

UNIVERSITI TEKNOLOGI MARA

**APPLICATION OF VIRTUAL
MANUFACTURING USING FEM IN
DISTORTION ANALYSIS FOR
WELDING, WELDING-FORMING
AND WIRE-ARC ADDITIVE
MANUFACTURING PROCESS**

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Thesis submitted in fulfillment
of the requirements for the degree of
Master of Science
(Mechanical Engineering)

Faculty of Engineering

August 2019

ABSTRACT

This master research deals with the application of Virtual Manufacturing (VM) using Finite Element Method (FEM) on manufacturing processes which consist of welding, coupled welding to forming and Wire Arc Additive Manufacturing (WAAM) process. Deformation behaviour caused by the mentioned manufacturing processes are main concern for this research investigated by means of VM and experiments. A series of experiment was conducted in order to verify the result of simulation, whereby materials chosen for this study are low carbon steel and High Strength Low Alloy (HSLA) steel. The material properties taken from experiment, previous researches and software database were implemented into simulation in order to ensure a realistic resemblance. The simulation was carried out by utilizing thermo-mechanical FEM under consideration of non-linear isotropic hardening using specialized and commercial FEM software namely SIMUFACT and MSC Marc/Mentat. The first case study is the investigation of angular distortion induced by T-Joint welding process using FEM software Simufact.Welding and MSC Marc/Mentat. In this case, low carbon steel S235 is selected as material for both simulation and experiment. For verification, experimental T-Joint welding was executed by means of robotic welding machine ABB IRB 2400/16 and power source KEMPPPI Pro-EvolutionProMig with shielding gas (80% Ar and 20% CO₂) and filler wire ER70S. The result of FEM-based VM simulation generated by both software would later be compared to analyse the angular distortion. The second case study is an analysis of springback effect caused by coupled process welding to forming using FEM software Simufact.Welding and Simufact.Forming. The final springback occurred at the end of the coupled process is the main concern of this study, in which low carbon steel DC04 is assigned as material. For experimental verification, a robotic welding machine Comau Robotics SMART NS-16-1.65 with power source Fronius TrasmaPuls Synergic 5000 CMT along with shielding gas (80% Ar and 20% CO₂) and filler wire G2Si was assigned for welding process, while sheet metal bending machine VEB WERKZEUG PYE 160s was utilized for experimental forming process. The last case study is the analysis of substrate distortion induced by WAAM process in which FEM-based VM simulation was executed by using MSC Marc/Mentat and two different bead modelling strategies were implemented and compared with S235 as substrate material. The experimental WAAM was conducted by using robotic welding machine similar to first case study with filler material low alloy steel ER80S-Ni. For all three case studies, comparative analysis between simulation and experimental result were compared. The percentage errors range between 11,25% to 22%, 4,54% to 33,1% and 17,3% to 20% for T-Joint, coupled welding to forming and WAAM respectively. It can be concluded that FEM-based VM can produce results which show a good agreement compared to experiment.

ACKNOWLEDGEMENT

Firstly, I wish to thank God for giving me the opportunity to embark on my Master and for completing this long and challenging journey successfully. My gratitude and thanks go to my supervisor Prof Ir Dr. -Ing Ts Yupiter HP Manurung IWE/EWE/SFI CEng IMechE during the whole postgraduate research program.

My appreciation also goes to the assistant engineers of Advanced Manufacturing Technology laboratory of Faculty of Mechanical Engineering at UiTM Shah Alam for their assistance during the whole experimental process. I would like to give a thanks for Chemnitz University of Technology, Germany for giving me an opportunity to do a research stay in order to enhance the quality of this thesis to the whole next level. I would also like to show my gratitude for the research team of AMTE_x for being such an encouraging colleague for the last few years.

Finally, this thesis is dedicated to my father who supports my decision to study for Master degree in UiTM, my mother for her endless affection since the day I was born and my sister who always support her brother in cheerful way.

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