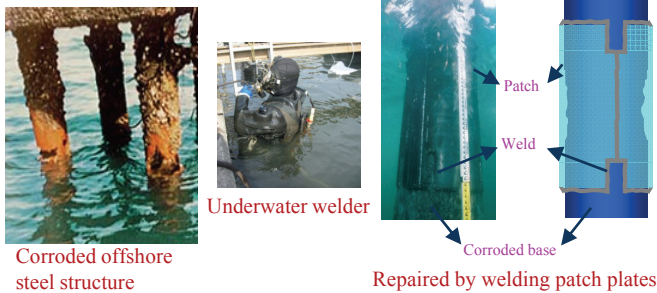


Experimental study on strength and ductility of underwater fillet welds in repairing offshore steel structures

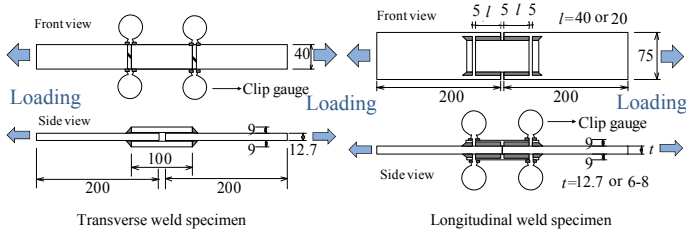
Xiao Chen, Yasuo Kitane & Yoshito Itoh
Dept. of Civil Engineering, Nagoya University, Japan

Introduction

Underwater wet welding is commonly used to repair corroded offshore steel structures. The study presents an investigation on strength and ductility of underwater fillet-welded joints. Fourteen different types of weld assemblies are tested to failure, and weld hardness and microstructures are investigated. Differences between underwater and in-air fillet welds are examined in terms of strength, ductility, and failure modes. Weldability of base steels in the underwater wet environment is also evaluated.



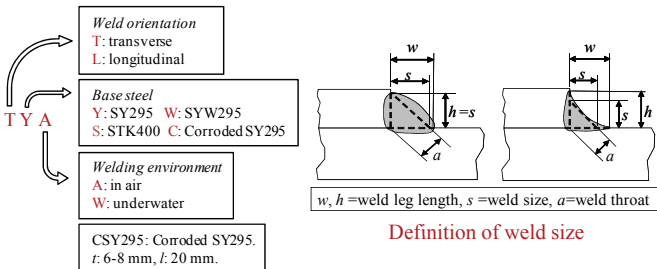
Experiment program



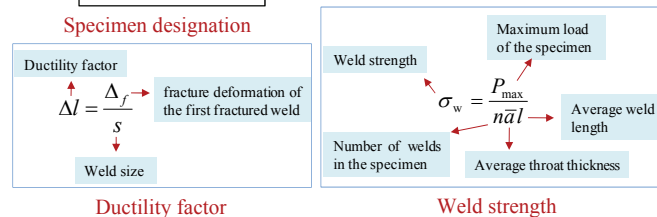
Specimen configuration

Material properties of steels

Material	Mechanical properties					Chemical compositions (wt-%)				
	Young's modulus, E(GPa)	Poisson's ratio, ν	Yield stress, σ_y (MPa)	Ultimate stress, σ_u (MPa)	Elongation, Δl (%)	C	Si	Mn	P	S
SY295	213	0.29	273	497	41	0.30	0.06	0.72	0.016	0.020
CSY295	212	0.29	349	531	34	0.27	0.02	0.96	0.013	0.019
SYW295	213	0.28	392	513	42	0.10	0.23	1.41	0.020	0.005
STK400	203	0.28	362	394	41	0.12	0.10	0.56	0.013	0.006
Electrode	-	-	410	460	30	0.10	0.10	0.43	0.015	0.007



Definition of weld size

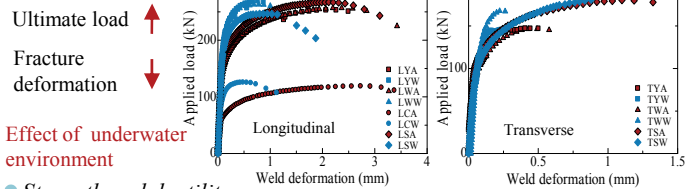


Ductility factor

Weld strength

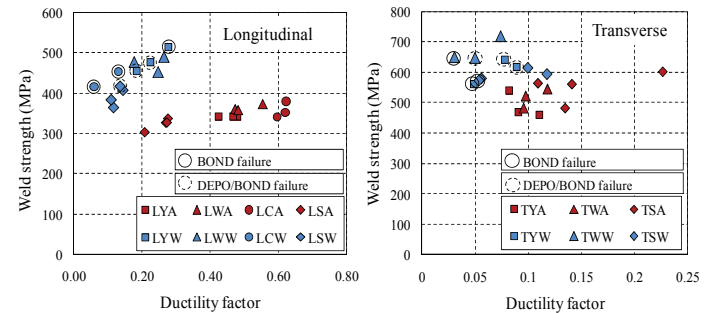
Results

Load-deformation

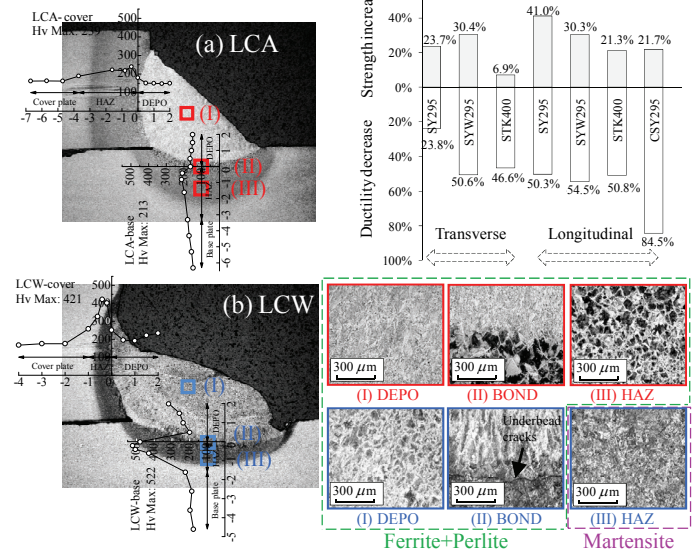


Effect of underwater environment

Strength and ductility



Hardness and microstructure



Conclusions

- (1) Underwater fillet welds have larger strength but smaller ductility when compared with in-air welds. Strength increase ranges from 6.9% to 41.0%, while ductility decrease is nearly the same at 50%.
- (2) Underwater fillet welds on corroded SY295 steels show a drastic ductility decrease of 84.5%, resulting from mechanical mismatching and underbead cracks.
- (3) The weldability of SY295 steel is undesirable in underwater welding due to its high carbon equivalent.

Contact: Department of Civil Engineering, Nagoya University
Chikusa-ku, Furo-cho, 464-8603, Nagoya, Japan
E-mail: chenxiao@civil.nagoya-u.ac.jp

