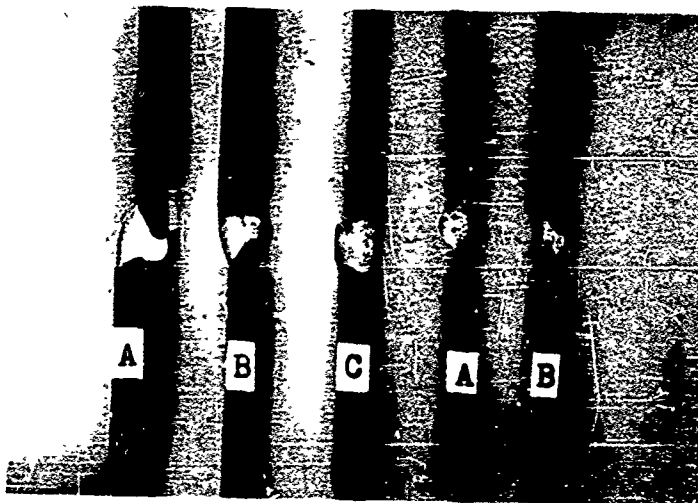


Figure 1. Photomicrograph showing various percentages of mismatch. Specimens marked

- A = 100%
- B = 50%
- C = 25%

Model	12-29-61	WILL. A. BROWN & SONS COMPANY DIVISION OF WILL. A. BROWN CORPORATION	Page	8
Date			Report	ELR 61-40 (M)

B. Weld Repair

This portion of the program deals with the effort made to ascertain strength depreciation following weld repairs. It is standard practice in the fabrication of parts to grind out defects found by radiographic techniques and re-weld the joint. The size and depth of the weld repair determines the area of depreciation.

Three plates were heliarc welded with the direction of rolling and three transverse to the direction of rolling. Fifty per cent of the weld metal was ground out of, 2 plates manually heliarc welded with the direction of rolling, two plates manually heliarc welded transverse to the direction of rolling, two plates automatic heliarc welded with the rolling direction and two plates automatically heliarc welded in the transverse rolling direction. The plates were then rewelded using the same welding method used on the original weld. One of two plates from each group was ground out for the second time and re-welded. After welding the plates were artificially aged to the T6 condition. Tensile specimens blanks were then cut from the welded plates and subsequently machined to the standard tensile specimen configuration. Tables V through XI present the data obtained. The control samples were taken at the beginning and end of each weld repair. They are representative of the welded sheet unrepaired.

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TABLE V

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Model _____		BELL AEROSYSTEMS COMPANY DIVISION OF BELL TELEPHONE CORPORATION		Page 10
Date 12-22-61				Report BLR 61-40 (M)
TABLE VI (1) 6061T6 - Automatic Weld and Used to 76				
Thickness	Specimen Number	.050"		.125"
		Tensile Str.	Yield Str.	Fracture
Transverse	1.	42,400	37,400	10
	2.	42,400	37,200	9
	3.	42,400	37,100	10
	4.	42,200	37,400	10
	5.	42,000	37,100	10
	6.	42,400	37,000	10
	Avg.	42,300	37,200	2.8
Longitudinal	1.	42,700	38,700	5
	2.	43,400	39,000	9
	3.	43,200	38,800	8
	4.	42,700	38,800	10
	5.	42,700	38,400	9
	6.	42,700	38,400	9
	Avg.	42,100	38,800	8.3

Welded at 20 ipm.

TABLE VII

(1)
6061T4 - Automatic Weld and (one) Repair - Aged to T6

Model		BELL AEROSPACE TENSILE COMPANY DIVISION OF BELL AEROSPACE CORPORATION		Page	11
Date		12-29-61		Report	HLA 01-40 (M)
Thickness	Specimen Number	Tensile Str.	Yield Str.	Elong.	Fracture
.050"	Transverse Control Specimens				
	1.	12,400	38,000	6	OM
	2.	12,400	38,000	6	OM
	Avg.	12,400	38,000	6	
	Repair Area				
	3.	10,200	36,500	1	OM
	4.	39,100	36,100	1	OM
	5.	38,200	35,900	1	OM
	6.	39,000	36,000	3	OM
	7.	33,900	36,200	3	OM
	8.	39,100	36,100	3.4	OM
	Avg.	39,100	36,100	3.4	
.125"	Longitudinal Control Specimens				
	1.	12,800	38,100	6	OM
	2.	12,000	38,400	6	OM
	Avg.	12,400	38,100	6	
	Repair Area				
	3.	38,400	36,100	3	OM
	4.	38,200	35,100	3	OM
	5.	10,000	36,500	1	OM
	6.	39,300	36,600	3.7	OM
	7.	12,800	37,100	1	OM
	8.	39,700	36,100	1	OM
	Avg.	39,100	36,300	3.4	
.125"	Transverse Control Specimens				
	1.	12,800	38,100	6	OM
	2.	12,000	38,400	6	OM
	Avg.	12,400	38,100	6	
	Repair Area				
	3.	38,400	36,100	3	OM
	4.	38,200	35,100	3	OM
	5.	10,000	36,500	1	OM
	6.	39,300	36,600	3.7	OM
	7.	12,800	37,100	1	OM
	8.	39,700	36,100	1	OM
	Avg.	39,100	36,300	3.4	
.125"	Longitudinal Control Specimens				
	1.	12,800	38,100	6	OM
	2.	12,000	38,400	6	OM
	Avg.	12,400	38,100	6	
	Repair Area				
	3.	38,400	36,100	3	OM
	4.	38,200	35,100	3	OM
	5.	10,000	36,500	1	OM
	6.	39,300	36,600	3.7	OM
	7.	12,800	37,100	1	OM
	8.	39,700	36,100	1	OM
	Avg.	39,100	36,300	3.4	

(1) Welded at 20 ipm.

Model _____		BELL AEROSYSTEMS COMPANY DIVISION OF BELL AIRCRAFT CORPORATION		Page <u>11</u>
Date <u>12-29-61</u>				Report <u>SLT 01-4u (M)</u>

IX
00174 - Stensfeld and Aged to 16

Thickness .125"	Specimen Number	Transverse			Longitudinal		
		Tensile Str.	Yield Str.	Elong.	Tensile Str.	Yield Str.	Elong.
	1.	41,000	37,200	4	42,700	39,800	3.5
	2.	41,100	38,300	5	41,500	39,200	4.5
	3.	41,200	38,400	4	41,400	38,200	4
	4.	42,700	39,100	3	41,400	38,500	4
	5.	43,200	39,300	4	42,000	39,000	4
	6.	42,400	37,500	4	43,100	40,300	3.5
	Avg.	41,900	38,300	4	42,000	39,200	3.9

Fracture
 04
 04
 04
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 04
 04

TABLE XI

6061T6 - Sigma Weld and (two) Repairs - Aged to T6

Thickness .125"

		Bell Aircraft Systems Company Division of Bell Aerospace Corporation							
	Specimen Number	Transverse			Longitudinal				
		Tensile Str.	Yield Str.	Elong.	Fracture	Tensile Str.	Yield Str.	Elong.	Fracture
Control Specimens	1.	44,600	38,600	5	OW	43,900	38,200	5	OW
	2.	38,100	32,800	4	OW	44,400	38,700	5	OW
	AVG.	41,350	25,700	4.5		44,150	38,450	5	
	3.	33,100	28,700	4	OW	32,300	26,100	3	OW
Repair Area	4.	32,700	27,200	4	OW	32,800	26,100	3	OW
	5.	32,200	25,700	4	OW	32,300	26,300	4	OW
	6.	32,100	26,800	4	OW	31,500	24,600	3	OW
	7.	32,900	26,700	4	OW	32,400	25,300	4	OW
	8.	33,300	25,800	3	OW	32,900	25,400	4	OW
	AVG.	32,700	26,850	3.8		32,450	25,700	3.5	

Model	12-29-61	BELL AEROSPACE SYSTEMS COMPANY DIVISION OF BELL AEROSPACE CORPORATION	Page 15
Date			Report BLR 61-40 (H)

Model _____	BELL AEROSYSTEMS COMPANY DIVISION OF BELL AIRCRAFT CORPORATION	Page <u>16</u>
Date <u>29 June 1962</u>		Report <u>ELR 61-40(M) Rev. A</u>

C. Mechanical Properties

This section presents the mechanical properties of the aluminum alloy 6061 in the welded and unwelded conditions. The alloy was studied in the solution heat treated condition (T3), and in the fully aged condition (T6), in both directions of rolling, transverse and longitudinal, as well as at various temperatures (-320 F, -65 F, R.T. and +150 F). "V" notches were also machined into welded and unwelded test bars, in both heat treat tempers, and tested at the various temperatures. The "V" notch used was representative of a stress concentration factor (K) of 3 on the 0.125 inch material.

The data obtained under the specified conditions is presented in Tables XII through XIV. Figures 2 through 30 give representative curves of a single specimen under the various tempers, temperatures and welded conditions studied.

Model

12-29-61

Date

WILL ABROSEY'S BAKE COMPANY

DIVISION OF BELL AEROSPACE CORPORATION

Page

17

Report

BLR 61-40 (H)

TABLE XII

Unwelded 6061 T4 Transverse Properties

Thickness	Test Temp	Specimen Number	.064"		Elong	.125"		Elong
			Tensile Str.	Yield Str.		Tensile Str.	Yield Str.	
-65°F		1	45,240	25,550	20	44,240	22,705	28
		2	44,975	25,255	24	44,605	22,930	28
		3	45,060	25,390	26	44,360	23,715	26
		Avg.	45,530	25,400	23.3	44,400	23,115	27.3
R.T.		1	42,048	22,605	23	38,795	21,167	25
		2	42,300	23,423	23	38,640	21,725	25
		3	42,739	23,197	23	38,418	22,305	24
		Avg.	42,362	23,212	23	38,618	21,732	24.6
-150°F		1	40,670	-	23	37,890	23,820	25
		2	40,825	23,235	22	37,820	20,620	22
		3	40,915	22,620	22	37,865	20,670	24
		Avg.	40,800	22,925	22.3	37,860	21,700	23.6
-320°F		1	59,140	28,685	34	57,460	26,170	32
		2	58,395	28,905	34	58,610	26,465	37
		3	59,250	28,550	36	57,795	26,115	33
		Avg.	59,100	28,710	34.6	57,955	26,250	34

Form 941 Rev. 12-19

Thickness	Test Temp	Specimen Number	Tensile Str.	Yield Str.	Elong	Tensile Str.	Yield Str.	Elong	.125"
-65°F		1	47,190	26,560	25	41,275	24,320	25	
		2	46,780	26,295	20	41,115	22,800	22	
		3	46,945	26,265	22	41,765	22,900	26	
		Avg.	46,975	26,375	22.3	41,345	23,340	25	
		1	44,185	25,250	17	38,545	21,195	22	
R.T.		2	42,480	24,750	20	38,555	21,260	22	
		3	43,435	24,220	24	38,445	21,419	23	
		Avg.	43,365	24,740	20.3	38,515	21,290	22.3	
		1	42,440	24,330	21	37,970	20,835	21	
		2	42,030	24,595	23	38,130	21,140	22	
+150°F		3	42,225	23,900	23	38,475	20,990	22	
		Avg.	42,225	24,275	22.3	38,190	20,990	21.6	
		1	64,235	34,700	33	57,130	28,130	37	
		2	63,160	31,630	25	57,510	27,775	37	
		3	64,635	33,290	34	57,745	28,445	37	
-320°F		Avg.	64,010	32,540	31	57,460	28,115	37	

Model: _____	BELL AEROSYSTEMS COMPANY DIVISION OF BELL TELEPHONE CORPORATION	Page: <u>19</u>
Date: <u>12-29-61</u>		Report: <u>BLR 61-40 (H)</u>

TABLE XIV
(1)
As-welded 6061-T4 (Transverse Properties of Sheet)

Thickness	Test Temp	Specimen Number	Tensile Str.	Yield Str.	Elong	Tensile Str.	Yield Str.	Elong
.064"	-65° F	1	37,270	21,390	11	37,265	19,255	16
		2	36,225	21,360	11	37,010	20,040	16
		3	38,725	24,570	11	37,185	20,235	16
		Avg.	37,405	22,440	11	37,155	19,845	16.6
R.T.		1	32,610	20,320	8	34,790	19,385	14
		2	35,560	20,775	10	34,255	19,530	13
		3	33,675	19,570	10	34,360	18,710	14
		Avg.	33,945	20,220	9.3	34,465	19,210	13.6
+150° F		1	37,000	22,200	10	34,645	18,530	14
		2	34,440	20,630	9	34,290	19,270	14
		3	-	-	-	35,815	19,685	18
		Avg.	35,720	21,425	9.5	34,935	19,160	15.3
-320° F		1	53,570	29,900	13	53,870	26,550	21
		2	-	29,900	5	-	-	-
		3	50,475	30,130	17	53,905	26,235	24
		Avg.	55,020	29,975	14.5	53,890	26,395	22.5

(1) Welded at 20 ion.

(1) Welded at 20 lpm.

Model

12-29-61

DELL ASSOCIATES, INC. COMPANY

DIVISION OF DELL AEROSPACE CORPORATION

Page

20

Date

12-29-61

Report

BLR 61-40 (H)

(1)

XV

Ac-Welded 6061-T4 (Longitudinal Properties of Sheet)

Thickness		.064 in.		.125 in.			
Test Temp	Specimen Number	Tensile Str.	Yield Str.	Elong	Tensile Str.	Yield Str.	Elong
-65°F	1	37,915	22,565	11	37,420	20,720	16
	2	39,575	23,555	11	36,120	19,895	14
	3	35,865	20,950	11	36,010	20,480	14
	AVG.	37,785	22,355	11	36,715	20,365	14.6
R.T.	1	37,125	21,280	10	34,910	18,475	14
	2	35,450	20,655	10	34,760	18,820	14
	3	37,515	21,915	10	35,360	18,860	16
	AVG.	36,695	21,285	10	35,010	18,720	14.6
+150°F	1	37,220	22,845	10	35,540	19,380	14
	2	36,710	22,405	10	35,300	20,085	14
	3	37,250	22,160	10	36,490	19,950	17
	AVG.	37,060	22,470	10	35,805	19,800	15
-320°F	1	50,915	24,195	18	53,280	26,135	21
	2	52,755	27,450	18	-	-	-
	3	53,015	25,470	18	55,590	26,415	22
	AVG.	52,430	25,705	18	54,435	26,215	21.5

(1) Cold-drawn at 20 in.

(1) Cold-chambered at 20 fpm.

Model		BELL AEROSPACE TESTS COMPANY	Page	21
Date	12-29-61	DIVISION OF BELL AEROSPACE CORPORATION	Report	BIR 61-40 (H)

TABLE XVI

Unwelded Notched 0061-T4 Transverse Properties *

Thickness	Test Temp	Specimen Number	Tensile Str.	Yield Str.	Elong	Tensile Str.	Yield Str.	Elong
	-65°F	1	45,310	34,220	3	42,570	30,065	4
		2	45,815	31,900	3	44,930	30,460	4
		3	45,550	34,110	2	43,600	30,545	4
		Avg.	45,560	34,075	2.6	43,700	30,355	4
	R.T.	1	43,125	31,865	4	42,545	29,200	5
		2	43,735	31,575	3	41,935	29,840	6
		3	42,265	31,200	3	41,380	29,215	4.5
		Avg.	43,040	31,580	3.3	41,955	29,420	5.2
	+150°F	1	43,290	31,760	3	40,100	29,685	4
		2	41,845	31,040	3	40,455	27,920	4
		3	42,110	31,780	3	40,085	29,085	4
		Avg.	42,415	31,525	3	40,215	29,075	4
	-320°F	1	58,300	45,060	2	50,655	31,955	4
		2	59,205	43,540	2	57,410	39,445	4
		3	58,200	43,215	2	57,160	39,530	4
		Avg.	58,570	44,170	2	55,075	36,475	4

* Notch Factor = K3

* Notch Factor = K3

Model	12-29-21	DELL APPROVED TEST COMPANY DIVISION OF DELL AEROSPACE CORPORATION	Page	22
Date			Report	BLR 01-40(M)

TABLE XVII
Unwelded Notched 0061-Ti Longitudinal Properties*

Thickness	Test Temp	Specimen Number	Tensile Str.	Yield Str.	Elong	Tensile Str.	Yield Str.	Elong
	-65°F	1	16,360	34,835	3	13,950	31,855	4
		2	16,620	34,630	3	14,045	30,395	4
		3	16,620	34,477	3	13,715	31,120	4
		Avg.	16,530	34,645	3	13,905	31,125	4
	R.T.	1	13,515		3	11,665	28,630	4
		2	14,125	32,445	3	12,070	29,200	4
		3	14,125	32,290	3	12,055	29,525	4
		Avg.	13,930	32,365	2	12,265	29,150	4
	+150°F	1	12,110	32,415	3	10,850	28,475	4
		2	12,635	32,095	3	11,345	28,595	4
		3	12,265	31,505	3	11,415	29,115	4
		Avg.	12,335	32,005	3	11,205	28,730	4
	-320°F	1	61,355	14,675	3	59,650	39,045	4
		2	61,110	14,555	3	58,465	38,950	4
		3	60,845	14,370	3	58,600	38,925	4
		Avg.	61,102	14,535	3	58,905	38,973	4

* Notch Factor = K3

* Notch Factor = K3

Model _____	BELL AEROSPACE ENGINE COMPANY DIVISION OF BELL AEROSPACE CORPORATION	Page 23
Date 12-29-61		Report AIR 61-40 (*)

TABLE XVIII
(1)
As-welded and notched 6061-T6 (Transverse Properties of Sheet)*

Thickness	Test Temp	Specimen Number	Tensile Str.,	Yield Str.,	Elong	Tensile Str.,	Yield Str.,	Elong
			.064"			.125"		
	-65°F	1	25,685	18,385	4	25,660	19,295	3
		2	25,020	20,175	3	21,520	21,660	3
		3	28,495	18,110	6	27,335	20,440	3
		Avg.	26,400	18,890	4.3	28,170	20,465	2
	R.T.	1	26,000	21,065	2	27,625	18,205	3
		2	29,235	18,915	5	27,975	20,565	3
		3	27,300	19,220	4	26,515	19,675	2
		Avg.	27,511	19,755	3.6	27,270	19,480	2.6
	+150°F	1	26,480	19,335	3	26,495	-	3
		2	27,680	18,260	4	30,230	20,280	3
		3	24,073	17,075	4	28,910	19,200	3
		Avg.	26,185	18,220	3.6	28,545	19,740	2
	-320°F	1	32,440	25,550	2	33,750	-	3
		2	32,355	22,940	2	32,980	26,420	2
		3	30,935	23,895	3	32,475	26,530	2
		Avg.	32,075	24,130	2.3	32,715	26,475	2.3

* Notch Factor = K3

(1) Loaded at 20 ipm.

* Notch Factor = K3

(1) Notched at 20 ipm.

Model 12-29-61
Date

CELL AEROSYSTEMS COMPANY
DIVISION OF CELL AEROSPACE CORPORATION

Page 24
Report BLR 01-40 (H)

TABLE XIX
(1) As-welded and Notched 6061-T6 (Longitudinal Properties of Sheet) *

Thickness	Test Temp	Specimen Number	.064"		Elong	.125"		Elong
			Tensile Str.	Yield Str.		Tensile Str.	Yield Str.	
-65°F		1	28,160	17,610	6	30,465	20,805	4
		2	24,475	16,925	4	29,365	20,475	4
		3	28,620	18,785	5	31,390	22,165	3
		AVG.	27,085	17,775	5	30,405	21,150	3.6
R.T.		1	23,380	14,290	6	25,940	18,940	4
		2	26,820	18,750	5	-	-	-
		3	25,990	18,285	4	-	-	-
		AVG.	25,395	17,105	5	-	-	-
+150°F		1	25,060	17,325	5	27,835	19,580	4
		2	24,790	16,520	4	29,685	20,725	4
		3	26,555	-	4	-	-	-
		AVG.	25,470	16,920	4.3	28,760	20,055	4
-320°F		1	31,430	24,745	2	-	-	-
		2	29,310	21,035	3	36,140	24,830	2
		3	31,305	22,890	3	34,055	26,110	3
		AVG.	30,680	22,690	2.5	35,095	25,470	2.5

* Notch Factor = K3

(1) Welded at 20 ipm.

TABLE IX

Unwelded 6061-T6 Transverse Properties

Thickness

Test Temp	Specimen Number	.061"		.125"		Elong	Total Elong in 2"	Yield Str.	Total Elong in 2"	Elong	Total Elong in 2"
		Tensile Str.	Yield Str.	Tensile Str.	Yield Str.						
-320°F	1	65,405	47,850	62,620	49,485	21	62,620	49,485	21	21.1	18.91
	2	65,430	48,130	62,901	49,935	21	62,901	49,935	21	15	13.75
	3	65,905	48,320	60,856	45,741	20.5	60,856	45,741	22	14.5	13.52
	4	-	-	60,410	46,343	21	60,410	46,343	21	14.75	13.64
	5	-	-	60,970	47,876	21	60,970	47,876	21	13	12.53
	AVG.	65,456	48,100	61,551	47,876	21.1	61,551	47,876	21.1	12.5	11.06
-65°F	1	54,345	44,170	50,970	43,765	15	50,970	43,765	15	14.5	13.75
	2	54,345	44,075	50,935	43,825	15	50,935	43,825	15	14.5	13.52
	3	54,430	44,035	50,650	43,940	15	50,650	43,940	15	14.5	13.52
	4	-	-	49,600	43,920	14.5	49,600	43,920	14.5	14.75	13.64
	5	-	-	49,440	43,499	14.5	49,440	43,499	14.5	13	12.53
	AVG.	54,380	44,095	49,195	43,190	14.5	49,195	43,190	14.5	12.5	11.06
R.T.	1	50,140	42,285	50,130	44,023	13	50,130	44,023	13	12.6	11.92
	2	49,590	40,765	47,185	41,560	12	47,185	41,560	12	12.5	11.06
	3	49,970	41,695	47,410	41,290	12	47,410	41,290	12	12.5	11.06
	4	49,070	40,683	46,385	40,393	14	46,385	40,393	14	12.5	11.06
	5	49,215	40,440	45,555	40,032	13	45,555	40,032	13	12.5	11.06
	AVG.	48,590	40,467	46,505	40,253	12.5	46,505	40,253	12.5	12.6	11.92
	6	48,935	40,547	46,580	40,527	12.5	46,580	40,527	12.5	12.6	11.92
	AVG.	49,275	40,900	46,650	40,811	12.6	46,650	40,811	12.6	12.6	11.92

Model _____
Date 12-29-61BELL AEROSYSTEMS COMPANY
DIVISION OF BELL AEROSPACE CORPORATIONPage 25
Report BLR 61-40 (M)

Model: _____
Date: 12-29-61

BELL AEROSYSTEMS COMPANY
DIVISION OF BELL TELEPHONE CORPORATION

Page: 26
Report: BLR 61-40 (N)

TABLE XX (continued)

Thickness	Test Temp +150°F	Specimen Number	.064" <u>Yield</u>		.125" <u>Yield</u>		<u>Elong</u>	
			Tensile Str.	Str.	Tensile Str.	Str.	Elong	Str.
		1	48,340	40,475	46,165	40,790	15	13.7
		2	48,025	39,970	46,350	41,450	14	13.7
		3	47,910	40,700	47,375	42,050	14	13
		AVG.	48,090	40,380	46,630	41,430	14.3	13.5

Model	12-29-61	WELL APPROXIMATE COMPANY DIVISION OF WELL SERVICES CORPORATION	Page	28
Date			Report	BLR 61-40 (H)

TABLE XII (continued)

Thickness	Test Temp	Specimen Number	Tensile Str.	Yield Str.	Elong	Tensile Str.	Yield Str.	Elong
	+150°F	1	48,550	43,285	14	45,845	42,340	13
		2	48,550	42,875	14	46,200	42,590	13
		3	48,610	42,075	14	46,015	42,165	13
		Avg.	48,570	42,745	14	46,000	42,365	13

Form 604 Rev. 1-61

BELL AEROSPACE TECHNOLOGY
DIVISION OF BELL AEROSPACE CORPORATION

Model _____
Date 12-29-61

Page 29
Report BLR 61-40 (H)

TABLE XXII
(1)
6061-Ti Welded and Aged (Transverse Properties of Sheet)

Thickness

Test Temp	Specimen Number	Tensile Str.	Yield Str.	Elong	Tensile Str.	Yield Str.	Elong	Total Elong in 2"	
-65°F	1	45,300	30,850	4	48,650	12,635	8	8.5	
	2	49,420	45,355	2	49,415	13,545	6	1.59	
	3	48,125	43,125	4	46,700	11,155	3.5	3.31	
	4	-	-	-	45,116	39,784	4.0	3.69	
	5	-	-	-	45,609	39,364	4.0		
	6	-	-	-	40,923	10,023	5.7	2.86	
Avg.		47,615	42,775	3.3	47,074	11,238	6		
R.T.	1	44,520	40,035	4	44,290	10,325	6		
	2	-	-	3	-	-	6		
	3	46,045	41,860	-	43,715	39,530	3.5	2.34	
	4	-	-	-	40,958	36,692	4.0	3.19	
	5	-	-	-	43,215	30,053	4.0	3.00	
	6	-	-	-	42,178	37,577	4.6	2.84	
Avg.		45,285	40,950	3.5	42,877	36,835	8		
+150°F	1	45,285	42,075	3	44,550	39,815	7		
	2	46,335	43,205	3	43,955	38,875	7		
	3	43,885	41,085	3	44,070	38,850	7		
	Avg.		45,165	42,190	2	44,190	39,190	7.3	
	1	62,800	-	6	56,290	48,345	4		
	2	55,360	50,495	1	60,855	47,955	12		
-320°F	3	62,155	50,515	8	60,610	48,395	12		
	4	-	-	-	70,685	45,937	1.5	1.77	
	5	-	-	-	54,140	45,732	3	3.48	
	Avg.		60,105	50,505	5	58,504	47,261	6.5	2.37

(1) Welded at 20 ipm.

TABLE XVIII (1) Welded and Aged 6061-T4 (Longitudinal Properties of Sheet)									
Thickness	Test Temp	Specimen Number	$\frac{0.041"}{1000}$ Tensile Str.	Yield Str.	Flow	Tensile Str.	$\frac{0.125"}{1000}$ Yield Str.	Flow	Total Elong in 2"
-65°F		1	45,525	40,135	4	48,615	43,810	6	6
		2	49,485	44,785	4	46,695	41,130	6	6
		3	44,850	40,075	4	47,090	41,325	6	6
		4	-	-	-	47,741	41,963	4	4.73
		5	-	-	-	41,963	39,366	1	.6
		6	-	-	-	44,444	39,187	3	2.63
R.T.		Avg.	46,680	41,665	4	46,091	41,130	4.2	2.65
		1	39,690	36,805	3	44,000	40,125	6	6
		2	42,472	-	3	43,900	38,695	6	6
		3	48,990	45,735	3	45,845	41,075	6	6
		4	-	-	-	43,984	39,484	5	3.56
		5	-	-	-	43,818	39,687	4	4.00
+150°F		Avg.	43,715	40,270	2	44,202	39,813	5.4	2.78
		1	-	-	-	43,765	39,685	6	6
		2	45,760	43,175	3	42,540	38,390	5	5
		3	46,610	44,005	3	42,370	38,500	5	5
		Avg.	46,185	43,590	2	42,890	38,860	5.3	5.3
		1	59,415	49,985	6	58,275	46,295	10	-
-320°F		2	55,995	45,910	2	60,365	48,005	10	-
		3	55,520	-	-	57,187	46,059	4	5.38
		4	-	-	-	55,968	48,226	3.5	3.12
		5	-	-	-	57,729	46,845	4	5.24
		6	-	-	-	57,905	47,091	6.3	4.58
		Avg.	56,875	47,925	3.3	57,905	47,091	6.3	4.58

(1) Welded at 20 in.

Model:

12-29-61

BELL AEROSPACE COMPANY
 DIVISION OF BELL AEROSPACE CORPORATION

Page:

3

Report:

BLR 61-40 (N)

TABLE XXIV

Unwelded Notched 6061-T6 Transverse Properties*

Thickness	Test Temp	Specimen Number	.064" Tensile Str.	Yield Str.	Elong	.125" Tensile Str.	Yield Str.	Elong
	-65°F	1	55,965	53,305	2	56,705	53,980	2
		2	56,195	53,455	2	56,450	53,455	2
		3	56,745	54,275	2	56,710	54,370	2
		Avg.	56,300	53,680	2	56,620	53,935	2
	R.T.	1	52,650	50,495	1	53,115	52,090	2
		2	53,570	51,225	2	53,280	52,425	2
		3	53,290	50,890	2	52,550	50,080	2
		4	52,820	50,175	1.5	52,175	50,054	2
		5	53,075	50,462	1.5	51,770	49,646	2
		Avg.	53,077	50,768	1.4	52,584	50,652	2
	+ 150°F	1	50,645	48,490	2	51,480	49,815	2
		2	50,985	49,340	2	51,610	50,000	2
		3	50,710	48,905	2	51,665	49,865	2
		Avg.	50,780	48,922	2	51,585	49,890	2
	-320°F	1	69,890	61,600	2	69,070	-	3
		2	68,450	60,565	2	69,340	61,605	2
		3	69,050	61,795	2	68,940	61,135	2
		Avg.	69,130	61,320	2	69,185	61,270	2.3

* Notch Factor = .75

* Notch Factor = .75

Model _____
Date 12-29-61

BELL AEROSPACE TESTING COMPANY
DIVISION OF BELL AEROSPACE CORPORATION

Page 32
Report BLR 61-40 (H)

TABLE AAV
Unwelded Notched 0061-To Longitudinal Properties *

Thickness	Test Temp	Specimen Number	.061"		Yield Str.	Klong	.125"		Yield Str.	Klong
			Tensile Str.	Tensile Str.			Tensile Str.	Tensile Str.		
-65°F		1	57,120	54,560	2	56,715	54,175	2	54,175	2
		2	56,350	53,790	2	56,585	53,885	2	53,885	2
		3	56,510	53,905	2	55,920	53,700	2	53,700	2
R.T.		AVG.	56,660	54,085	2	56,405	53,920	2	53,920	2
		1	53,155	50,820	2	52,090	50,235	3	50,235	3
		2	53,230	50,530	2	53,580	50,985	3	50,985	3
		3	53,610	49,245	2	52,485	50,560	3	49,454	3
		4	51,115	51,160	2	51,560	51,910	2	49,771	2
+150°F		5	54,120	51,154	2	51,910	52,325	2	50,111	2
		AVG.	53,712	50,582	2	52,325	48,940	2	49,235	2
		1	51,155	49,160	2	50,765	49,365	2	49,180	2
		2	50,915	48,655	2	50,900	61,870	2	61,870	2
		3	50,915	48,975	2	51,030	60,005	2	60,005	2
-320°F		AVG.	51,095	49,030	2	50,895	60,355	2	60,355	2
		1	72,700	60,335	2	69,805	61,115	2	61,115	2
		2	71,155	63,435	2	69,115	68,940	2	68,940	2
		3	70,370	62,275	2	68,940	61,120	2	61,120	2
		AVG.	71,408	62,015	2	69,297				

* Notch Factor = 1.3

Model _____
Date 12-27-51

BELL AEROSYSTEMS COMPANY
DIVISION OF BELL AIRCRAFT CORPORATION

Page 33
Report AL-1-43 ()

TABLE XVI
(1)
6051-T4 Welded and Aged, Notched (Transverse Properties of Sheet)*

Thickness	Test Temp	Specimen Number	Tensile Str.	Yield Str.	Elong	Tensile Str.	Yield Str.	Elong
	-65° F	1	35,675	33,255	4	38,815	-	1
		2	38,920	35,755	2	39,885	-	1
		3	-	-	-	35,670	-	1
		AVG.	37,200	34,505	2	38,125	-	1
	R. V.	1	-	-	-	39,540	-	2
		2	35,335	32,960	1	35,630	-	2
		3	33,610	-	1	36,765	-	2
		AVG.	34,470	32,960	1	37,310	-	2
	+150° F	1	37,160	36,190	1	39,015	-	2
		2	34,000	31,920	2	39,215	-	2
		3	32,390	28,180	2	36,935	-	1
		AVG.	34,285	32,195	1.6	38,600	-	1.6
	-320° F	1	46,215	39,105	1	44,825	-	1
		2	39,680	36,745	1	-	-	1
		3	37,535	36,275	1	41,856	-	1
		AVG.	39,153	37,375	1	43,345	-	1

* Notch Factor = K3

(1) Welded at 20 ipm.

* Notch Factor = K3

(1) Welded at 20 ipm.

Model		BELL AEROSYSTEMS COMPANY DIVISION OF BELL ASSOCIATED CORPORATION	Page <u>34</u>
Date	<u>12-29-61</u>		Report <u>BLR 61-44 (M)</u>

TABLE XXVII
(1)
6061-Ti Welded and Aged, Notched (Longitudinal Properties of Sheet)

Thickness	Test Temp	Specimen Number	Tensile Str.	Yield Str.	Elong	Tensile Str.	Yield Str.	Elong
.064"	-65°F	1	33,455	28,055	1	41,405	-	1
		2	35,910	33,635	1	43,760	-	1
		3	33,715	31,635	1	36,945	-	1
		Avg.	34,270	31,110	1.6	40,700	-	1
	R.T.	1	33,590	31,075	1	42,125	41,165	1
2		33,410	29,440	1	38,580	-	1	
3		32,735	30,035	2	-	-	1	
Avg.		33,245	30,185	1.6	40,355	41,165	1	
+150°F		1	20,465	26,315	2	42,080	41,145	2
	2	32,830	29,325	2	39,035	37,420	2	
	3	34,720	33,250	2	40,540	39,405	2	
	Avg.	32,340	29,630	2	40,550	39,325	2	
	-320°F	1	38,135	-	1	41,620	-	1
2		39,410	38,710	1	40,565	-	2	
3		40,130	38,280	1	47,100	-	2	
Avg.		39,225	38,495	1	43,095	-	1.6	

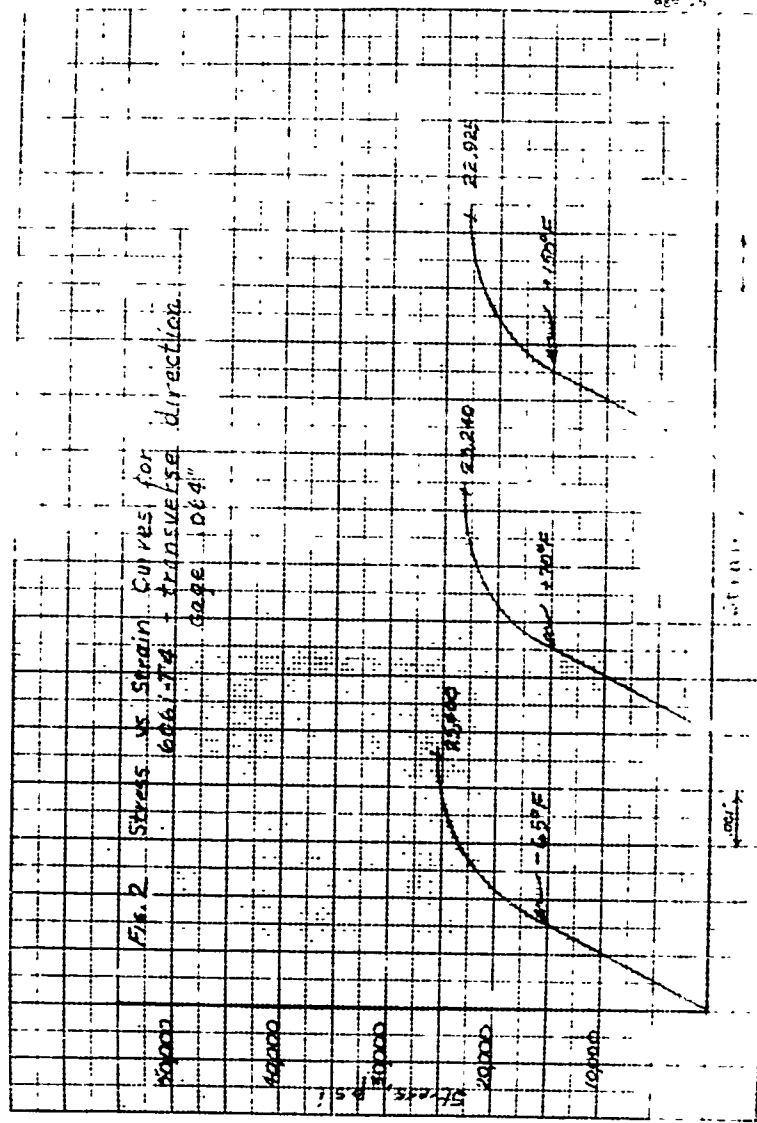
* Notch Factor = K3

(1) Welded at 20 ipm.

* Notch Factor = K3

(1) Welded at 20 ipw.

Fig. 2 Stress vs. Strain Curves for
6061-T4 - Transverse
direction
gage 1064"



1 - 13X10707M, INCH 3597 11
2 - 13X10707M, INCH 3597 11

Fig. 3 STRESS VS STRAIN CURVES FOR
6061-T6 - Longitudinal direction
page 0.04

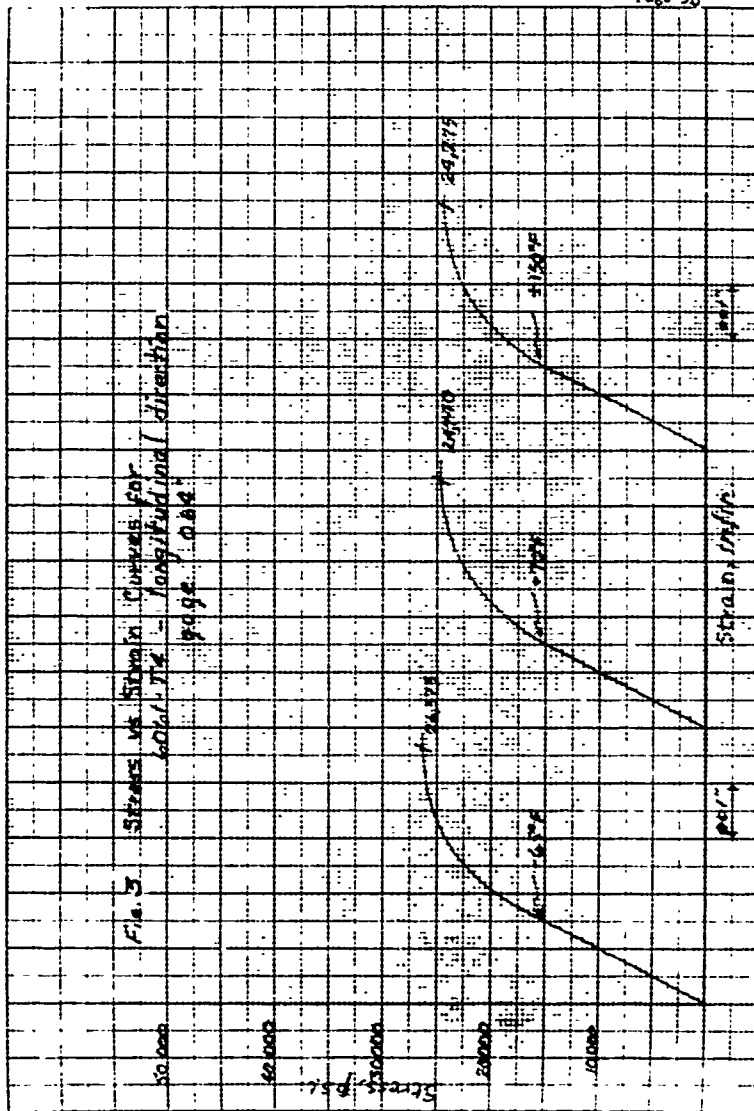
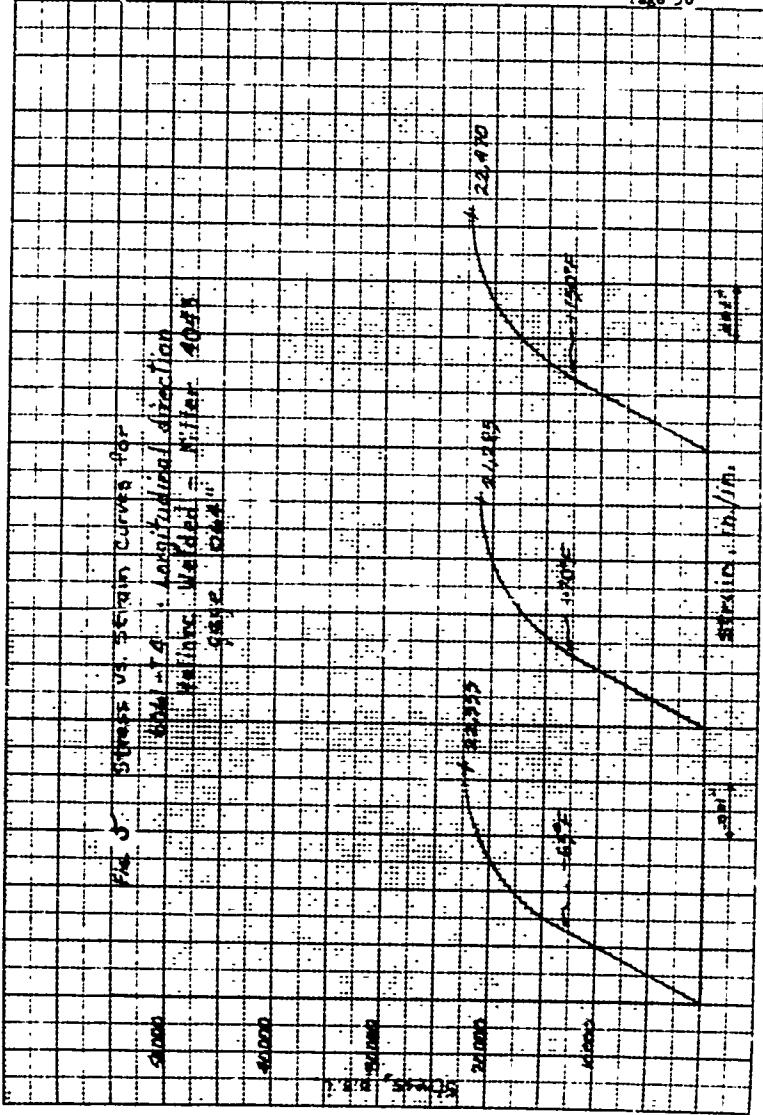
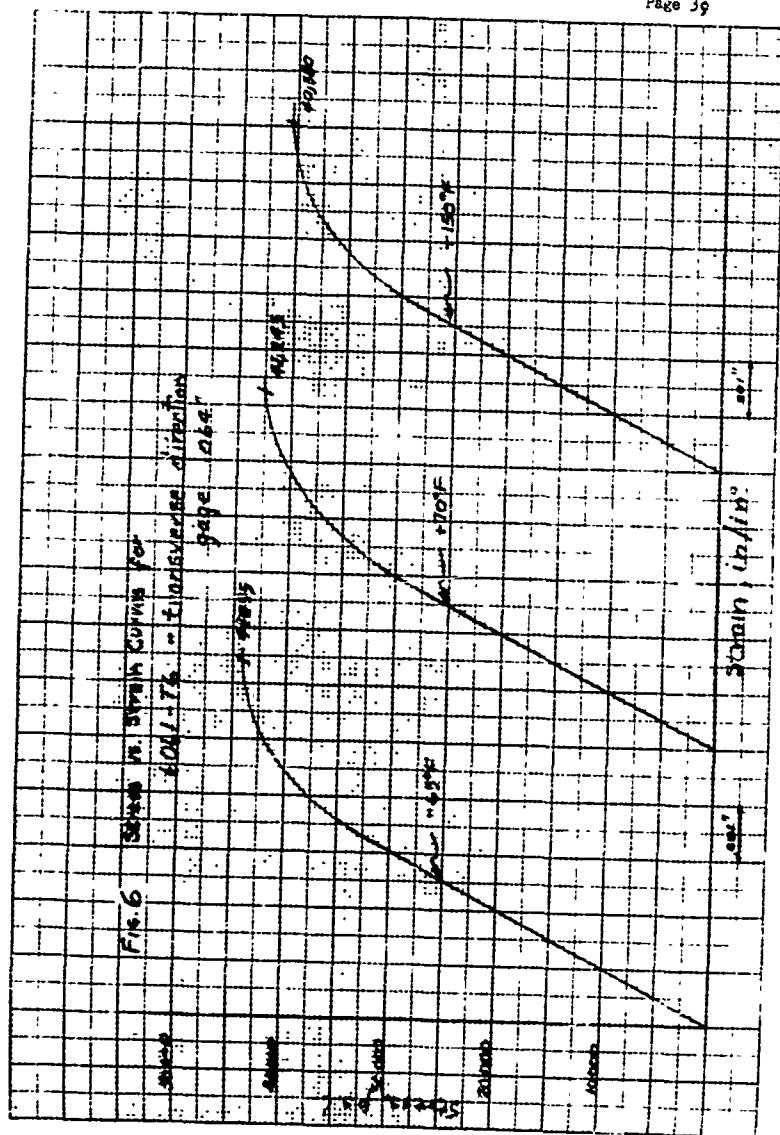
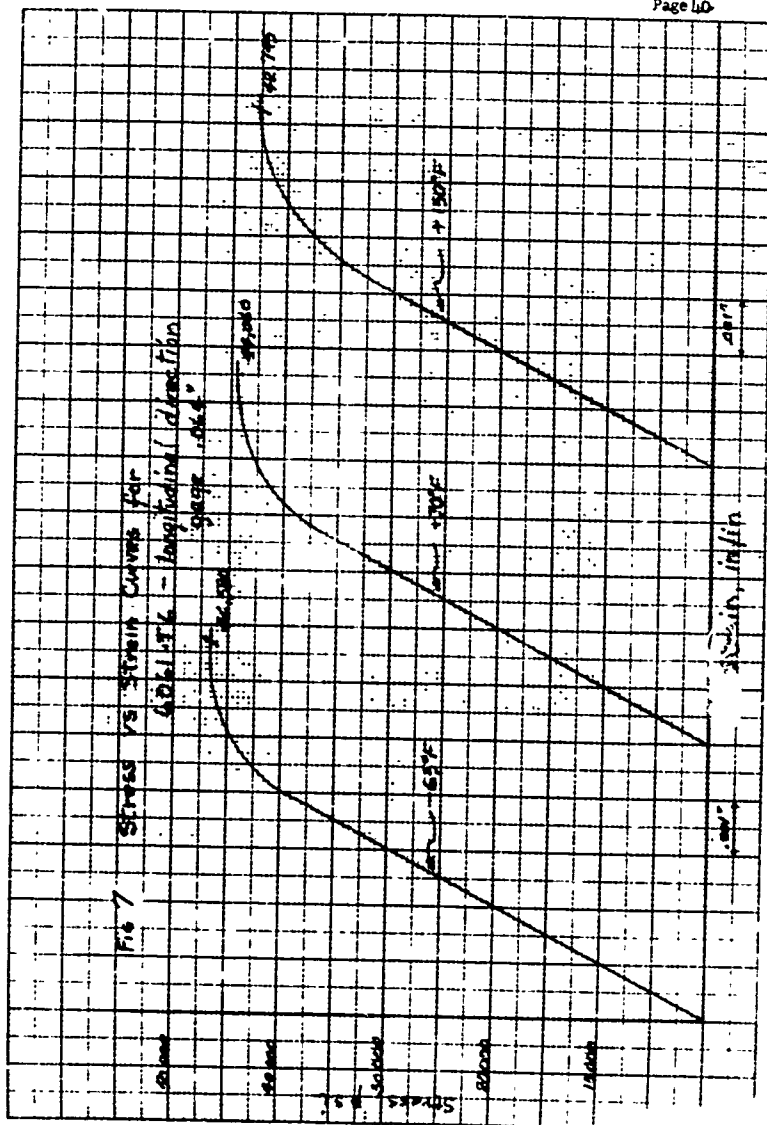


Fig. 5 Stress vs. Strain Curves for
 6061-T6 Longitudinal direction
 Gauge Welded = Miller 4045
 gauge 0.4"





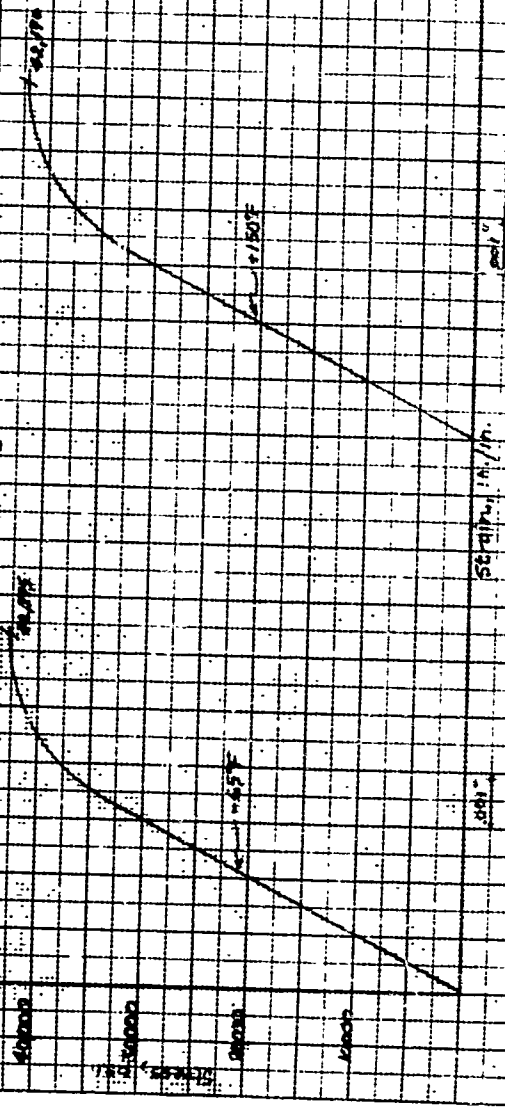
1-2 1010 TENSILE, INCH 3897 11
 1-2 1010 TENSILE, INCH 3897 11



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Fig. 8. Stress vs. Strain Curves for

Alloy-76 Titanium Bar
Machine Welded - Filter - 9045
Gage OK



Feb. 9 ... STRESS vs STRAIN CURVES for
6061-T6 - longitudinal direction
Holes, welded - filled with
1018 steel

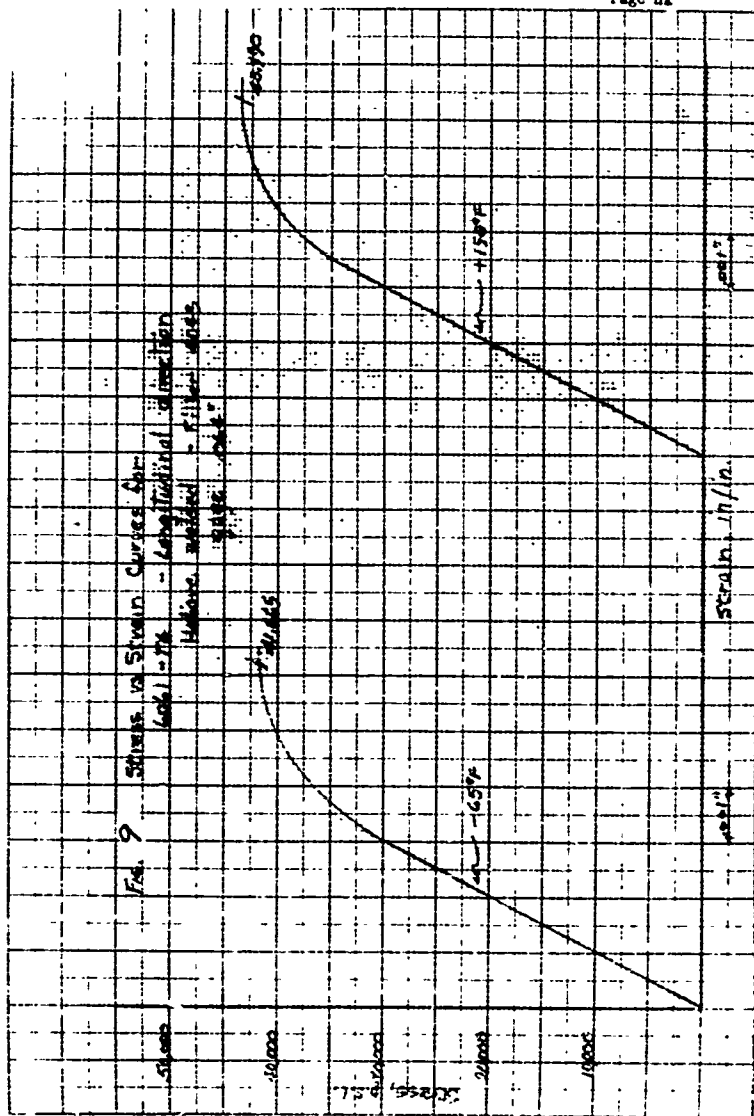
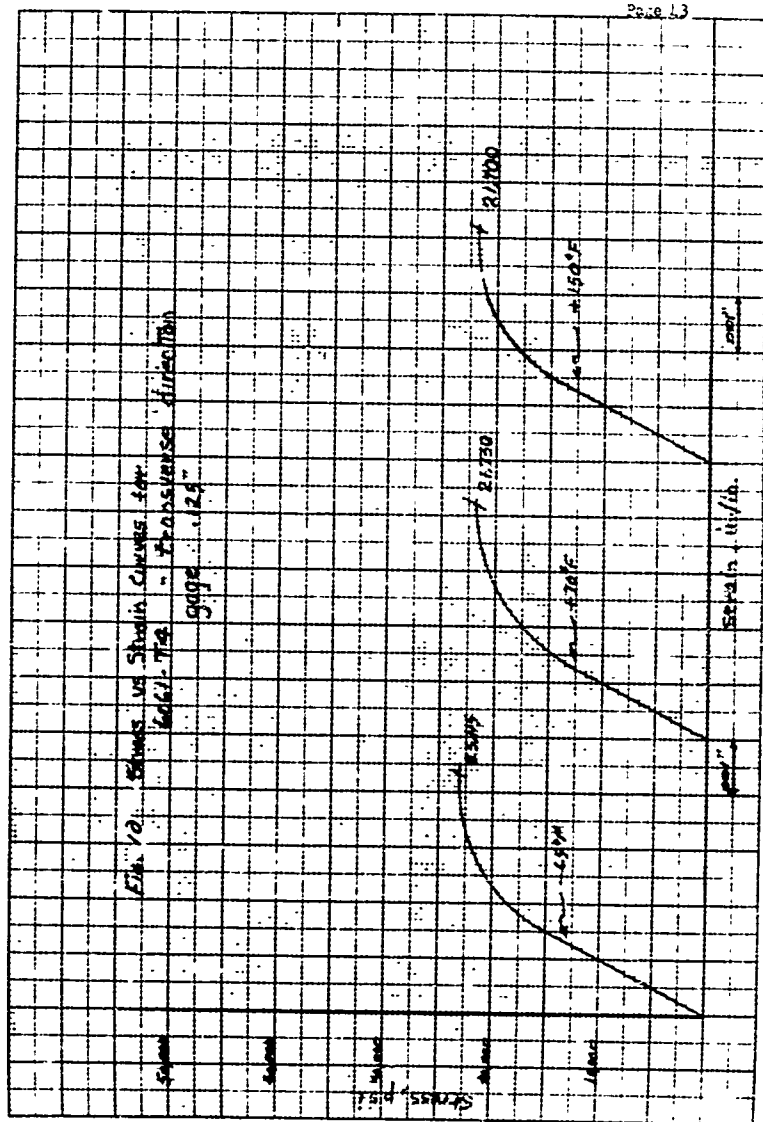
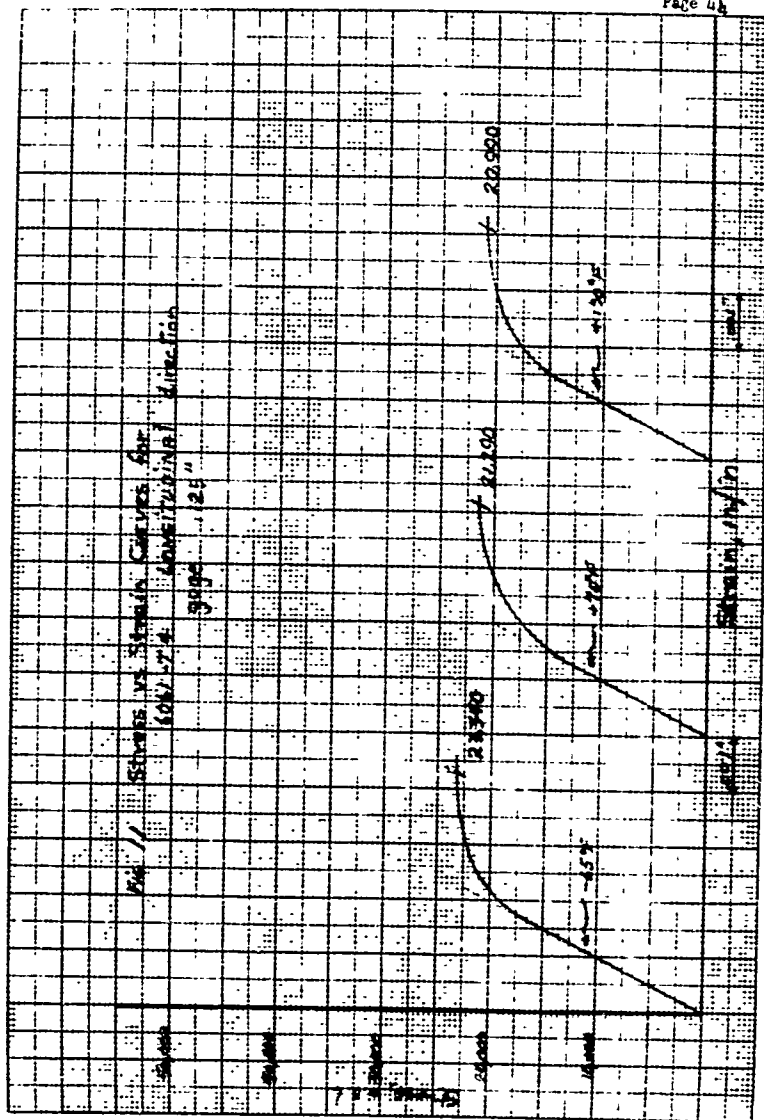


Fig. 10. Stress vs. Strain Curves for
 6061-Ti6 - Transverse Direction
 gage .125"

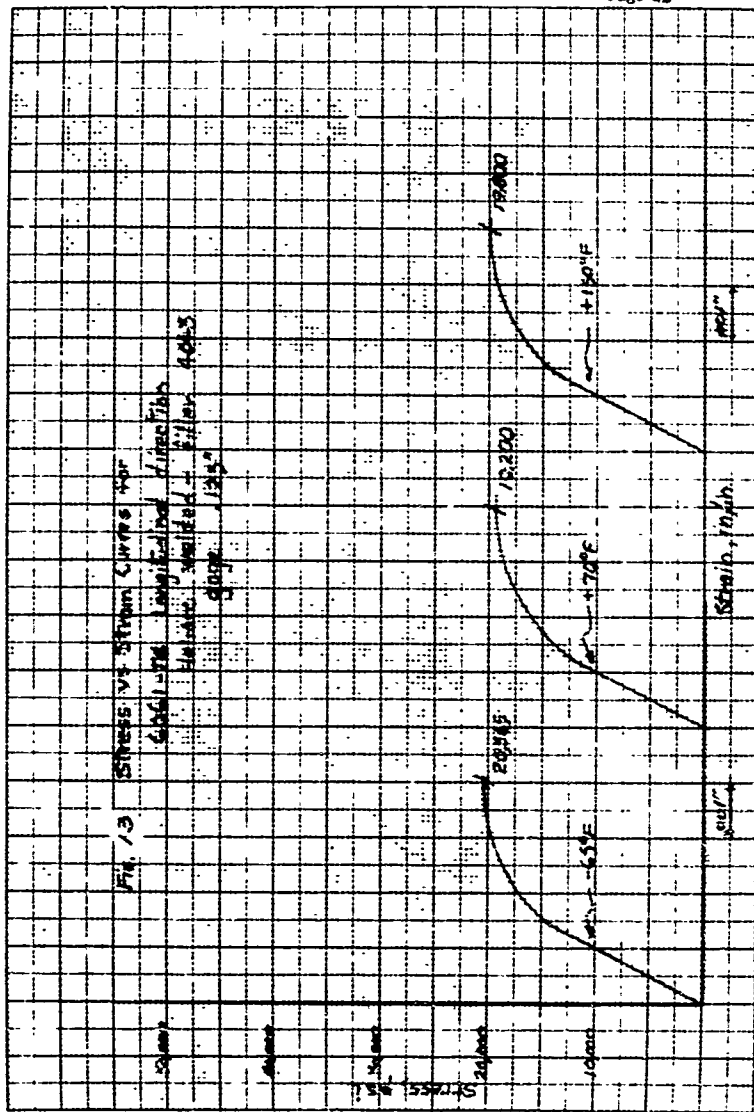


K-E 10 K TO THE 1/2 INCH 3857.11
 SUPPL. 8-20-55 1118 5555
 1118 5555

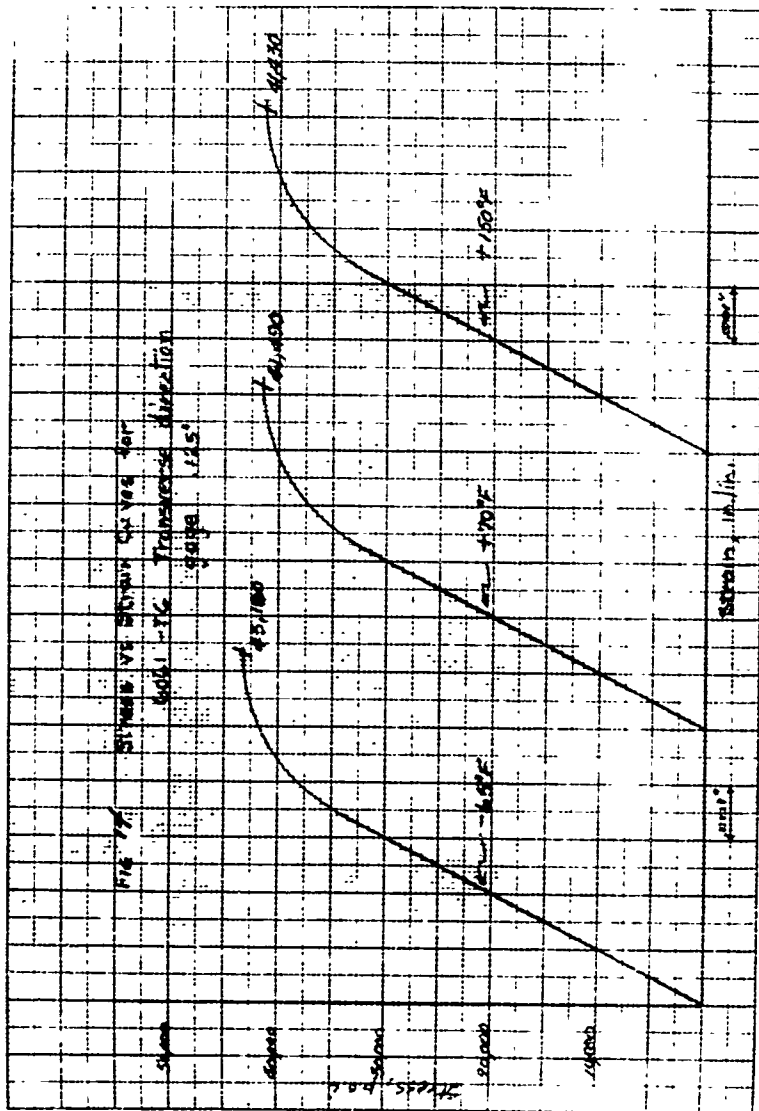


359T 11
10 X 10 TO THE 1/2 INCH
1/2 INCH, 1/2 INCH, 1/2 INCH
1/2 INCH, 1/2 INCH, 1/2 INCH

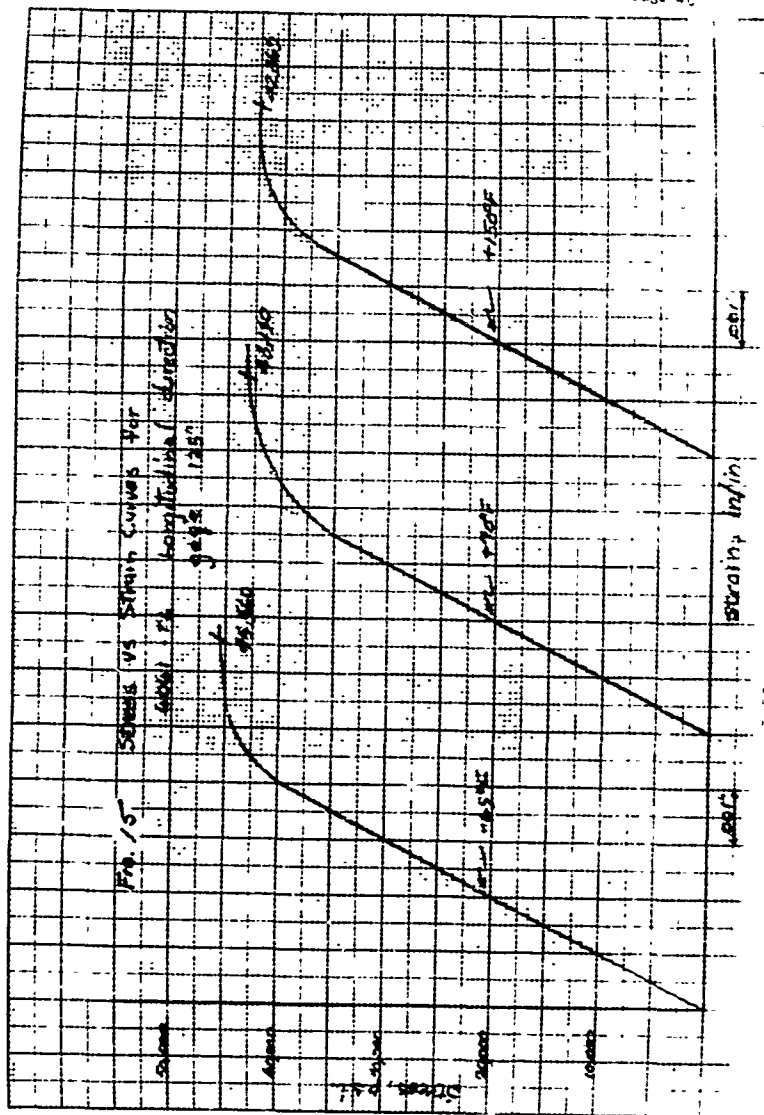
Fig. 13
Stress vs Strain Curves for
6061-T6 Anodized Aluminum
Heater welded - then
quenched. 150°



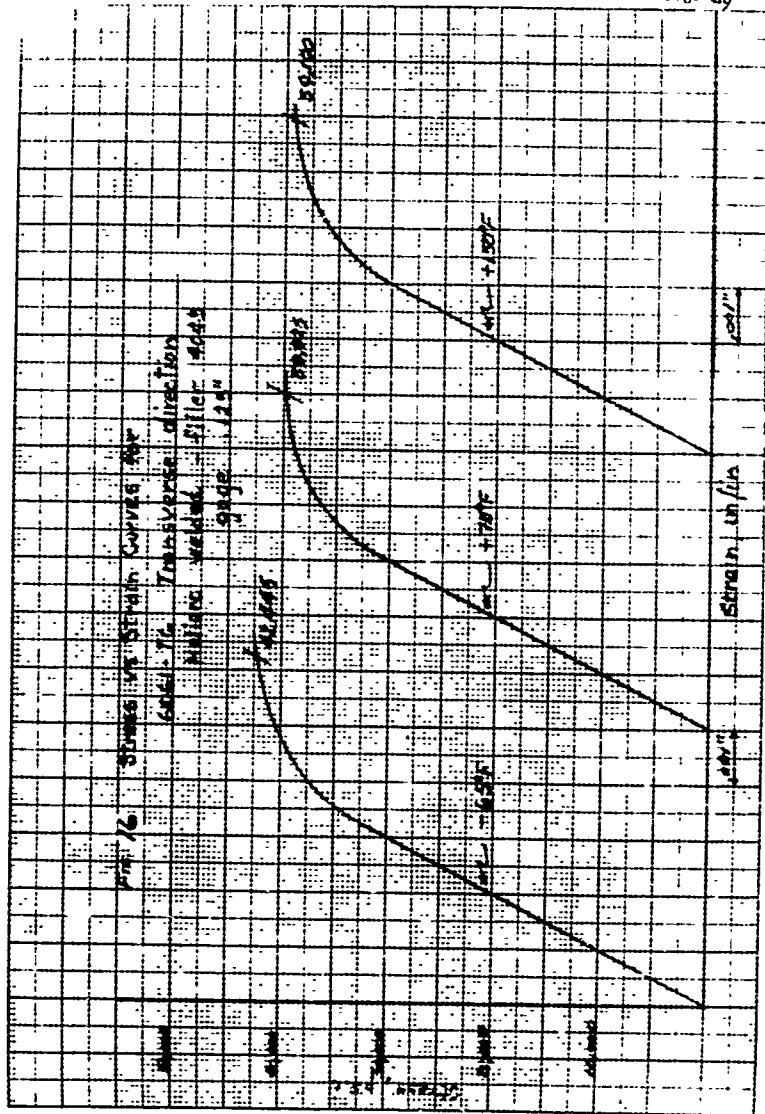
1/2 10 X 10 TO THE 1 INCH 389T 11
ALFRED BARBER CO. NEW YORK



1/2 IN. 10 X 10 TUB. 1 INCH. SPOT 11
 1/2 IN. 10 X 10 TUB. 1 INCH. SPOT 11

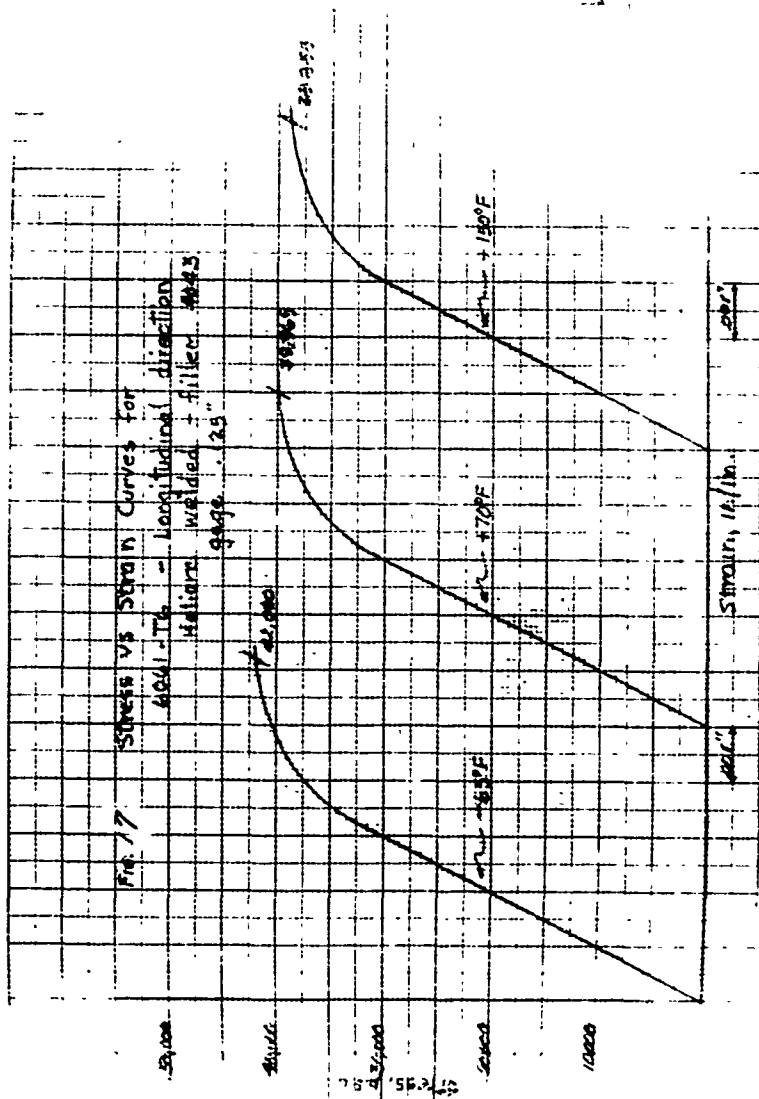


K-2 10.810 TME - INCH 3897 11
 ALUFIL DESIGN NO. 4045
 ALL MARKS

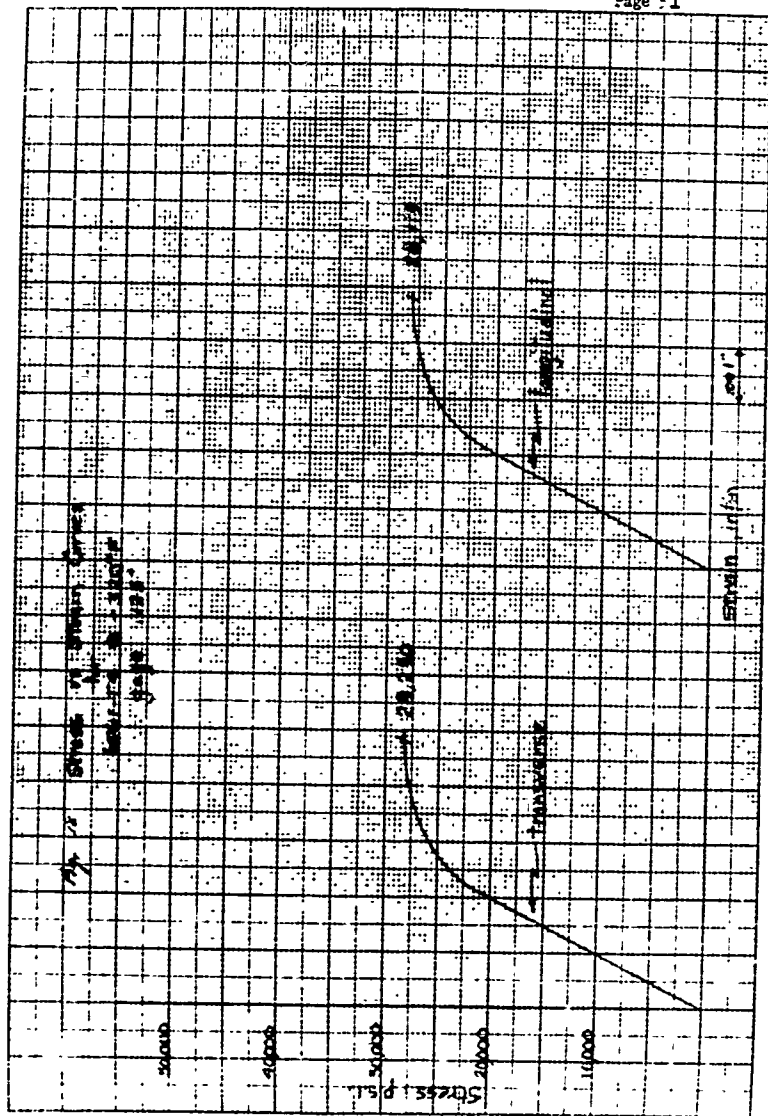


U.S. AIR FORCE, MEMPHIS, TENN.

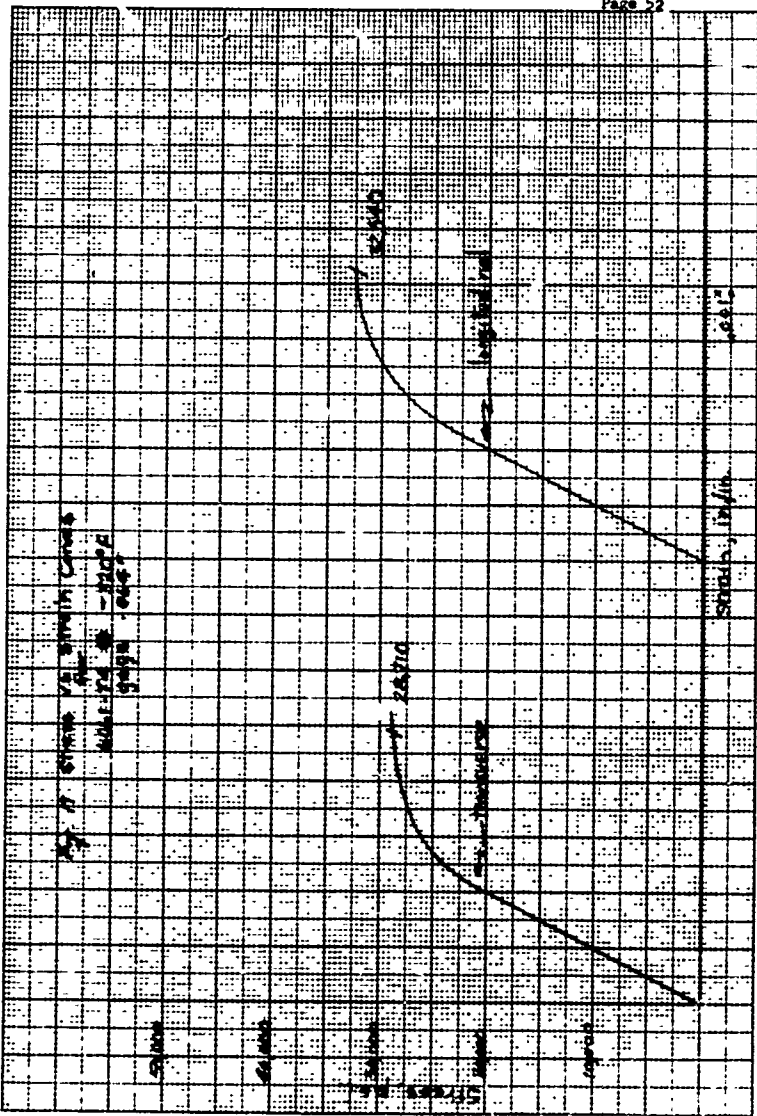
Fig. 17 Stress vs Strain Curves for
6061-T6 - Longitudinal direction
Material welded + filler #443
Gage .25"



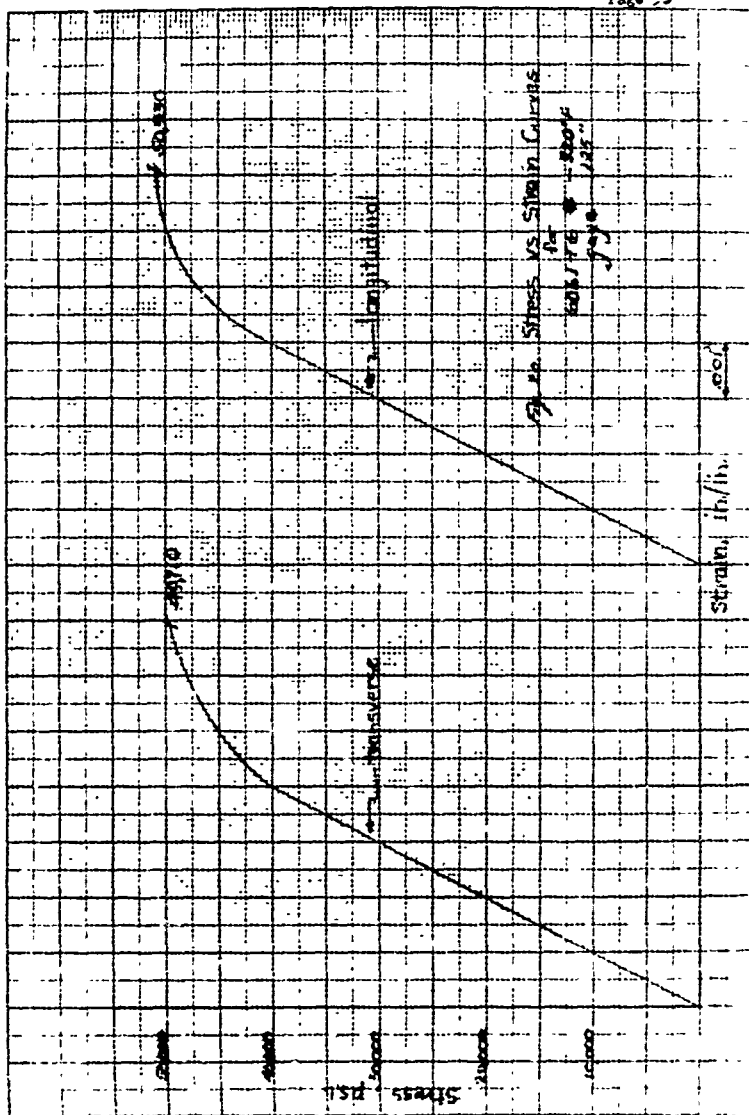
K&E 10 X 10 TO THE 1/2 INCH
SUPPLY CO. ESTIM. CO.
ALBANY, N.Y.

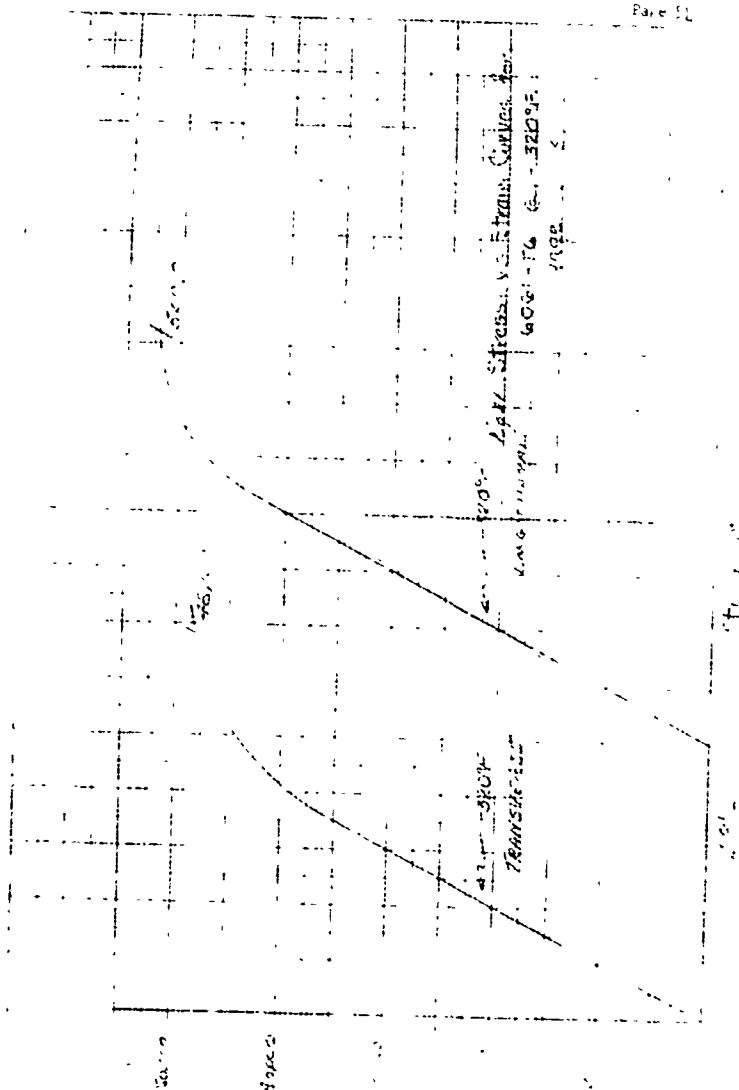


1944-1945



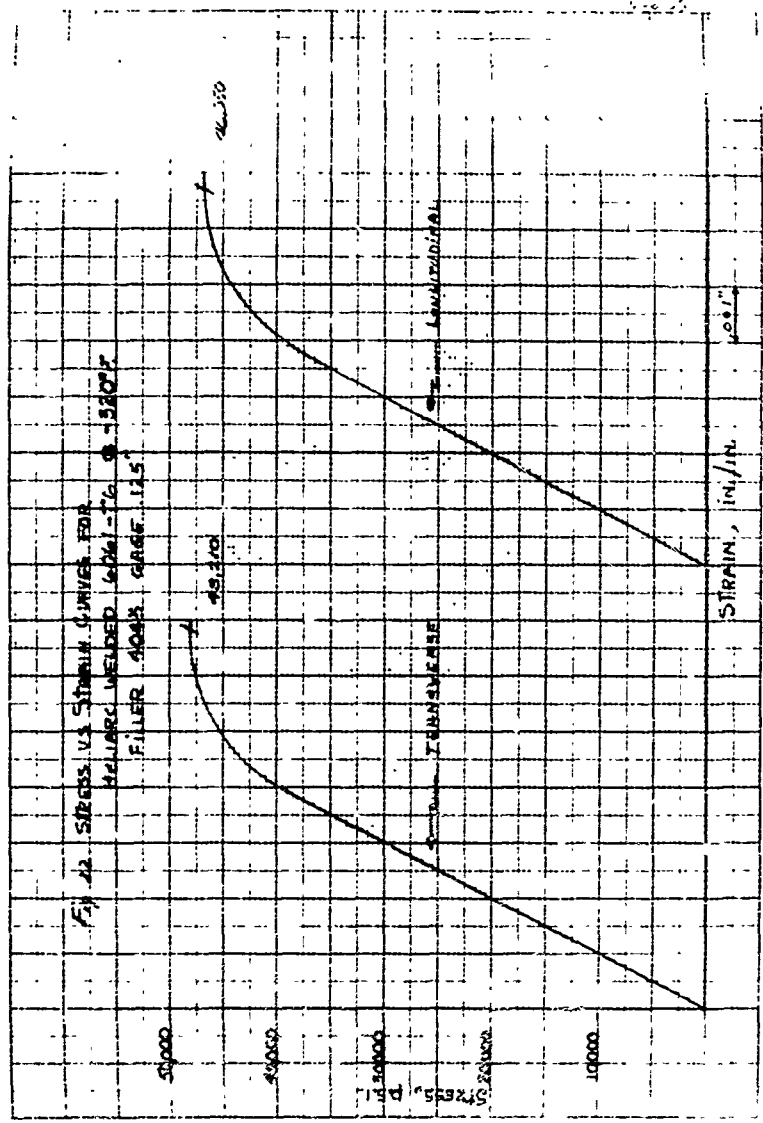
K-E 1010 TENSILE V. INCH 280T.11
 STRESS VS. STRAIN ALUMINUM 6





K&E
10 X 10 TO THE 1/2 INCH 389T-11
REDFUEL 0.05 10.10 10.10
© 1987 K&E

F₁ 12 STRESS VS STRAIN CURVES FOR
HELARC WELDED 1/2" x 1/2" x 1/2" 1520°F
FILLER 904SS GAGE 12.5"



350511
 10000
 10000
 10000

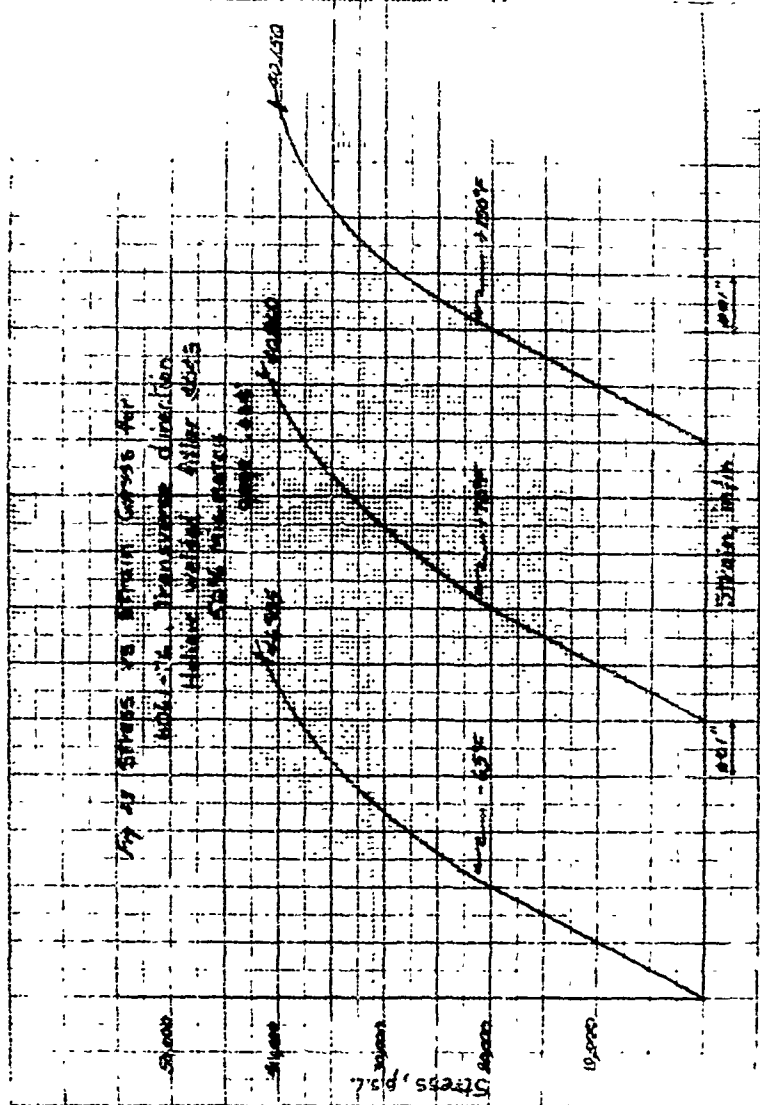
BY
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BELL *Strength* EXPERIMENT

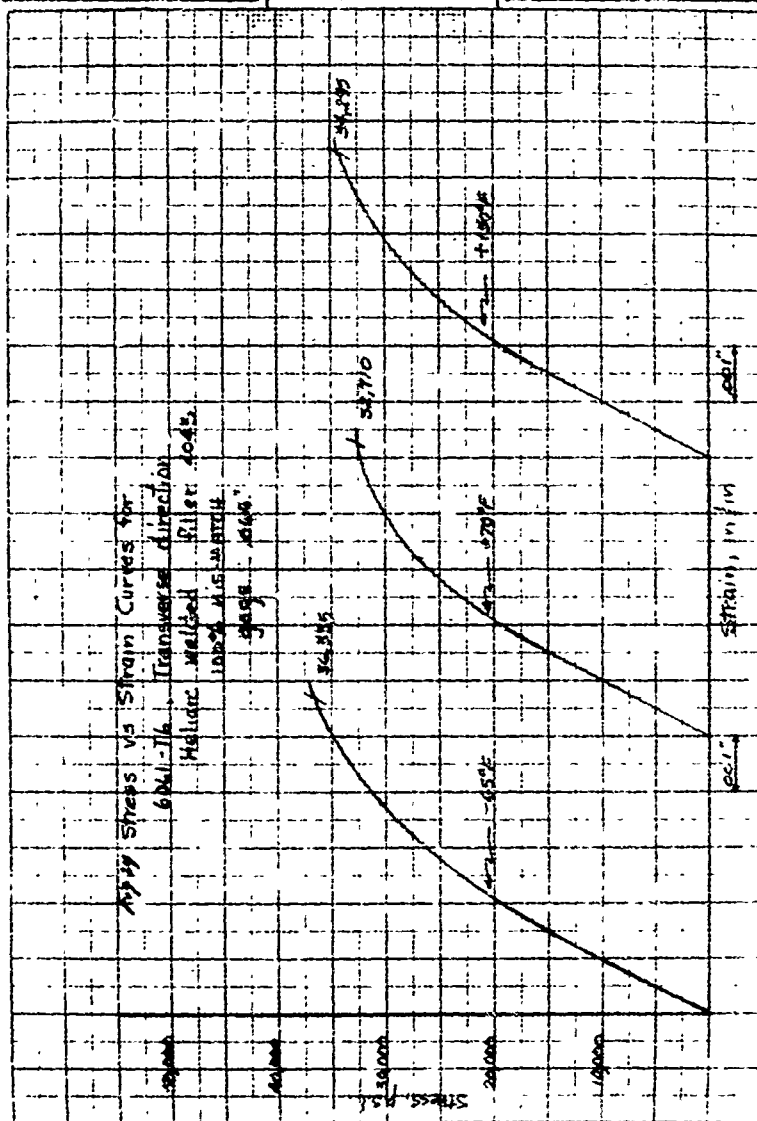
MODEL
 SHIP

PAGE
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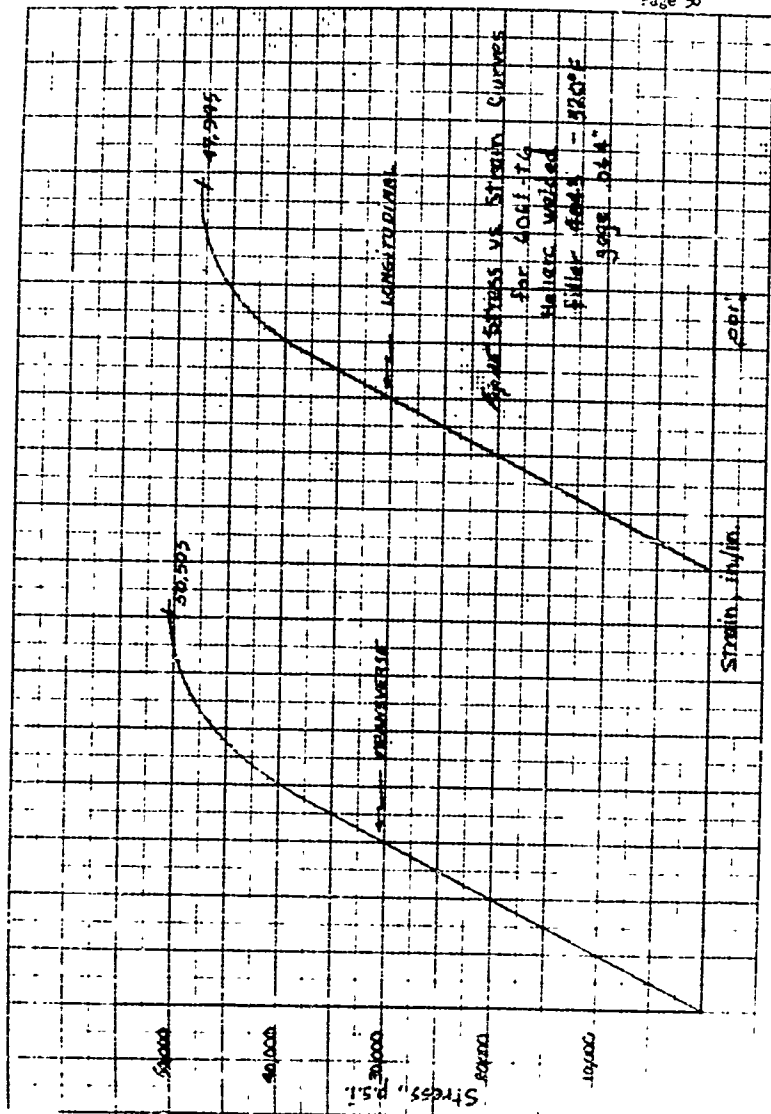


BY _____ DATE _____
 CHECKED _____ DATE _____

BELL Aircraft Corporation

 MODEL _____ PAGE 57
 SHIP _____ REPORT _____

 1039 STRESS VS STRAIN CURVES FOR
 6061-T6 TRANSVERSE DIRECTION
 HELIUM WELDED FILLET 4045
 100% A16-0.0014
 0.008 100%

K₂ 10.810 TO THE 1/4 INCH 3897-11
 10.810 TO THE 1/4 INCH 3897-11
 10.810 TO THE 1/4 INCH 3897-11

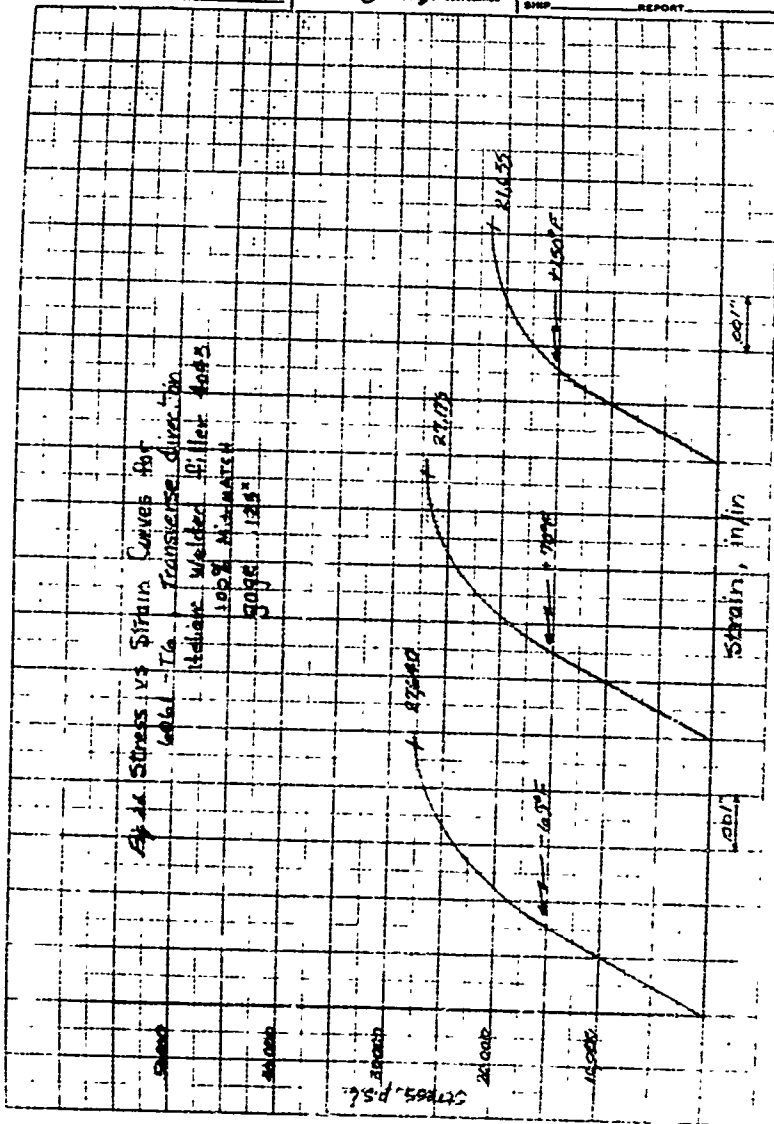


3597 11
JAN 11 1964
U.S. DEPT. OF THE INTERIOR
BUREAU OF LAND MANAGEMENT
DENVER, COLORADO

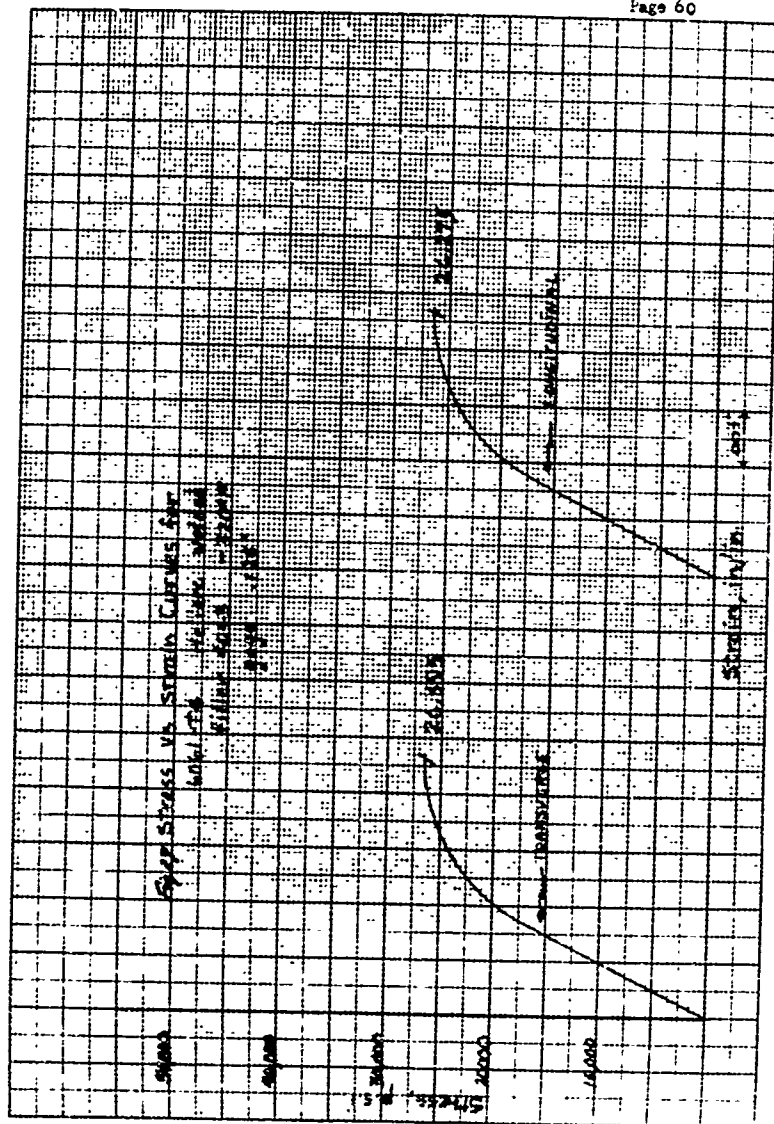
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CHECKED _____ DATE _____

BELL *Average* COVERAGE

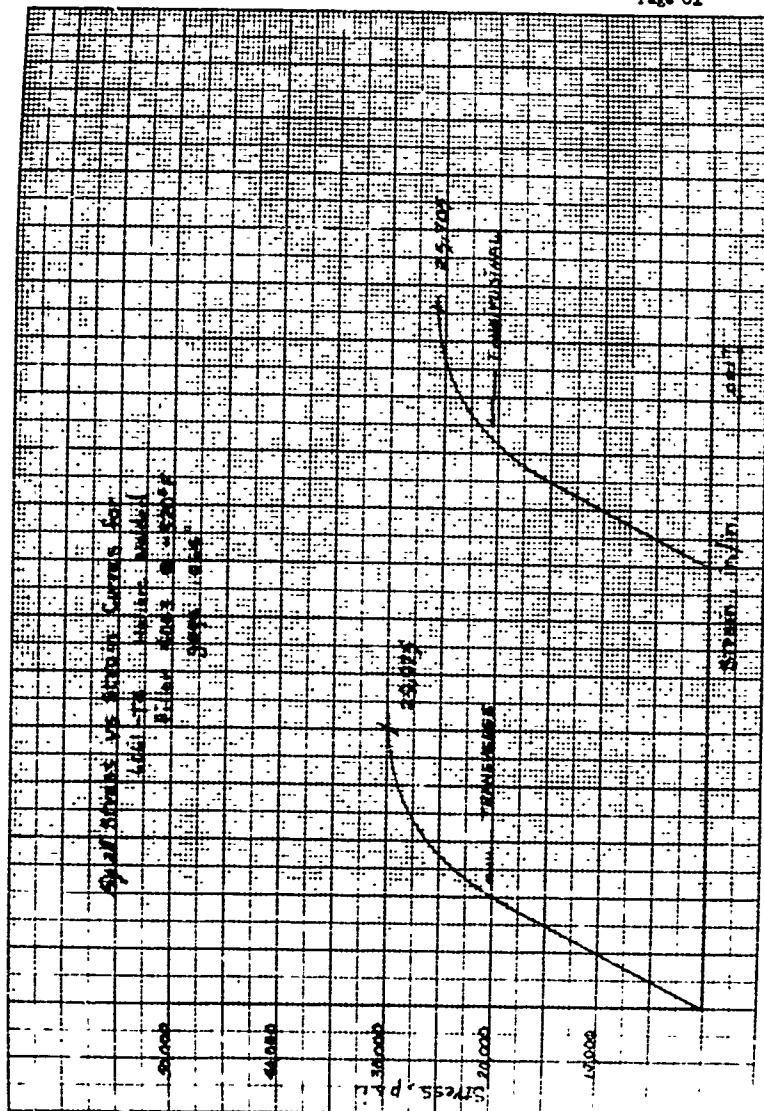
MODEL _____ PAGE 59



NOE 10 X 10 TO THE 1/2 INCH 2897-11
 REPRODUCED BY THE NATIONAL BUREAU OF STANDARDS



K-E 10.16 TO 10.18 IN. HIGH 2897.11
 10.16 TO 10.18 IN. HIGH 2897.11
 10.16 TO 10.18 IN. HIGH 2897.11

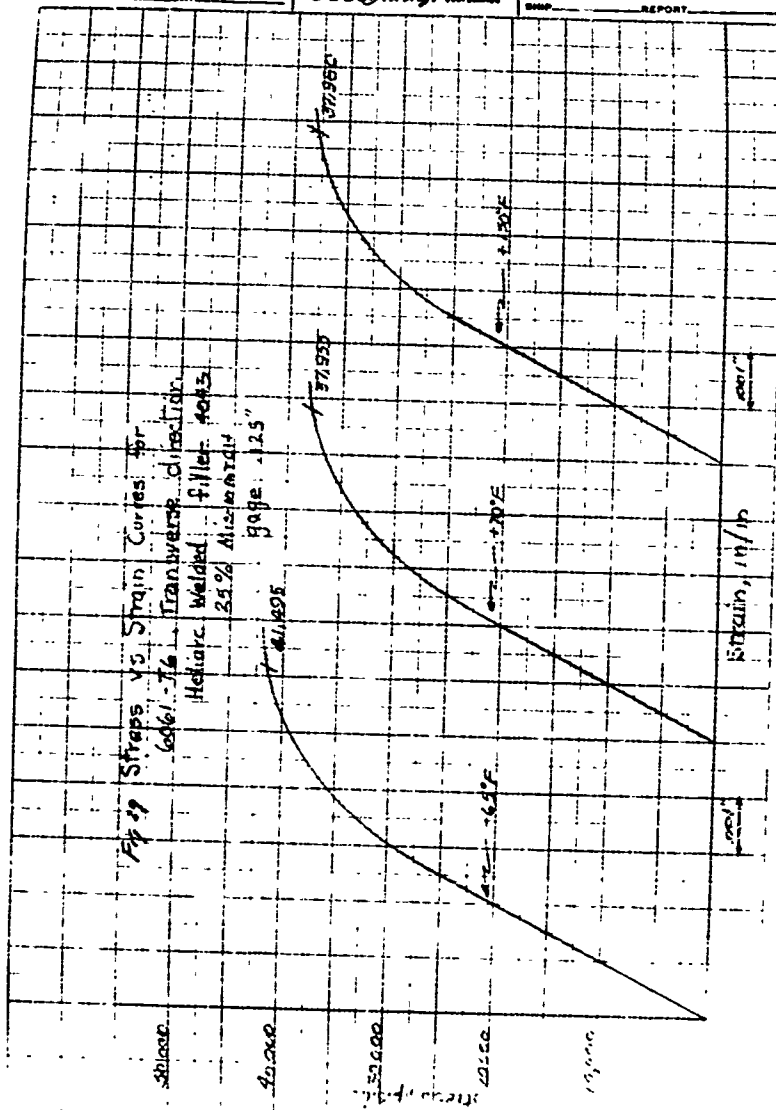


1-2E IN 310 TO THE 1/2 INCH 350T II
 1-2E IN 310 TO THE 1/2 INCH 350T II

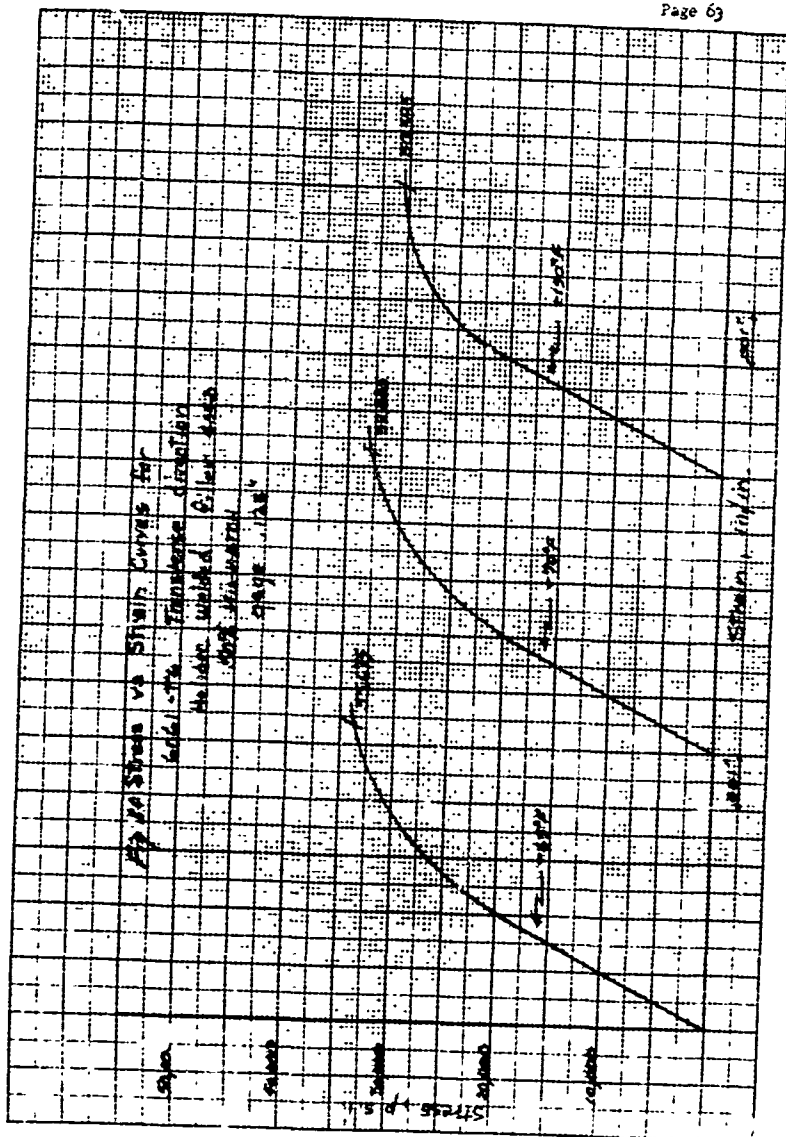
BY _____ DATE _____
 CHECKED _____ DATE _____

BELL Aircraft ENGINEERING

MODEL _____ PAGE 62
 SNIP _____ REPORT _____



K&E 10 X 10 TO THE 1/2 INCH
SUPPLY & ORDER CO
ALBANY, NY 12206
3507.11
416-486-9922



Model _____	DRILL AEROSYSTEMS COMPANY DIVISION OF DRILL HEADQUARTERS CORPORATION	Page 61
Date 29 June 1962		Report BLP 61-LO(11) Rev. A

D. Bulge Test

Experience has shown that there is very little if any correlation between tensile tests of small cross-welded specimens and the performance of pressure vessels under service conditions. The bulge test or hydraulic burst test has replaced the tensile test since it predicts full performance under biaxial stresses.

The fixture consists of a heavy steel plate in which the specimen was bolted at intervals along its outer circumference. The upper plate was machined to a semi-circular shape (figure 31) to allow for deformation of the welded sheet.

Biaxial tensile stress of the welded plate is calculated from measurements of pressure and height of deformation. This stress can be calculated at any point during the test allowing data to be obtained for stress height and pressure height curves.

One of the major weaknesses in this test is that no measure of the plate can be allowed to occur during loading. Errors produced by bending stresses are greatest when the height of the bulge is less than the ratio of plate diameter to sheet thickness of Hollis apparatus is 61 to 1. If the ratio were increased to 200 to 1 errors from bending stresses would be reduced.

Figures 32 and 33 show the full bulge test fixture and a specimen after test. The dial gage is used to measure the bulge height. The fixture and specimen after disassembly is shown in Figure 34.

Figure 31 is a diagrammatic sketch of the fixture showing the mathematical parameters of interest in determining the radius of curvature. A sheet panel bulged through an open circular die generally decreases in radius as bulging progresses. Unless bending stresses around the clamped edge are significant, all points in the sheet are under an equal biaxial tensile stress, which can be calculated from the equation for membranes:

$$\sigma = \frac{p \cdot r}{2 t_0}$$

where σ is the biaxial stress, p is the bulging pressure, r is the radius of curvature of the bulge, and t_0 is the original sheet thickness. In using the height of the bulge the assumption is made that the deformation occurring is spherical.

DESK _____ DATE _____	DELL APPROXIMATE COMPANY 10000 N. 10TH AVE. SUITE 100 DENVER, CO 80231	Page <u>55</u> Rev <u>BLK -1.0 (1)</u>
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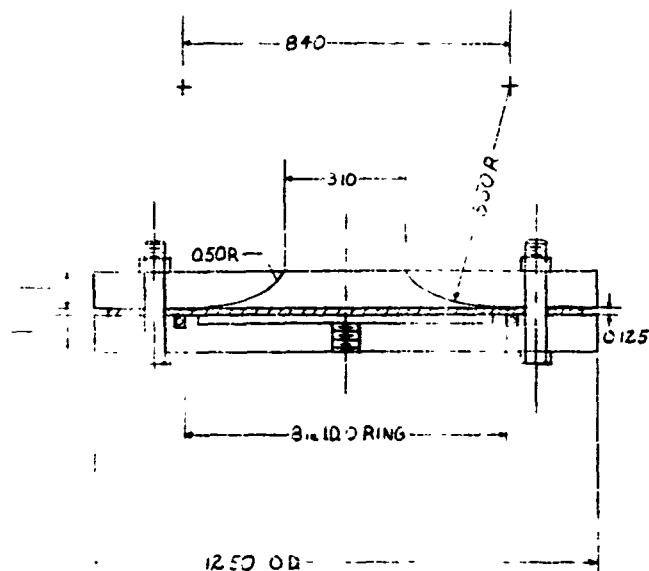


Figure 31

DIAPHRAGM TEST FIXTURE

Model _____	BELL AEROSPACE COMPANY DIVISION OF BELL AIRCRAFT CORPORATION	Page <u>66</u>
Date <u>12-29-61</u>		Report <u>BLS 61-40 (M)</u>

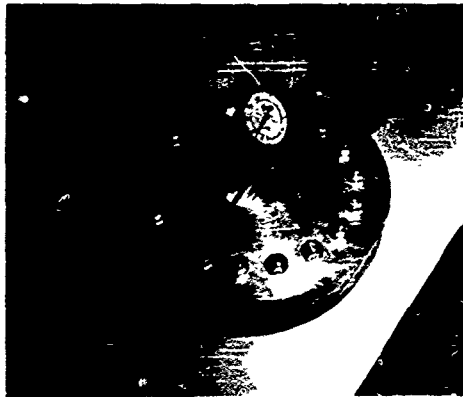


Figure 32. Bulge Test Fixture

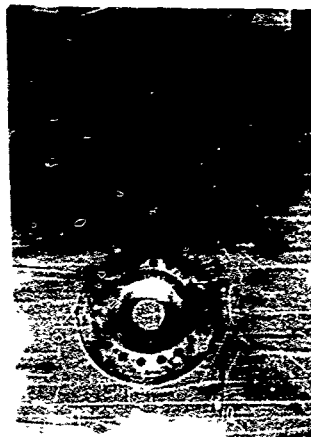


Figure 33. Bulge Test Fixture Disassembled

Model _____
 Date 12-29-61

BELL AEROSYSTEMS COMPANY
 DIVISION OF BELL TELEPHONE CORPORATION

Page 67
 Report ALA 61-40 (N)

R = RADIUS OF CURVATURE
 Z = RADIUS OF DIE EDGE
 T = RADIUS OF DIE OPENING
 h = BULGE HEIGHT

① BASIC RELATIONSHIP: $(R+Z)^2 = (T+Z)^2 + (R-h+Z)^2$
 ② SOLVE FOR R: $R = \frac{T^2 + h^2 + Z^2 + 2ZT - 2Zh}{2h}$

③ SUBSTITUTE THE DIMENSIONS: $R = \frac{h^2 - Zh + 25}{2h}$
 $Z = 1"$
 $T = 4"$

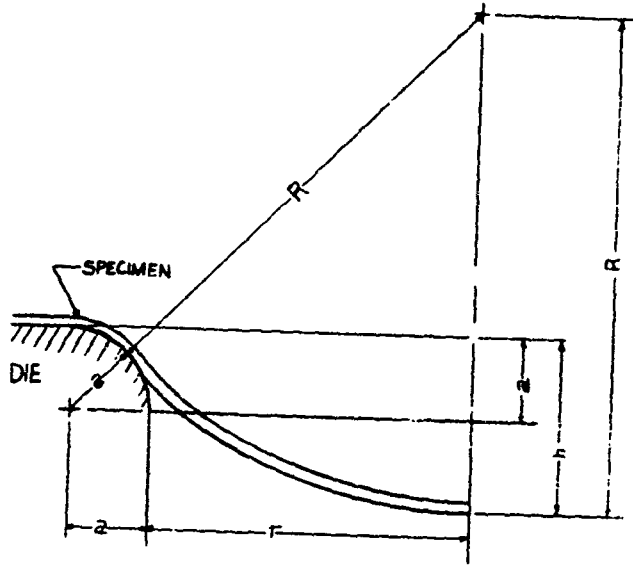


Figure 3a. RADIUS OF CURVATURE CALCULATION

Chen et al.

Form 800 Rev. 1961

TABLE XVIII
Bulge Test Data

Model _____

Date 12-29-61

BELL AEROSYSTEMS COMPANY
DIVISION OF BELL AIRCRAFT COMPANY **

Page 68

Report BLR 61-40 (M)

TABLE XVIII
Bulge Test Data

Material	Heat Treatment	Thickness (inch)	Deflection (inch)	Pressure (psi)
6061T4	As welded	.125	.095	100
			.140	200
			.215	300
			.275	400
			.330	500
			.385	600
			.425	700
			.460	800
			.495	900
			.530	1000
			.560	1100
			.585	1200
			Burst	2350
6061T6	Aged after welding	.125	.074	100
			.140	200
			.200	300
			.250	400
			.290	500
			.330	600
			.360	700
			.390	800
			Burst	1350

Model _____
Date 12-29-61

BELL AIRCRAFT SYSTEMS COMPANY
DIVISION OF BELL AIRCRAFT CORPORATION

Page 69
Report BLR 61-40 (M)

III. METALLURGY AND HEAT TREATMENT OF ALUMINUM ALLOY 6061

Aluminum alloy 6061 is an aluminum magnesium, silicon alloy which is responsive to precipitation heat treatment. Magnesium silicide is dissolved into the aluminum matrix during solution heat treatment at 970-1010 F. Upon quenching, small microscopic particles of magnesium silicide are ejected from the solid solution. Aging at 340-355 F causes growth of the precipitate thus strengthening the atomic lattice.

This alloy offers good strength, formability, weldability and very good corrosion resistance. It is widely used by the aircraft industry in applications requiring the combination of properties this alloy possesses.

IV. DISCUSSION OF FINDINGS

Mismatch

The tabulated results of this study presented in Table III and Table IV show that there is very little depreciation of properties up to 50% mismatch. At 100% mismatch there is an appreciable decrease in the strength of the welded material. These specimens all failed at the edge of the weld or in the annealed zone area which does not respond to aging. The specimens were shimmed during loading to eliminate bending stresses.

Weld Repair

The properties of the material were reduced to the annealed condition by manual welding. No further tests were conducted as to evaluating repairs, for the strength of the material was reduced to a minimum and the structure due to annealing would be unresponsive to aging. The automatic welded (heliarc and sigma) 0.064 inch thick material showed slight decreases in tensile and yield strengths as shown by the data given in Tables V to XI. There was, however, a marked decrease in elongation which, when considered with the strengths obtained, is due to the increase in size of the weld bead.

The 0.125 inch thick material, in comparison to the 0.064 inch material, welded in the same manner shows a much greater decline in tensile and yield strengths, due to the higher heat input during welding which caused more overaging of the heat affected zone than experienced with the 0.064 inch thick material.

Mechanical Properties

The increase in yield, tensile and elongation properties at low temperatures is brought out by both tempers (T4 and T6) studied. This increase is best explained by the application of dislocation theory. Upon subjection to low temperatures the atomic lattice undergoes a contraction. the thermal agitation of the atoms is reduced and the material will undergo a greater amount of uniform strain before dislocation pile ups become keyed. During this strain period the lattice becomes strengthened by the repeated generation of dislocations and a higher yield stress and tensile stress is obtained. The period of uniform elongation is of longer duration than at room or elevated temperatures resulting in a higher measured elongation.

Model _____

BELL AEROSYSTEMS COMPANY
DIVISION OF BELL AIRCRAFT CORPORATIONPage 71Date 29 Aug 1962Report ELR 1-20(1) Rev. A

The difference in the T4 yield strength and the T6 at - 20 ° reflects the difference in the matrix strength the T4 being considerably weaker due to submicroscopic particles. In the T6 condition, the matrix has been strengthened by the growth of these particles.

The "V" notch data was obtained late in this program. Notches to unnotched ratios will be obtained in the next phase and stress concentrations factors (K) greater and less than 3 will be evaluated.

Bulge Test

The data presented herein is raw data and will be reduced during the coming year. Modification of the jig will be accomplished also to improve the accuracy of the test results.