

AWS C3.14M/C3.14:2020
An American National Standard

Standard Method for Evaluation of Brazed Joints Using Visual and Metallographic Techniques



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Standard Method for Evaluation of Brazed Joints Using Visual and Metallographic Techniques

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Prepared by the
American Welding Society (AWS) C3 Committee on Brazing and Soldering

Under the Direction of the
AWS Technical Activities Committee

Approved by the
AWS Board of Directors

Abstract

This standard describes and illustrates the test methods used to obtain information related to brazed joint quality and structural integrity. Verification methods include visual observation, as well as metallography of such parameters as braze wetting, braze joint erosion, brazing filler metal penetration, differences between excess wetting, lack of wetting and dewetting, and formation of voids, cracks, and features which may be detrimental to end use. Additionally, methods to determine diffusion of braze alloying elements and procedures to qualify such methods are described. Photographs illustrating visual inspection, schematic illustrations, and photomicrographs illustrating various aspects of brazed joint integrity are presented.



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This standard is subject to revision at any time by the AWS C3 Committee on Brazing and Soldering. It must be reviewed every five years, and if not revised, it must be either reaffirmed or withdrawn. Comments (recommendations, additions, or deletions) and any pertinent data that may be of use in improving this standard are required and should be addressed to AWS Headquarters. Such comments will receive careful consideration by the AWS C3 Committee on Brazing and Soldering and the author of the comments will be informed of the Committee's response to the comments. Guests are invited to attend all meetings of the AWS C3 Committee on Brazing and Soldering to express their comments verbally. Procedures for appeal of an adverse decision concerning all such comments are provided in the Rules of Operation of the Technical Activities Committee. A copy of these Rules can be obtained from the American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166.

Foreword

This foreword is not part of this standard but is included for informational purposes only.

Currently there are no industry standards or guidelines for the evaluation of brazed joint external (visual) and internal (microstructural) features. Aerospace prime contractors are faced with increasing demand for third-party accreditation of suppliers for various brazing processes; yet are faced with a lack of a reliable method for assessing the supplier skills and capabilities in this area. This standard is intended to provide a vehicle for third party assessment of supplier capabilities by including test methods and criteria for evaluating brazed joint quality. This standard is intended to complement the AWS C3.2M/C3.2, *Standard Method for Evaluating the Strength of Brazed Joints*. By effective use of both of these standards one can obtain a complete assessment of brazed joint quality, both mechanical (strength—AWS C3.2) as well as metallurgical (AWS C3.14). Both standards are intended to serve as guidelines and contain best practices. Their use as a governing, requirement document is left to the discretion of the Organization Having Quality Responsibility and the various agencies employing the methods described herein.

A Commentary Annex on AWS C3.14M/C3.14:2020 has been prepared to generate a better understanding in the application of this specification in visual and metallographic evaluation of brazed joints, and is included for informational purposes only.

All errata to a standard shall be published in the *Welding Journal* and posted on the AWS website.

Comments and suggestions for the improvement of this standard are welcome. They should be sent to the Secretary, AWS C3 Committee on Brazing and Soldering, American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166.

NOTE: The user's attention is called to the possibility that compliance with this standard may require use of an invention covered by patent rights.

By publication of this standard, no position is taken with respect to the validity of any such claim(s) or of any patent rights in connection therewith. If a patent holder has filed a statement of willingness to grant a license under these rights on reasonable and nondiscriminatory terms and conditions to applicants desiring to obtain such a license, then details may be obtained from the standard developer.

Table of Contents

	Page No.
<i>Personnel</i>	v
<i>Foreword</i>	ix
<i>List of Tables</i>	xii
<i>List of Figures</i>	xii
1. General Requirements	1
1.1 Scope	1
1.2 Units of Measurement	1
1.3 Safety	1
2. Normative References	2
3. Terms and Definitions	2
4. Testing Procedures for Evaluating Brazed Joints	3
4.1 Sample Preparation	3
4.2 External Brazed Joint Inspection	4
4.3 Specimen Selection and Sectioning	4
4.4 Specimen Preparation	4
4.5 Internal Brazed Joint Inspection	4
4.6 Recording and Reporting of Results	4
5. Visual Inspection	6
5.1 Tools	6
5.2 Methods and Inspection Personnel	6
5.3 Measured/Evaluated External Characteristics of Brazed Joints	6
6. Internal Inspection of Brazed Joints	9
6.1 Selection of Location	9
6.2 Microscopes	9
6.3 Methods and Inspection Personnel	12
6.4 Measured/Evaluated Internal Characteristics of Brazed Joints	12
Annex A (Informative)—Informative References	21
Annex B (Informative)—Requesting an Official Interpretation on an AWS Standard	23
Annex C (Informative)—Commentary	25
List of AWS Documents on Brazing and Soldering	31

List of Tables

Table	Page No.
4.1 Applicable AWS Brazing Process Specifications	3

List of Figures

Figure	Page No.
4.1 Typical Data Sheet for Recording Details of Brazed Joint Quality and Workmanship Assessment	5
5.1 Schematic Illustration of Braze Wetting and Fillet Formation Across Mutually Perpendicular Faying Surfaces	6
5.2 Schematic Illustration of Faying Surfaces and Fillet Configuration	7
5.3 Cross Section of Edge Void That is a Through Void, Penetrating Through the Brazed Joint	8
5.4 Appearance of a Braze Void That Penetrates Between the Faying Surfaces	8
5.5 Example of Void in a Fillet Inspected Visually	9
5.6 (A) Oxidized Filler Metal and (B) Unmelted Filler Metal	10
5.7 Complete vs. Partial Melting of Braze Rings	11
5.8 Excess Braze (Arrow)	11
6.1 Appearance of Erosion in a Low Power Optical Microscope	12
6.2 Erosion of Inconel® 625 Tubing [(150X Magnification) (Etchant: Kalling's)]	13
6.3 Schematic Illustration of Internal Void	13
6.4 Cross Section Showing Large Internal Void in a Brazed Joint Between Inconel® Alloy 718/Inconel® Alloy 718 [(50X Magnification) (Unetched)]	14
6.5 Small Internal Voids in a Brazed Joint [(25X Magnification) (Unetched)]	14
6.6 Braze Void [(30X Magnification) (Etchant Unknown)]	15
6.7 Silicon Diffusion and Braze Alloy Penetration in Aluminum Alloy [(100X Magnification) (Etchant: Keller's)]	15
6.8 Deep Silicon Diffusion in Aluminum Alloy [(50X Magnification) (Etchant: Keller's)]	16
6.9 Brazing Filler Metal Diffusing into the Parent Metal [(150X Magnification) (Etchant: Fry's Reagent)] ...	16
6.10 Metallographic Cross Section of Unmelted/Unflowed Powder/Paste Brazing Filler Metal Due to Oxidation [(50X Magnification) (Unetched)]	17
6.11 Brazed Joint Cracks and Inclusions [(50X Magnification) (Etchant: Marble's)]	18
6.12 (A) Poor Wetting Due to Oxidation at Braze Interface and (B) Good Wetting with Very Little Oxidation [(50X Magnification) (Unetched)]	18
6.13 Aluminum Oxide Grit Contaminated Braze Interface [(50X Magnification) (Unetched)]	19
6.14 Semi-Continuous Inclusions [(100X Magnification) (Unetched)]	19
6.15 Lack of Wetting on a T-Joint [(25X Magnification) (Etched)]	20
6.16 T-Joint 304 Stainless, AWS A5.8 BNi-2 Filler Metal [(50X Magnification) (Unetched)]	20
<i>Commentary</i>	
C-4.1 Copper (Liquid Metal) Embrittlement [(325X Magnification) (Unetched)]	27
C-4.2 Intermetallic Compound Formation in Inconel® 625 [(150X Magnification) (Etchant: Fry's Reagent)] ...	27
C-5.1 Proper Brazed Joint Quality and Fillet Formation [(50X Magnification) (Unetched)]	28
C-5.2 Poor Brazed Joint Quality and Fillet Formation (25X Magnification)	28
C-6.1 Measuring a Void Length	29
C-6.2 Linear Intercept Method for Void Measurement	29

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1. General Requirements

1.1 Scope. This standard describes the test methods used to obtain reliable data related to external braze features and microstructural information to ensure compliance to the requirements of the following braze processes: Torch Brazing, Induction Brazing, Furnace Brazing, Resistance Brazing, Dip Brazing, Infrared Brazing, and Diffusion Brazing.

This standard also covers evaluation of joints, prepared and brazed according to a Brazing Procedure Specification and the applicable brazing specification utilizing samples that are representative of the part, or an actual part, at the discretion of the Organization Having Quality Responsibility (OHQR) or the Organization Performing the Brazing Operation (OPBO). Evaluation may be performed using external visual inspection, various metallographic techniques, and destructive testing such as peel testing.

Figures and illustrations are included wherever appropriate to clarify the expectations and interpretations of the data. This document provides information to assist in standardizing the evaluation and interpretation of brazed joint features but the acceptability of those features will be governed by the applicable brazing process specification, engineering drawing requirements, and the OHQR.

1.2 Units of Measurement. This standard does not require units of measure. Therefore, no equivalents or conversions are contained except when they are cited in examples.

1.3 Safety. Safety and health issues and concerns are beyond the scope of this standard; some safety and health information is provided, but such issues are not fully addressed herein.

Safety and Health information is available from the following sources:

American Welding Society:

- (1) ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*
- (2) AWS Safety and Health Fact Sheets
- (3) Other safety and health information on the AWS website

Material or Equipment Manufacturers:

- (1) Safety Data Sheets supplied by the materials manufacturers
- (2) Operating Manuals supplied by equipment manufacturers

Applicable Regulatory Agencies

Work performed in accordance with this standard may involve the use of materials that have been deemed hazardous, and may involve operations or equipment that may cause injury or death. This standard does not purport to address all safety and health risks that may be encountered. The user of this standard should establish an appropriate safety program to address such risks as well as to meet applicable regulatory requirements. ANSI Z49.1 should be considered when developing the safety program.