



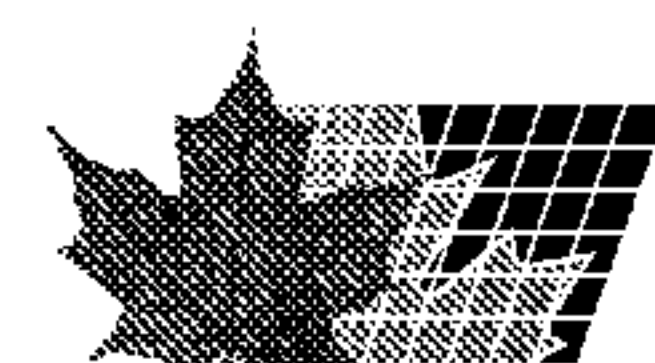
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(54) **Titre : JOINT SOUDE PAR POINTS PRESENTANT UNE HAUTE RESISTANCE ET UNE EXCELLENTE APTITUDE A LA MISE EN
FORME, ET SON PROCEDE DE PRODUCTION**
(54) **Title: SPOT WELDED JOINT USING HIGH STRENGTH AND HIGH FORMING AND ITS PRODUCTION METHOD**

(57) **Abrégé/Abstract:**

The present invention relates to a spot welded joint of at least two steel sheets, wherein at least one of the steel sheets presents yield strength above or equal to 600 MPa, an ultimate tensile strength above or equal to 1000 MPa, uniform elongation above or equal to 15%. The base metal chemical composition comprises $0.05 \leq C \leq 0.21$ %, $4.0 \leq Mn \leq 7.0$ %, $0.5 \leq Al \leq 3.5$ %, $Si \leq 2.0$ %, $Ti \leq 0.2$ %, $V \leq 0.2$ %, $Nb \leq 0.2$ %, $P \leq 0.025$ %, $B \leq 0.0035$ %, and the spot welded joint contains a molten zone microstructure containing more than 0.5 % of Al and containing a surface fraction of segregated areas lower than 1 %, said segregated areas being zones larger than $20\mu m^2$ and containing more than the steel nominal phosphorus content.



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(54) Title: SPOT WELDED JOINT USING HIGH STRENGTH AND HIGH FORMING AND ITS PRODUCTION METHOD

(57) Abstract: The present invention relates to a spot welded joint of at least two steel sheets, wherein at least one of the steel sheets presents yield strength above or equal to 600 MPa, an ultimate tensile strength above or equal to 1000 MPa, uniform elongation above or equal to 15%. The base metal chemical composition comprises $0.05 \leq C \leq 0.21$ %, $4.0 \leq Mn \leq 7.0$ %, $0.5 \leq Al \leq 3.5$ %, $Si \leq 2.0$ %, $Ti \leq 0.2$ %, $V \leq 0.2$ %, $Nb \leq 0.2$ %, $P \leq 0.025$ %, $B \leq 0.0035$ %, and the spot welded joint contains a molten zone microstructure containing more than 0.5 % of Al and containing a surface fraction of segregated areas lower than 1 %, said segregated areas being zones larger than $20\mu m^2$ and containing more than the steel nominal phosphorus content.



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SPOT WELDED JOINT USING HIGH STRENGTH AND HIGH FORMING STEEL AND ITS PRODUCTION METHOD

The present invention relates to a spot welded joint of at least two steel sheets
5 wherein at least one of the steel sheets, presents yield strength above or equal to 600 MPa, an ultimate tensile strength above or equal to 1000 MPa, uniform elongation above or equal to 15%.

In the automotive industry in particular, there is a continuous need to lighten
vehicles and to increase safety by using and by joining light steels or steels
10 presenting high tensile strength to compensate lower thickness. Thus, several families of steels like the ones mentioned below offering various strength levels have been proposed.

Firstly, steels have been proposed that have micro-alloying elements whose
hardening is obtained simultaneously by precipitation and by refinement of the grain
15 size. The development of such steels has been followed by those of higher strength called Advanced High Strength Steels which keep good levels of strength together with good cold formability.

For the purpose of obtaining even higher tensile strength levels, steels
exhibiting TRIP (Transformation Induced Plasticity) behaviour with highly
20 advantageous combinations of properties (tensile strength/deformability) have been developed. These properties are associated with the structure of such steels, which consists of a ferritic matrix containing bainite and residual austenite. The residual austenite is stabilized by an addition of silicon or aluminium, these elements retarding the precipitation of carbides in the austenite and in the bainite. The presence of
25 residual austenite improves ductile behavior Under the effect of a subsequent deformation, for example when stressed uni-axially, the residual austenite of a part made of TRIP steel is progressively transformed to martensite, resulting in substantial hardening and delaying the appearance of necking.

To achieve an even higher tensile strength, that is to say a level greater than
30 800-1000 MPa, multiphase steels having a predominantly bainitic structure have been developed. In the automotive industry or in industry in general, such steels are

advantageously used for structural parts such as bumper cross-members, pillars, various reinforcements and abrasion-resistant wear parts. However, the formability of these parts requires, simultaneously, a sufficient elongation, greater than 10% and not a too high yield strength/tensile strength ratio so as to have a sufficient reserve of plasticity.

All these steel sheets present relatively good balances of resistance and ductility, but new challenges appear when it comes to assemble these sheets using for instance conventional spot welding techniques. Henceforth, new concepts presenting, high strength and high formability while being weldable using existing welding techniques are needed.

So as to reduce body in white weight, European application EP1987904 aims at providing a joint product of a steel product and an aluminium material, and a spot welding method for the joint product, ensuring that spot welding with high bonding strength can be performed. In one embodiment, a steel product having a sheet thickness t_1 of 0.3 to 3.0 mm and an aluminium material having a sheet thickness t_2 of 0.5 to 4.0 mm are joined together by spot welding to form a joint product of a steel product and an aluminium product. In this joint product, the nugget area in the joint part is from $20 \times t_2^{0.5}$ to $100 \times t_2^{0.5} \text{ mm}^2$, the area of a portion where the thickness of the interface reaction layer is from 0.5 to 3 μm is $10 \times t_2^{0.5} \text{ mm}^2$ or more, and the difference between the interface, reaction layer thickness at the joint part center and the interface reaction layer thickness at a point distant from the joint part center by a distance of one-fourth of the joint diameter D_c is 5 μm or less. According to this construction, there is provided a dissimilar material joint product with excellent bonding strength, which can be formed by an existing spot welding apparatus at a low cost without using other materials such as clad material. This is done without adding a separate step and a spot welding method for the dissimilar material joint product. Such a method implies welding steel sheet to an aluminium one, the joint material resistance will have a soft area on the aluminium side compared to the steel one.

US application US2012141829 comes up with a spot welded joint which includes at least one thin steel plate with a tensile strength of 750 MPa to 1850 MPa and a carbon equivalent C_{eq} of equal to or more than 0.22 mass % to 0.55 mass % and in which a nugget is formed in an interface of the thin steel plates. In the nugget
5 outer layer zone, a microstructure consists of a dendrite structure in which an average value of arm intervals is equal to or less than 12 μm , an average grain diameter of carbides contained in the microstructure is 5 nm to 100 nm, and a number density of carbides is equal to or more than $2 \times 10^6/\text{mm}^2$. Such application does not aim at third generation steels but conventional ones only.

10 None of the mentioned prior arts faced nor solved the challenge of welding steels with non conventional amounts of alloying elements in steels, which remains unsolved.

The present invention relates to a spot welded joint of at least two steel sheets, wherein at least one of the steel sheets is an aluminium alloyed steel sheet
15 presenting:

- A yield strength above or equal to 600 MPa
- A tensile strength above or equal to 1000 MPa
- A uniform elongation above or equal to 15%.

The welded joint being characterized by:

- 20 – a molten zone containing at least 0.5wt%Al and a surface fraction of coarse segregated areas lower than 1%. The coarse segregated areas are defined as zones larger than $20\mu\text{m}^2$ containing at least the base metal nominal phosphorus content.
- Optionally, a molten zone microstructure containing a density of iron carbides
25 larger than 50nm equal or above 2×10^6 per mm^2 .
- Optionally, a microstructure at the boundary between molten zone and the steel according to the invention does not have martensite 18R inside the ferritic grains.

Another aim of the invention is to provide a process for making such welded joint with a steel that can be easily cold rolled down to its final thickness while being compatible with usual continuous annealing lines and having a low sensitivity to process parameters.

5 The invention has, as a first object, a spot welded joint of at least two steel sheets, with at least one of them being an aluminium alloyed steel, comprising, by weight percent:

$$0.05 \leq C \leq 0.21\%$$

$$4.0 \leq Mn \leq 7.0\%$$

10 $0.5 \leq Al \leq 3.5\%$

$$Si \leq 2.0\%$$

$$Ti \leq 0.2\%$$

$$V \leq 0.2\%$$

$$Nb \leq 0.2\%$$

15 $P \leq 0.025\%$

$$B \leq 0.0035\%$$

$$S \leq 0.004\%$$

The remainder of the composition being iron and unavoidable impurities resulting from the smelting, said steel presenting a yield strength above or equal to 600 MPa, an ultimate tensile strength above or equal to 1000 MPa, and uniform elongation
20 above or equal to 15%, the microstructure of said steel contains 20% to 50% of austenite, 40% to 80% of annealed ferrite, less than 25% of martensite and wherein the spot welded joint is characterized by a molten zone microstructure containing more than 0.5 % of Al and containing a surface fraction of coarse segregated areas
25 lower than 1%. The coarse segregated areas are defined as zones larger than $20\mu m^2$ containing phosphorus in an amount superior to the steel phosphorus content.

In another preferred embodiment, said aluminium alloyed steel chemical composition has an aluminum content such that, $1.0 \leq Al \leq 3.0\%$, or even $1.0 \leq Al \leq 2.5\%$.

Preferably, said aluminium alloyed steel chemical composition has a silicon content such that, $\text{Si} \leq 1.5 \%$ or even $\text{Si} \leq 1.0\%$.

In a preferred embodiment, said aluminium alloyed steel microstructure contains between 50% and 70% of annealed ferrite.

5 In a preferred embodiment, said aluminium alloyed steel presents less than 20% of martensite.

Preferably, the density of iron carbides larger than 50nm is equal or above 2×10^6 per mm^2 in the spot welded joint molten zone.

10 Preferably, the microstructure at the boundary between molten zone and the steel according to the invention does not have martensite 18R with orthorhombic needle-like phase inside the ferritic grains.

The invention also has, as an object, an assembly of two steel sheets including a spot welded joint according to the invention.

15 The invention has, as a second object a process to produce the spot welded joint of at least two steel sheets, with at least one of them being an aluminium alloyed steel sheet, produced by:

- Casting aluminium alloyed steel which composition is according to the present invention so as to obtain a slab,
- Reheating the slab at a temperature T_{reheat} between 1150°C and 1300°C ,
- 20 - Hot rolling the reheated slab with a temperature between 800°C and 1250°C to obtain a hot rolled steel, the last hot rolling pass taking place at a temperature T_{lp} above or equal to 800°C .
- Cooling the hot rolled steel between 1 and 150°C/s until a coiling temperature T_{coiling} lower or equal to 650°C .
- 25 - Then, coiling the hot rolled steel cooled at T_{coiling} .
- Optionally, the hot rolled steel is batch annealed between 400°C and 600°C between 1 and 24 hours, or continuously annealed between 650°C and 750°C between 20 and 180s.

- The invention has also as an object a process to obtain the steel directly using a casting machine where the product is immediately rolled after casting. This process is called 'Thin Slab Casting'.

Then:

- 5 - Descaling the hot rolled steel sheet
- Cold rolling the steel sheet with a cold rolling ratio between 30% and 70% so as to obtain a cold rolled steel sheet.
- Heating the steel sheet at a heating rate H_{rate} at least equal to 1°C/s up to the annealing temperature T_{anneal}
- 10 - Annealing the steel at a temperature T_{anneal} between T_{min} and T_{max} defined by
 $T_{min}=721-36\cdot C-20\cdot Mn+37\cdot Al+2\cdot Si$ (in $^{\circ}\text{C}$)
 $T_{max}=690+145\cdot C-6.7\cdot Mn+46\cdot Al+9\cdot Si$ (in $^{\circ}\text{C}$)
 during a time between 30 and 700 seconds,
- Cooling the steel sheet at a cooling rate preferably between 5°C/s and 70°C/s ,
- 15 Cutting the cold rolled steel into sheets to obtain a cold rolled steel sheet
- welding at least one of the cold rolled steel sheets to another metal with an effective intensity between 3kA and 15kA and a force applied on the electrodes between 150 and 850 daN, said electrode active face diameter being between 4 and 10mm.
- Optionally, the steel sheet is cooled down at $V_{cooling2}$ to a temperature T_{OA} between
- 20 350°C and 550°C and kept at T_{OA} for a time between 10 and 300 seconds so as to be hot dip coated.
- further cooling the steel sheet at a cooling rate $V_{cooling3}$ preferably above 5°C/s and below 70°C/s down to room temperature to obtain a cold rolled and annealed steel sheet.
- 25 Optionally, the cold rolled and annealed steel is tempered at a temperature T_{temper} between 170 and 400°C for a time t_{temper} between 200 and 800s.

In a preferred embodiment, the cold rolled steel sheet according to the invention is , after annealing, coated with Zn or a Zn alloy.

In another embodiment, the cold rolled steel sheet according to the invention is after annealing coated with Al or Al alloy.

- 5 Optionally, the spot welded joint according to the invention undergoes, after the welding, a post thermal treatment which is applied with an intensity between 60% and 90% of the welding intensity for a time between 0.1 and 2 seconds.

10 The steel sheets or assembly of two steel sheets welded according to the invention can be used to produce car structural parts for vehicles body in white in the automotive industry.

Other features and advantages of the invention will appear through the following detailed description. The figures joined are given by way of examples and shall not be taken as limiting the scope of the present invention. They are such that:

- Figure 1 illustrates the evolution of the hardness of hot rolled materials B1, C1, E1 and F1
- Figure 2 illustrates the tensile properties of hot rolled materials B1, C1, E1 and F1
- Figure 3 illustrates the tensile properties of cold rolled materials B1, C1, E1 and F1 before annealing.
- Figure 4 A shows the tensile properties of cold rolled and annealed materials B1, C1, E1 and F1
- Figure 4 B shows the tensile properties of cold rolled and annealed materials G1, H1, H2, H3 and I2.
- 25 - Figure 5 shows the scanning electron micrographs of the molten zone after Nital etching and image analysis highlighting the effect of aluminium content on the cementite particles (in white) in the microstructure for the assemblies A+A, B+B, C+C and E+E as detailed in table 5.
- Figure 6 shows the heterogeneous weld strength characterized by cross-tensile specimen (A, B, C , E and F welded with J)
- 30 - Figure 7 illustrates the CTS coefficient as a function of Al content (A, B, C, E and F

welded with J for heterogeneous)

- Figure 8 shows the welding range for homogeneous welding (A, B, C, E and F)
- Figure 9 shows the welding range for heterogeneous welding (A, B, C, E and F welded with J)
- 5 - Figure 10 shows the heterogeneous tensile shear stress results (A, B, C, E and F welded with J)
- Figure 11 shows the micrographs for spot welded joints with an aluminium alloyed steel containing 2.9 & 3.9% of Al (Spot welds E+E and F+F as detailed in table 5) and illustration of Martensite 18R
- 10 - Figure 12 shows the micro-hardness filiations for homogeneous spot weld (A, B, C, E and F)
- Figure 13 shows the micro-hardness filiations for heterogeneous spot weld using an aluminium alloyed steel and a typical Dual Phase of 600 MPa of resistance. (A, B, C, E and F welded with J)
- 15 - Figure 14 illustrates the effect of the aluminium content in the molten zone on hardness (A, B, C, E and F welded with J for heterogeneous)
- Figure 15 shows the failure modes as a function of the Al content of an aluminium alloyed steel from 1 to 4% (left to right) for B, C, E and F.
- Figure 16 A shows the heterogeneous plug ratios for examples A, B, C, E and F
- 20 welded with J
- Figure 16 B shows the homogeneous plug ratios, for examples G and H.
- Figure 17 gives a schematic description of Tensile Shear and Cross-tension tests used to characterize the resistance of the spot weld.
- Figure 18 gives a non limitative example of a plug ratio and a molten zone geometry
- 25 between an aluminium alloyed steel according to the invention and a Dual Phase 600 (DP). H is the MZ height, PD is the Plug diameter, MZ-D is MZ diameter, where MZ means Molten zone.
- Figure 19 shows the microprobe analysis images with a threshold at the nominal P content showing the effect of Al on the P segregation for A, B, C, E.
- 30 - Figures 20 A and B illustrate the surface fraction of areas with more than the

nominal P content as the function of their size, Figure 20A being for examples A, B, C, E while Figure 20B is for G and H.

- Figure 21 shows the evolution of the surface fraction of areas larger than $20\mu\text{m}^2$ with more than the nominal P content in the molten zone as a function of Al content for A, B, C, E.

-Figures 22 A and B illustrate the CTS coefficient as a function of Al content with and without post treatment: A for examples A, B, C, E and F in homogeneous welding and B for examples A, B, C, E and F welded with J.

The present invention relates to a spot welded joint of two steel sheets wherein at least one of the steel sheets, called an aluminium alloyed steel, presents yield strength above or equal to 600 MPa, an ultimate tensile strength above or equal to 1000 MPa, uniform elongation above or equal to 15%. The base metal chemical composition comprising more than 0.5% of Al, being easy to weld and to cold roll to its targeted final thickness. To do so, the chemical composition is very important as well as the annealing parameters so as to reach all the objectives. Following chemical composition elements are given in weight percent.

According to the invention, the carbon content is between 0.05 and 0.21%. Carbon is a gamma-former element. It promotes, with the invention Mn content, the stabilization of austenite. Below 0.05%, the tensile strength above 1000 MPa is difficult to achieve. If the carbon content is greater than 0.21%, the cold-rollability is reduced and the weldability becomes poor. Preferably, carbon content is between 0.10 and 0.21%.

Manganese must be between 4.0% and 7.0%. This element, also austenite-stabilizer, is used to stabilize enough austenite in the microstructure. It also has a solid solution hardening and a refining effect on the microstructure. For Mn content less than 4.0%, the retained austenite fraction in the microstructure is less than 20% and the combination of the uniform elongation above 15% and the tensile strength above 1000 is not achieved. Above 7.0%, weldability becomes poor, while segregations and inclusions deteriorate the damage properties.

With regard to aluminum, its content must be between 0.5% and 3.5%. Above 0.5wt%, aluminum additions are interesting for many aspects to increase the stability

of retained austenite through an increase of carbon in the retained austenite. Al enables to decrease the hardness of the hot band, which can be then easily cold rolled down to its final thickness as seen in figures 1, 2 and 3. The robustness is also improved during annealing with Al additions. Addition of Al leads to lower variation of austenite fraction as a function of temperature and leads to improve plug ratio as illustrated in figures 15 and 16. Furthermore, Al is the most efficient element when it comes to opening a large feasibility window for annealing temperature in continuous annealing since it favours the combination of advanced recrystallization at temperatures above the non-recrystallization temperature and austenite stabilization.

Aluminium should be lower or equal to 3.5% to avoid the formation of coarse primary ferrite grains formed during the solidification and not transformed into austenite during further cooling, leading to tensile strength below 1000MPa. It should be understood that since Al is alphageneous whilst C and Mn are both gammageneous, the optimum Al content to limit the formation of coarse primary ferrite grains decreases when C and Mn contents decrease.

Aluminium is also detrimental for continuous casting since the casting powder may react with the liquid metal, the kinetics of reaction being increased when Al content is increased. These coarse primary ferrite grains reduce the tensile strength below 1000MPa. As a consequence, Al content is preferably between 1.0 and 3.0% and even more preferably between 1.0 and 2.5%.

Silicon is also very efficient to increase the strength through solid solution. However its content is limited to 2.0%, because beyond this value, the rolling loads increase too much and hot rolling process becomes difficult. The cold-rollability is also reduced. Preferably, to avoid edge cracks, Si content is lower than 1.5% or even lower than 1.0%.

Micro-alloying elements such as titanium, vanadium and niobium may be added respectively in an amount less than 0.2% for each, in order to obtain an additional precipitation hardening. In particular titanium and niobium are used to

control the grain size during the solidification. One limitation, however, is necessary because beyond, a saturation effect is obtained.

As for sulphur, above a content of 0.004 %, the ductility is reduced due to the presence of excess sulphides such as MnS, in particular hole-expansion tests show
5 lower values in presence of such sulphides.

Phosphorus is an element which hardens in solid solution but which reduces the spot weldability and the hot ductility, particularly due to its tendency to segregation at the grain boundaries or co-segregation with manganese. For these reasons, its content must be limited to 0.025 %, and preferably 0.020 %, in order to
10 obtain good spot weldability.

The maximum boron content allowed by the invention is 0.0035 %. Above such limit, a saturation level is expected as regard to hardenability.

The balance is made of iron and inevitable impurities. Impurity level means
15 below 0.04% of elements such as Ni, Cr, Cu, Mg, Ca...

The steel microstructure contains, as surface fraction, 20% to 50% of austenite, 40% to 80 % of annealed ferrite and martensite lower than 25%. The sum of these microstructural phases equals more than 95%. The balance is made of small inevitable precipitates such as carbides.

20 Austenite is a structure that brings ductility, its content must be above 20% so that the steel of the invention is enough ductile with uniform elongation above 15% and its content must be below 50% because above that value the mechanical properties balance deteriorates.

Ferrite in the invention is defined by a cubic center structure obtained from
25 recovery and recrystallization upon annealing whether from preceding ferrite formed during solidification or from bainite or martensite of the hot rolled steel sheet. Hence, the term annealed ferrite implies that more than 70% of the ferrite is recrystallized. The recrystallized ferrite is characterized by a mean average misorientation, as measured by SEM-EBSD, lower than 3° inside the grains. Its content must be

between 40 and 80% so as to have 1000 MPa minimum of tensile strength, with at least 600 MPa of yield strength and at least 15% of uniform elongation.

Martensite is the structure formed during cooling after the soaking from the unstable austenite formed during annealing. Its content must be limited to 25% so that the uniform elongation remains above 15%. A specific kind of martensite is the so-called 18R martensite structure which is an orthorhombic needle-like phase with a specific crystallography which has been identified and well documented by Cheng et al. [W.-C. Cheng, C.-F. Liu, Y.-F. Lai, Scripta Mater., 48 (2003), pp. 295–300].

The method to produce the steel according to the invention implies casting steel with the chemical composition of the invention.

The cast steel is reheated between 1150°C and 1300°C. When slab reheating temperature is below 1150°C, the rolling loads increase too much and hot rolling process becomes difficult. Above 1300°C, oxidation is very intense, which leads to scale loss and surface degradation.

Hot rolling the reheated slab is done at a temperature between 1250°C and 800°C, the last hot rolling pass taking place at a temperature T_{lp} above or equal to 800°C. If T_{lp} is below 800°C, hot workability is reduced.

After hot rolling, the steel is cooled at a cooling speed $V_{cooling1}$ between 1°C/s to 150°C/s, until the coiling temperature $T_{coiling}$ lower or equal to 650°C. Below 1°C/s, a coarse microstructure is formed and the final mechanical properties balance deteriorates. Above 150°C/s, the cooling process is difficult to control.

The coiling temperature $T_{coiling}$ must be lower or equal to 650°C. If the coiling temperature is above 650°C, coarse ferrite and bainite structure is formed leading to a more heterogeneous microstructure after cold-rolling and annealing.

Optionally, the steel undergoes an intermediate annealing at this stage to reduce its hardness and facilitate the subsequent cold-rolling process and eventually to avoid cracks during cold rolling. The annealing temperature shall be between 450°C and 600°C between 1 and 24 hours in the case of batch annealing, or between 650°C and 750°C between 20 and 180s in the case of continuous annealing.

Next step consists in descaling and cold rolling the steel with a cold rolling ratio between 30% and 70% so as to obtain a cold rolled steel with thickness generally between 0.6 and 3 mm. Below 30%, the recrystallization during subsequent annealing is not favoured enough and the uniform elongation above 15% is not achieved due to a lack of recrystallization. Above 70%, there is a risk of edge cracking during cold-rolling.

Annealing can then be performed by heating the steel at a heating rate H_{rate} at least equal to 1°C/s up to the annealing temperature T_{anneal} . Such temperature T_{anneal} has minimum and maximal values defined by the following equations:

$$- T_{min} = 721 - 36 \cdot C - 20 \cdot Mn + 37 \cdot Al + 2 \cdot Si, \text{ in } ^{\circ}\text{C}$$

$$- T_{max} = 690 + 145 \cdot C - 6.7 \cdot Mn + 46 \cdot Al + 9 \cdot Si, \text{ in } ^{\circ}\text{C},$$

where the chemical composition elements are given in weight percent.

Controlling the annealing temperature is an important feature of the process since it enables to control the austenite fraction and its chemical composition as well as the recrystallization of the steel of the invention. Below T_{min} , the minimum austenite fraction is not formed, or its stability is too high, leading to a limited tensile strength below 1000 MPa. Above T_{max} , there is a risk to form too much martensite, leading to a limited uniform elongation below 15%.

After annealing, the steel sheet is cooled at a cooling rate between 5°C/s and 70°C/s .

Optionally, the steel sheet is cooled down to a temperature T_{OA} between 350°C and 550°C and kept at T_{OA} for a time between 10 and 300 seconds. It was shown that such a thermal treatment which facilitates the Zn coating by hot dip process for instance does not affect the final mechanical properties.

Optionally, the cold rolled and annealed steel sheet is tempered at a temperature T_{temper} between 170 and 400°C for a time t_{temper} between 200 and 800s. This treatment enables the tempering of martensite, which might be formed during cooling after the soaking from the unstable austenite. The martensite hardness is thus

decreased and steel ductility is improved. Below 170°C, the tempering treatment is not efficient enough. Above 400°C, the strength loss becomes high and the balance between strength and ductility is not improved anymore.

5 The cold rolled and annealed steel sheet is afterwards spot welded so as to obtain a welded joint with high resistance.

To obtain a spot weld according to the invention, welding parameters can be defined as follows. Effective intensity can be between 3kA and 15kA. As a non limitative example, spot weld intensity according to the invention are shown in figures 8 and 9. Force applied on the electrodes is between 150 and 850 daN. Electrode
10 active face diameter is between 4 and 10mm. A suitable spot weld is defined by its molten zone characteristic dimension. Its molten zone height is between 0.5 and 6mm and diameter between 3 and 12mm as in figure 18.

The spot welded joint according to the invention is characterized by a molten zone microstructure containing a surface fraction of coarse segregated areas lower
15 than 1%. The coarse segregated areas are defined as zones larger than 20 μ m² containing phosphorus in an amount superior to the base metal nominal phosphorus content. Above such value, the segregation is too high, which decreases the nugget toughness as in figures 19, 20 and 21.

In addition, the molten zone microstructure contains a density of iron carbides
20 larger than 50nm equal or above 2x10⁶ per mm². Below such density, martensite is not enough tempered and the nugget microstructure does not present enough toughness as in figures 5, 12, 13 and 14.

Preferably, in at least one side of the welded joint, the microstructure at the boundary between molten zone and the steel according to the invention does not
25 have any martensite 18R inside the ferritic grains so that the coarse grain zone keeps enough toughness as in figure 11 for the 3% Al content.

Optionnally, the spot welded joint according to the invention undergoes a thermal post treatment to further improve the spot weld resistance as illustrated in figures 22 A and B. Such post treatment can be done both on homogeneous or
30 heterogeneous welding. The oven post treatment consists in an austenitization

treatment over 1000°C for at least 3 minutes followed by a rapid cooling i.e above 50°C/s for the welded joint.

The *in situ* post treatment consists, after welding in a two step treatment:

- A first step without any applied current of at least 0.2 seconds
- A second step consisting in applying to the welded joint a current between 60% and 90% of the mean intensity applied during welding.

so as to temper the martensite and improve the toughness of the nugget and the Heat Affected Zone. The total time of the step 1 and step 2 is between 0.1 to 2 seconds.

The invention will be better understood with the following non limitative examples. Indeed, the spot welded steel of the invention can be obtained with any other steel as, for instance: Interstitial free steels, Dual phase steels, TRIP steels, BH steels, Press hardened steels, multiphase steels.

Semi-finished products have been produced from a steel casting. The chemical compositions of the semi-finished products, expressed in weight percent, are shown in Table 1 below. The rest of the steel composition in Table 1 consists of iron and inevitable impurities resulting from the smelting.

	C	Mn	Al	Si	P	S	Nb
A	0.209	4.91	0.024	0.013	0.02	0.001	
B	0.196	5.01	1.03	0.012	0.022	0.002	
C	0.192	5.03	1.87	0.014	0.021	0.002	
D	0.188	4.9	1.9	0.017	0.02	0.002	
E	0.189	5.01	2.85	0.02	0.02	0.0021	
F	0.175	4.77	3.72	0.024	0.02	0.0023	
G	0.109	5.28	0.02	0.52	0.018	0.0034	
H	0.109	5.17	1.81	0.507	0.017	0.0035	
I	0.123	5.05	1.71	0.521	0.008	0.004	0.032
J	0.089	1.82	0.01	0.145	0.015	0.003	

Table 1: Chemical composition (wt%).

Ti and V contents of steels A to J are lower than 0.010%. Boron content is lower than 35 ppm.

The steels A to I have first been reheated and hot-rolled down to 2.4 mm thick plates. Steel J is a typical Dual Phase steel with 600 MPa of tensile strength, such type of steel is known by the man skilled in the art, it is used as the steel to which steels A to I are welded to for heterogeneous welding cases. The hot rolled steel plates A to I were then cold rolled and annealed. The process parameters undergone are shown in Table 2 with the following abbreviations:

- T_{reheat} : is the reheating temperature
- T_{lp} : is the finishing rolling temperature
- V_{cooling1} : cooling rate after last hot rolling pass
- 10 – T_{coiling} : is the coiling temperature
- IA T: is the temperature of the intermediate annealing performed on the hot band
- IA t: is the duration of the intermediate annealing performed on the hot band
- Rate: is the rate of cold rolling reduction
- H_{rate} : is the heating rate
- 15 – T_{anneal} : is the soaking temperature during annealing.
- t_{anneal} : is the soaking duration during annealing.
- V_{cooling2} : is the cooling rate after annealing to room temperature.

	T _{reheat} (°C)	T _{lp} (°C)	V _{cooling1} (°C/s)	T _{coiling} (°C)	IA T (°C)	IA t (min)	Rate (%)	H _{rate} (°C/s)	T _{min}	T _{max}	T _{anneal} (°C)	t _{anneal} (s)	V _{cooling2} (°C/s)
A1	1250	950	8	650			70	10	616	689	<u>700</u>	60	10
B1	1250	940	8	600			50	10	652	732	710	120	8
C1	1250	940	8	600			50	10	683	770	720	120	8
D1	1250	900	8	650			50	10	687	772	710	150	5
D2	1250	900	8	650			50	10	687	772	720	150	5
D3	1250	900	8	650			50	10	687	772	730	150	5
D4	1250	900	8	20			50	10	687	772	710	150	5
D5	1250	900	8	20			50	10	687	772	720	150	5
D6	1250	900	8	20			50	10	687	772	730	150	5
D7	1250	900	8	550			50	10	687	772	710	150	5
D8	1250	900	8	550			50	10	687	772	720	150	5
D9	1250	900	8	550			50	10	687	772	730	150	5
D10	1250	900	8	550	700	2	50	10	687	772	710	150	5
D11	1250	900	8	550	700	2	50	10	687	772	720	150	5
D12	1250	900	8	550	700	2	50	10	687	772	730	150	5
D13	1250	900	8	550	700	2	50	10	687	772	740	150	5
D14	1250	900	8	550	500	300	50	10	687	772	710	150	5
D15	1250	900	8	550	500	300	50	10	687	772	720	150	5
D16	1250	900	8	550	600	300	50	10	687	772	720	150	5
D17	1250	900	8	550	600	300	50	10	687	772	730	150	5
D18	1250	900	8	550			70	10	687	772	710	150	5
D19	1250	900	8	550			70	10	687	772	720	150	5
D20	1250	900	8	550			70	10	687	772	730	150	5
E1	1250	940	8	600			50	10	719	815	770	120	8
F1	1250	900	65	450			50	10	757	855	810	120	8
G1	1250	900	8	600	600	300	50	10	613	676	<u>690</u>	150	8
H1	1250	900	8	600	600	300	50	10	682	759	740	150	8
H2	1250	900	8	600	600	300	50	10	682	759	<u>770</u>	150	8
H3	1250	900	8	600	700	2	50	10	682	759	740	150	8
I1	1250	900	8	600	600	300	50	20*	680	757	730	150	8
I2	1250	900	8	600	600	300	50	20*	680	757	740	150	8
I3	1250	900	8	600	600	300	50	20*	680	757	750	150	8

Table 2: Hot-rolling and cold-rolling and annealing conditions.

In table 2, "blank" means that no intermediate annealing was performed and "*" means that the heating rate was 20°C/s up to 600°C and then 1°C/s up to the annealing temperature.

The table 3 presents the following characteristics:

- Ferrite: "OK" refers to the presence of ferrite with a volume fraction between 40 and 80% in the microstructure of the annealed sheet. "KO" refers to comparative examples where ferrite fraction is outside this range.
- 5 • Austenite: "OK" refers to the presence of austenite with a volume fraction between 20 and 50% in the microstructure of the annealed sheet. "KO" refers to comparative examples where austenite fraction is outside this range.
- Martensite: "OK" refers to the presence or not of martensite with a volume fraction less than 25% in the microstructure of the annealed sheet. "KO" refers to comparative
10 examples where martensite fraction is above 25%.
- UTS (MPa) refers to the ultimate tensile strength measured by tensile test in the longitudinal direction relative to the rolling direction.
- YS (MPa) refers to the yield strength measured by tensile test in the longitudinal direction relative to the rolling direction.
- 15 • UEI (%) refers to the uniform elongation measured by tensile test in the longitudinal direction relative to the rolling direction.
- YS/TS refers to the ratio between Yield strength and ultimate tensile strength.
- TEI refers to the total elongation measured on ISO 12.5x50 specimen.

	Ferrite	Austenite	martensite	YS(MPa)	TS (MPa)	UEI (%)	YS/TS	EI	TS*EI
A1	OK (48%)	OK (26%)	KO (26%)	499	1250	14	0,4	15,4	19250
B1	OK (55%)	OK (45%)	OK (5%)	860	1075	23	0,8	25,9	27896
C1	OK (60%)	OK (40%)	OK (0%)	812	1023	24	0,79	27,0	27621
D1	OK	OK	OK	872	1082	26	0,81	30,7	33253
D2	OK	OK	OK	824	1171	21	0,7	24,2	28338
D3	OK	OK	OK	758	1239	17	0,61	20,5	25338
D4	OK	OK	OK	865	1018	27	0,85	33,3	33865
D5	OK	OK	OK	837	1150	21	0,73	24,9	28673
D6	OK	OK	OK	792	1228	18	0,64	21,2	26075
D7	OK	OK	OK	882	1101	28	0,8	33,0	36333
D8	OK	OK	OK	817	1187	19	0,69	22,4	26589
D9	OK	OK	OK	769	1252	17	0,61	20,0	24998
D10	OK	OK	OK	883	1033	27	0,85	33,6	34743
D11	OK	OK	OK	872	1085	29	0,8	34,8	37722
D12	OK	OK	OK	806	1154	24	0,7	29,8	34351
D13	OK	OK	OK	774	1217	21	0,64	24,6	29979
D14	OK	OK	OK	810	1056	27	0,77	31,8	33546
D15	OK	OK	OK	683	1224	16	0,56	18,6	22766
D16	OK	OK	OK	787	988	26	0,8	30,1	29706
D17	OK	OK	OK	755	1078	22	0,7	26,1	28100
D18	OK	OK	OK	718	1146	18	0,63	21,6	24792
D19	OK	OK	OK	904	1098	28	0,82	30,9	33965
D20	OK	OK	OK	880	1154	24	0,76	27,8	32081
D21	OK	OK	OK	796	1252	17	0,64	18,7	23412
E1	OK (61%)	OK (37%)	OK (2%)	698	1007	23	0,69	26,7	26887
F1	OK (35%)	OK (65%)	OK (0%)	560	840	26	0,67	29,4	24696
G1	OK (52%)	KO (17%)	KO (31%)	701	1060	13	0,66	14,4	15264
H1	OK (68%)	OK (27%)	OK (5%)	624,5	1002	17	0,62	19,7	19689
H2	OK (57%)	KO (15%)	KO (28%)	516	1138	9	0,45	10,3	11665
H3	OK	OK	OK	690,5	1006,5	18	0,69	21,1	21237
I1	OK	OK	OK	875	1026,5	18	0,85	20,6	21146
I2	OK	OK	OK	845,5	1063	17	0,80	20,0	21207
I3	OK	OK	OK	804,5	1082	16	0,74	18,6	20071

Table 3: Properties of cold-rolled and annealed sheets

The steels A to I are then spot welded to a DP 600 GI as an example following the welding parameters presented in table 4: Sheet thickness for A to I material and DP600 GI is 1.2mm. The welding parameters are the same between grades and differ only between homogeneous and heterogeneous welding.

	Current frequency (Hz)	Squeezing time (period)	Welding time (period)	Holding time (period)	Electrod active face diameter (mm)	Electrode Force (daN)
Homogeneous	50	70	14	14	6	400
Heterogeneous	50	70	15	15	6	400

Table 4: steel welding parameters.

The different values are explained here below:

- Welding current range: The welding current (also called welding intensity) range is expressed in kA. The minimum of the weld range is defined by the welding current necessary to develop a nugget that diameter is $4.25\sqrt{t}$ or more, where t is the thickness of the material in mm. The maximum of the welding current range is defined by the current at which expulsion of the molten metal from the nugget occurs.
- Alpha value is the maximum load in cross test divided by the weld diameter and the thickness. It is a normalised load for resistant spot welding expressed in daN/mm².
- Plug ratio: The plug ratio is equal to the plug diameter divided by the MZ diameter. The lower the plug ratio, the lower the molten zone toughness as shown in figure 18.

Assembly	Average nugget hardness (Hv)	Nugget microstructure	Presence of ferrite at MZ/CGHAZ boundary	number density of carbides larger than 50nm in the nugget (mm ⁻²)	Surface fraction of coarse segregated area (%)	Welding range (kA)	Alpha CTS (daN/mm ²)	TSS average strength (daN)
A1+A1	535	Martensite	No	0.72×10^6	<u>1.32</u>	2	21	790
B1+B1	505	Martensite	No	3.12×10^6	0.26	2.5	28	1644
D1+D1	480	Martensite	No	8.66×10^6	0.083	2.5	38	1590
E1+E1	422	Bainite+delta ferrite	YES	9.55×10^6	0.041	1.8	52	1800
F1+F1	308	Martensite+delt a ferrite	YES	Not measured	Not measured	2	29	1213
A1+J1	487	Martensite	No	Not measured	Not measured	2.8	26	813
B1+J1	443	Martensite	No	Not measured	Not measured	2.3	37	951
D1+J1	456	Martensite	No	Not measured	Not measured	2	39	1004
E1+J1	464	Martensite	YES	Not measured	Not measured	1.9	53	1070
F1+J1	405	Martensite	YES	Not measured	Not measured	2	30	697
G1+G1	502	Martensite	NO	Not measured	<u>2.83</u>	2.4	31	1439
H1+H1	451	Martensite	NO	6.17×10^6	0.22	1.6	77	1599
I1+I1	Not measured	Martensite	NO	Not measured	Not measured	Not measured	85	Not measured
G1+J1	Not measured	Martensite	NO	Not measured	Not measured	3	52	1522
H1+J1	Not measured	Martensite	NO	Not measured	Not measured	1.6	90	1407

Table 5: spot welded results. CGHAZ means coarse grain heat affected zone.

All cold rolled and annealed steels produced with chemical compositions from B, C, D, E, H (excepted H2) and I are produced according to the invention, they present YS above 600 MPa, tensile strength above 1000 MPa and uniform elongation 15% as illustrated in figure 4 A for B1, C1, E1 and F1(reference) and figure 4B for G1, H1, H2, H3, and I2 where G1 and H2 are references. The chemical composition is within the targeted range as well as the microstructure; the process parameters of the invention have also been followed. A1, F1, G1, and H2 are not according to the invention. Resistance testing of spot welds has been done according to test as

depicted in figure 17. They are called tensile shear tests and cross tension tests. These tests are used to determine the weld strength. As shown in figures 6, 7 and 10, the spot weld resistance increases with Al content within the Al range of the invention.

Furthermore an examination of macro-etch specimens can reveal the nugget
5 diameters (figure 11) as well as penetration and weld microstructures in the different zones.

When it comes to the thermal post treatments, as can be seen from figure 22, Cross Tensile Strength coefficient is further improved with this said treatment for spot welded joints with at least one Al containing steel. This is due to the synergistic
10 effect of Al which opens a tempering window below A_{c1} allowing not to re-austenitize upon welding the critical parts of the welded joint.

The steel sheets assembly according to the invention will be beneficially used for the manufacture of structural or safety parts in the automobile industry.

CLAIMS

1. Spot welded joint of at least two steel sheets, wherein at least one sheet is made of an aluminium alloyed steel comprising, by weight percent:

$0.05 \leq C \leq 0.21\%$

5 $4.0 \leq Mn \leq 7.0\%$

$0.5 \leq Al \leq 3.5\%$

$Si \leq 2.0\%$

$Ti \leq 0.2\%$

$V \leq 0.2\%$

10 $Nb \leq 0.2\%$

$P \leq 0.025\%$

$B \leq 0.0035\%$

$S \leq 0.004\%$

the balance of the composition being iron and unavoidable impurities resulting from the smelting, said aluminium alloyed steel sheet presenting a yield strength above or equal to 600 MPa, an ultimate tensile strength above or equal to 1000 MPa and uniform elongation above or equal to 15%, the microstructure of said aluminium alloyed steel sheet containing 20% to 50% of austenite, 40% to 80% of annealed ferrite, less than 25% of martensite and wherein the spot welded joint presents a molten zone microstructure containing more than 0.5 % of Al and containing a surface fraction of segregated areas lower than 1%, said segregated areas being zones larger than $20\mu m^2$ containing an amount of phosphorous superior to said aluminium alloyed steel nominal phosphorus content.

25 2. Spot welded joint according to claim 1 wherein said aluminium alloyed steel chemical composition has aluminum content such that: $1.0 \leq Al \leq 3.0\%$.

3. Spot welded joint according to claim 2 wherein said aluminium alloyed steel chemical composition has aluminum content such that: $1.0 \leq Al \leq 2.5\%$.

4. Spot welded joint according to anyone of claims 1 to 3, wherein said aluminium alloyed steel chemical composition has a silicon content such that, $Si \leq 1.5 \%$.
5. Spot welded joint according to claim 4, wherein said aluminium alloyed steel chemical composition has a silicon content such that, $Si \leq 1.0 \%$.
6. Spot welded joint according to anyone of claims 1 to 5, wherein said aluminium alloyed steel microstructure contains between 50% and 70% of annealed ferrite.
- 10 7. Spot welded joint according to anyone of claims 1 to 6, wherein said aluminium alloyed steel microstructure contains less than 20% of martensite.
8. Spot welded joint according to anyone of claims 1 to 7, wherein said joint contains iron carbides larger than 50nm which density is equal or above 2×10^6 per mm^2 and the microstructure at the boundary between molten zone and said aluminium alloyed steel does not have martensite 18R with orthorhombic needle-like phase inside the ferritic grains.
- 15
9. Assembly of two steel sheets including a spot welded joint according to anyone of claims 1 to 8.
- 20
10. Method to produce a spot welded joint of at least two steel sheets, wherein at least one sheet is made of an aluminium alloyed steel sheet according to anyone of claims 1 to 8, comprising the successive following steps :
- 25
- casting an aluminium alloyed steel which composition is according to anyone of claims 1 to 5 so as to obtain a slab,
 - reheating the slab at a temperature T_{reheat} between $1150^\circ C$ and $1300^\circ C$,
 - hot rolling the reheated slab with a temperature between $800^\circ C$ and $1250^\circ C$ to obtain a hot rolled steel, the last hot rolling pass taking place at a temperature T_{lp}
- 30 above or equal to $800^\circ C$,

25

25

- cooling the hot rolled steel between 1 and 150°C/s until a coiling temperature T_{coiling} lower or equal to 650°C, then

- coiling the hot rolled steel cooled at T_{coiling} .

- de-scaling,

5 - cold rolling with a cold rolling ratio between 30% and 70% so as to obtain a cold rolled steel sheet,

- heating at a heating rate H_{rate} at least equal to 1°C/s up to the annealing temperature T_{anneal}

- annealing at a temperature T_{anneal} between T_{min} and T_{max} defined by

10 $T_{\text{min}} = 721 - 36 \cdot C - 20 \cdot \text{Mn} + 37 \cdot \text{Al} + 2 \cdot \text{Si}$ (in °C)

$T_{\text{max}} = 690 + 145 \cdot C - 6.7 \cdot \text{Mn} + 46 \cdot \text{Al} + 9 \cdot \text{Si}$ (in °C)

during a time between 30 and 700 seconds.

- cooling down to the targeted temperature at a cooling rate which is between 5°C/s and 70°C/s,

15 -cutting the cold rolled steel into sheets to obtain cold rolled steel sheets

- welding at least one of said cold rolled steel sheets to another metal with an effective intensity between 3kA and 15kA and a force applied on the electrodes between 150 and 850 daN, said electrode active face diameter being between 4 and 10mm.

20

11. Method to produce a spot welded joint according to claim 10 wherein the hot rolled steel sheet is batch annealed between 400°C and 600°C between 1 and 24 hours.

25 12. Method to produce a spot welded joint according to claim 10 wherein the hot rolled steel sheet is continuously annealed between 650°C and 750°C between 20 and 180s.

13. Method to produce a spot welded joint according to any of claims 10 to 11 wherein the cast of the steel is done using a thin slab casting machine to obtain said hot rolled steel sheet.

5

14. Method to produce a spot welded joint according to claim 10 wherein said targeted temperature is a temperature T_{OA} between 350°C and 550°C and kept at T_{OA} for a time between 10 and 300 seconds.

10 15. Method to produce a spot welded joint according to claim 14 wherein the steel sheet is further cooled down to room temperature at a cooling rate $V_{cooling3}$ above 5°C/s and below 70°C/s to obtain a cold rolled and annealed steel sheet.

15 16. Method to produce a spot welded joint according to any of claims 10 to 14 wherein the steel sheet is tempered at a temperature T_{temper} between 170 and 400°C for a time t_{temper} between 200 and 800s.

20 17. Method to produce a spot welded joint according to any of claims 10 to 15 wherein, after annealing, the cold rolled steel sheet is further coated with Zn or a Zn alloy.

18. Method to produce a spot welded joint according to any of claims 10 to 15 wherein, after annealing, the cold rolled steel sheet is further coated with Al or an Al alloy.

25

19. Method to produce a spot welded joint according to any of claims 10 to 17 wherein a post thermal treatment is applied with an intensity between 60% and 90% of welding intensity for a time between 0.1 and 2 seconds.

20. Structural part containing a spot welded joint or an assembly of two steel sheets according to anyone of claims 1 to 9 or a spot welded joint produced according to anyone of claims 10 to 19.

- 5 21. Vehicle containing a spot welded joint, structural part or assembly according to anyone of claims 1 to 9 or produced with a spot welded joint according to anyone of claims 10 to 20.

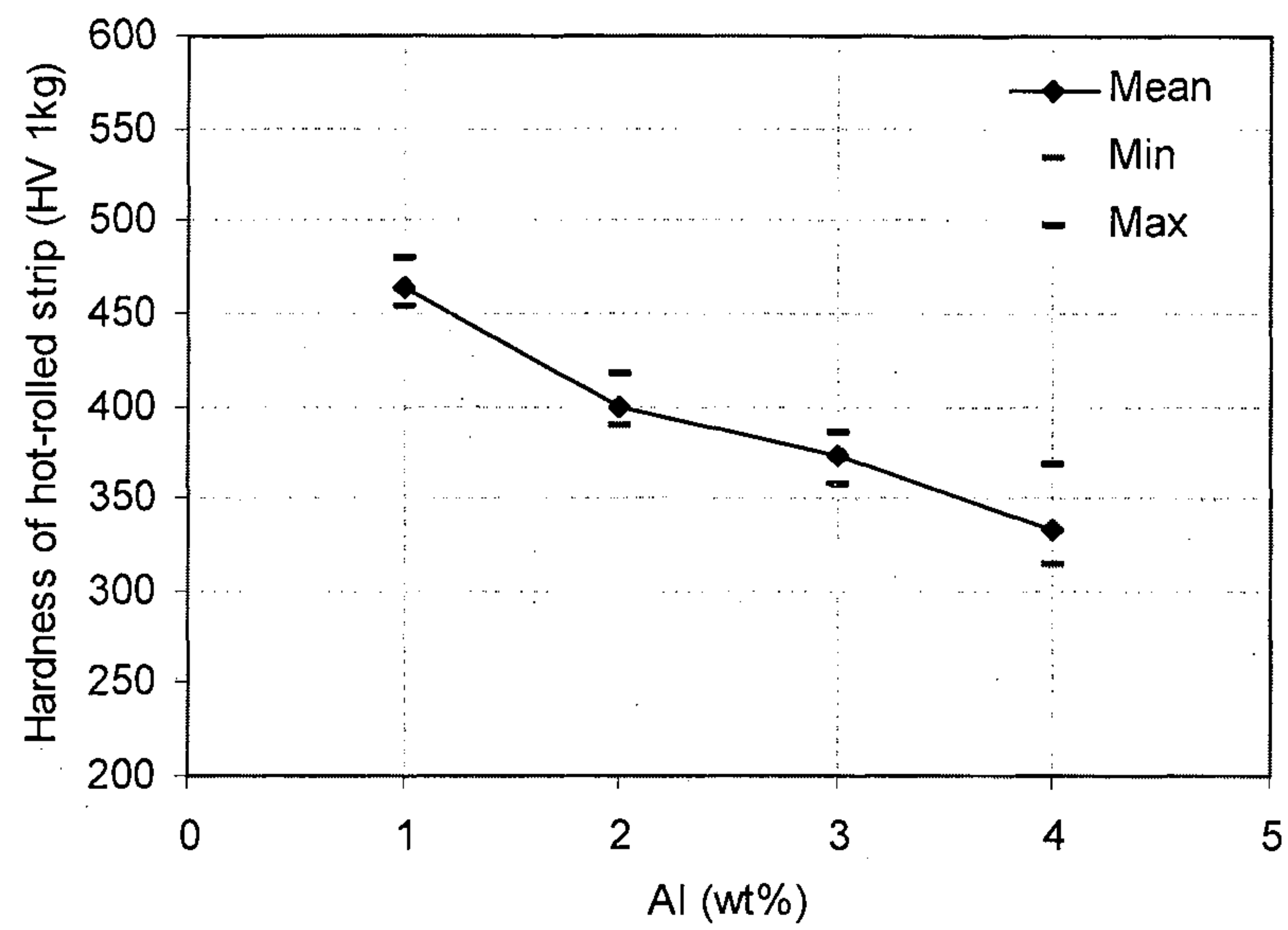
Figures

FIG 1

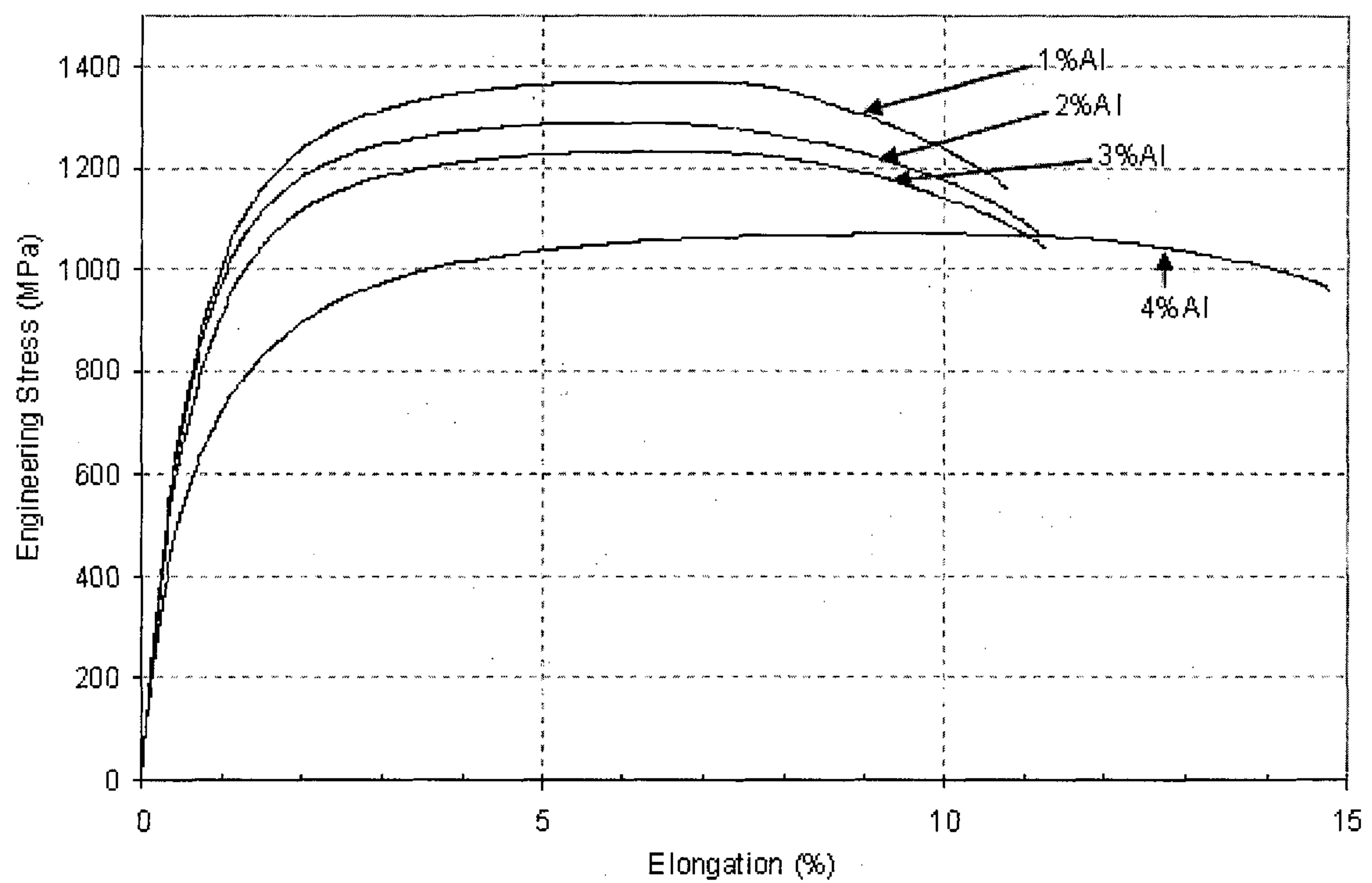


FIG 2

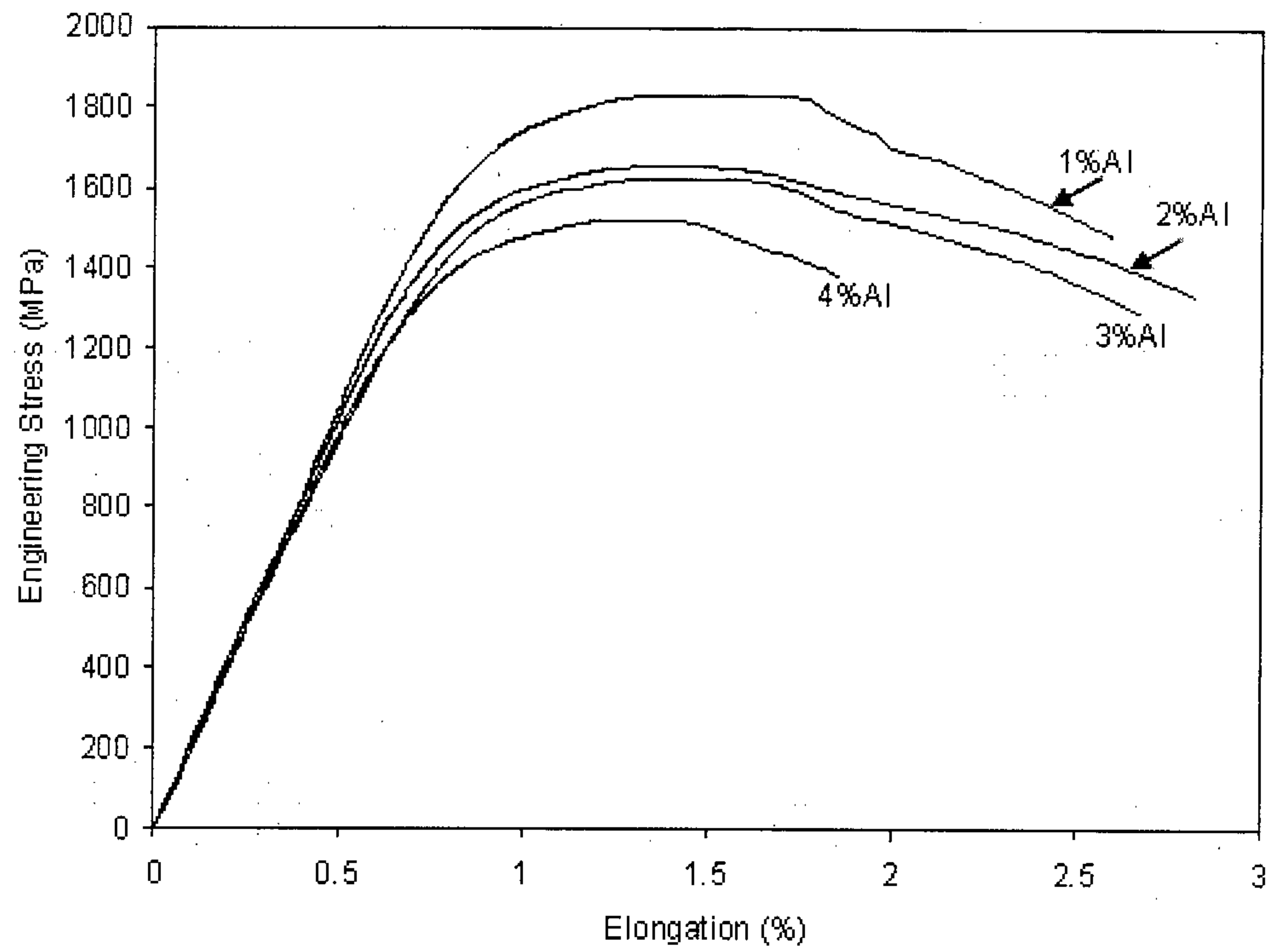


FIG 3

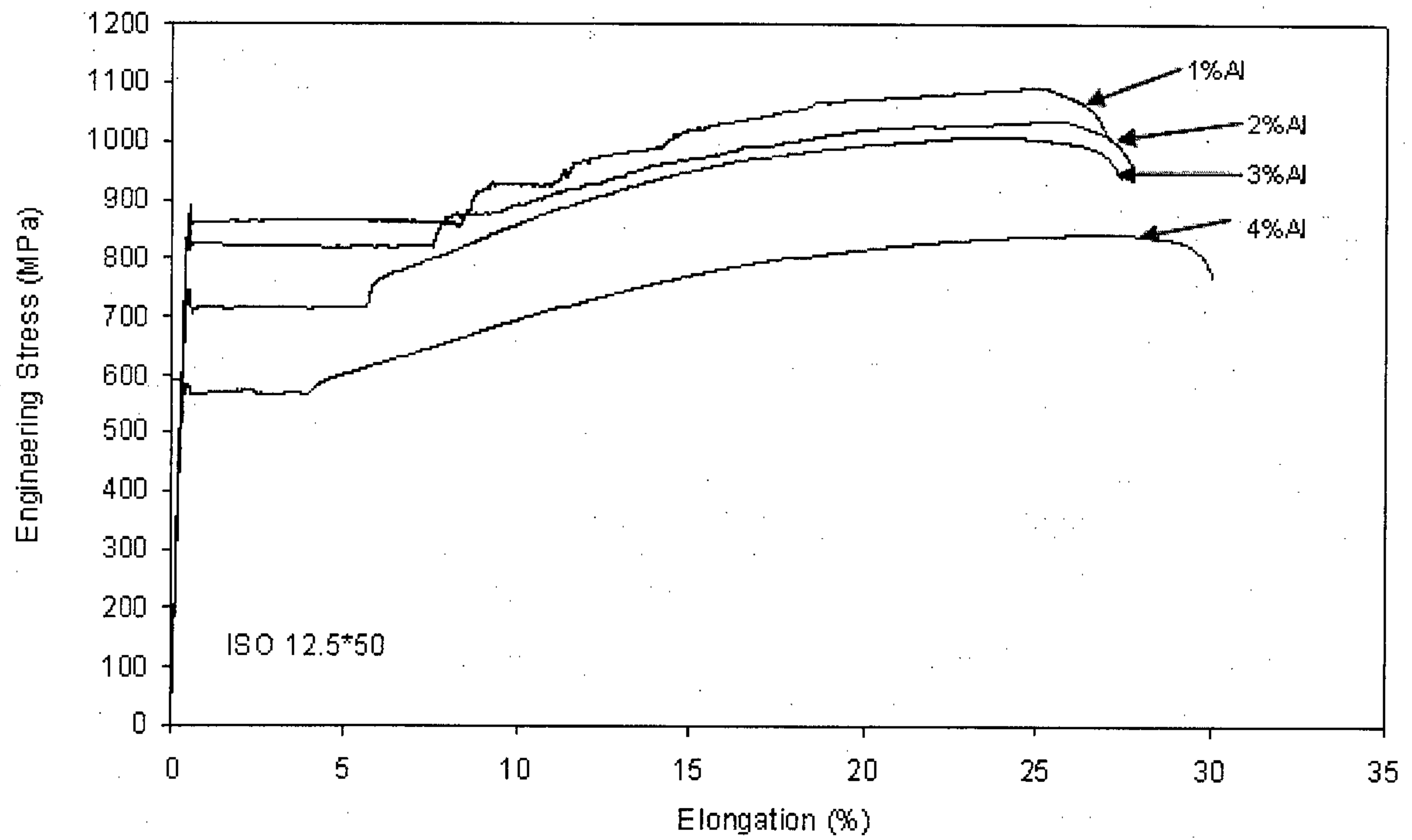


FIG 4 A

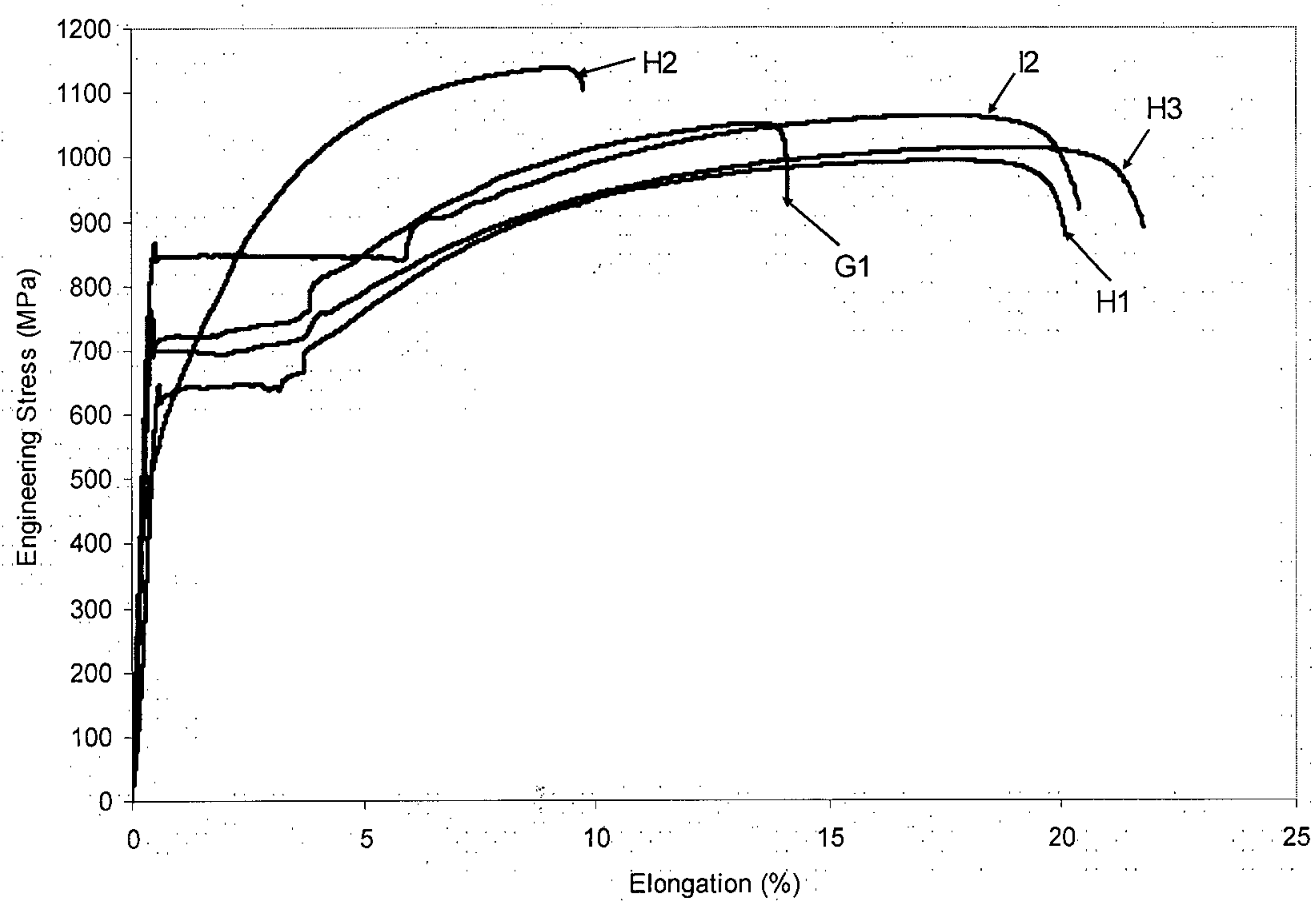


FIG 4 B

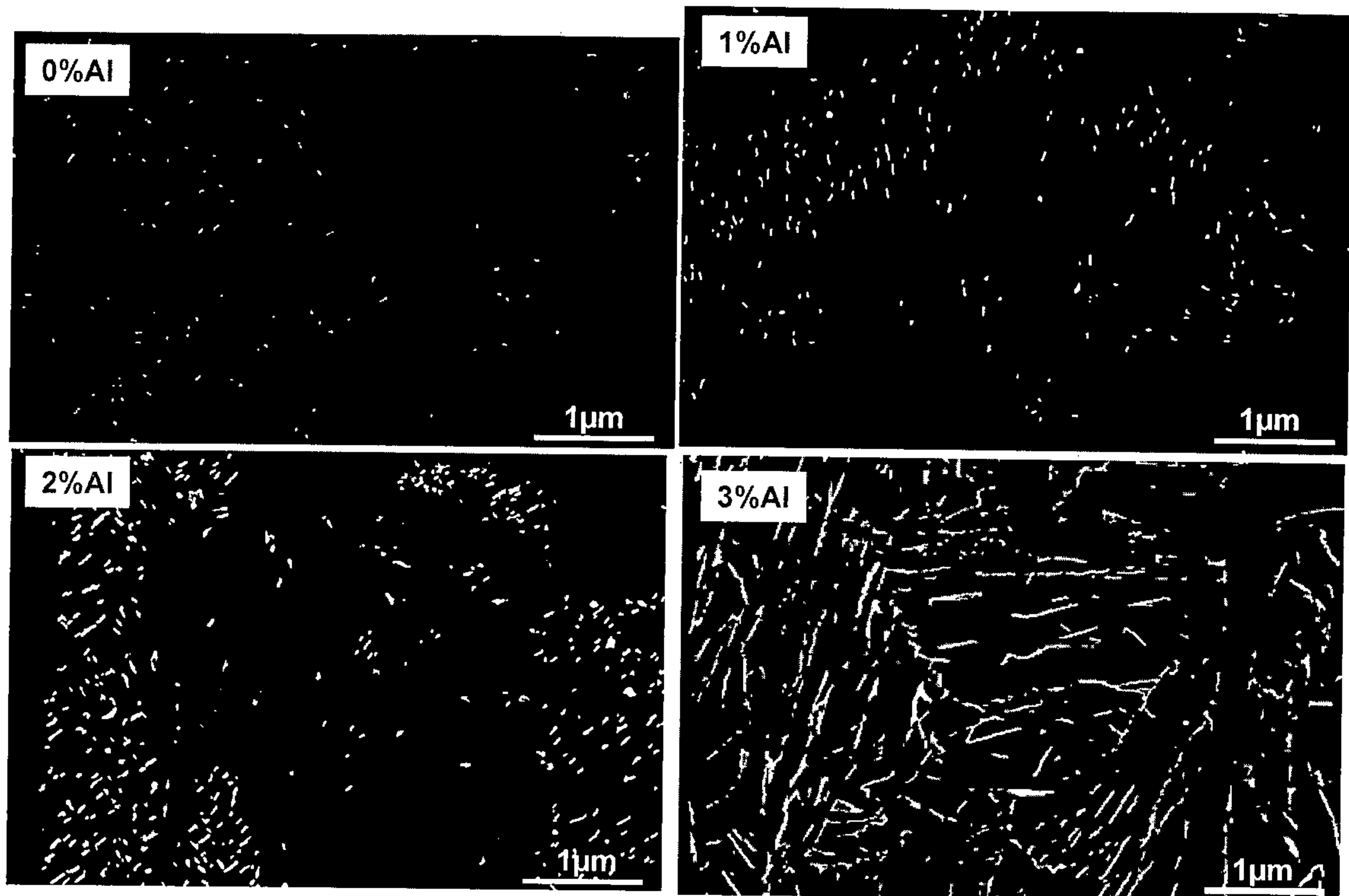


FIG 5

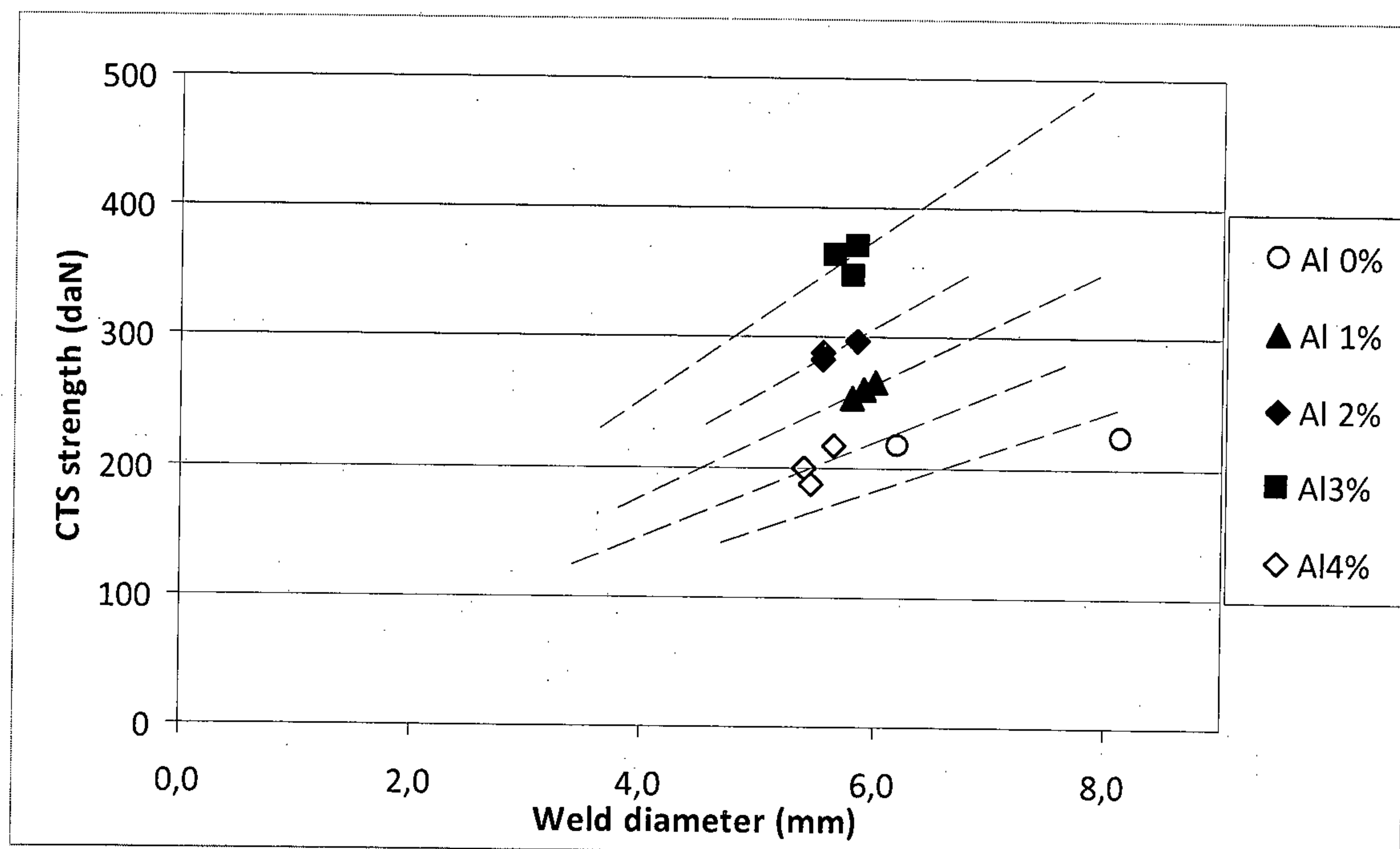


FIG 6

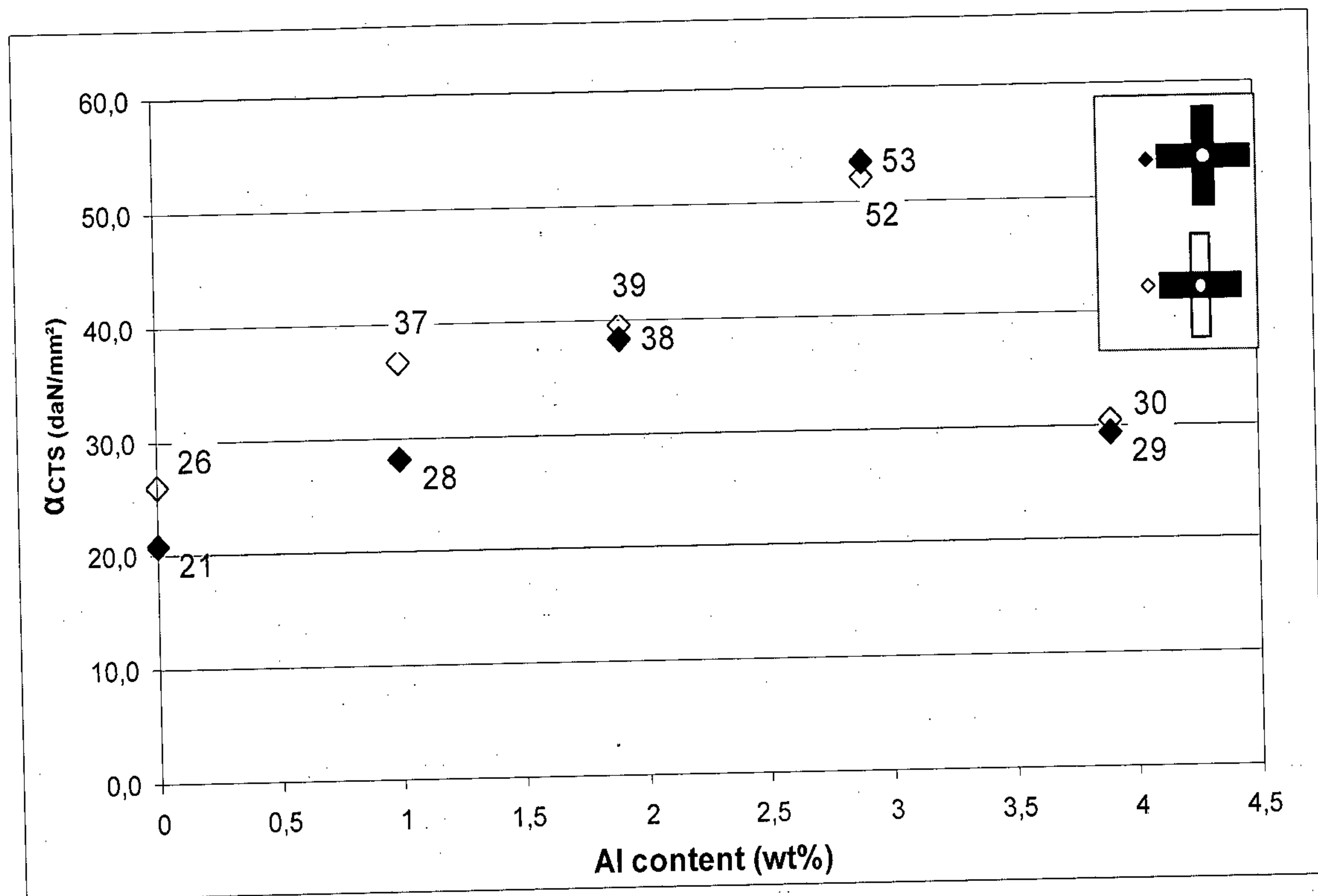


FIG 7

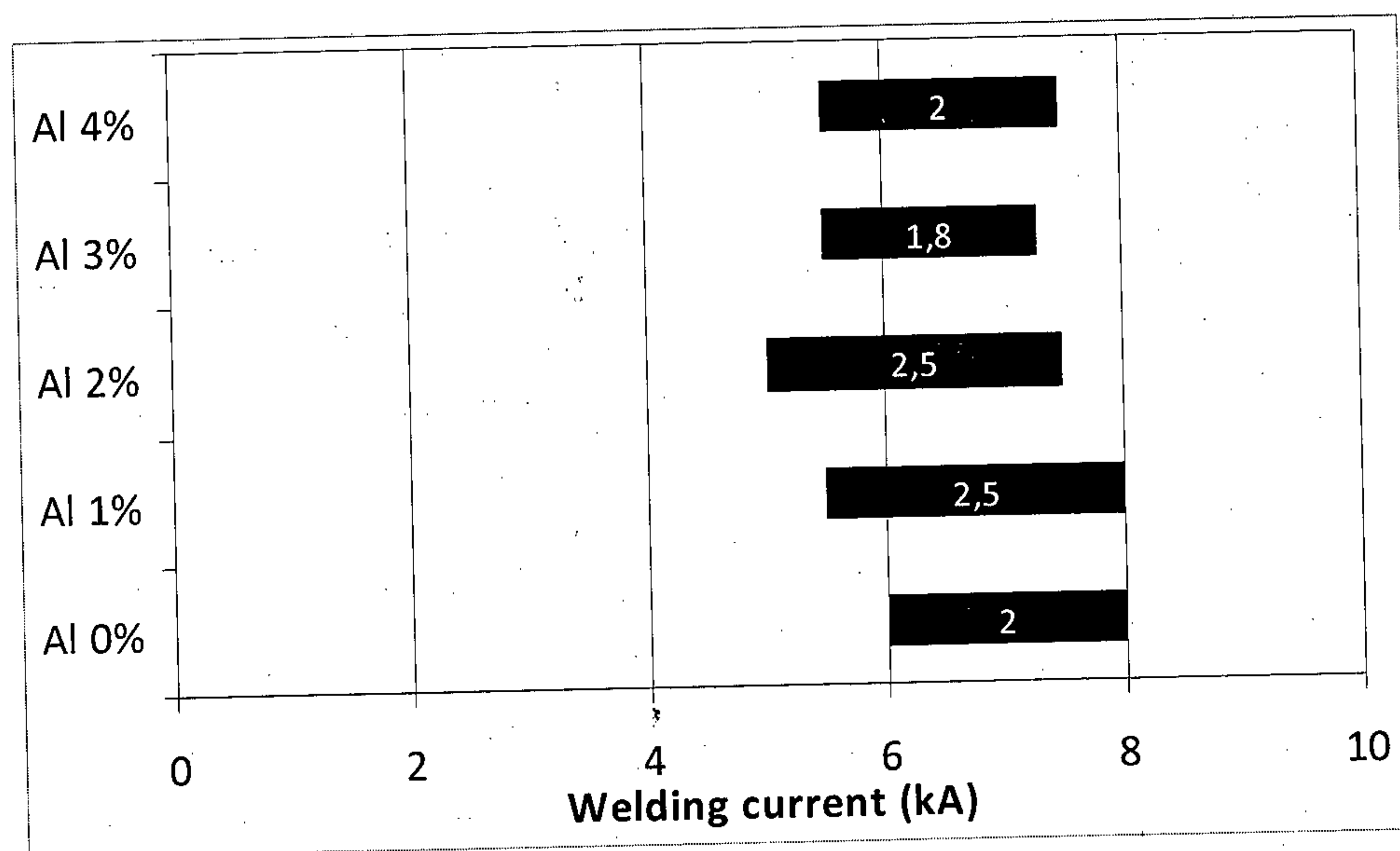


FIG 8

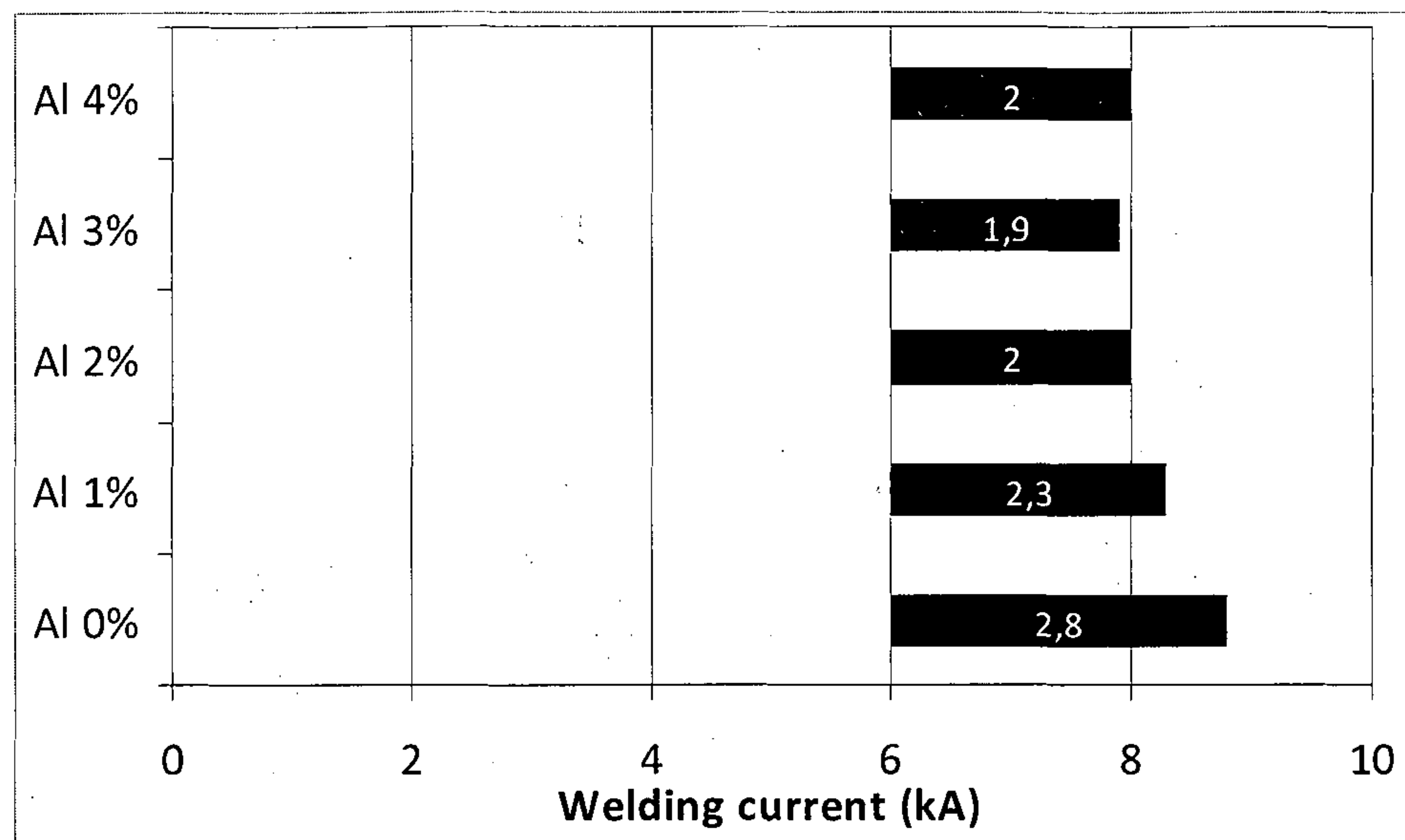


FIG 9

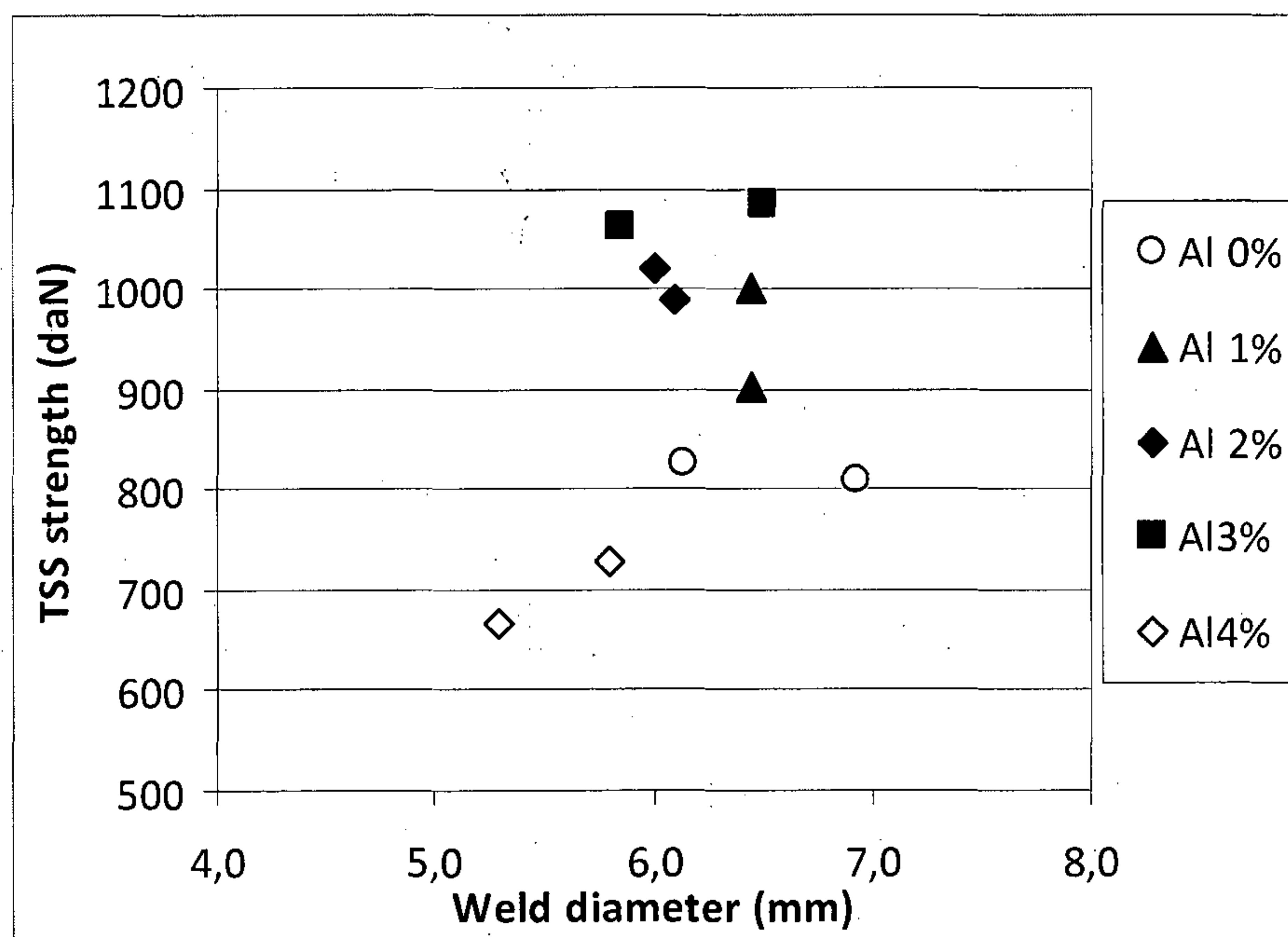


FIG 10

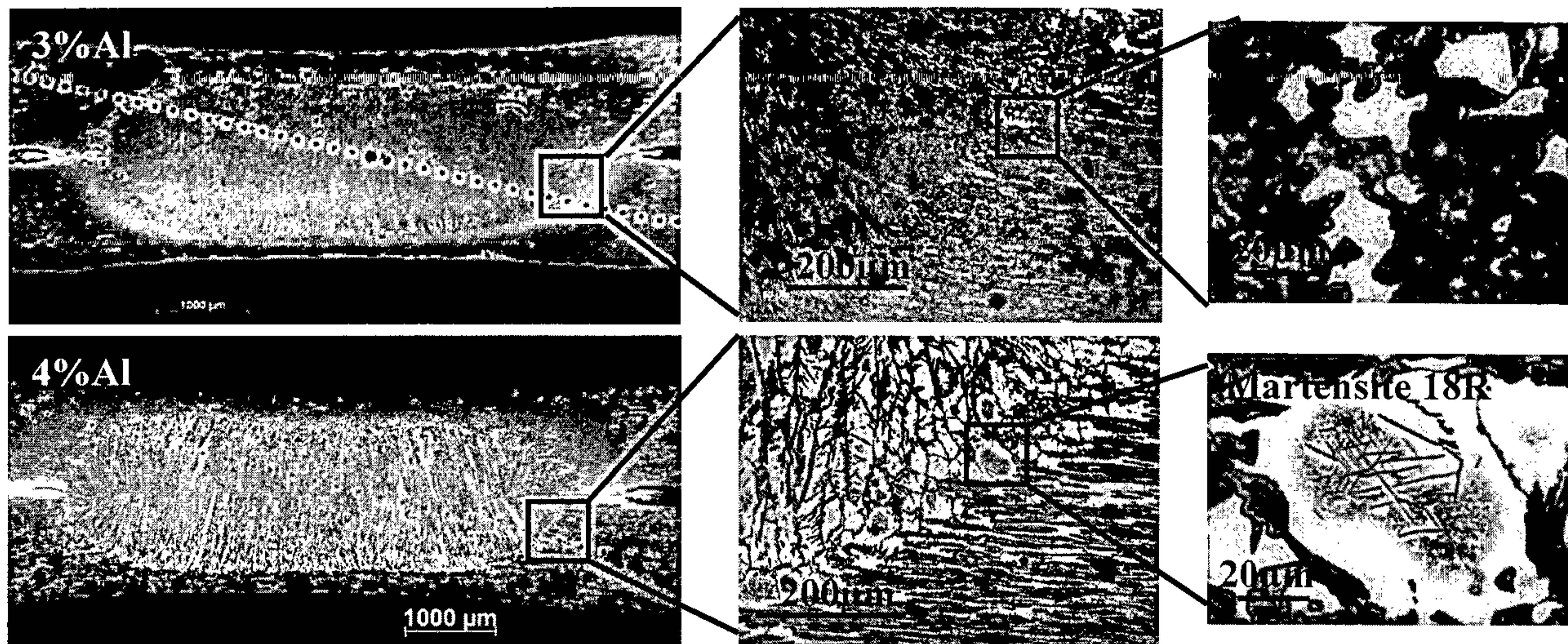


FIG 11

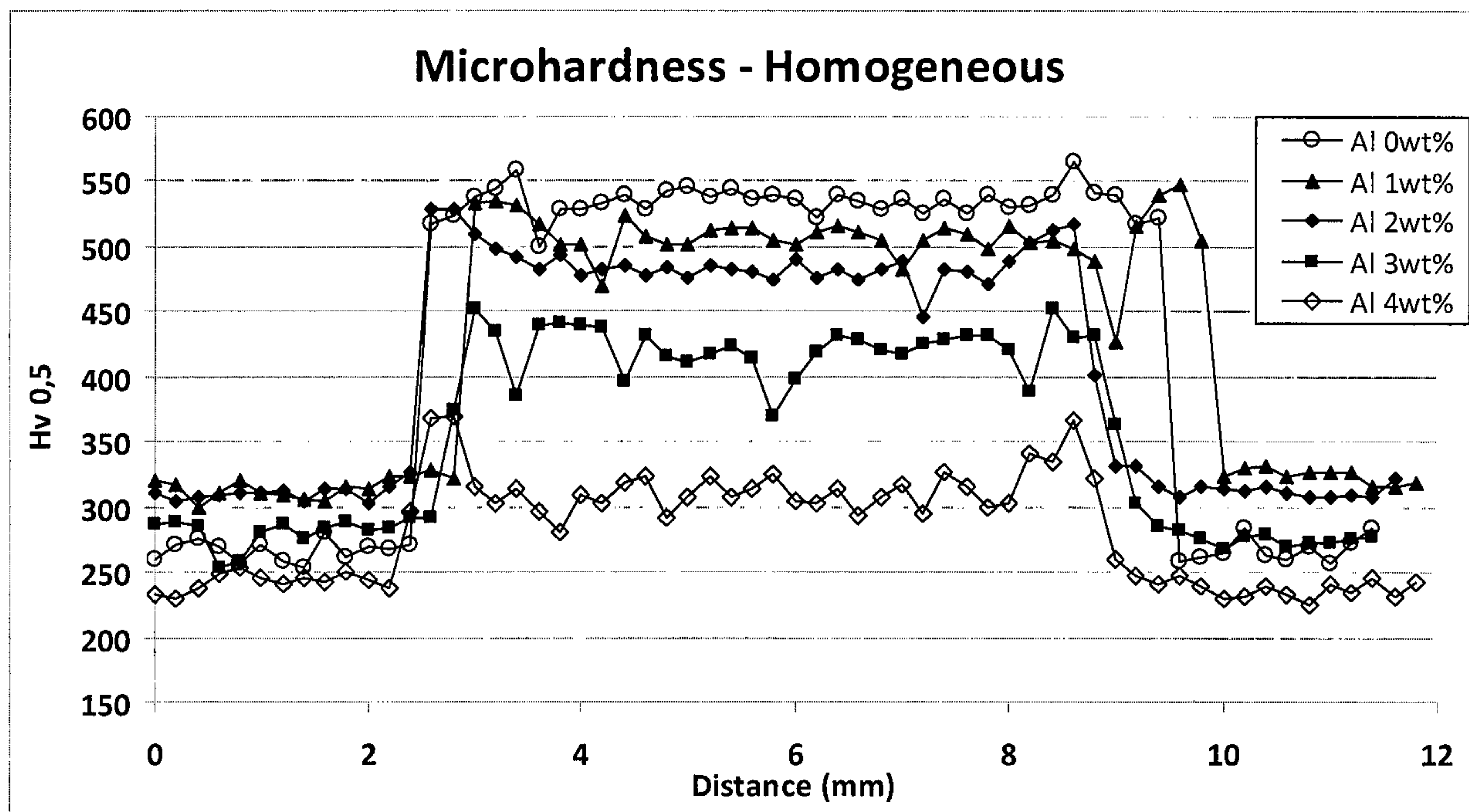


FIG 12

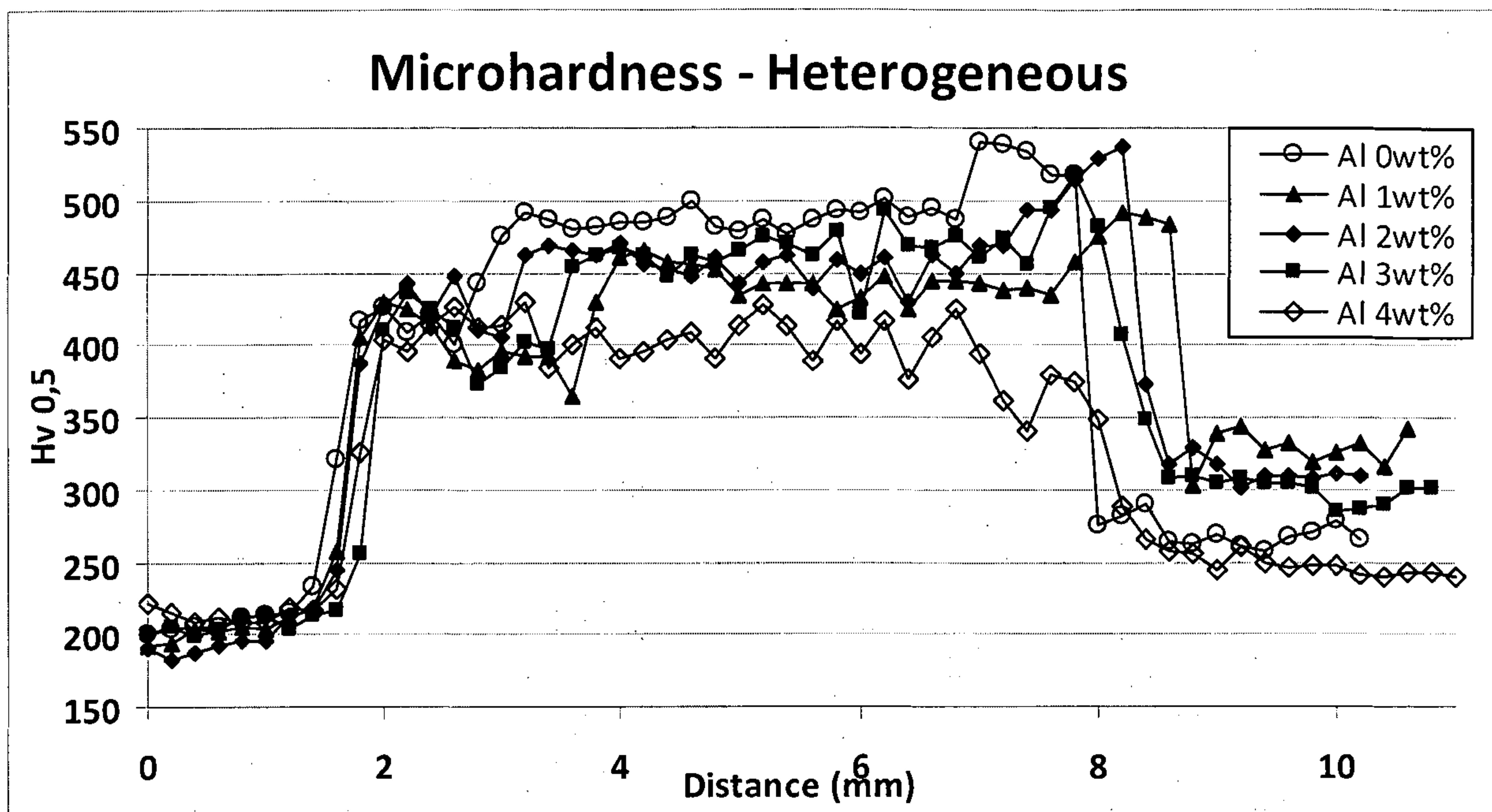


FIG 13

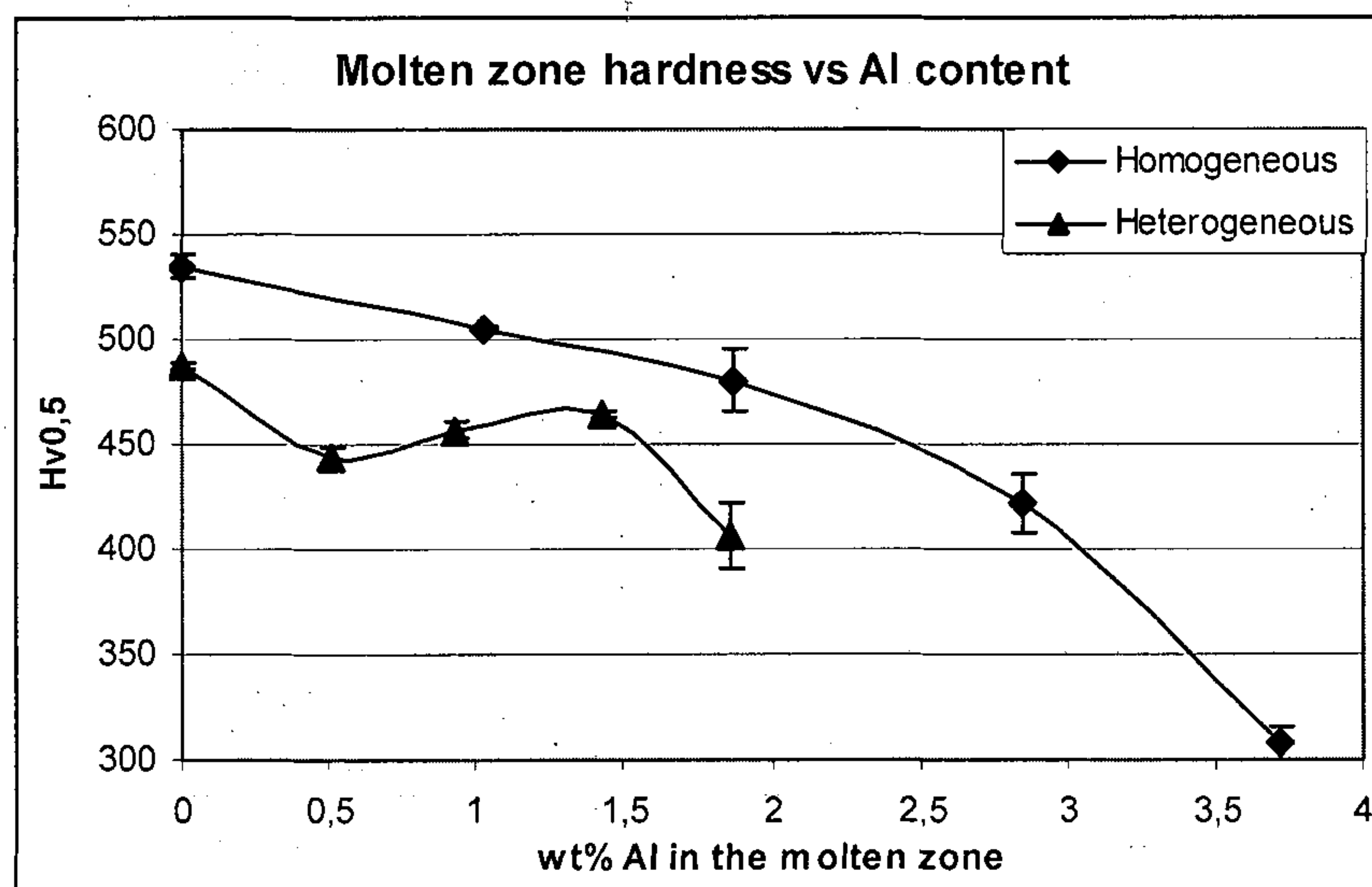


FIG 14

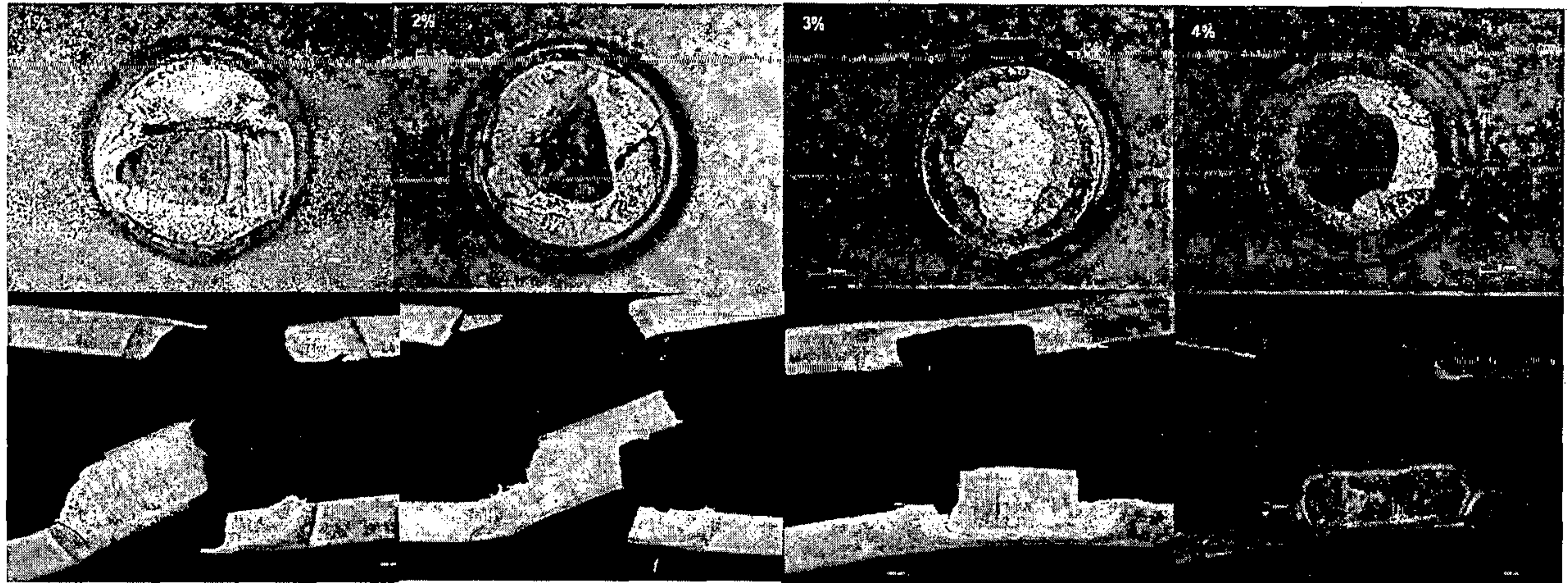


FIG 15

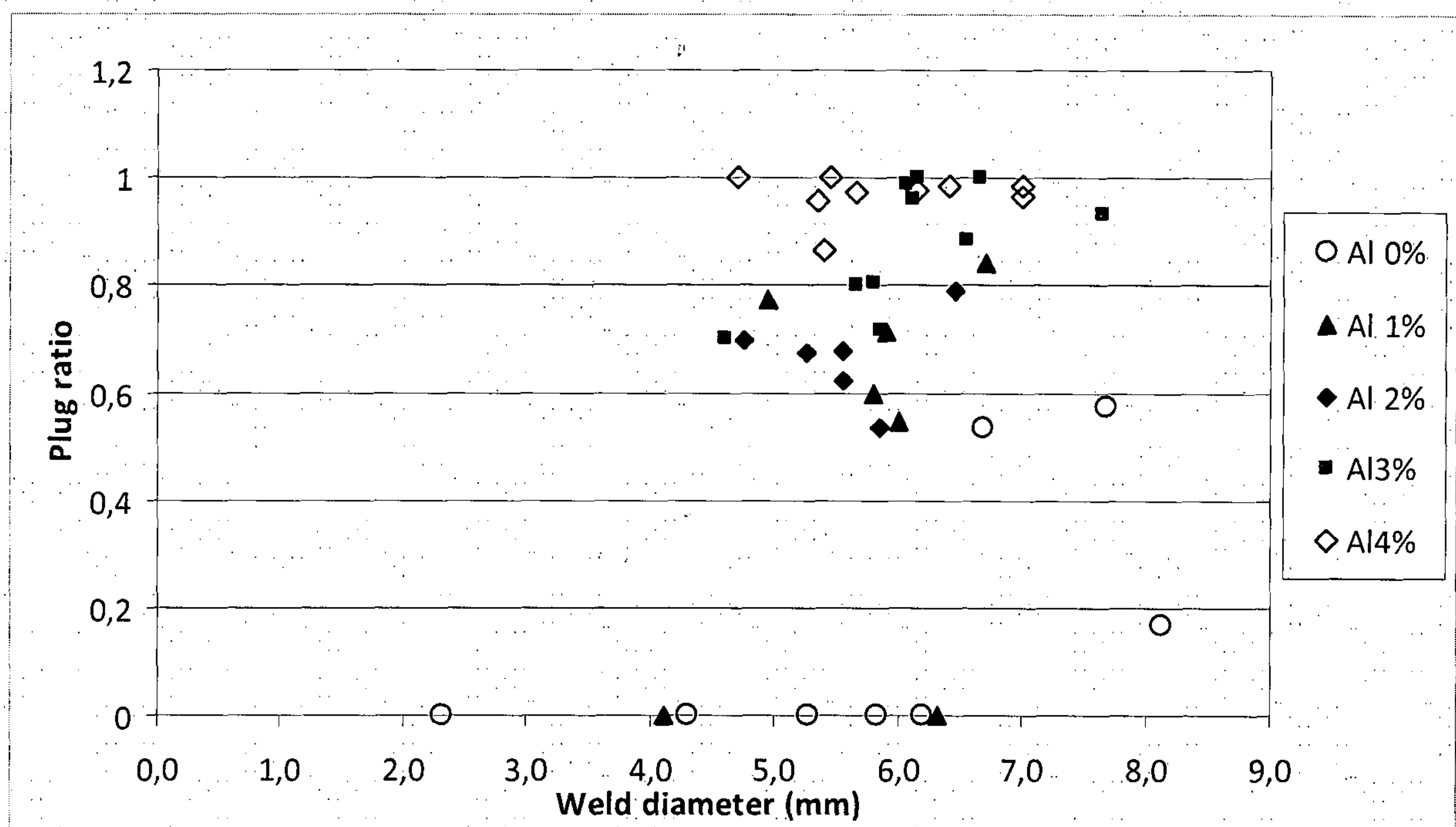


FIG 16 A

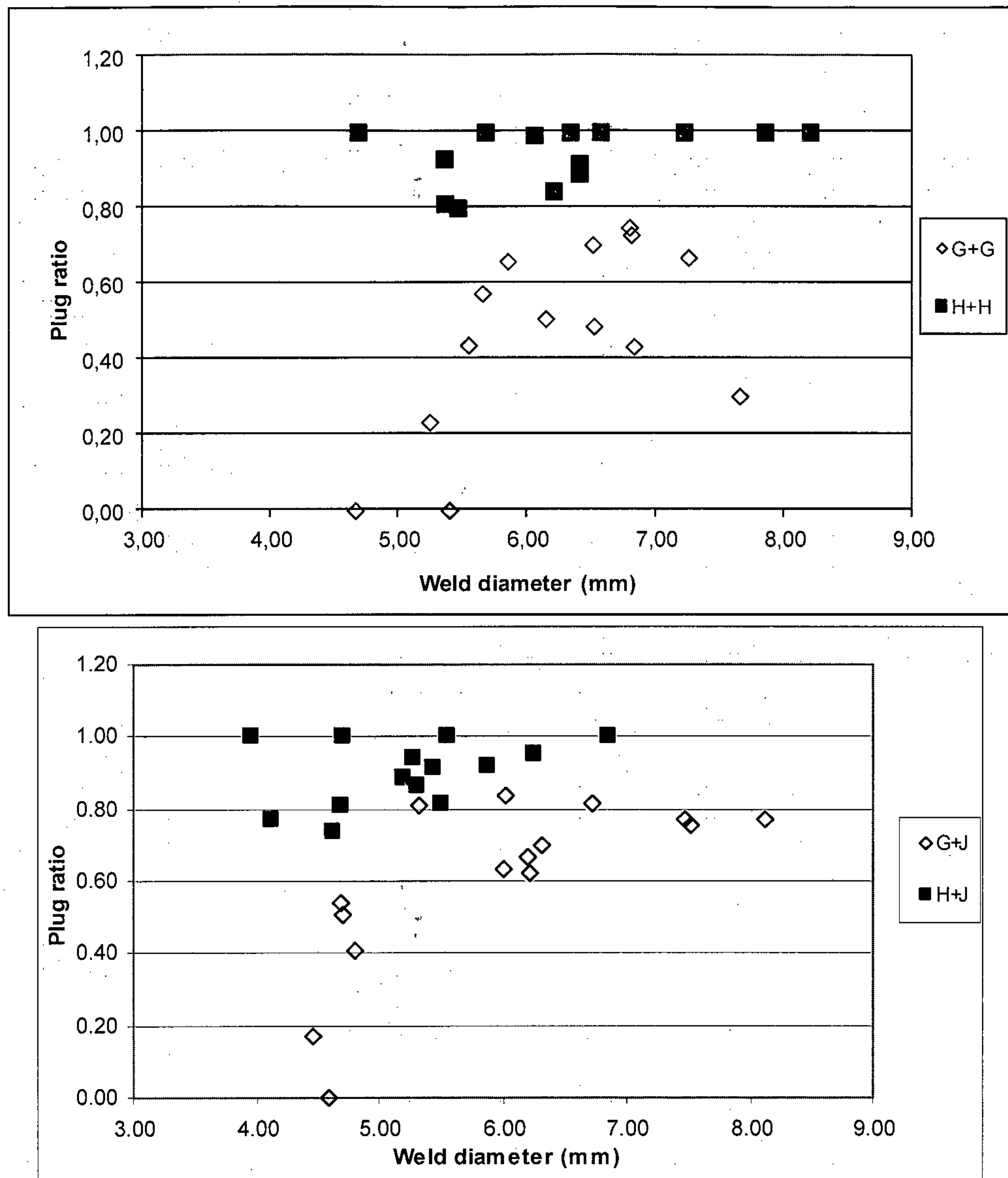


FIG 16 B

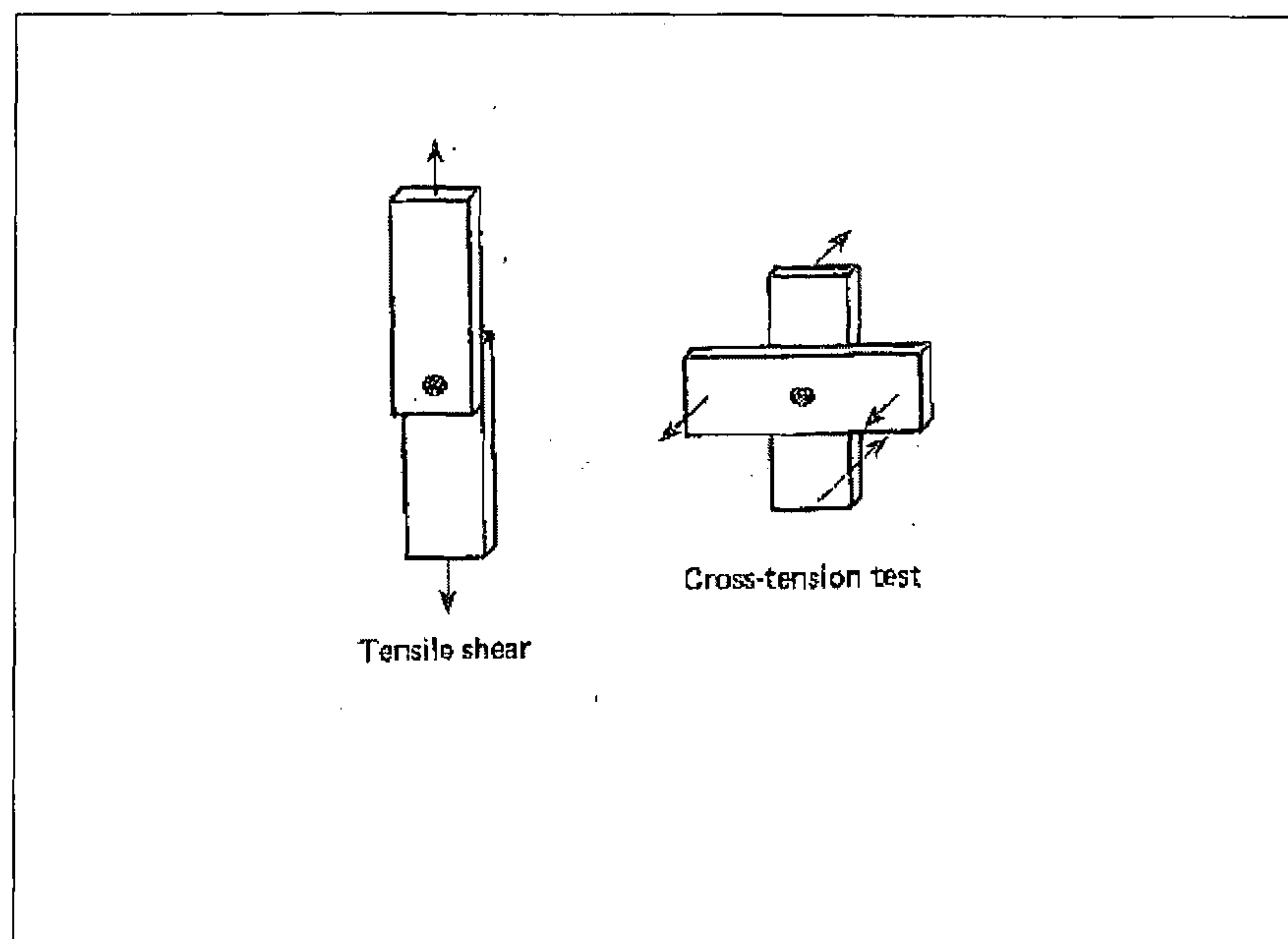


FIG 17

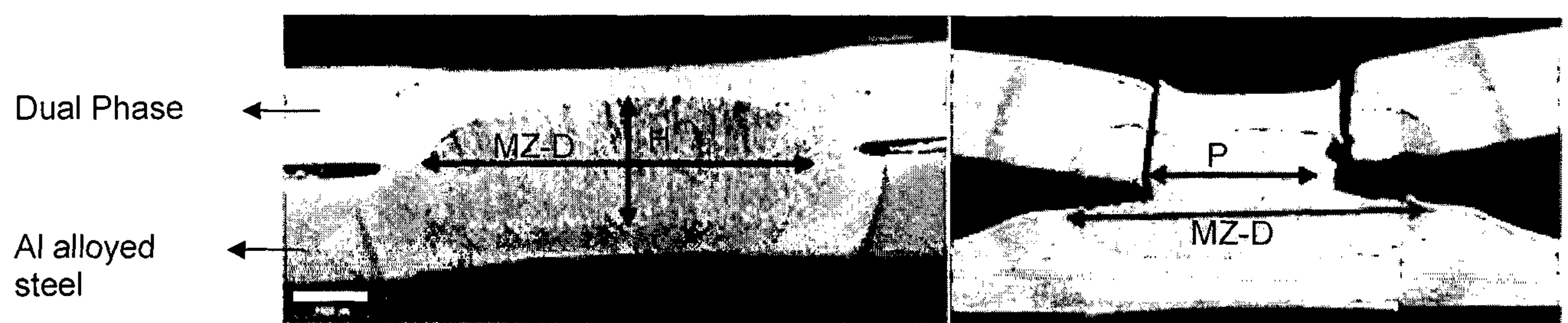
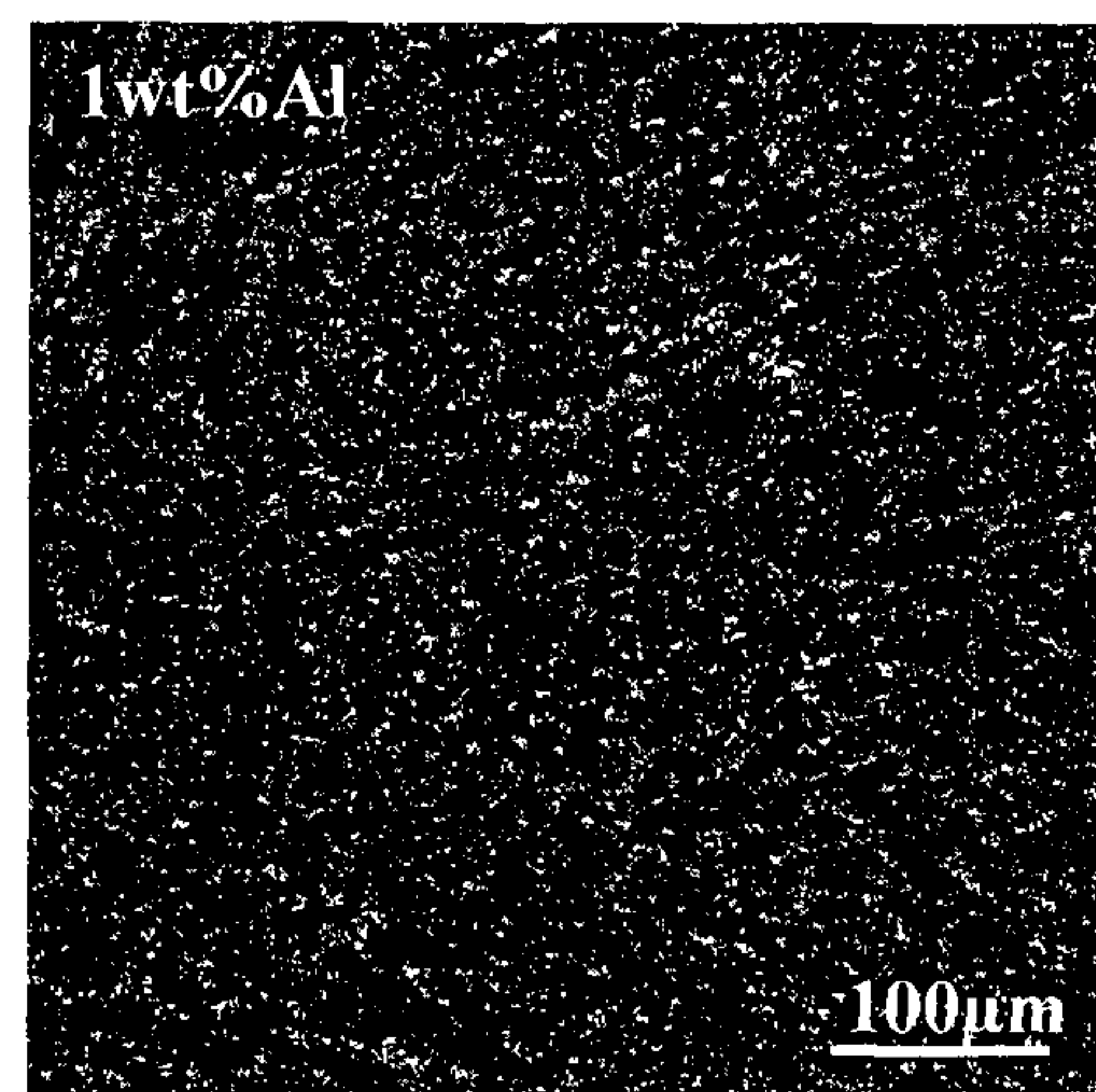
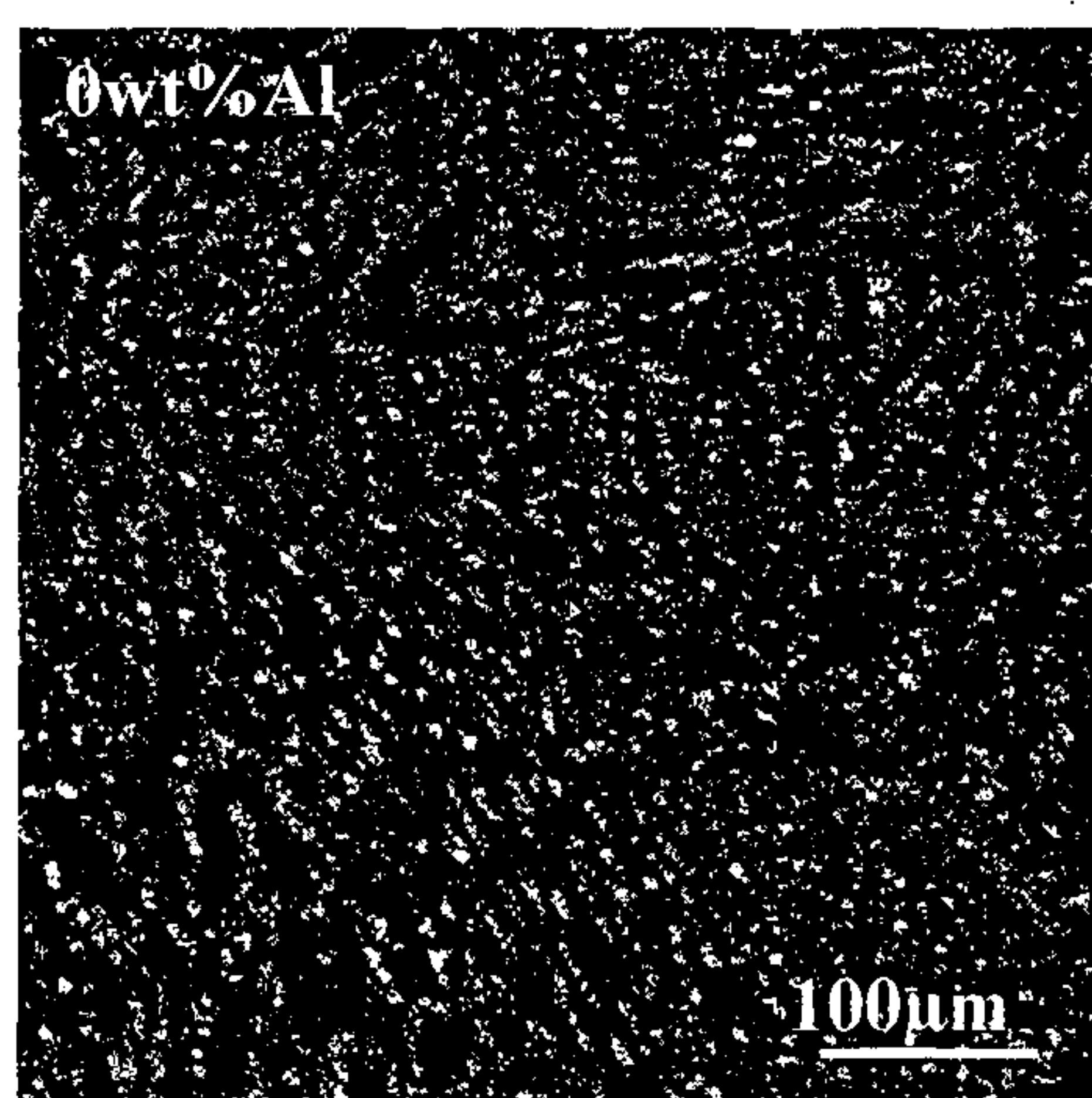


FIG 18



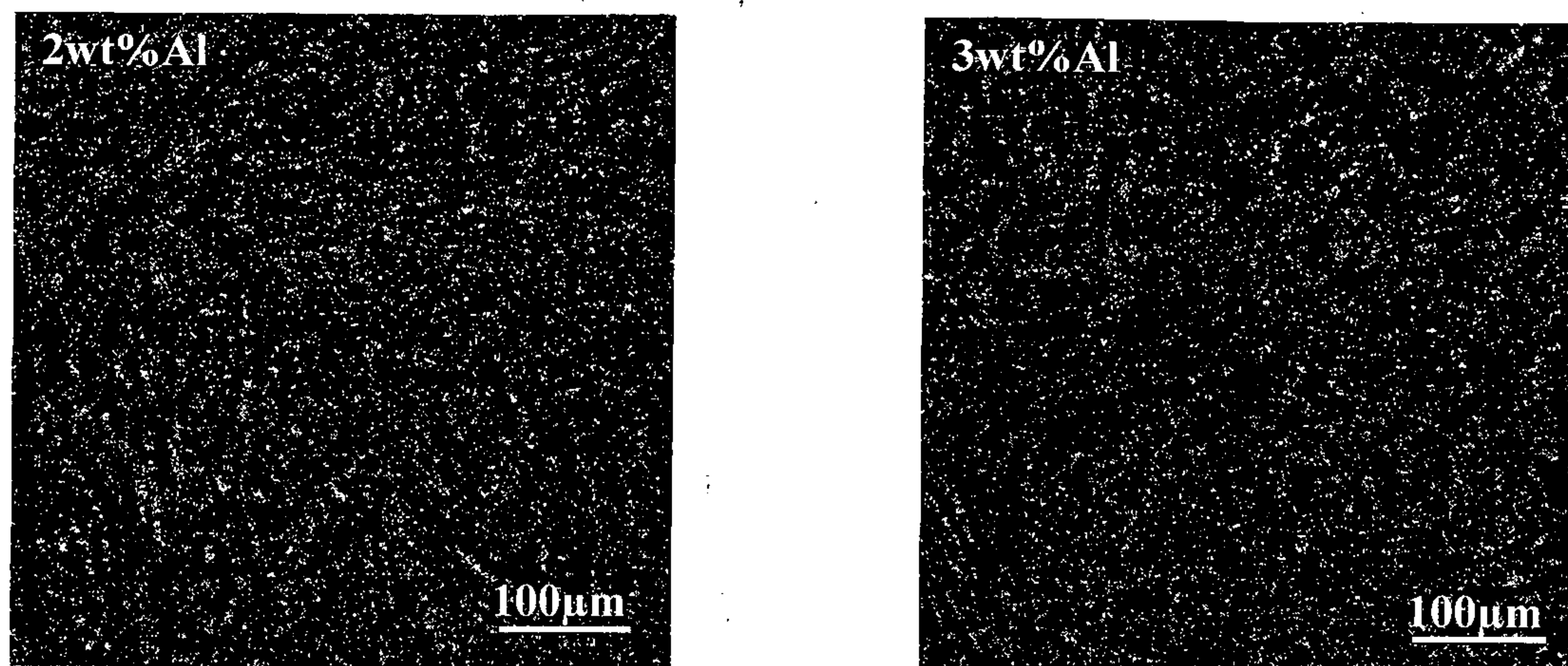


FIG 19

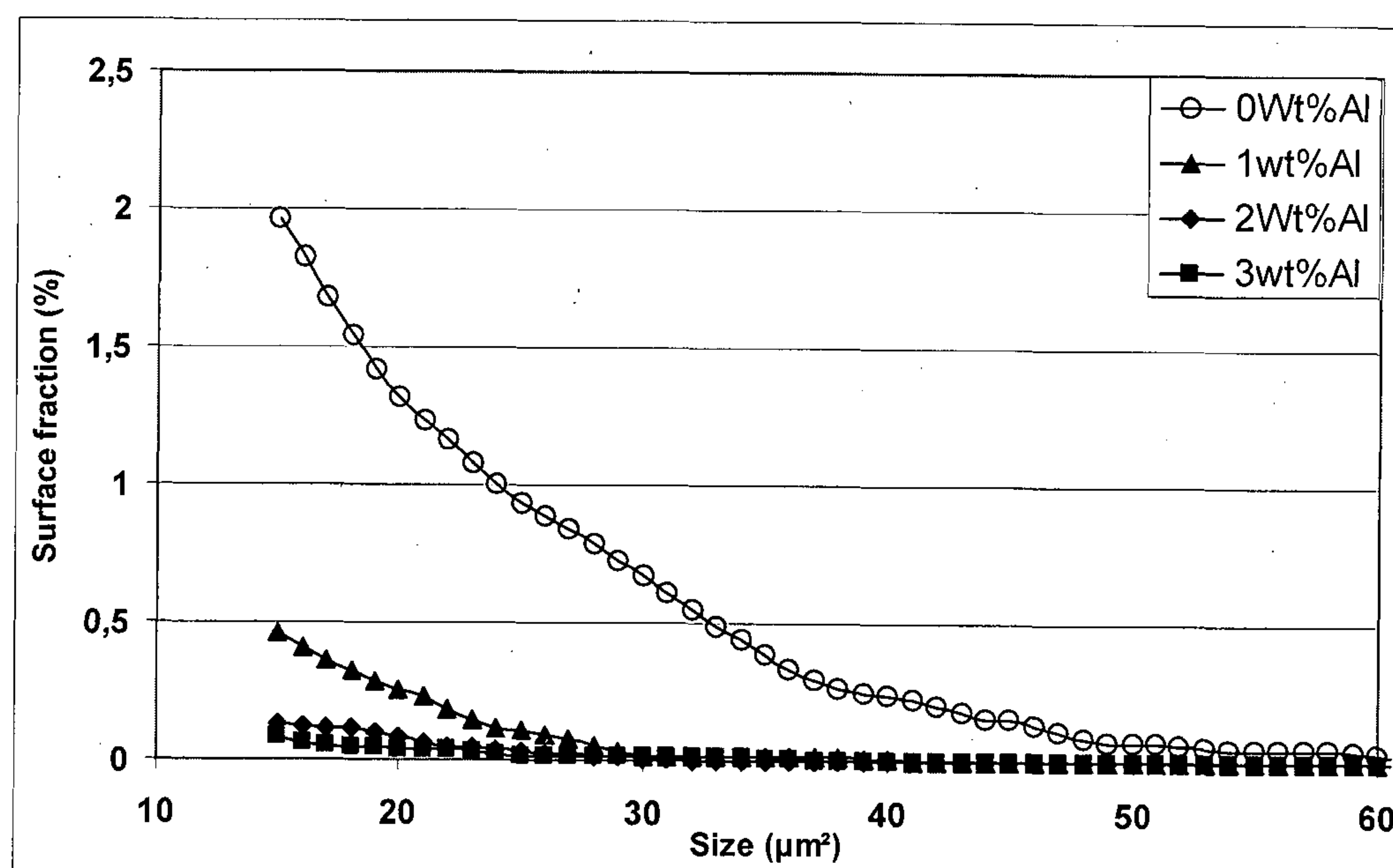


FIG 20 A

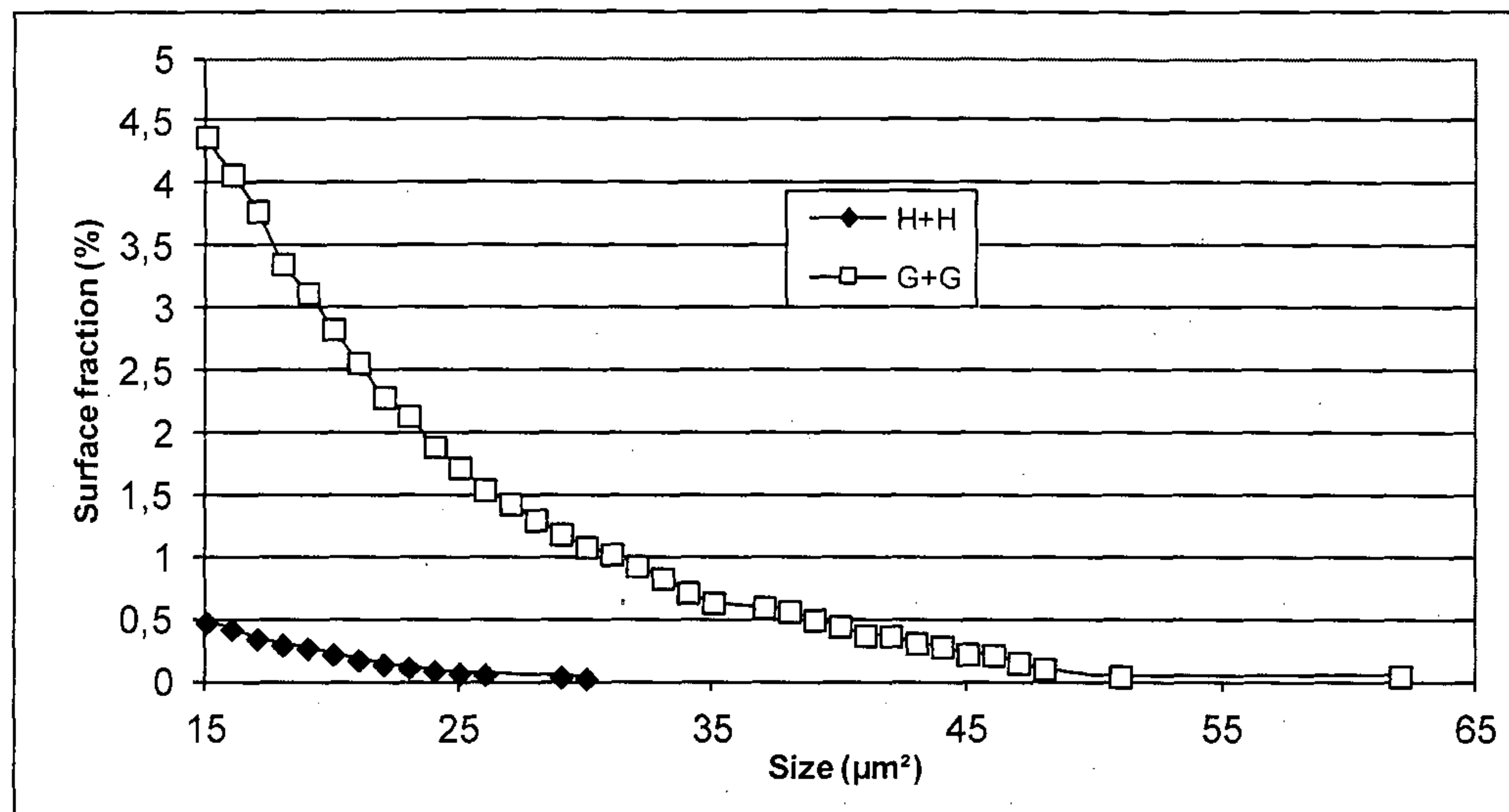


FIG 20 B

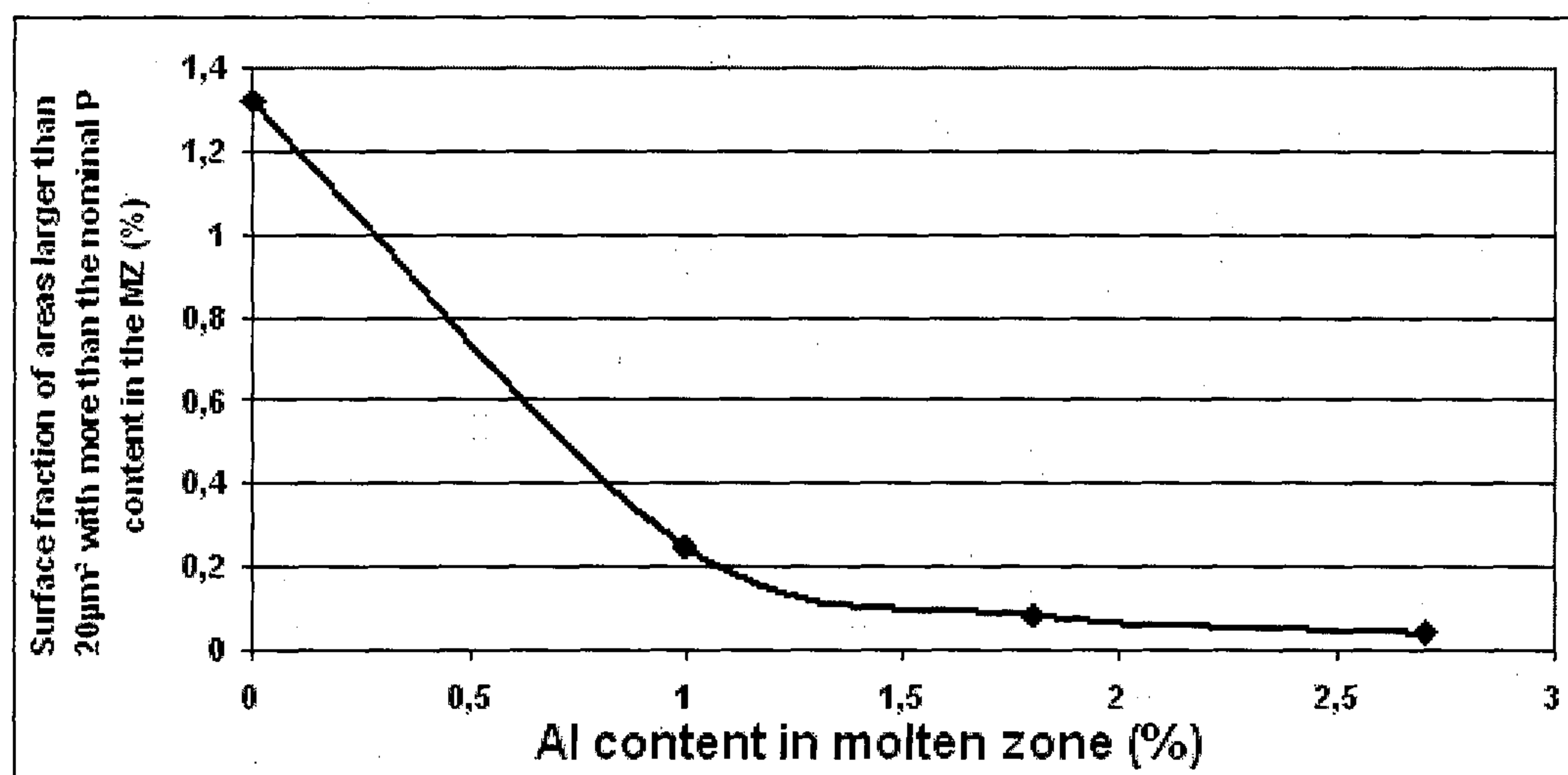


FIG 21

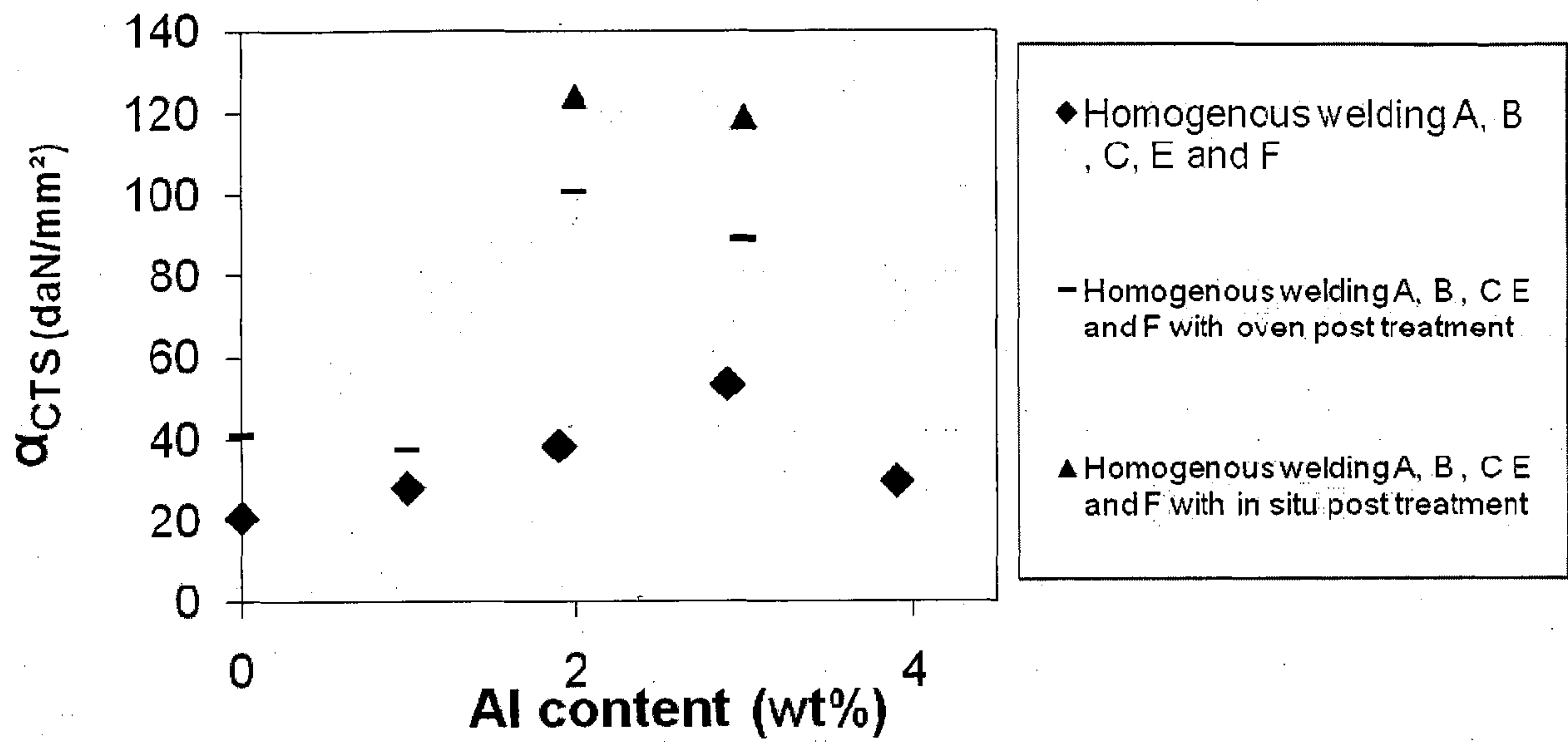


FIG 22 A

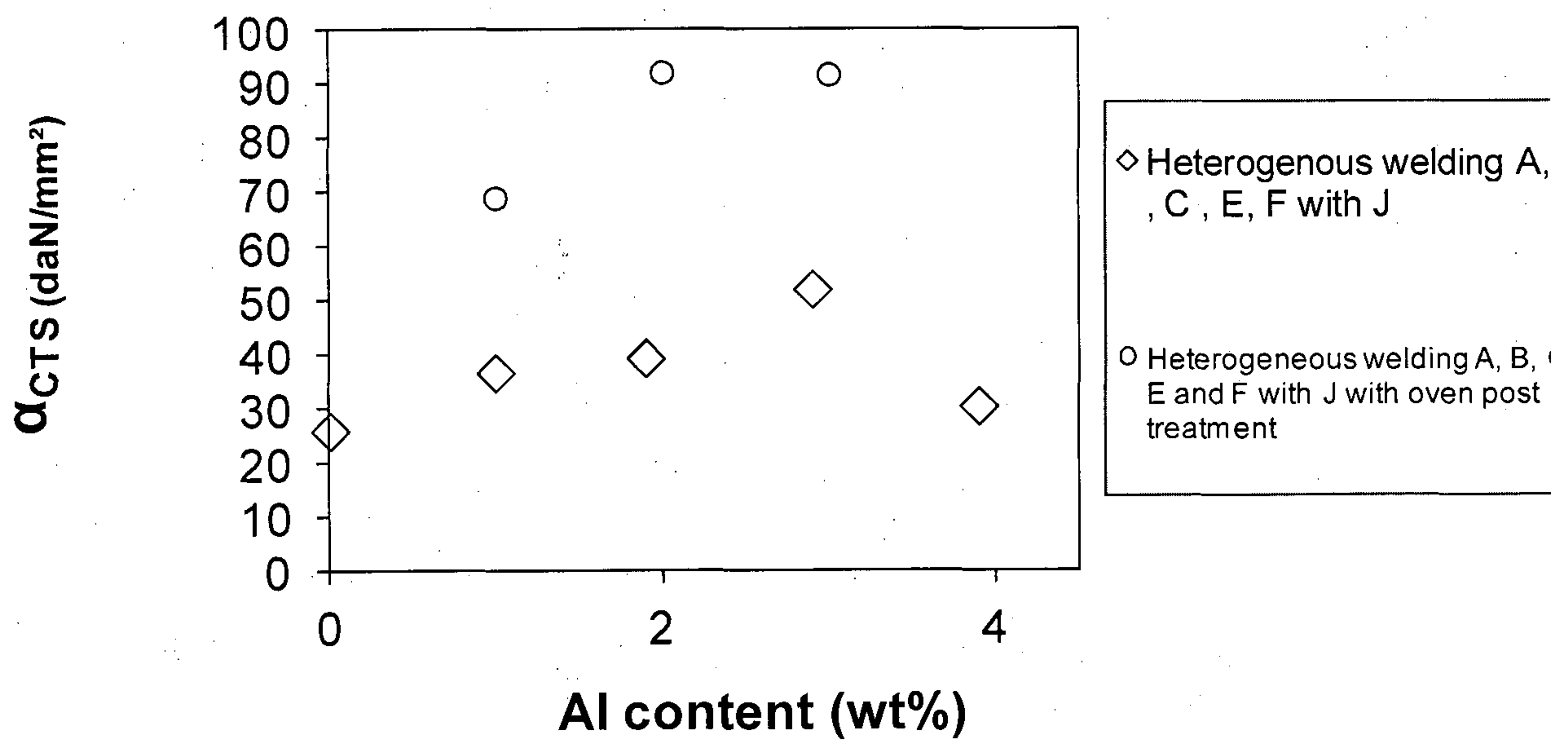


FIG 22 B