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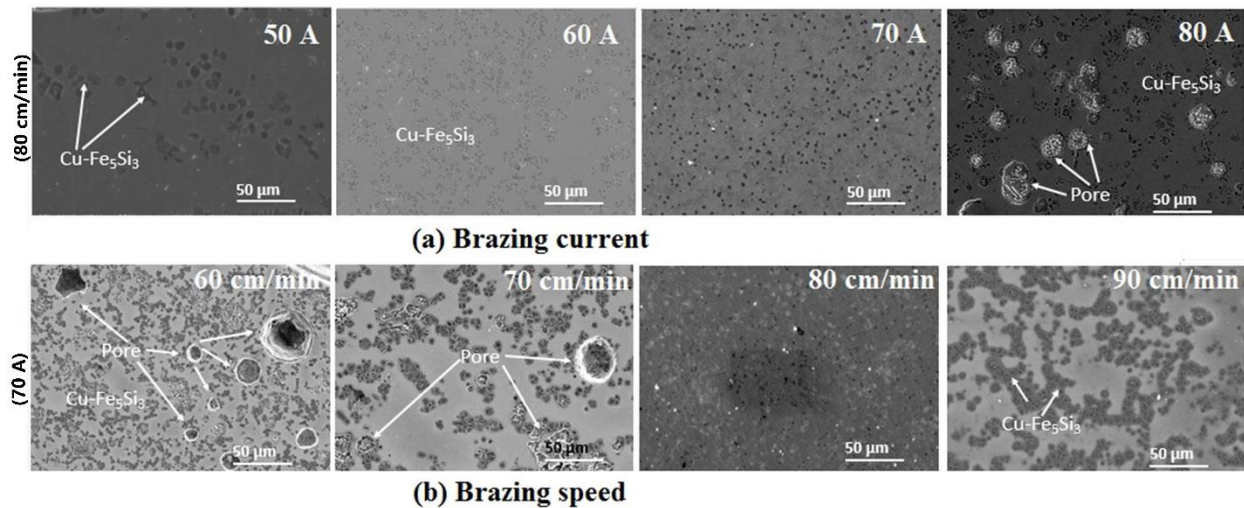
Effect of brazing current and speed on the bead characteristics, microstructure, and mechanical properties of the arc brazed galvanized steel sheets

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Graphical Abstract



Abstract:

Gas metal arc (GMA) brazing was employed to join hot-dip galvanized steel sheets (GI) in lap joint configuration using CuSi₃ filler. The effects of brazing current and speed on the joint characteristics such as bead geometry, microstructure, weldability, microhardness and tensile shear strength were studied. The bead geometry was assessed by examining the bead shape, width, throat thickness, penetration width and depth of the fused zone. The microstructural

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