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ENVIRONMENTAL DURABILITY OF THE WELDBOND, FPL, AND PABST JOINING SYSTEMS

Northrop Corporation
Aircraft Group
3901 West Broadway
Hawthorne, California 90250

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FINAL REPORT FOR PERIOD DEC 1977 - MAY 1979

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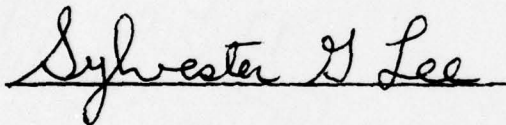
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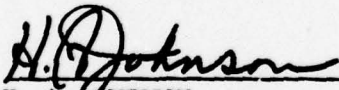
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H. A. JOHNSON
Chief, Metals Branch
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20. ABSTRACT (Continue on reverse side if necessary and identify by block number) This program was conducted as an addendum to Contract No. F33615-76-C-5412, "Advanced Weldbonding Process Establishment for Aluminum". Under controlled stress and environmental conditions, a direct comparison of durability and surface corrosion behavior was made for three surface preparation/adhesive systems. These systems included the PABST adhesive bonding system, the FPL adhesive bonding system, and the Northrop weldbond system. The three types of tests used were the wedge test, the constant load-salt water immersion		

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→ test, and the surface scratch test. Four different environmental exposures were used: (1) 95 to 100 percent relative humidity at 120F, (2) 5 percent salt fog at 95F, (3) 3.5 percent salt water and (4) the sea coast beach site at El Segundo, California. Four material combinations were evaluated for this program: 2024-T3 alclad bonded to 7075-T6 bare, 2024-T3 bare bonded to 7075-T6 bare, 2024-T3 bare bonded to 2024-T3 bare, and 7075-T6 bare bonded to 7075-T6 bare.

The objective of this program was to rank the three bonding systems and four material combinations in terms of durability and corrosion behavior.

The results of this evaluation showed that the PABST system had the best durability, the FPL system was second, and the weldbond system was third in durability ranking. A separate Northrop IRAD program was conducted to improve the durability of the weldbond system. The results of this program showed that the addition of a thin, 0.00004 inch, layer of BR-127 primer (air dried then co-cured) to the standard weldbond surface improved its durability so that it is nearly equal to that of the PABST system and vastly superior to the commonly used FPL system. The corrosion behavior of the three surface preparation processes were equal when the surfaces were primed and painted.

The ranking of the four material combinations in terms of decreasing durability is as follows:

2024-T3 bare/2024-T3 bare
2024-T3 bare/7075-T6 bare
7075-T6 bare/7075-T6 bare
2024-T3 alclad/7075-T6 bare

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PREFACE

This report was prepared by the Northrop Corporation, Aircraft Group, Hawthorne, California, under USAF Contract No. F33615-76-C-5412, as an addendum to the basic weldbond program, "Advanced Weldbonding Process Establishment for Aluminum." The contract work was performed under Project No. 828-6 and was sponsored by the Air Force Materials Laboratory, Air Force Systems Command, Wright-Patterson Air Force Base, Dayton, Ohio. Mr. S. G. Lee of the Metals Branch (LTM) of the Manufacturing Technology Division, AFML was the project engineer.

Northrop Corporation, Aircraft Group, was the contractor, with Mr. R. G. Hocker serving as the program manager for this addendum. Other Northrop personnel who made major contributions include: K. C. Wu, H. E. Langman, H. R. Miller, and J. W. Lewis (for welding and specimen preparation); V. S. Srinath, G. G. Richards, and L. M. Urzua (for surface preparation); and R. E. Herfert and S. L. Feenstra (for scanning electron microscope surface analysis).

McDonnell Douglas, Long Beach, California provided the PABST test panels and availability to their sea coast exposure site at El Segundo, California. The cooperation and assistance of the following McDonnell Douglas personnel is gratefully acknowledged: E. W. Thrall, Jr., PABST, Program Manager; R. W. Shannon, Materials and Process Engineering, Section Chief; R. W. Ochsner, Materials and Process Engineering, Unit Chief; and R. L. Radecky, Materials and Process Engineer.

The contractor report number is NOR-79-41. This report covers work performed from December 1977 through May 1979.

TABLE OF CONTENTS

<u>Section</u>	<u>Page</u>
1 INTRODUCTION	1
2 TECHNICAL DISCUSSION	4
TEST MATRIX AND TEST DESCRIPTION	4
Wedge Test	4
Constant Load-Salt Water Immersion Test	10
Surface Scratch Test	11
SURFACE PREPARATION AND ADHESIVE APPLICATION	11
RESULTS AND DISCUSSION	12
Wedge Tests - Sea Coast	12
Wedge Tests - 5 Percent Salt Fog, 95F	18
Wedge Tests - 95 to 100 Percent Relative Humidity, 120F.	19
Constant Load - Salt Water Immersion Tests	24
Surface Scratch Tests	25
Durability Ranking of Three Joining Systems	30
WELDBOND DURABILITY IMPROVEMENT STUDY	32
Weldability Evaluation	32
Wedge Test Durability Results	33
Weldbond Properties With and Without BR-127 Primer	33
Wedge Test with Spot Weld.	36
Conclusions for the Weldbond Durability Improvement Study	38
3 CONCLUSIONS	40
REFERENCES	41
APPENDIX A - WEDGE TEST DATA	43

LIST OF ILLUSTRATIONS

<u>Figure</u>		<u>Page</u>
1	Surface/Adhesive Systems for FPL, Weldbond, and PABST Joining Processes	3
2	Test Coupon Configurations	6
3	Typical Anodized Layer on 2024-T3 Alclad	13
4	Typical Anodized Layer on 2024-T3 Bare	14
5	Typical Anodized Layer on 7075-T6 Bare	15
6	Average Wedge Crack Growth of 2024-T3 Alclad/7075-T6 Bare - Sea Coast Exposure	16
7	Average Wedge Crack Growth of 2024-T3 Bare/7075-T6 Bare - Sea Coast Exposure	16
8	Average Wedge Crack Growth of 2024-T3 Bare/2024-T3 Bare - Sea Coast Exposure	17
9	Average Wedge Crack Growth of 7075-T6 Bare/7075-T6 Bare - Sea Coast Exposure	17
10	Average Wedge Crack Growth of 2024-T3 Alclad/7075-T6 Bare - Salt Fog Exposure	20
11	Average Wedge Crack Growth of 2024-T3 Bare/7075-T6 Bare - Salt Fog Exposure	20
12	Average Wedge Crack Growth of 2024-T3 Bare/2024-T3 Bare - Salt Fog Exposure	21
13	Average Wedge Crack Growth of 7075-T6 Bare/7075-T6 Bare - Salt Fog Exposure	21
14	Average Wedge Crack Growth of 2024-T3 Alclad/7075-T6 Bare - 95-100 Percent Relative Humidity	22
15	Average Wedge Crack Growth of 2024-T3 Bare/7075-T6 Bare - 95-100 Percent Relative Humidity	22
16	Average Wedge Crack Growth of 2024-T3 Bare/2024-T3 Bare - 95-100 Percent Relative Humidity	23
17	Average Wedge Crack Growth of 7075-T6 Bare/7075-T6 Bare - 95-100 Percent Relative Humidity	23
18	Average Wedge Crack Growth of 2024-T3 Alclad/7075-T6 Bare Including Weldbond/BR-127 - Salt Fog Exposure	35
19	Average Wedge Crack Growth of 2024-T3 Alclad/7075-T6 Bare Including Weldbond/BR-127 - Sea Coast Exposure	35
20	Average Wedge Crack Growth of 2024-T3 Alclad/7075-T6 Bare Weldbond with Spot Weld - Salt Fog Exposure	39

LIST OF TABLES

<u>Table</u>	<u>Page</u>
1 Test Matrix for Each Joining System – FPL, Weldbond and PABST	5
2 FPL Process.	7
3 Northrop Weldbond Process	8
4 PABST Process	9
5 Constant Load/Salt Water Immersion Test Results for the FPL System	26
6 Constant Load/Salt Water Immersion Test Results for the Weldbond System	27
7 Constant Load/Salt Water Immersion Test Results for the PABST System.	28
8 Surface Scratch Test Results	29
9 Durability Ranking of Three Joining Systems.	31
10 Test Matrix for Weldbond/BR-127 Evaluation	34
11 Lap-Shear Strength for Primed and Unprimed Weldbonded 7075-T6. . .	34
12 High-Load Transfer Fatigue Behavior for Primed and Unprimed Weldbonded 7075-T6.	37
APPENDIX A	43
A1 Wedge Test Data - Sea Coast Exposure - 2024-T3 Alclad/7075-T6 Bare FPL Bonding System	44
A2 Wedge Test Data - Sea Coast Exposure - 2024-T3 Alclad/7075-T6 Bare Weldbond System	45
A3 Wedge Test Data - Sea Coast Exposure - 2024-T3 Alclad/7075-T6 Bare PABST System.	46
A4 Wedge Test Data - Sea Coast Exposure - 2024-T3 Bare/7075-T6 Bare FPL Bonding System.	47
A5 Wedge Test Data - Sea Coast Exposure - 2024-T3 Bare/7075-T6 Bare Weldbond System	48
A6 Wedge Test Data - Sea Coast Exposure - 2024-T3 Bare/7075-T6 PABST System.	49
A7 Wedge Test Data - Sea Coast Exposure - 2024-T3 Bare/2024-T3 Bare FPL Bonding System.	50

LIST OF TABLES (Continued)

<u>Table</u>		<u>Page</u>
A8	Wedge Test Data - Sea Coast Exposure - 2024-T3 Bare/2024-T3 Bare Weldbond System	51
A9	Wedge Test Data - Sea Coast Exposure - 2024-T3 Bare/2024-T3 Bare PABST System	52
A10	Wedge Test Data - Sea Coast Exposure - 7075-T6 Bare/7075-T6 Bare FPL Bonding System	53
A11	Wedge Test Data - Sea Coast Exposure - 7075-T6 Bare/7075-T6 Bare Weldbond System	54
A12	Wedge Test Data - Sea Coast Exposure - 7075-T6 Bare/7075-T6 Bare PABST System	55
A13	Wedge Test Data - Salt Fog Exposure - 2024-T3 Alclad/7075-T6 Bare FPL Bonding System	56
A14	Wedge Test Data - Salt Fog Exposure - 2024-T3 Alclad/7075-T6 Bare Weldbond System	56
A15	Wedge Test Data - Salt Fog Exposure - 2024-T3 Alclad/7075-T6 Bare PABST System	57
A16	Wedge Test Data - Salt Fog Exposure - 2024-T3 Bare/7075-T6 Bare FPL Bonding System	57
A17	Wedge Test Data - Salt Fog Exposure - 2024-T3 Bare/7075-T6 Bare Weldbond System	58
A18	Wedge Test Data - Salt Fog Exposure - 2024-T3 Bare/7075-T6 Bare PABST System	58
A19	Wedge Test Data - Salt Fog Exposure - 2024-T3 Bare/2024-T3 Bare FPL Bonding System	59
A20	Wedge Test Data - Salt Fog Exposure - 2024-T3 Bare/2024-T3 Bare Weldbond System	59
A21	Wedge Test Data - Salt Fog Exposure - 2024-T3 Bare/2024-T3 Bare PABST System	60
A22	Wedge Test Data - Salt Fog Exposure - 7075-T6 Bare/7075-T6 Bare FPL Bonding System	60
A23	Wedge Test Data - Salt Fog Exposure - 7075-T6 Bare/7075-T6 Bare Weldbond System	61
A24	Wedge Test Data - Salt Fog Exposure - 7075-T6 Bare/7075-T6 Bare PABST System	61
A25	Wedge Test Data - 95-100% Relative Humidity Exposure - 2024-T3 Alclad/7075-T6 Bare-FPL Bonding System	62
A26	Wedge Test Data - 95-100% Relative Humidity Exposure - 2024-T3 Alclad/7075-T6 Bare-Weldbond System	62

LIST OF TABLES (Continued)

<u>Table</u>		<u>Page</u>
A27	Wedge Test Data - 95-100% Relative Humidity Exposure - 2024-T3 Alclad/7075-T6 Bare - PABST System.	63
A28	Wedge Test Data - 95-100% Relative Humidity Exposure - 2024-T3 Bare/7075-T6 Bare - FPL Bonding System.	63
A29	Wedge Test Data - 95-100% Relative Humidity Exposure - 2024-T3 Bare/7075-T6 Bare - Weldbond System	64
A30	Wedge Test Data - 95-100% Relative Humidity Exposure - 2024-T3 Bare/7075-T6 Bare - PABST System.	64
A31	Wedge Test Data - 95-100% Relative Humidity Exposure - 2024-T3 Bare/2024-T3 Bare - FPL Bonding System.	65
A32	Wedge Test Data - 95-100% Relative Humidity Exposure - 2024-T3 Bare/2024-T3 Bare - Weldbond System	65
A33	Wedge Test Data - 95-100% Relative Humidity Exposure - 2024-T3 Bare/2024-T3 Bare PABST System.	66
A34	Wedge Test Data - 95-100% Relative Humidity Exposure - 7075-T6 Bare/7075-T6 Bare - FPL Bonding System.	66
A35	Wedge Test Data - 95-100% Relative Humidity Exposure - 7075-T6 Bare/7075-T6 Bare - Weldbond System	67
A36	Wedge Test Data - 95-100% Relative Humidity Exposure - 7075-T6 Bare/7075-T6 Bare - PABST System.	67
A37	Wedge Test Data - Sea Coast Exposure - 2024-T3 Alclad/7075-T6 Bare Weldbond System with Primer BR-127	68
A38	Wedge Test Data - Salt Fog Exposure - 2024-T3 Alclad/7075-T6 Bare Weldbond System with Primer BR-127	69
A39	Wedge Test Data for Weldbond Specimens with Welds - 2024-T3 Alclad/7075-T6 Bare	70

SECTION 1

INTRODUCTION

During the past six years, two new processes have become available for surface treatment of aluminum prior to adhesive bonding. These are the 10-volt phosphoric acid anodizing process developed by Boeing, which has been integrated into the PABST (Primary Adhesively Bonded Structure Technology) program by McDonnell Douglas, (Reference 1) and the low-voltage dilute phosphoric acid/sodium dichromate anodizing process developed by Northrop (References 2, 3, and 4) for use in the weldbond manufacturing process. A third system for adhesive bonding, the FPL (Forest Products Laboratory) system, has been used extensively and is used presently by Fairchild Republic Corporation to adhesively bond panels for the A-10 aircraft. Reference made to the FPL system throughout this report is an abbreviated term for the bonding system in which an FPL etch is used with the BR-127 primer and the FM 123-2 mat adhesive.

The Northrop weldbond joining system was developed to have durability better than that of the spot weld etch joining system, which was previously used, and approximately equal to that of the FPL joining system. Comparison of the durability of these joining systems was based initially on a 1-day wedge test in 95-100 percent humidity at 120F. This test indicated only if a system was poor or good. A CL/SWIT (constant load-salt water immersion test) was then developed, which differentiated between a fair and a good system. At this stage of the test development, the weldbond system was shown to be equal or better than the FPL system. Currently, for the PABST system, long term wedge tests are used to evaluate durability. The long term wedge test differentiates between a good and an excellent adhesive bonding system. However, it does not evaluate the durability of the complete weldbond system since welds are not included in the preparation of the wedge test specimen; and yet, spot welding is an integral part of the weldbond joining system.

Northrop recently completed a program on "Advanced Weldbonding Process Establishment for Aluminum," (Reference 4). As part of this program, a technology transfer of the weldbond process to the Fairchild Republic Corporation was accomplished. A follow-on contract was awarded to Fairchild Republic to initiate production weldbonding of several fuselage panels for the A-10 aircraft.

One of the primary concerns in the use of adhesively bonded structures is premature failure due to a time-dependent crack growth in the bond joint under the combined influence of applied stress and a corrosive environment. This type of failure is commonly termed "environmental stress cracking." Resistance to environmental stress cracking is defined as environmental durability, and is referred to as durability in this report.

In order to compare the durability of the weldbond system with that of the other two adhesive bonding systems (PABST and FPL), an addendum program to the Northrop weldbonding contract (Reference 4) was conducted. Under controlled stress and environmental conditions, a direct comparison of durability behavior was made for the three systems. These systems included the PABST adhesive bonding system, the FPL adhesive bonding system, and the Northrop weldbond system.

A schematic representation of these systems is shown in Figure 1. The FPL system utilizes a thin (300 to 600 angstroms) boehmite layer ($\alpha\text{Al}_2\text{O}_3 \cdot \text{H}_2\text{O}$), which is formed during the FPL process. This bonding system also includes the BR-127 primer and the FM 123-2 mat adhesive. The weldbond system also utilizes a thin (400 to 800 angstroms) boehmite layer applied by anodizing, but this system does not include a primer. A chromated paste adhesive, Goodrich A1444B, is used for the weldbond system so that the welds can be made through the adhesive. The PABST adhesive system utilizes a much thicker (approximately 3,000 angstroms) boehmite layer and includes the BR-127 primer and the FM-73 mat adhesive. In order to evaluate these three joining systems, three different types of tests, including the wedge test, the constant load-salt water immersion test, and the surface scratch test, were used. Four different environmental exposures were used: (1) 95 to 100 percent relative humidity at 120F, (2) 5 percent salt fog at 95F, (3) 3.5 percent salt water at room temperature, and (4) the McDonnell Douglas sea coast beach site at El Segundo, California. Four material combinations were evaluated for this program: 2024-T3 alclad bonded to 7075-T6 bare, 2024-T3 bare bonded to 7075-T6 bare, 2024-T3 bare bonded to 2024-T3 bare, and 7075-T6 bare bonded to 7075-T6 bare.

The objective of this program was to rank the three bonding systems and the four material combinations in terms of durability behavior.

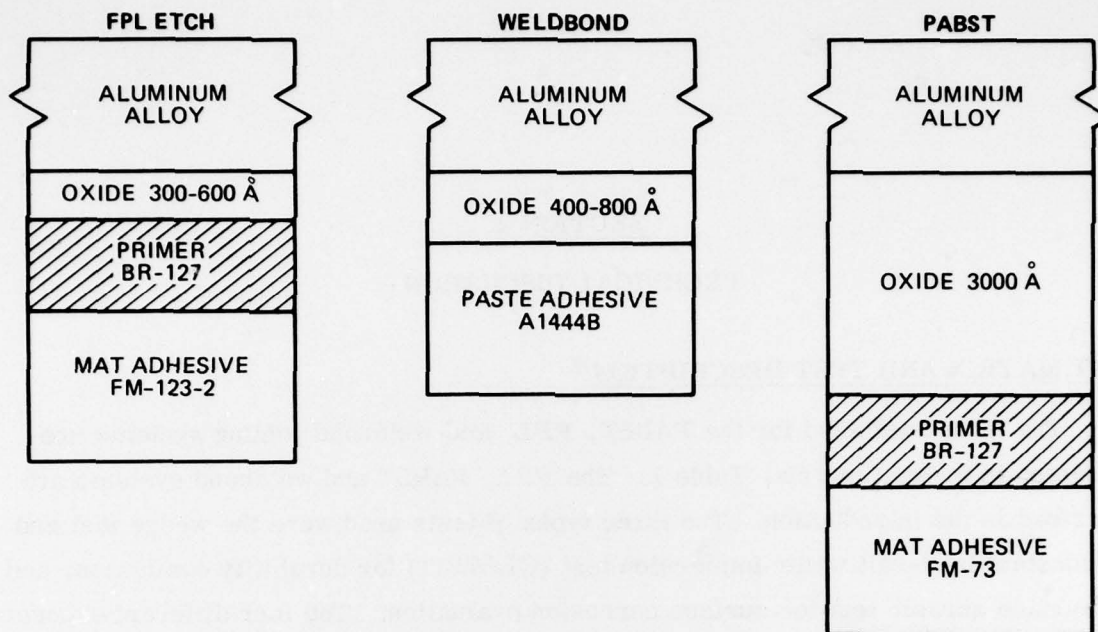


FIGURE 1. SURFACE/ADHESIVE SYSTEMS FOR FPL, WELDBOND, AND PABST JOINING PROCESSES

SECTION 2

TECHNICAL DISCUSSION

TEST MATRIX AND TEST DESCRIPTION

The tests conducted for the PABST, FPL, and weldbond joining systems are presented in the test matrix, Table 1. The FPL, PABST and weldbond systems are described in the introduction. The three types of tests used were the wedge test and the constant load-salt water immersion test (CL/SWIT) for durability evaluation, and the surface scratch test for surface corrosion evaluation. The four different exposure environments include: 95 to 100 percent relative humidity at 120F, 5 percent salt fog at 95F per ASTM standard B117, 3.5 percent salt water at room temperature, and the McDonnell Douglas beach site located in El Segundo, California, approximately 75 yards from the ocean.

Wedge Test

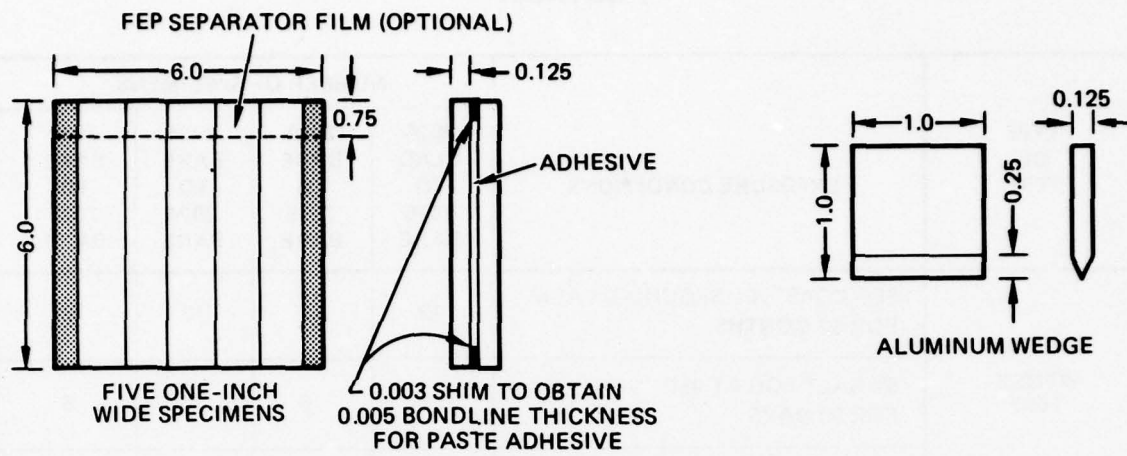
For the wedge tests, crack-growth measurements were made periodically for exposure times up to 90 days in the 95-100 percent relative humidity and salt fog environments, and once a month for a total of 1 year in the sea coast environment.

A sketch of the wedge coupon is shown in Figure 2. The wedge test panels measured 6 inches x 6 inches x 0.125 inch. The panels were cleaned, surface treated, and bonded, according to the procedures outlined in Tables 2, 3, and 4 for each of the three joining systems. After the cure cycle, all test panels were primed with MIL-P-23377 epoxy polyamide primer and painted with MIL-C-81773 polyurethane aircraft top coat paint. Ultrasonic inspections were made of each panel and only panels without voids in the adhesive bondline were accepted for tests. Five wedge coupons were saw cut from each 6-inch x 6-inch panel. One edge of each wedge specimen was machined or polished smooth so that wedge crack-growth measurements could easily be made. These edges were left unprotected throughout the exposure.

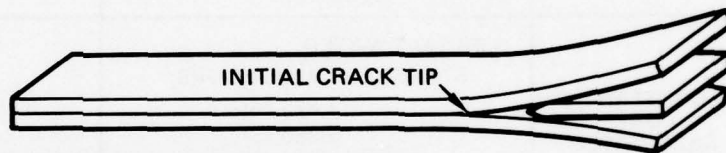
**TABLE 1. TEST MATRIX FOR EACH JOINING SYSTEM-FPL, WELDBOND,
AND PABST**

TYPE OF TEST	EXPOSURE CONDITIONS	NUMBER OF SPECIMENS			
		2024 CLAD TO 7075 BARE	2024 BARE TO 7075 BARE	2024 BARE TO 2024 BARE	7075 BARE TO 7075 BARE
WEDGE TEST	SEA COAST, EL SEGUNDO, CALIF FOR 12 MONTHS	12	12	12	12
	5% SALT FOG AT 95F FOR 90 DAYS	6	6	6	6
	95-100% RELATIVE HUMIDITY AT 120F FOR 90 DAYS	6	6	6	6
CONSTANT LOAD SALT WATER IMMERSION TEST	3.5% SALT WATER STRESS FOR 2,000 HOURS: 1,875 PSI 2,380 PSI	3 —	3 —	3 —	— 3
	STRESS FOR 1,000 HOURS: 2,380 PSI 3,000 PSI	3 —	3 —	3 —	— 3
SURFACE SCRATCH TEST	5% SALT FOG AT 95F FOR 2,000 HOURS 2024-T3 ALCLAD — COATED* — 10 2024-T3 ALCLAD — UNCOATED — 10 2024-T3 BARE — COATED* — 10 2024-T3 BARE — UNCOATED — 10 7075-T6 BARE — COATED* — 10 7075-T6 BARE — UNCOATED — 10				

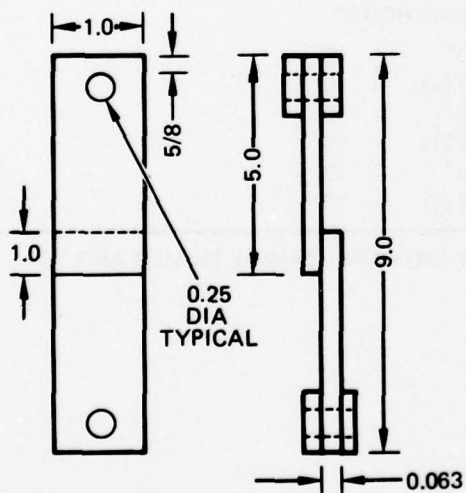
*COATED SPECIMENS WERE PRIMED WITH MIL-P-23377 EPOXY POLYAMIDE PRIMER AND TOP COATED WITH MIL-C-81773 POLYURETHANE PAINT



THE ENDS AND SIDES OF THE WEDGE SHALL BE APPROXIMATELY FLUSH WITH SPECIMEN END AND SIDES

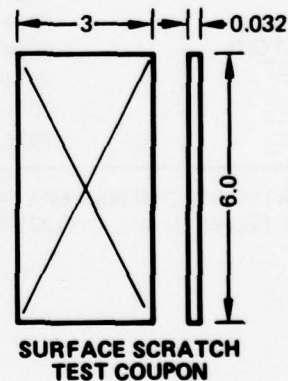


WEDGE TEST PANEL, COUPON, AND WEDGE



CONSTANT LOAD/SALT WATER IMMERSION TEST COUPON

SCRIBE PER ASTM D1654



NOTE: ALL DIMENSIONS ARE IN INCHES

FIGURE 2. TEST COUPON CONFIGURATIONS

TABLE 2. FPL PROCESS

OPERATION	MATERIAL	PROCESS
VAPOR DEGREASE	1-1-1 TRICHLOROETHANE	
ALKALINE CLEAN	ALTREX 1097 5-8 OZ/GAL	10-15 MINUTES 160-190F
SPRAY RINSE	DEIONIZED WATER	5-7 MINUTES 110F
DEOXIDIZE AND ETCH	FPL-ETCH 96% SULFURIC ACID: 38.5-41.5 FLUID OZ/GAL SODIUM DICHROMATE, DIHYDRATE: 8 OZ/GAL 2024 ALUMINUM SCRAP: 0.2 OZ/GAL	12-15 MINUTES 150-160F
PRIME	BR-127, 0.00015-INCH TO 0.00030-INCH THICKNESS SPRAY COAT	AIR DRY: 30 MINUTES AT RT. CURE: 60-120 MINUTES AT 250F
ADHESIVE	FM 123-2 0.045 LB/SQ FT, 2 LAYERS	VACUUM BAG. APPLY AUTOCLAVE PRESSURE OF 50-100 PSI. CURE: 90 MINUTES AT 260F

TABLE 3. NORTHROP WELDBOND PROCESS

OPERATION	MATERIAL	PROCESS
VAPOR DEGREASE	1-1-1 TRICHLOROETHANE	VAPOR 60 SECONDS; CONDENSED FLUID-60 SECONDS; COOL, REPEAT.
ALKALINE CLEAN	TURCO 4215-S, 6-8 OZ/GAL SOLUTION	12-15 MINUTES, 125-165F
SPRAY RINSE	COLD DEIONIZED WATER WITH TAP WATER MIX	5-7 MINUTES
DEOXIDIZE	NITRIC ACID/AMCHEM-7 (MODIFIED) NITRIC ACID - 11-14% BY VOLUME, BE ^o 42 (70% HNO ₃) AMCHEM-7: 2.9 - 3.3 WT OZ/GALLON SOLUTION ALODINE-45: 11.2 - 11.5 ML/GALLON SOLUTION ALODINE 1200E ACTIVATOR - 13.2 - 13.4 ML/GALLON SOLUTION BALANCE - DI WATER	6-8 MINUTES, ROOM TEMPERATURE IN AGITATED SOLUTION
SPRAY RINSE	COLD DEIONIZED WATER WITH TAP WATER MIX	5-7 MINUTES
ANODIZE	PSD SOLUTION PHOSPHORIC ACID - 1.2 - 1.5 FL OZ/ GALLON SOLUTION (85% H ₃ PO ₄) SODIUM DICHROMATE DIHYDRATE: - 1.3 - 1.5 OZ/GALLON SOLUTION	20-25 MINUTES, ROOM TEMPERATURE VOLTAGE - 1.4-1.6 VOLTS, DC FOR BARE ALLOYS 0.9-1.1 VOLTS, DC FOR CLAD ALLOYS
SPRAY RINSE	COLD DEONIZED WATER WITH TAP WATER MIX	5-7 MINUTES
OVEN DRY	CIRCULATING HOT AIR	30-40 MINUTES, 150±10F
ADHESIVE	A1444B PASTE	APPLY TO BOTH SURFACES
WELD		RESISTANCE SPOT WELD
CURE		250-260F FOR 2 HOURS

TABLE 4. PABST PROCESS

OPERATION	MATERIAL	PROCESS
VAPOR DEGREASE OR SOLVENT WIPE	1-1-1 TRICHLOROETHANE	
ALKALINE CLEAN	TURCO 4215-S	4-8 OZ/GAL 15 MINUTES 140F
SPRAY RINSE	DEIONIZED WATER	5-7 MINUTES ROOM TEMPERATURE
DEOXIDIZE	NITRIC ACID/AMCHEM 6-16	15 MINUTES
	AMCHEM 6-16: 6-8% BY VOLUME 8-10% BY WEIGHT	75-95F
	NITRIC ACID: 20 FLUID OZ/GAL, (70% HNO ₃)	
	DEIONIZED WATER: BALANCE	
SPRAY RINSE	DEIONIZED WATER	5-7 MINUTES ROOM TEMPERATURE
ANODIZE	PHOSPHORIC ACID	20-25 MINUTES ROOM TEMPERATURE AT 10-15 VOLTS
	96% H ₃ PO ₄ : 11-16 OZ/GAL DEIONIZED WATER: BALANCE	
SPRAY RINSE	DEIONIZED WATER	5-7 MINUTES ROOM TEMPERATURE
OVEN DRY	CIRCULATING HOT AIR	30-60 MINUTES 150-160F
PRIME:	BR-127, 0.00015-INCH TO 0.00030-INCH THICKNESS SPRAY COAT	AIR DRY: 30 MINUTES AT RT CURE: 1 HOUR AT 225F
ADHESIVE:	FM 73, 0.060 LB/SQ FT	VACUUM BAG APPLY AUTOCLAVE PRESSURE OF 50-100 PSI. CURE: 90 MINUTES AT 250F

On the day the specimens were to be exposed, an aluminum wedge was driven into one end of the specimen, as shown in Figure 2. A 3X magnifying glass was used to determine the initial crack length and a scribe mark was made on the edge of the specimen. The initial crack length and the adhesive bondline thickness were measured and recorded. A high stress was created at the initial crack tip along the bondline across the one-inch wide specimen. During exposure to the corrosive environment, the crack progressed uniformly toward the bottom end of the wedge specimen. The progression of the crack, or crack-growth, was easily measured by placing a steel ruler along the edge of the specimen using the initial crack length scribe mark as the reference line. Measurements were made to the nearest 0.01 inch.

Constant Load-Salt Water Immersion Test (CL/SWIT)

A sketch of the constant load-salt water immersion specimen is shown in Figure 2. For this test specimen, a sheet thickness of 0.063 inch was used. Doublers of the same thickness were also used at the ends of the specimen to prevent failure at the pin loading holes.

In order to obtain 10 one-inch wide specimens from one bonded panel, 5-inch x 12-inch panels were cleaned, surface treated, and adhesive bonded or weldbonded with a one-inch overlap joint. X-ray analysis was made of the weldbonded panels to confirm that high quality welds existed at the lap-joint. These panels were then primed and top coated using the same materials as used for the wedge test panels. Ten specimens were cut from each panel and the edges were machined smooth. These edges were left unprotected during the test.

Four control tests were conducted for each material combination shown in Table 1, in order to establish baseline lap-shear strengths. To provide the salt water environment, a slit was made in the bottom of a small, open plastic bottle so that the specimen could be pulled through the bottom of the bottle. The slit was then sealed which allowed the lap-joint to be immersed in a salt water solution. After the specimens were loaded in the constant load creep frame, a 3.5 percent salt water solution was poured into the bottle. This solution was replaced once a week during the 1,000 hour and 2,000 hour exposures. For the 1,000 hour exposure, the specimens were stressed at loads which were equal to 60 percent of the ultimate tensile strength of the lowest strength aluminum alloy used in the joint. For the 2,000 hour exposure, the specimens were stressed at loads which were equal to 48 percent of the ultimate tensile strength of the lowest strength aluminum alloy used in the joint. The relationships of the

constant load to the percent ultimate strength and to the percent yield strength, based on MIL-Hdbk-5 "A" values, for each material are as follows:

	FTU (psi)	FTY (psi)	Exposure Time (Hours)	Constant Load (lbs)	Percent FTU	Percent FTY
2024-T3 alclad	62,000	45,000	2,000	1,875	48	66
			1,000	2,380	61	84
2024-T3 bare	65,000	47,000	2,000	1,875	46	63
			1,000	2,380	58	80
7075-T6 bare	78,000	70,000	2,000	2,380	48	54
			1,000	3,000	61	68

After the CL/SWIT specimens completed the constant load-salt water immersion exposure, they were lap-shear tested to determine if there was any loss in strength or any corrosion attack at the joint. These lap-shear strength values were compared to the control lap-shear strength of unexposed specimens.

Surface Scratch Test

The third test, which was used to evaluate the general surface corrosion behavior of the three joining systems, was the surface scratch test. The test specimen is shown in Figure 2. Three-inch x 6-inch panels were used for this test. Half of the specimens were uncoated and half were primed and top coated as shown in Table 1. An "X" was scribed on the surfaces of these panels with a Stanley knife, as defined in ASTM standard D 1654, "Evaluation of Painted or Coated Specimens Subjected to Corrosive Environments." The test panels were exposed to 5 percent salt fog at 95F for 2,000 hours. Alodined control specimens for each of the alloys were also exposed. Periodically, the specimens were examined for evidence of corrosion at the scratch and on the surface.

SURFACE PREPARATION AND ADHESIVE APPLICATION

The aluminum surfaces were cleaned, deoxidized, and anodized, according to the process descriptions shown in Tables 2, 3, and 4. The type of adhesive and cure cycles used are also shown in these tables. The FPL process and the weldbond process were accomplished at Northrop, and the PABST test panels were surface treated and adhesively bonded at McDonnell Douglas at Long Beach, California. Scanning electron

microscope (SEM) analysis on bent specimens was used to determine the thickness of the oxide layer and to provide assurance that the proper surface treatment was achieved. The SEM samples were processed at the same time as the test panels. Typical anodized layers for each material are shown in Figures 3, 4, and 5 for all three surface treatments. The thicknesses of the oxide layers were within the range noted in Figure 1.

A mat adhesive and autoclave cure were used for the FPL and PABST system panels, and a paste adhesive and oven cure were used for the weldbond panels. With the paste adhesive, a 0.003-inch thick aluminum shim, Figure 2, extending 3/8-inch in from the sides of the 6-inch x 6-inch weldbond panels, was used to maintain a minimum bondline thickness of 0.005 inch. Ten pounds of lead weights were placed on each weldbond panel during the cure cycle to obtain a uniform bondline thickness.

Lots E and F of the paste adhesive A1444B (Reference 4), were used to prepare all the weldbond specimens. However, the wedge crack growth after only one month exposure at the sea coast was greater than 0.5 inch for three of the material combinations. An investigation was conducted which revealed that the adhesive for the weldbond test panels was undercured. Therefore, a second set of weldbond wedge panels was prepared using Lot J, A1444B. This delayed the initial exposure at the sea coast by two months for the weldbond specimens.

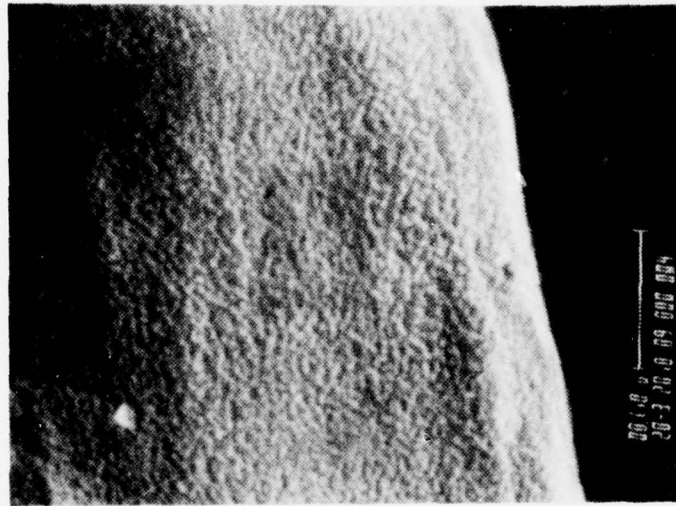
RESULTS AND DISCUSSION

Wedge Tests - Sea Coast

The average wedge crack growth for the sea coast exposure is presented in Figures 6, 7, 8, and 9 for the three bonding systems and the four material combinations. For all four material combinations, the wedge crack-growth rate was higher for the weldbond system than for the FPL bonding system and the PABST bonding system. However, the FPL system had a crack-growth rate very similar to the weldbond system with a delay time of only approximately one month to reach the same crack growth as the weldbond system. Therefore, although the relative ranking of durability shows the FPL system to be better than the weldbond system, from a practical point of view the two systems have essentially the same durability for a sea coast exposure with a crack-growth greater than 1 inch in three or four months for three of the four material combinations, and approximately 0.8-inch crack growth for 2024-T3 bare bonded to 2024-T3 bare after 10 months exposure. In contrast, the PABST bonding system showed essentially no crack growth (less than 0.04 inch) after a 12 month sea coast exposure

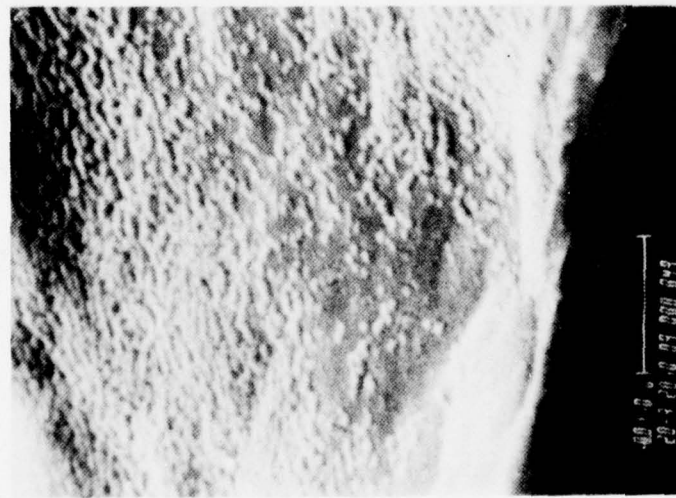


PABST SURFACE TREATMENT



WELDBOND SURFACE TREATMENT

MAGNIFICATION 20,000X

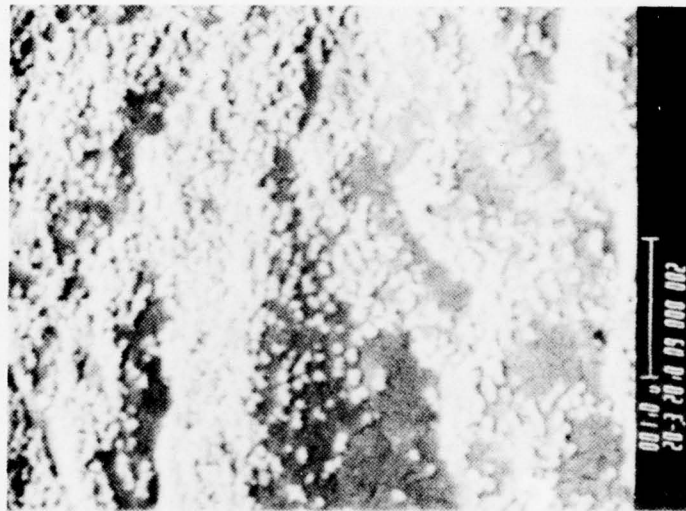


FPL SURFACE TREATMENT

FIGURE 3. TYPICAL ANODIZED LAYER ON 2024-T3 ALCLAD

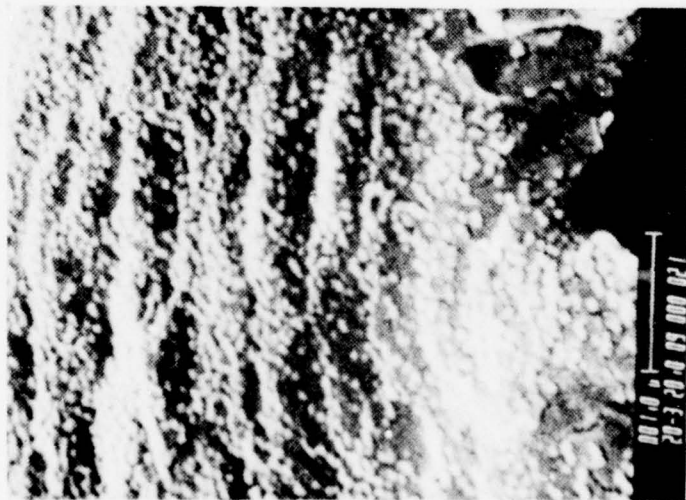


PABST SURFACE TREATMENT



WELDBOND SURFACE TREATMENT

MAGNIFICATION 20,000X



FPL SURFACE TREATMENT

FIGURE 4. TYPICAL ANODIZED LAYER ON 2024-T3 BARE

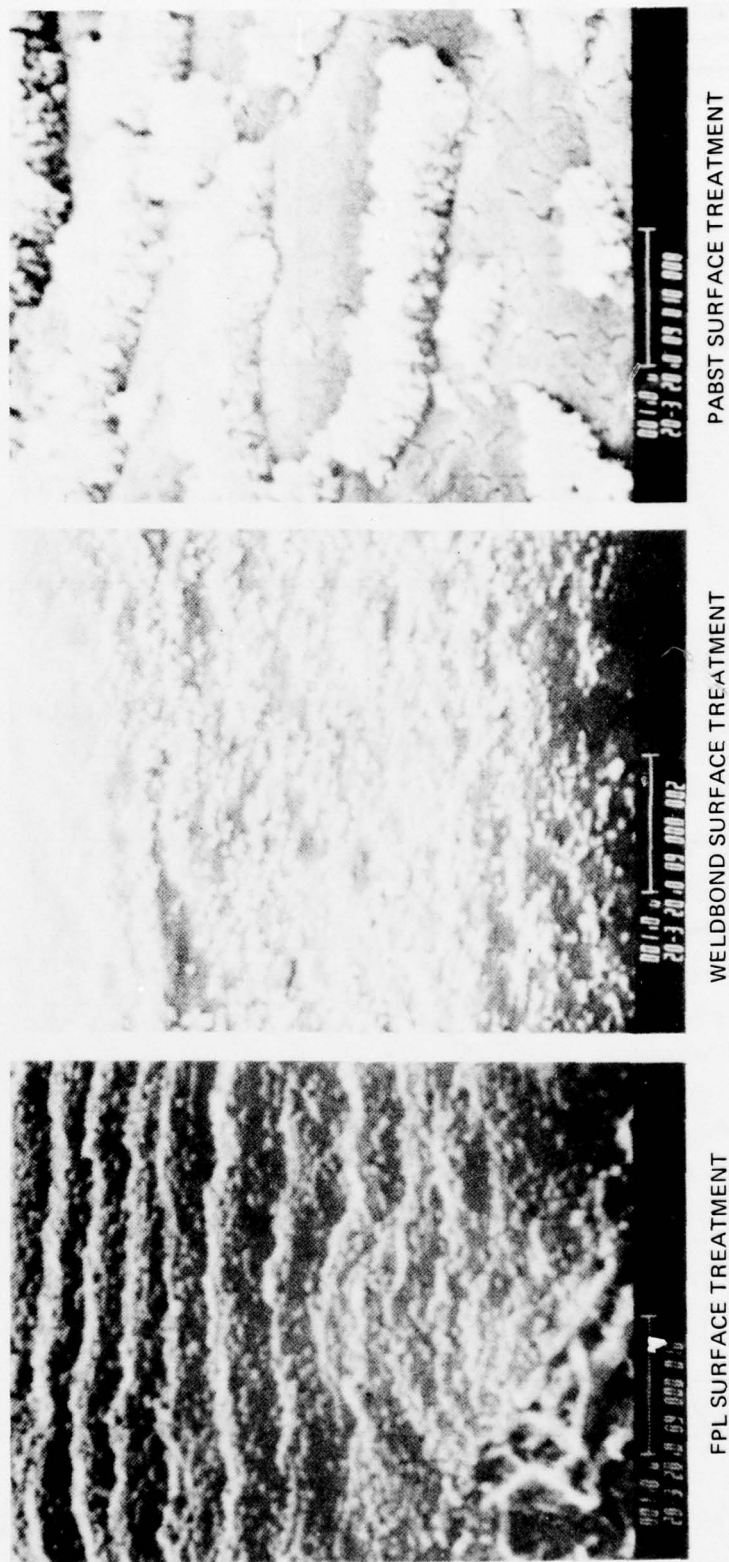


FIGURE 5. TYPICAL ANODIZED LAYER ON 7075-T6 BARE

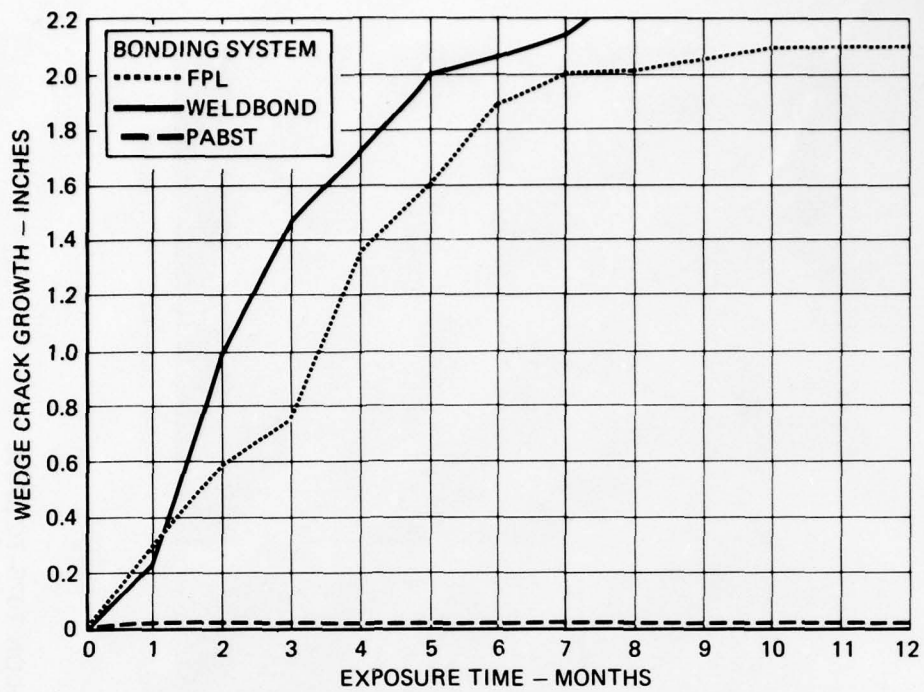


FIGURE 6. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 ALCLAD/7075-T6 BARE – SEA COAST EXPOSURE

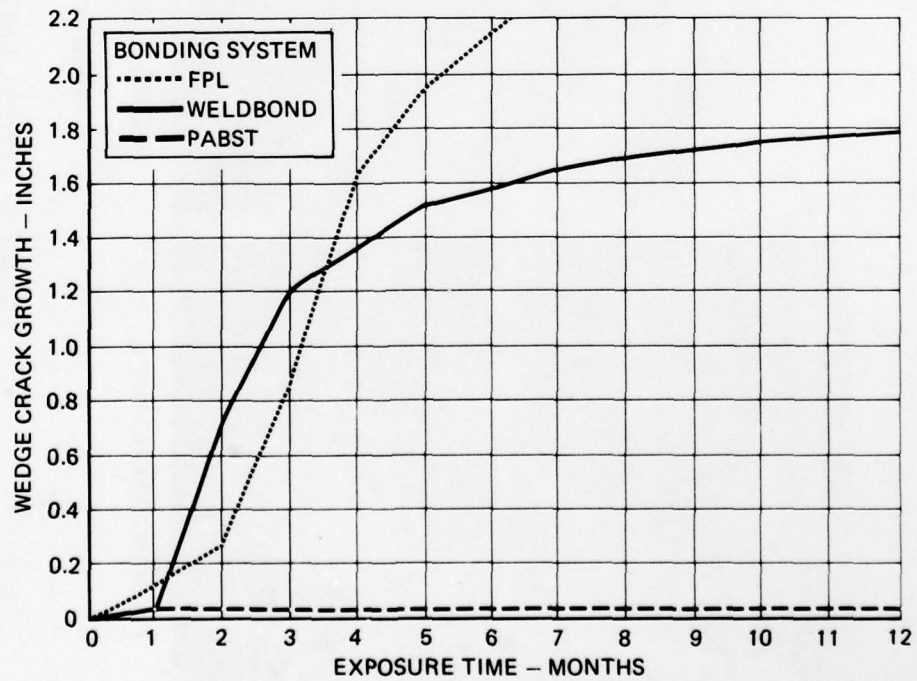


FIGURE 7. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 BARE/7075-T6 BARE – SEA COAST EXPOSURE

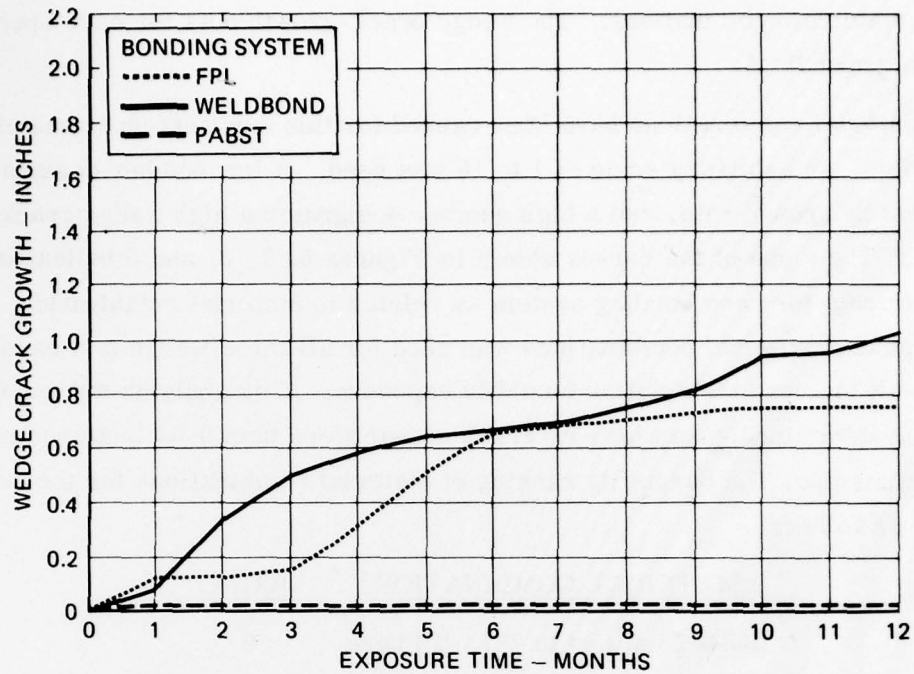


FIGURE 8. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 BARE/2024-T3 BARE - SEA COAST EXPOSURE

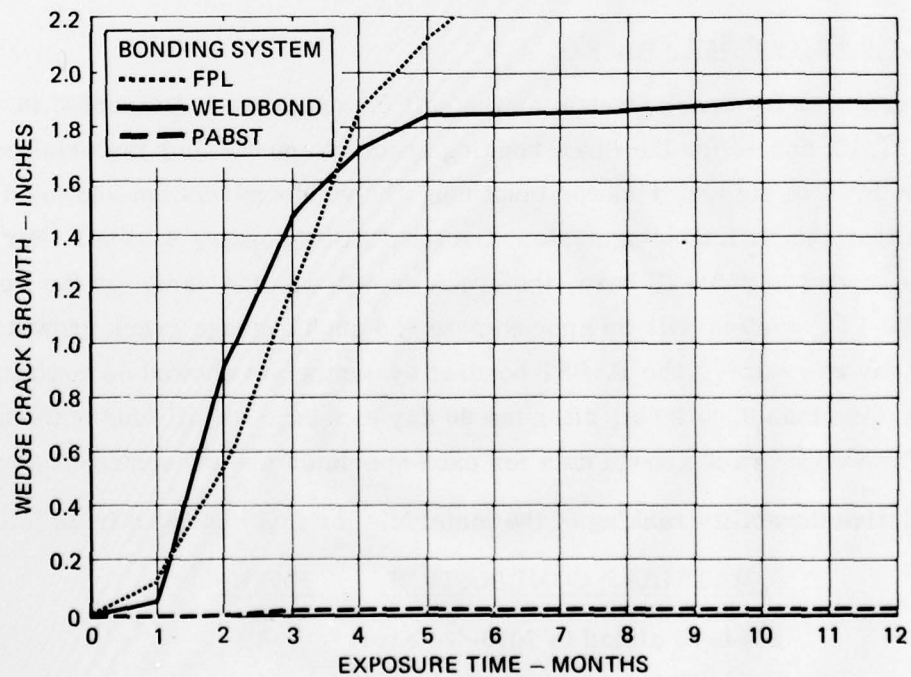


FIGURE 9. AVERAGE WEDGE CRACK GROWTH OF 7075-T6 BARE/7075-T6 BARE - SEA COAST EXPOSURE

for all four material combinations. The wedge crack-growth data for each specimen are presented in Appendix A.

The material combinations have been ranked for this exposure in terms of durability behavior. An arbitrary scale of 1 to 10 was used. A low number designates a low wedge crack-growth rate, and a high number designates a high wedge crack-growth rate. The slope of the curves shown in Figures 6, 7, 8, and 9 indicates the wedge crack-growth rate for each bonding system as related to material combination. This method of ranking material combinations was used for all three wedge test exposures, sea coast, salt fog, and the relative humidity exposure. This analysis did not include the PABST system since essentially no crack growth (less than 0.04 inch) occurred for these environments. The durability ranking of material combinations for the sea coast exposure is as follows:

<u>MATERIAL COMBINATION</u>	<u>RANK</u>
2024-T3 alclad to 7075-T6 bare	9
2024-T3 bare to 7075-T6 bare	8
2024-T3 bare to 2024-T3 bare	3
7075-T6 bare to 7075-T6 bare	10

Wedge Tests - 5 Percent Salt Fog, 95F

The average wedge crack growth for the salt fog exposure is presented in Figures 10, 11, 12, and 13 for the three bonding systems and the four material combinations. For three of the material combinations, the weldbond system showed a faster crack growth than the FPL bonding system and the PABST bonding system. For 2024-T3 bare bonded to 2024-T3 bare, the crack growth was the same for the weldbond system and the FPL system with an approximate 0.5-inch average crack growth at the end of the 90 day exposure. The PABST bonding system again showed essentially no crack growth (less than 0.03 inch), after the 90 day exposure for all four material combinations. The wedge crack growth data for each specimen are presented in Appendix A.

The relative durability ranking of the materials for this exposure is as follows:

<u>MATERIAL COMBINATION</u>	<u>RANK</u>
2024-T3 alclad to 7075-T6 bare	8
2024-T3 bare to 7075-T6 bare	5
2024-T3 bare to 2024-T3 bare	3
7075-T6 bare to 7075-T6 bare	4

A question arose as to which environment is more severe, the sea coast beach site or the salt fog exposure. An analysis of the wedge test data shows that the answer depends upon the bonding system, the material combination, and the exposure time. The severity of the sea coast exposure as compared to the severity of the salt fog exposure for a 90 day (or 3 month) time period is as follows:

BONDING SYSTEM	MATERIAL COMBINATION	MORE SEVERE
FPL	2024-T3 alclad/7075-T6 bare	Sea Coast
	2024-T3 bare/7075-T6 bare	Sea Coast
	2024-T3 bare/2024-T3 bare	Salt Fog
	7075-T6 bare/7075-T6 bare	Sea Coast
Weldbond	2024-T3 alclad/7075-T6 bare	Salt Fog
	2024-T3 bare/7075-T6 bare	Same
	2024-T3 bare/2024-T3 bare	Same
	7075-T6 bare/7075-T6 bare	Sea Coast

It can be seen from this analysis that the severity question is not easily answered. For the weldbond system, two material combinations showed the same wedge crack growth for both environments, one material combination showed less crack growth at the sea coast, and one material combination showed greater crack growth. However, for the FPL bonding system, three of the four material combinations showed greater crack-growth for the 90-day sea coast exposure than the 90-day salt fog exposure.

Although there is not a clear correlation between the sea coast and the salt fog exposure, the 90-day salt fog test is more easily reproduced and is more available to most companies, as an alternate to the sea coast exposure.

Wedge Tests - 95 to 100 Percent Relative Humidity, 120F

The average wedge crack growth for the 95 to 100 percent relative humidity exposure is shown in Figures 14, 15, 16, and 17 for the three bonding systems and the four material combinations. For all three bonding systems, the average wedge crack growth was less than 0.2 inch for the 60-day exposure and less than 0.4 inch for the 90-day exposure. Therefore, it is difficult to rank the three bonding systems or the

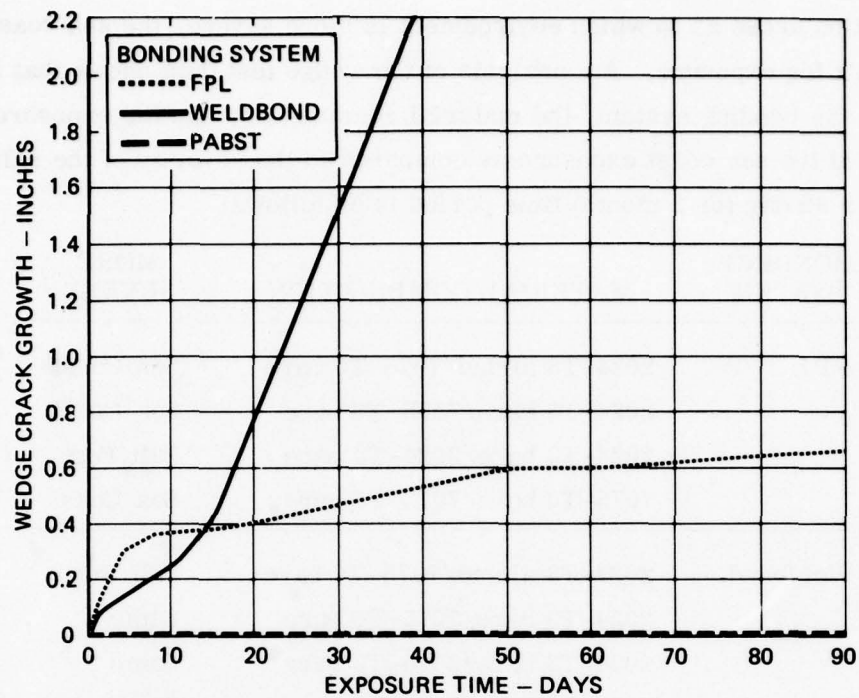


FIGURE 10. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 ALCLAD/7075-T6 BARE - SALT FOG EXPOSURE

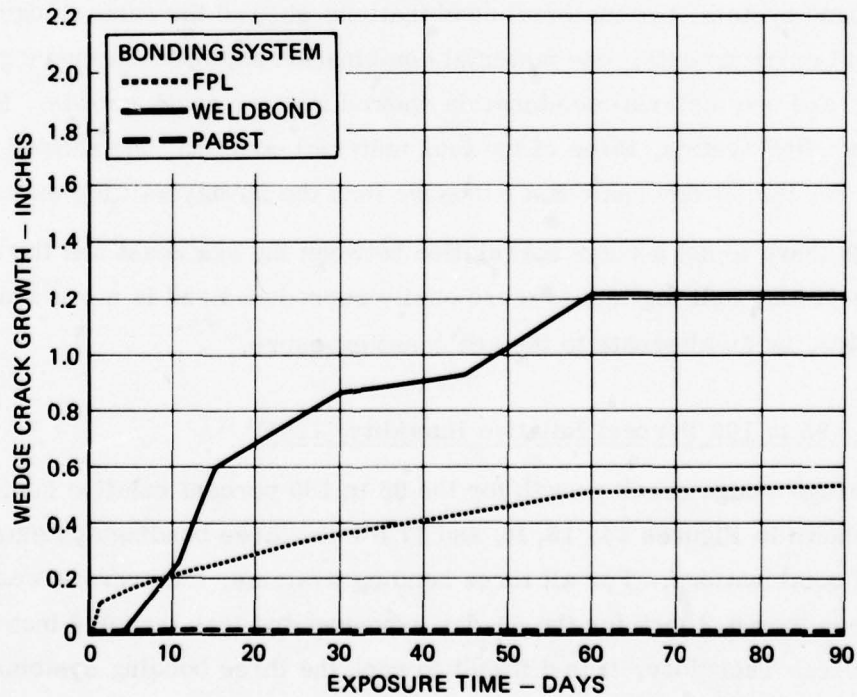


FIGURE 11. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 BARE/7075-T6 BARE - SALT FOG EXPOSURE

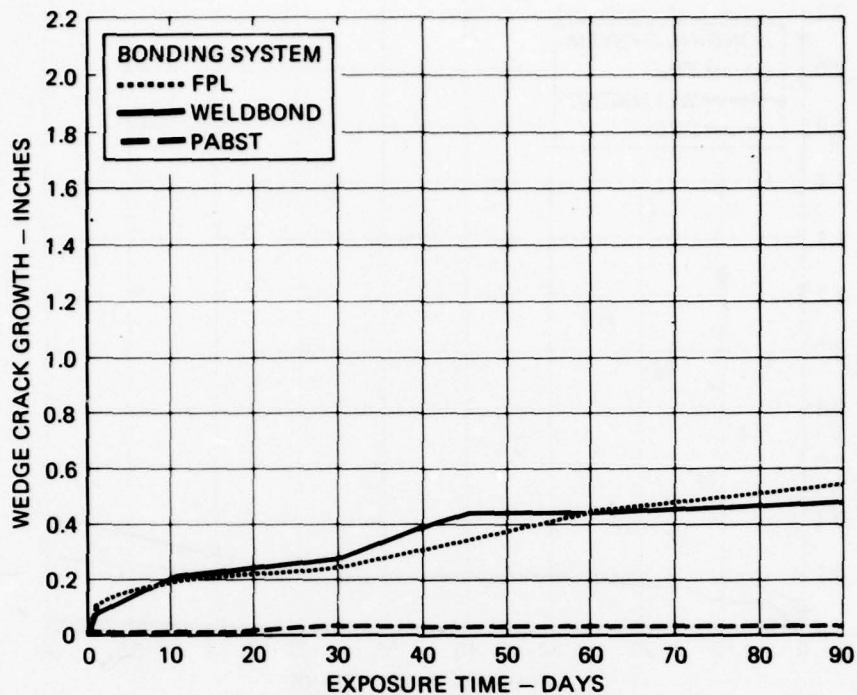


FIGURE 12. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 BARE/2024-T3 BARE - SALT FOG EXPOSURE

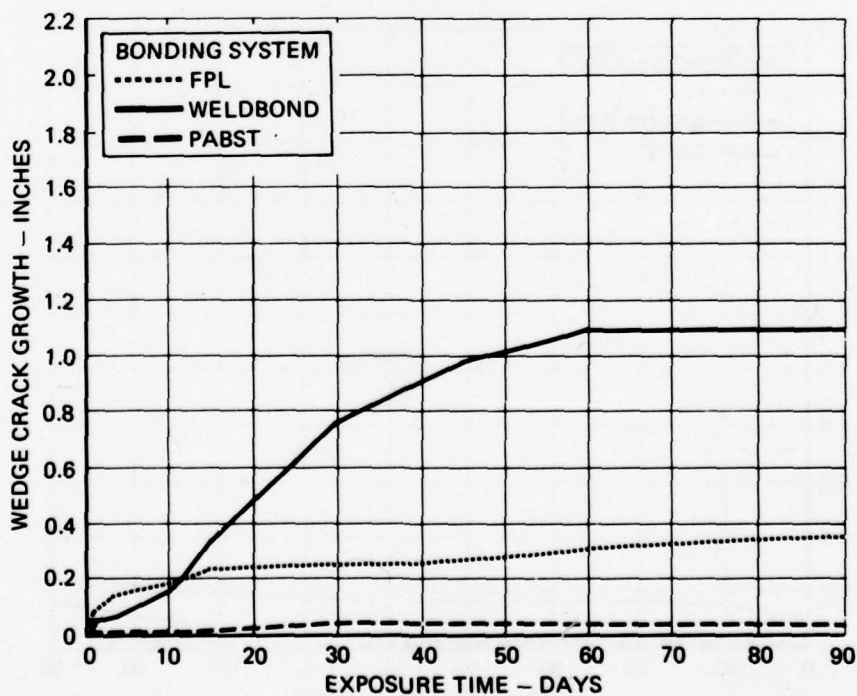


FIGURE 13. AVERAGE WEDGE CRACK GROWTH OF 7075-T6 BARE/7075-T6 BARE - SALT FOG EXPOSURE

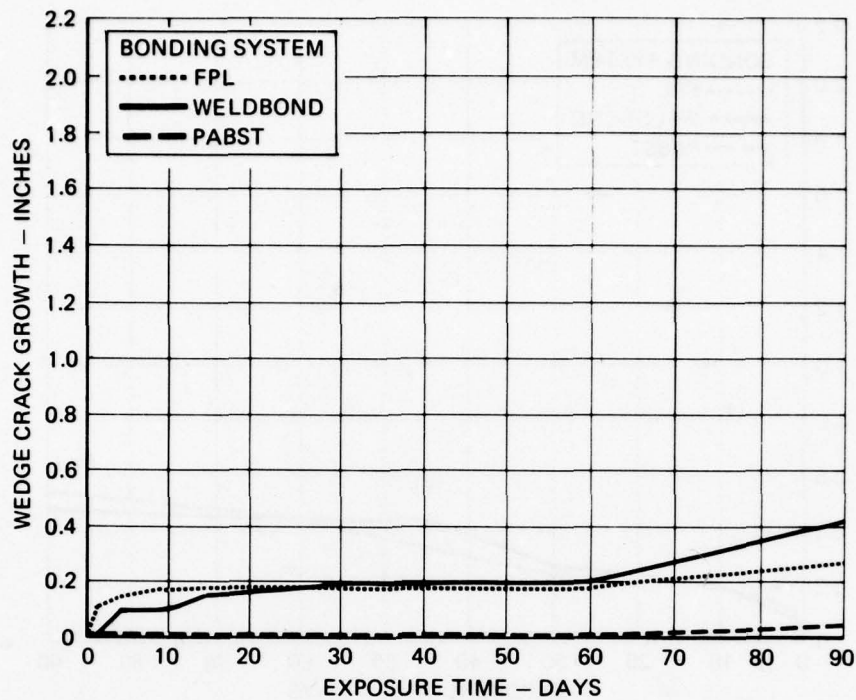


FIGURE 14. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 ALCLAD/7075-T6 BARE – 95-100 PERCENT RELATIVE HUMIDITY

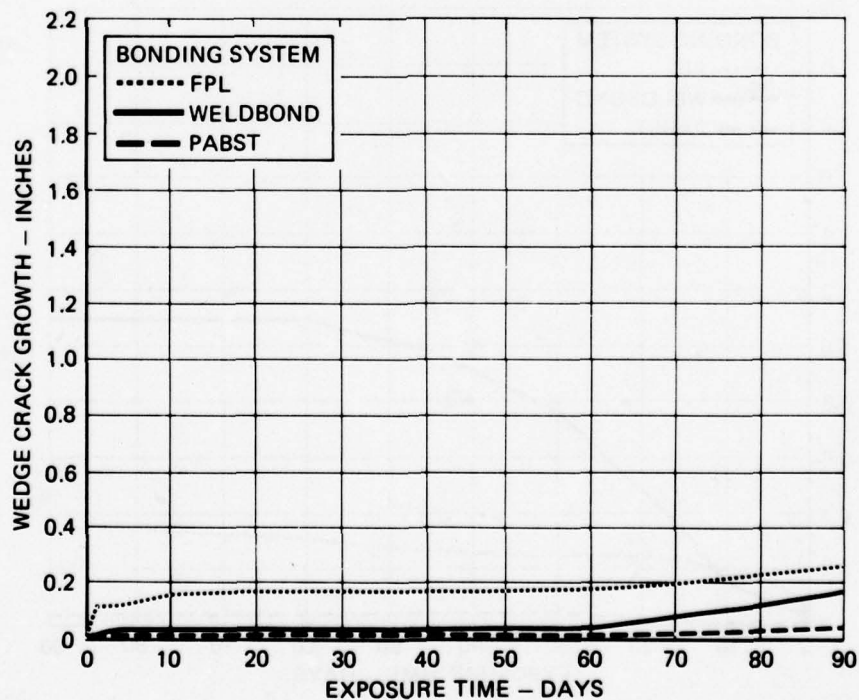


FIGURE 15. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 BARE/7075-T6 BARE – 95-100 PERCENT RELATIVE HUMIDITY

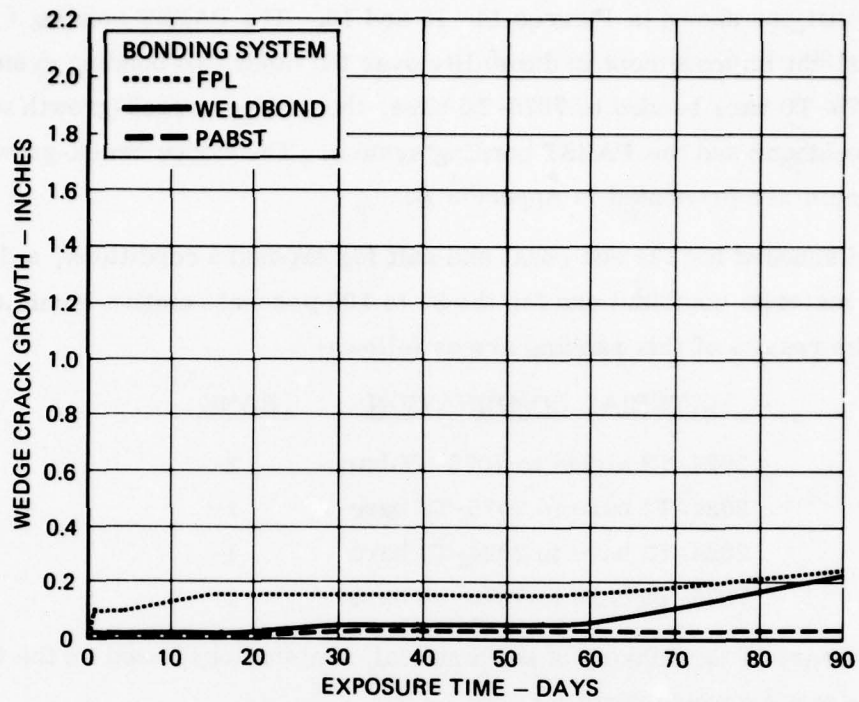


FIGURE 16. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 BARE/2024-T3 BARE - 95-100 PERCENT RELATIVE HUMIDITY

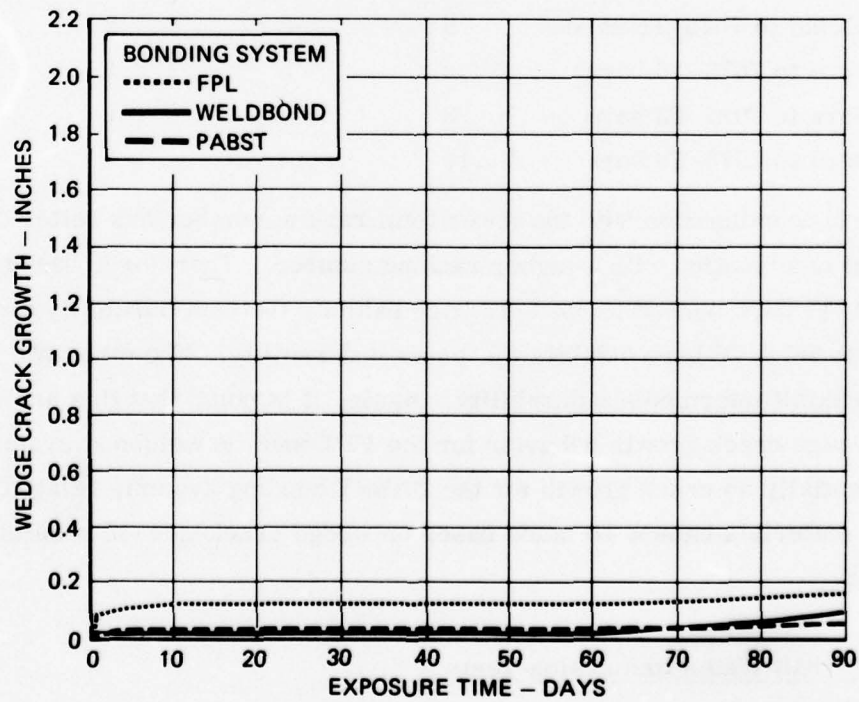


FIGURE 17. AVERAGE WEDGE CRACK GROWTH OF 7075-T6 BARE/7075-T6 BARE - 95-100 PERCENT RELATIVE HUMIDITY

material combinations shown in Figures 14, 15 and 16. The PABST bonding system had only very slight improvement in durability over the other two bonding systems. In fact, for 7075-T6 bare bonded to 7075-T6 bare, the average crack-growth was equal for the weldbond and the PABST bonding system. The wedge crack-growth data for each specimen are presented in Appendix A.

As was discussed for the sea coast and salt fog exposure conditions, a durability ranking of the material combinations for the 95 to 100 percent relative humidity exposure was made. The results of this ranking are as follows:

<u>MATERIAL COMBINATION</u>	<u>RANK</u>
2024-T3 alclad to 7075-T6 bare	2
2024-T3 bare to 7075-T6 bare	1
2024-T3 bare to 2024-T3 bare	1
7075-T6 bare to 7075-T6 bare	1

An overall summary of the ranking of the material combinations based on the three different wedge test exposure conditions is:

<u>Material Combination</u>	<u>Sea Coast</u>	<u>Salt Fog</u>	<u>Relative Humidity</u>	<u>Total</u>
2024-T3 alclad to 7075-T6 bare	9	8	2	19
2024-T3 bare to 7075-T6 bare	8	5	1	14
2024-T3 bare to 2024-T3 bare	3	3	1	7
7075-T6 bare to 7075-T6 bare	10	4	1	15

The material combination with the lower total ranking number has better durability than a material combination with a higher ranking number. Therefore, based on this analysis, 2024-T3 bare bonded to 2024-T3 bare exhibits the best durability and 2024-T3 alclad bonded to 7075-T6 bare exhibits the poorest durability. The other two material combinations exhibit intermediate durability. Again, it is noted that this analysis is based on the wedge crack growth behavior for the FPL and the weldbond systems. Since there was essentially no crack growth for the PABST bonding system, relative durability ranking of the materials cannot be made based on wedge crack-growth results for the PABST system.

Constant Load - Salt Water Immersion Tests

The results for the constant load-salt water immersion tests are shown in Tables 5, 6, and 7 for both the 1,000 hour and the 2,000-hour immersion in the 3.5

percent salt water under a constant load. The residual strength for the specimens tested after this exposure was greater than 96 percent of the control test strength values for all three bonding systems and all four material combinations except for one value of 94 percent obtained for the weldbond system for 7075-T6 bare weldbonded to 7075-T6 bare, under high load (1,000 hour) conditions. This average loss of 6 percent of the ultimate lap-shear strength is not considered significant, but for the purposes of this program the weldbond system was assigned a higher durability ranking number (poorer durability) than the other bonding systems. Also, the weldbond system had an unexplained premature failure after 615 hours for the 1,000 hour, 2024-T3/2024-T3 test series, which again earned this system a poorer durability ranking.

The lap-shear area was examined for corrosion attack after the residual strength tests were conducted. No evidence of corrosion attack was found for any of the lap-shear test specimens. Since there was no evidence of corrosion attack at the lap-joint interface and since there was no significant loss in residual lap-shear strength, the relative durability ranking of the material combinations cannot be made for this test series.

Surface Scratch Test

The results for the surface scratch tests are shown in Table 8, for the three bonding surface treatments and three materials. The objective of this test was to determine if the surface treatment used for each of the three joining systems would pass the 2,000 hour salt fog exposure if a scratch were made through the standard coating of MIL-P-23377 epoxy polyamide primer and MIL-C-81773 polyurethane top coat. All three surface treatments when coated with the standard primer and top coat passed the 2,000 hour exposure to the 5 percent salt fog at 95F. No evidence of surface corrosion or corrosion at the scratch was found on these panels. Therefore, all three surface treatments and three materials were rated equal for this series of surface corrosion tests.

In addition to the coated panels, uncoated panels were also exposed for 2,000 hours. The results of this exposure for uncoated panels is also shown in Table 8. As expected, panels prepared by the PABST method showed no evidence of corrosion; panels prepared by the FPL method showed slight corrosion; and panels prepared by the weldbond method showed moderate to severe corrosion. As seen in Figure 1, the PABST surface treatment prior to adhesive application produces an aluminum surface with a thick oxide layer on which a protective primer, BR-127, is applied. The FPL

**TABLE 5. CONSTANT LOAD/SALT WATER IMMERSION TEST RESULTS
FOR THE FPL SYSTEM**

	2024-T3 CLAD TO 7075-T6 BARE		2024-T3 BARE TO 7075-T6 BARE		2024-T3 BARE TO 2024-T3 BARE		7075-T6 BARE TO 7075-T6 BARE	
CONTROL STRENGTH (LBS)	A11	3650	B11	3700	C11	3850	D11	5150
	A12	3700	B12	3650	C12	3800	D12	4950
	A7	3650	B7	3750	C7	3750	D7	5100
	A8	3700	B8	3700	C8	3800	D8	5150
AVERAGE		3675		3700		3800		5088
1000 HOUR DATA: LOAD (LBS)		2380		2380		2380		3000
RESIDUAL STRENGTH (LBS)	A1	3850	B1	3650	C2	3700	D1	4800
	A2	3850	B2	3800	C3	3800	D2	5000
	A3	3700	B3	3750	C4	3750	D3	5050
AVERAGE		3800		3730		3750		4950
PERCENT LOSS		NONE		NONE		1.3%		2.7%
2000 HOUR DATA: LOAD (LBS)		1875		1875		1875		2380
RESIDUAL STRENGTH (LBS)	A4	3650	B4	3700	C1	3600	D4	5100
	A5	3700	B5	3700	C5	3650	D5	4850
	A6	3650	B6	3650	C6	3700	D6	4950
AVERAGE		3665		3680		3650		4970
PERCENT LOSS		NONE		NONE		3.9%		2.3%
FAILURE MODE		100% COHESIVE		100% COHESIVE		100% COHESIVE		100% COHESIVE

TABLE 6. CONSTANT LOAD/SALT WATER IMMERSION TEST RESULTS FOR THE WELDBOND SYSTEM

	2024-T3 CLAD TO 7075-T6 BARE	2024-T3 BARE TO 7075-T6 BARE	2024-T3 BARE TO 2024-T3 BARE	7075-T6 BARE TO 7075-T6 BARE
CONTROL STRENGTH (LBS)	E9 4000 E3 4000 E7 4000	F5 3900 F8 3800 F1 4000 F3 3900	G1 3800 G9 3750 G8 3900 G10 3800	H1 5200 H9 5150 H2 5200 H10 5200
AVERAGE	4000	3900	3815	5190
1000 HOUR DATA: LOAD (LBS)	2380	2380	2380	3000
RESIDUAL STRENGTH (LBS)	E4 3700 E5 3900 E6 4100	F7 3850 F8 3800 F10 3900	G5 3750 G6 3800 G7 (1)	H6 4800 H7 4700 H8 5000
AVERAGE	3900	3850	3775	4830
PERCENT LOSS	2.5%	1.3%	1.0%	5.9%
2000 HOUR DATA: LOAD (LBS)	1875	1875	1875	2380
RESIDUAL STRENGTH (LBS)	E1 3900 E2 4100 E8 4150	F2 3900 F4 3850 F6 3900	G2 4050 G3 3900 G4 3550	H3 5100 H4 5050 H5 5000
AVERAGE	4050	3880	3830	5050
PERCENT LOSS	NONE	0.5%	NONE	2.7%
FAILURE MODE	60 TO 70% COHESIVE	60 TO 80% COHESIVE	60 TO 90% COHESIVE	80 TO 95% COHESIVE

(1) FAILED IN 615 HOURS Not included in average.

TABLE 7. CONSTANT LOAD/SALT WATER IMMERSION TEST RESULTS FOR THE PABST SYSTEM

	2024-T3 CLAD TO 7075-T6 BARE	2024-T3 BARE TO 7075-T6 BARE	2024-T3 BARE TO 2024-T3 BARE	7075-T6 BARE TO 7075-T6 BARE
CONTROL STRENGTH (LBS)	I11 4150 I12 3750 I7 4000 I8 3950	J1 3950 J10 4000 J8 3950 J9 4000	K1 3700 K11 3750 K8 3850 K9 3850	L10 5200 L11 5250 L7 5100 L8 5150
AVERAGE	3962	3975	3787	5175
1000 HOUR DATA: LOAD (LBS)	2380	2380	2380	3000
RESIDUAL STRENGTH (LBS)	I1 4100 I2 4050 I3 4000	J5 4050 J6 4050 J7 4050	K5 3950 K6 3850 K7 3950	L1 5200 L2 5200 L3 5100
AVERAGE	4050	4050	3915	5165
PERCENT LOSS	NONE	NONE	NONE	NONE
2000 HOUR DATA: LOAD (LBS)	1875	1875	1875	2380
RESIDUAL STRENGTH (LBS)	I4 3900 I5 4000 I6 4100	J2 4000 J3 4050 J4 4050	K2 3850 K3 3900 K4 3850	L4 5050 L5 5100 L6 5000
AVERAGE	4000	4035	3865	5050
PERCENT LOSS	NONE	NONE	NONE	2.4%
FAILURE MODE	100% COHESIVE	100% COHESIVE	100% COHESIVE	100% COHESIVE

TABLE 8. SURFACE SCRATCH TEST RESULTS

EXPOSURE: 5 PERCENT SALT FOG AT 95F, ASTM B 117

CORROSION RESULT CODE: O – NO CHANGE
S – SLIGHT CORROSION
M – MODERATE CORROSION
X – SEVERE CORROSION

JOINING SYSTEM	MATERIAL	CORROSION RESULTS FOR EXPOSURE (HOURS)				
		72	500	1000	1500	2000
FPL	2024-T3 ALCLAD – COATED*	O	O	O	O	O
	– UNCOATED	O	O	O	S	S
	2024-T3 BARE – COATED*	O	O	O	O	O
	– UNCOATED	O	O	O	O	S
	7075-T6 BARE – COATED*	O	O	O	O	O
	– UNCOATED	O	O	S	S	S
WELDBOND	2024-T3 ALCLAD – COATED*	O	O	O	O	O
	– UNCOATED	S	S	M	M	M
	2024-T3 BARE – COATED*	O	O	O	O	O
	– UNCOATED	X	X	X	X	X
	7075-T6 BARE – COATED*	O	O	O	O	O
	– UNCOATED	X	X	X	X	X
PABST	2024-T3 ALCLAD – COATED*	O	O	O	O	O
	– UNCOATED	O	O	O	O	O
	2024-T3 BARE – COATED*	O	O	O	O	O
	– UNCOATED	O	O	O	O	O
	7075-T6 BARE – COATED*	O	O	O	O	O
	– UNCOATED	O	O	O	O	O
ALODINE CONTROL PANELS	2024-T3 ALCLAD	O	O	O	O	O
	2024-T3 BARE	O	O	O	O	O
	7075-T6 BARE	O	O	O	O	O

*COATED SPECIMENS WERE PRIMED WITH MIL-P-23377 EPOXY POLYAMIDE PRIMER AND TOP COATED WITH MIL-C-81773 POLYURETHANE PAINT

surface treatment produces a thin oxide layer but also includes a layer of protective primer, BR-127. On the other hand, the weldbond surface preparation was developed with a thin oxide layer and no protective primer so that resistance spot welds could easily be made. The intent of the weldbond surface preparation was to enable resistance spot welds to be made and to allow the durable paste adhesive, A1444B, to seal and protect the weldbond interface. The weldbond surface preparation alone will not provide sufficient corrosion protection for exterior aluminum surfaces. However, if the surface is primed or primed and painted, it can be expected to perform similar to the PABST and FPL panels.

Durability Ranking of Three Joining Systems

An analysis was made of all the durability tests conducted for the two adhesive bonding systems and the weldbond system. A summary of this analysis is presented in Table 9. The joining system which had the best durability for a specific test series and material combination was ranked as number 1, the second best was ranked as number 2, and the third best was ranked as number 3. The ranking numbers were totaled for each joining system. Therefore, the system having the lowest sum total had the best durability for the tests conducted for this program. The final ranking of the three joining systems in terms of decreasing durability is: PABST, FPL and weldbonding. As discussed in the results section for the surface scratch tests, this ranking is not surprising since both the PABST and FPL surface treatments prior to adhesive bonding include the addition of a protective coat of primer, BR-127, and the PABST system has the added advantage of a thick oxide layer.

Based on the results of the constant load-salt water immersion tests, the durability of the three joining systems is equal. Therefore, the durability ranking noted above was based on the results of the wedge tests. However, it is difficult to correlate the stress that is created in a wedge-test specimen to the stress that would occur in actual aircraft panels. Also, the wedge test does not evaluate completely the durability of the weldbond system since spot welding, which is an integral part of the weldbond joining system, is not used in the preparation of the standard wedge-test specimen. In order to have commonality for the wedge-test comparisons, the wedge-test specimens for the weldbond system were not welded. Data for wedge specimens which were welded are presented in the next section of this report. In summary, the wedge test provided a good method for evaluating the durability of adhesive bonding systems but not necessarily that of the complete weldbond system.

TABLE 9. DURABILITY RANKING OF THREE JOINING SYSTEMS

TYPE OF TEST	EXPOSURE CONDITIONS	MATERIAL (1)	FPL ETCH	WELDBOND	PABST
WEDGE	95-100% RELATIVE HUMIDITY AT 120F FOR 90 DAYS	24C-75B	2	2	1
		24B-75B	2	2	1
		24B-24B	2	2	1
		75B-75B	2	1	1
WEDGE	5% SALT FOG AT 95F FOR 90 DAYS	24C-75B	2	3	1
		24B-75B	2	3	1
		24B-24B	2	2	1
		75B-75B	2	3	1
WEDGE	SEA COAST, EL SEGUNDO, CALIF FOR 12 MONTHS	24C-75B	2	3	1
		24B-75B	2	3	1
		24B-24B	2	3	1
		75B-75B	2	3	1
CONSTANT LOAD SALT WATER IMMERSION	3.5% SALT WATER EXPOSURE FOR 2000 HOURS	24C-75B	1	1	1
		24B-75B	1	1	1
		24B-24B	1	1	1
		75B-75B	1	1	1
CONSTANT LOAD SALT WATER IMMERSION	3.5% SALT WATER EXPOSURE FOR 1000 HOURS	24C-75B	1	1	1
		24B-75B	1	1	1
		24B-24B	1	2	1
		75B-75B	1	2	1
SURFACE SCRATCH PANEL (2)	5% SALT FOG AT 95F FOR 2000 HOURS	ALL	1	1	1
	TOTAL		33	41	21

(1) 24C = 2024-T3 alclad; 24B = 2024-T3 bare; 75B = 7075-T6 bare.

(2) These surface scratch panels were primed with MIL-P-23377 epoxy polyamide primer and top coated with MIL-C-81773 polyurethane paint. This test is used to indicate surface corrosion behavior of the materials used in the three joining systems.

WELDBOND DURABILITY IMPROVEMENT STUDY (An Independent Northrop Program)

The object of the addendum to the weldbond program was to compare the durability of the FPL and PABST adhesive bonding system with that of the weldbond system. Concurrent with this effort, a separate Northrop IRAD program was conducted to determine if a spray coat of BR-127 primer on the weldbond surface would improve the durability of this joining method and still result in a surface that could be spot welded using the standard weld parameters that had been established during the weldbond program.

This separate effort was conducted in three phases. The first phase was to establish what thickness of BR-127 primer could be welded in the uncured state using standard weldbond weld parameters. The second phase was to determine if this weldable layer of BR-127 did improve the durability of the weldbond system. If the durability were improved, then a third phase was planned to show the effects of the BR-127 on the weldbond properties. A test matrix for the last two phases is shown in Table 10.

The material combination, 2024-T3 alclad bonded to 7075-T6, was selected for the durability evaluation since this combination was more susceptible to wedge crack growth than the other three material combinations tested during the weldbond addendum program. Wedge tests were conducted for two different exposures: 95F salt fog and the sea coast. Lap-shear tests were conducted at room temperature and -65F using 7075-T6 weldbonded to 7075-T6. High-load transfer fatigue tests and T-peel tests were also conducted using 7075-T6.

Weldability Evaluation

The first phase, weldability evaluation, revealed that resistance spot welds could easily be made through BR-127 primer if the primer thickness was 0.00004 inch, and the primer was air dried, not fully cured. Welds made on panels with a primer thickness of 0.00008 inch were inconsistent in quality, and panels with a primer thickness of 0.00015 inch could not be welded using the standard weldbond weld parameters. The standard thickness for BR-127 primer is 0.00015 to 0.00030 inch. Based on the results of the weldability study, the test specimens for this investigation were prepared using a very thin, 0.00004-inch coat of BR-127 primer. The aluminum sheet was cleaned and anodized according to the standard weldbond procedures. Then the primer was applied as a 1/2 box spray coat to match the color tone of prior samples of known primer thickness. Quality control panels were sprayed at the same time as the test panels. The thickness of the primer on these control panels after curing was found to be

0.00004 inch. Primer thickness was measured using a Fischer Permascope (eddy current system) which has an accuracy of 0.00003 inch (2 percent full scale). The primer was allowed to air dry for a minimum of 30 minutes before applying the adhesive. Paste adhesive A1444B, Lot K, was used for these test panels. The primer was co-cured with the adhesive at 250-260F for 2 hours.

Wedge Test Durability Results

The second phase, durability evaluation, revealed that a very thin (0.00004-inch) layer of BR-127 primer, co-cured with the adhesive, was sufficient to improve the durability of the weldbond system to the extent that it almost equals the durability of the PABST adhesive bonding system. The durability of the weldbond system with the BR-127 primer exposed to 95F salt fog shows an average wedge crack growth of less than 0.20 inch in 90 days compared to more than 1.0-inch crack growth in less than 25 days for the weldbond system without the BR-127 primer, Figure 18. These wedge tests for the weldbond/BR-127 system, still in progress, show an average wedge crack growth of less than 0.20 inch even after 214 days (7 months). Also the durability of the weldbond/BR-127 system is much better than the FPL adhesive system.

The results of the sea coast wedge tests are shown in Figure 19. For this exposure condition, the durability of the weldbond/BR-127 system is essentially equal to the durability of the PABST system after 5 months exposure, i. e., average wedge crack growth of 0.04 and 0.01 inch respectively. A crack growth less than 0.05 inch is considered to be negligible. The degree of improvement for the weldbond/BR-127 system is tremendous when compared to the 2.0-inch crack growth for the unprimed weldbond system and the 1.60-inch crack growth of the FPL bonding system for the same 5 month exposure time.

Weldbond Properties With and Without BR-127 Primer

For the third phase, lap-shear, T-peel and high-load transfer fatigue tests were conducted on panels which had been surface treated with and without the addition of the BR-127 primer, to determine if the primer would degrade the weldbond properties.

Lap-Shear Strength. Lap-shear specimens were weldbonded using 0.063-inch thick sheets of 7075-T6 bare. The lap-shear specimens were 1-inch wide with a 1-inch overlap. Tests were conducted at room temperature and -65F. The results are presented in Table 11. The lap-shear strength was almost equivalent for primed

TABLE 10. TEST MATRIX FOR WELDBOND/BR-127 EVALUATION

		NUMBER OF SPECIMENS	
		WITH BR-127	WITHOUT BR-127
DURABILITY WEDGE TESTS 2024-T3 ALCLAD TO 7075-T6	95F SALT FOG	5	6*
	SEA COAST	10	12*
WELDBOND PROPERTY TESTS 7075-T6 TO 7075-T6			
LAP-SHEAR	ROOM TEMPERATURE	5	5
	-65F	5	5
T-PEEL	ASTM D1876	6	6
FATIGUE	HIGH-LOAD TRANSFER	8	5*

*Data obtained from AFML-TR-79-4006 (Reference 4)

**TABLE 11. LAP-SHEAR STRENGTH FOR PRIMED
AND UNPRIMED WELDBONDED 7075-T6**

TEST TEMPERATURE	LAP SHEAR STRENGTH (PSI)	
	WITH BR-127	WITHOUT BR-127
ROOM TEMPERATURE	4920	4740
	4640	4990
	4540	4700
	4690	4800
	4690	4740
	AVERAGE	4700
-65F	3480	3640
	3670	4000
	4160	4330
	4060	3990
	2680	3310
	AVERAGE	3610

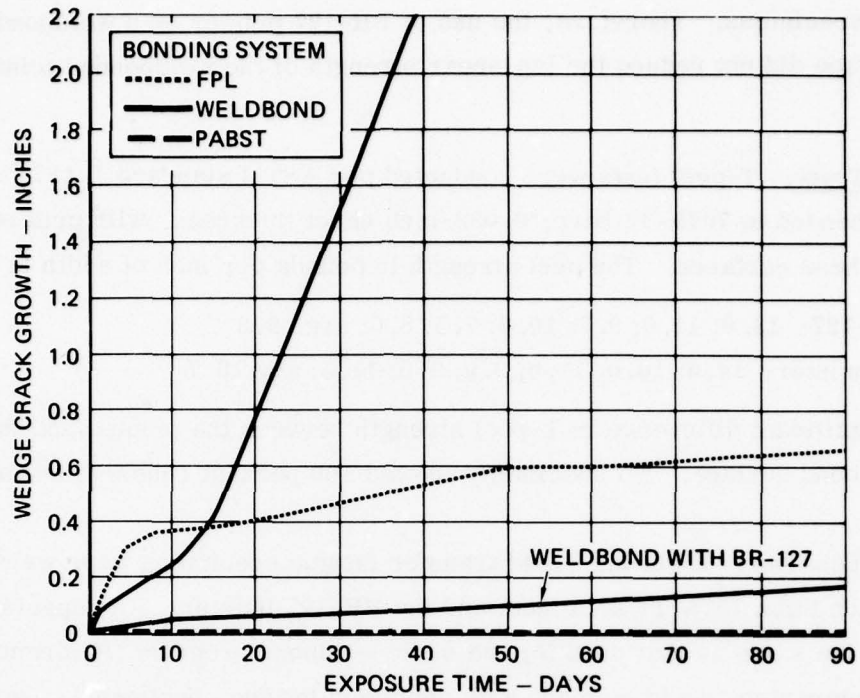


FIGURE 18. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 ALCLAD/7075-T6 BARE INCLUDING WELDBOND/BR-127 — SALT FOG EXPOSURE

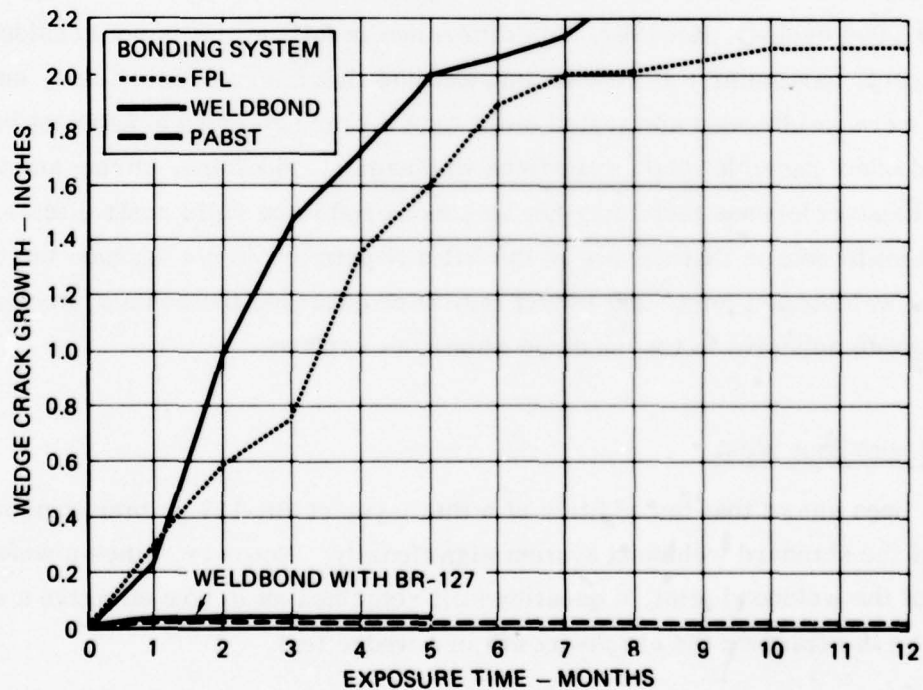


FIGURE 19. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 ALCLAD/7075-T6 BARE INCLUDING WELDBOND/BR-127 — SEA COAST EXPOSURE

and unprimed specimens. Therefore, the use of BR-127 primer on a weldbond prepared aluminum surface did not reduce the lap-shear strength of the weldbonded joint.

T-Peel Tests. T-peel tests were conducted per ASTM standard D 1876 using 7075-T6 bare bonded to 7075-T6 bare, 0.032-inch sheet thickness, with primed and unprimed weldbond surfaces. The peel strength in pounds per inch of width is as follows:

with BR-127: 13.0; 11.0; 9.5; 10.0; 7.5; 8.0; avg. 9.8

without primer: 14.0; 10.0; 11.0; 9.0; 9.0; 11.5; avg 10.7

There is no significant difference in T-peel strength between the primed and the unprimed weldbond surface. All specimens showed 100 percent cohesive failure.

Fatigue Behavior. Eight high-load transfer fatigue specimens were weldbonded using 0.063-inch thick 7075-T6 aluminum and the BR-127 primer. The specimen configuration was the same as that used for the basic weldbond program (Reference 4) so that a direct comparison could be made with unprimed fatigue specimens. Lap joint dimensions were 1.25 inches wide x 1.25 inches overlap and a single spot weld was used. The fatigue results are shown in Table 12. The average fatigue life for the primed specimens was higher than that of the unprimed specimens, i.e., 328,000 cycles vs 197,000 cycles. However, this difference in fatigue life is not considered to be significant, particularly if we take into account that the reference tests, unprimed specimens, were weldbonded and tested more than a year ago using a different batch of adhesive and other possible slight variations in cleaning, anodizing, curing and testing. Therefore, these reference tests may not be considered to be valid control tests. The important point to note is that the use of the BR-127 primer did not degrade the fatigue behavior of a weldbonded joint, and in fact may have enhanced the bonding strength of the A1444B paste adhesive to the anodized aluminum surface.

Wedge Test with Spot Weld

It has been shown that the addition of a thin layer of BR-127 primer improved the durability of the standard weldbond system significantly. However, since a weld nugget is part of the weldbond joint, a question still remained as to how effective a spot weld would be in retarding the crack-growth in a wedge test.

Five wedge specimens were fabricated using the standard weldbond surface preparation and paste adhesive A1444B with 2024-T3 alclad and 7075-T6 bare. Spot

**TABLE 12. HIGH-LOAD TRANSFER FATIGUE BEHAVIOR FOR PRIMED
AND UNPRIMED WELDBONDED 7075-T6**

R: 0.1
FREQUENCY: 10 HZ
MAXIMUM LOAD: 2,250 LBS.

PRIMED SPECIMENS	FATIGUE LIFE (CYCLES)	NUGGET DIAMETER MAX/MIN (INCH)
1	350,510	0.25/0.25
2	398,240	0.31/0.29
3	446,530	0.35/0.32
4	332,950	0.32/0.32
5	394,810	0.34/0.30
6	256,320	0.32/0.30
7	186,200	0.37/0.31
8	256,090	0.31/0.27
AVERAGE	327,706	
UNPRIMED SPECIMENS (1)	FATIGUE LIFE (CYCLES)	NUGGET DIAMETER (INCH)
1	130,970	0.28
2	133,670	0.34
3	187,780	0.31
4	235,230	0.32
5	296,120	0.30
AVERAGE	196,754	

(1) Data obtained from AFML-TR-79-4006 (Reference 4)

welds were centered 3 inches from the end of the 6-inch specimen as shown in Figure 20. The average initial crack length was 2.25 inches, therefore, the edge of the spot weld nugget was approximately 0.5 inch from the initial crack tip created by the wedge. These specimens were exposed to the 5 percent salt fog environment.

The results of these wedge tests are shown in Figure 20 along with the wedge test results for the standard weldbond system, the weldbond system with BR-127, and the PABST system for comparison purposes. After 13 days the crack had progressed up to the edge of the weld nugget, i. e., 0.52 inch. After 183 days (6 months) the crack progressed only a small additional amount to 0.60 inch. The spot weld restrained the wedge crack-growth for at least six months of exposure to the salt fog after the crack tip reached the nugget. Therefore, the weldbond system, which utilizes spot welds is very effective in retarding crack-growth that might occur along the adhesive bonded joint with the standard weldbond surface preparation.

Conclusions for the Weldbond Durability Improvement Study

1. The environmental-stress durability of the weldbond system in both the 95F salt fog and the sea coast environment is significantly improved by the addition of a thin (0.00004-inch) layer of BR-127 primer to the anodized surface.
2. The addition of a thin layer of BR-127 primer to the standard weldbond surface preparation does not reduce lap-shear strength, T-peel strength, or high-load transfer fatigue life for weldbonded panels.
3. High quality welds can easily be made through a thin (0.00004-inch) layer of air dried BR-127 primer added to the standard weldbond surface treatment.
4. Spot welds in weldbond wedge specimens are effective in retarding crack growth in a stress-corrosion environment.

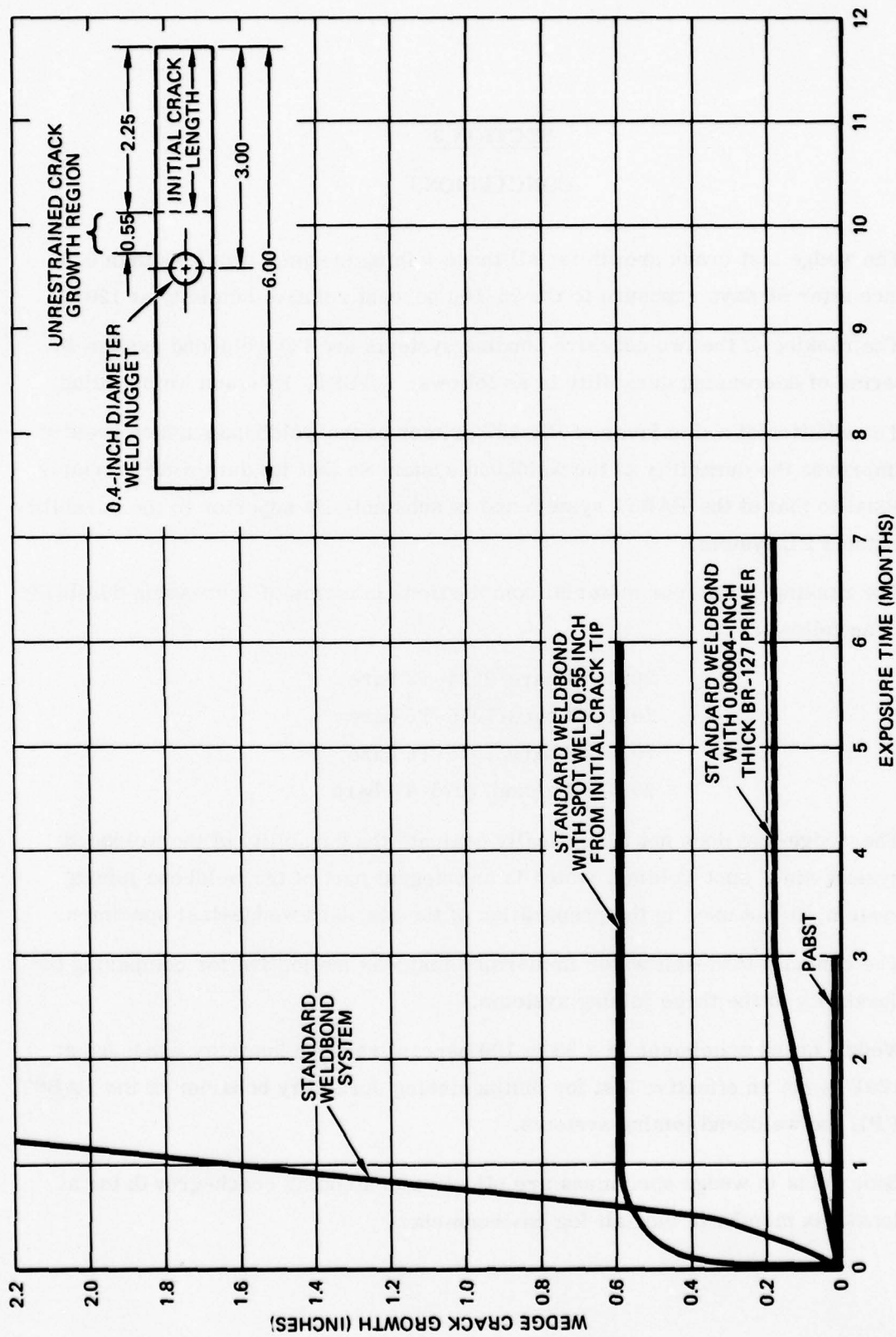


FIGURE 20. AVERAGE WEDGE CRACK GROWTH OF 2024-T3 ALCLAD/7075-T6 BARE WELDBOND WITH SPOT WELD - SALT FOG EXPOSURE

SECTION 3

CONCLUSIONS

1. The wedge test crack growth for all three joining systems was less than 0.5 inch after 90 days exposure to the 95-100 percent relative humidity at 120F.
2. The ranking of the two adhesive bonding systems and the weldbond system in terms of decreasing durability is as follows: PABST, FPL and weldbonding.
3. The addition of a thin layer of BR-127 primer to the weldbond surface greatly improves the durability of the weldbond system so that its durability is nearly equal to that of the PABST system and is substantially superior to the durability of the FPL system.
4. The ranking of the four material combinations in terms of decreasing durability is as follows:

2024-T3 bare/2024-T3 bare

2024-T3 bare/7075-T6 bare

7075-T6 bare/7075-T6 bare

2024-T3 alclad/7075-T6 bare

5. The wedge test does not realistically evaluate the durability of the weldbond system since spot welding, which is an integral part of the weldbond joining system, is not used in the preparation of the standard wedge-test specimen.
6. The constant load-salt water immersion test was ineffective for comparing the durability of the three joining systems.
7. Wedge-crack specimens in a 95 to 100 percent relative humidity exposure at 120F is not an effective test for distinguishing durability behavior of the PABST, FPL and weldbond joining systems.
8. Spot welds in wedge specimens are effective in stopping crack-growth for at least six months in the salt fog environment.

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- (1) "Primary Adhesively Bonded Structure Technology," Contract No. F33615-75-C-3016, (June 1979).
- (2) Bowen, B. B., Herfert, R. E., and Wu, K. C., "Development of Corrosion Resistant Surface Treatments for Aluminum Alloys for Spot-Weld Bonding," Report No. AFML-TR-75-69, (March 1975).
- (3) Wu, K. C., "Advanced Aluminum Weldbond Manufacturing Methods," Report No. AFML-TR-76-131, (September 1976).
- (4) Croucher, T. R., "Advanced Weldbonding Process Establishment for Aluminum," Report No. AFML-TR-79-4006, (April 1979).

APPENDIX A
WEDGE TEST DATA

TABLE A1

WEDGE TEST DATA - SEA COAST EXPOSURE - 2024-T3 ALCLAD/7075-T6 BARE

FPL BONDING SYSTEM

ADHESIVE SYSTEM:

FPL Etch - BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED:

29 March, 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
A1	0.006	1.90	0.20	1.15	1.25	1.25	1.45	1.60	1.60	1.60	1.60	1.60	1.60	1.60 (1)
A2	0.009	1.92	0.25	0.25	0.30	1.05	1.30	1.40	1.40	1.40	1.40	1.70	1.70	1.70 (2)
A3	0.009	1.95	0.55	1.20	1.35	1.40	1.50	1.60	1.60	1.60	1.60	1.70	1.70	1.70 (1)
A4	0.008	1.95	0.22	0.55	0.98	1.10	1.20	1.20	1.40	1.40	1.40	1.40	1.40	1.40 (1)
A5	0.007	2.02	0.19	0.23	0.23	1.15	1.35	1.50	1.80	1.80	2.20	2.30	2.30	2.30 (2)
A6	0.007	1.90	0.20	0.31	0.31	0.60	0.85	1.00	1.00	1.00	1.00	1.00	1.00	1.00 (1)
A7	0.010	1.91	0.18	0.21	0.25	1.95	2.50	3.20	3.20	3.20	3.20	3.20	3.20	3.20 (2)
A8	0.010	1.92	0.22	0.23	1.20	1.80	2.30	2.50	2.50	2.60	2.60	2.70	2.70	2.70 (2)
A9	0.008	1.99	0.72	1.15	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)
A10	0.008	1.96	0.15	0.90	1.48	2.15	2.20	2.80	3.40	3.40	3.40	3.40	3.40	3.40 (2)
A11	0.006	1.94	0.13	0.20	0.25	1.05	1.30	2.10	2.10	2.10	2.20	2.20	2.20	2.20 (2)
A12	0.008	1.92	0.52	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)	Discontinued(1)
Average			0.29	0.58	0.76	1.35	1.60	1.89	2.00	2.01	2.05	2.11	2.11	2.11
Range			0.13	0.21	0.23	0.60	0.85	1.00	1.00	1.00	1.00	1.00	1.00	1.00
			0.72	1.20	1.48	2.15	2.50	3.20	3.40	3.40	3.40	3.40	3.40	3.40

(1) Failure mode was 80 to 100 percent adhesive failure along the 2024-T3 alclad surface.

(2) Failure mode was 80 to 100 percent adhesive failure along the 7075-T6 surface.

TABLE A2

WEDGE TEST DATA - SEA COAST EXPOSURE - 2024-T3 ALCLAD/7075-T6 BARE

WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0 - 1.5 Volt Phosphoric Acid Anodize/A1444B Paste Adhesive
 EXPOSURE STARTED: 1 June, 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
M1	0.006	2.13	0.30	.95	1.50	1.50	1.90	2.00	2.20	2.20	2.40	2.50	2.50	2.50
M2	0.006	2.07	0.48	1.15	1.45	1.80	2.20	2.40	2.60	3.10	3.90	Discontinued		(2)
M3	0.006	2.12	0.08	1.10	1.65	2.20	2.20	2.20	2.30	2.30	2.40	2.50	2.50	(2)
M4	0.008	2.14	0.13	1.10	1.70	2.00	2.60	2.60	2.70	2.70	2.75	2.75	2.75	(2)
M5	0.008	2.09	0.16	1.50	2.20	2.40	2.60	2.60	2.60	2.60	2.60	2.60	2.60	(3)
M6	0.006	2.09	0.18	0.65	1.00	1.40	1.60	1.60	1.60	1.60	1.70	1.80	2.00	(4)
M7	0.007	2.04	0.55	1.35	1.90	2.00	2.10	2.10	2.10	2.90	3.97	Discontinued		(2)
M8	0.008	2.13	0.13	0.70	1.50	1.70	2.00	2.00	2.00	2.00	2.30	2.45	2.45	(3)
M9	0.010	1.97	0.37	1.05	1.20	1.45	1.90	2.20	2.40	4.00	Discontinued			(2)
M10	0.010	2.00	0.14	0.85	1.30	1.45	1.70	1.70	1.80	1.90	2.00	2.00	2.00	(3)
M11	0.005	2.19	0.20	0.65	0.85	0.90	0.90	1.00	1.00	1.20	1.20	1.40	1.60	(4)
M12	0.005	2.08	0.16	1.05	1.60	1.80	2.30	2.50	2.60	2.80	2.80	3.30	3.90	(4)
Average (1)			.24	1.01	1.49	1.72	2.00	2.08	2.16	2.44	2.67	2.76	2.83	2.87
Range			.08	.65	.85	.90	.90	1.00	1.00	1.20	1.20	1.40	1.60	1.90
			.55	1.50	2.20	2.40	2.60	2.60	2.70	4.00	4.00	4.00	4.00	4.00

(1) Average values include values for specimens which were discontinued.

(2) Failure mode was 100 percent adhesive failure along the 2024-T3 alclad surface.

(3) Failure mode was 100 percent adhesive failure, 20 to 50 percent of which occurred along the 2024-T3 alclad surface.

(4) Failure mode was 100 percent adhesive failure, 80 percent of which occurred along the 2024-T3 alclad surface.

TABLE A3

WEDGE TEST DATA - SEA COAST EXPOSURE - 2024-T3 ALCLAD/7075-T6 BARE

PABST SYSTEM

ADHESIVE SYSTEM:

10 - 15 Volt Phosphoric Acid Anodize/BR-127 Primer/FM 73 Mat Adhesive

EXPOSURE STARTED:

29 March 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
I 1	0.007	2.07	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 2	0.007	2.03	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 3	0.009	2.08	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 4	0.008	2.02	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 5	0.007	2.08	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 6	0.007	2.05	0.03	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 7	0.008	2.03	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 8	0.009	2.06	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01
I 9	0.007	2.08	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04
I 10	0.008	2.05	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 11	0.008	2.07	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04
I 12	0.008	2.04	0.0	Discontinued	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01
Average			0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01
Range			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04

TABLE A4

WEDGE TEST DATA - SEA COAST EXPOSURE - 2024 - T3 BARE/7075 - T6 BARE

FPL BONDING SYSTEM

ADHESIVE SYSTEM:

FPL Etch - BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 29 March, 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)													
			Exposure Time (Months)													
			1	2	3	4	5	6	7	8	9	10	11	12		
B1	0.006	1.93	0.10	0.86	2.30	3.85	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued
B2	0.010	1.88	0.18	0.18	0.75	1.75	2.00	2.20	2.40	2.40	2.40	2.40	2.40	2.40	2.40	2.40
B3	0.008	1.87	0.13	0.16	0.16	0.25	0.40	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60
B4	0.008	1.93	0.10	0.11	1.10	1.85	2.60	3.20	3.20	3.20	3.20	3.20	3.20	3.20	3.20	3.20
B5	0.007	1.95	0.16	0.16	1.35	2.50	4.05	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued
B6	0.005	1.92	0.13	0.14	1.25	1.80	2.20	2.50	2.70	2.70	2.70	2.70	2.70	2.70	2.70	2.70
B7	0.010	1.95	0.10	0.08	0.12	0.90	1.00	1.10	1.10	1.10	1.10	1.10	1.10	1.10	1.10	1.10
B8	0.010	1.94	0.10	0.10	0.25	0.30	0.70	1.10	1.10	1.30	1.30	1.30	1.30	1.30	1.30	1.30
B9	0.009	1.93	0.10	0.10	0.12	0.20	0.70	0.80	0.80	0.80	0.80	0.80	0.80	0.80	0.80	0.80
B10	0.007	1.99	0.15	0.15	1.30	2.80	4.0	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued
B11	0.006	1.99	0.12	0.85	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued
B12	0.010	1.95	0.13	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued
		Average (1)	0.13	0.26	0.87	1.62	1.96	2.17	2.24	2.24	2.24	2.24	2.24	2.24	2.24	2.24
		Range	0.10	0.10	0.12	0.20	0.40	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60	0.60
			0.18	0.86	2.30	3.85	4.05	4.05	4.05	4.05	4.05	4.05	4.05	4.05	4.05	4.05

(1) Average values include values for specimens B5 and B10.

(2) Failure mode was 80 to 100 percent adhesive failure along the 7075-T6 surface.

TABLE A5

WEDGE TEST DATA - SEA COAST EXPOSURE - 2024 - T3 BARE/7075-T6 BARE

WELDBOND SYSTEM

ADHESIVE SYSTEM:

1.0 - 1.5 Volt Phosphoric Acid Anodize/A1444B Paste Adhesive

EXPOSURE STARTED: 1 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
N1	0.009	2.19	0.05	1.20	1.70	1.80	1.80	1.80	1.80	1.80	1.80	1.80	1.80	1.80 (1)
N2	0.012	2.23	0.0	1.35	2.10	2.30	2.30	2.30	2.30	2.30	2.30	2.30	2.30	2.30 (1)
N3	0.015	2.16	0.0	1.20	1.50	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00 (2)
N4	0.015	2.49	0.0	1.05	1.50	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70	1.70 (1)
N5	0.013	2.75	0.0	0.75	1.30	1.50	1.50	1.70	1.70	1.90	2.00	2.00	2.00	2.00 (1)
N6	0.008	2.18	0.04	0.06	0.10	0.15	0.15	0.15	0.35	0.50	0.50	0.50	0.60	0.60 (2)
N7	0.011	2.38	0.0	0.0	0.0	0.0	0.0	0.70	0.70	0.70	0.70	0.80	0.80	0.90 (2)
N8	0.014	2.27	0.0	0.85	1.80	1.80	1.80	1.90	1.90	2.20	2.30	2.30	2.30	2.30 (1)
N9	0.012	2.17	0.0	0.0	.10	.40	.80	1.00	1.00	1.10	1.30	1.30	1.30	1.60 (1)
N10	0.013	2.07	0.05	1.25	1.95	2.20	2.20	2.20	2.20	2.20	2.20	2.20	2.20	2.20 (1)
N11	0.015	2.18	0.10	0.90	1.65	1.80	1.90	2.30	2.50	2.50	2.50	2.50	2.50	2.50 (1)
N12	0.013	2.31	0.05	0.10	0.60	0.75	1.20	1.35	1.35	1.40	1.40	1.50	1.50	1.50 (1)
Average			0.02	0.73	1.21	1.37	1.51	1.59	1.63	1.70	1.73	1.76	1.76	1.79
Range			0.0	0.0	0.0	0.0	0.15	0.15	0.35	0.50	0.50	0.60	0.60	0.60
			0.10	1.35	2.10	2.30	2.30	2.30	2.50	2.50	2.50	2.50	2.50	2.50

(1) Failure mode was 95 to 100 percent adhesive along the 7075-T6 surface.

(2) Failure mode was 100 percent adhesive failure.

TABLE A6 WEDGE TEST DATA - SEA COAST EXPOSURE - 2024 - T3 BARE/7075 - T6 BARE

ADHESIVE SYSTEM : 10 - 15 Volt Phosphoric Acid Anodize/ BR-127 Primer/ FM 73 Mat Adhesive
 EXPOSURE STARTED: 29 March, 1978

PABST SYSTEM

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
J1	0.006	2.17	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J2	0.008	2.08	.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02
J3	0.008	2.11	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J4	0.007	2.10	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J5	0.006	2.14	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J6	0.003	2.19	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J7	0.006	2.02	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J8	0.007	2.10	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J9	0.007	2.10	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J10	0.007	2.10	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J11	0.006	2.12	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J12	0.007	2.15	NC	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued	Discontinued
Average			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Range			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			.02	.02	.02	.02	.02	.02	.02	.02	.02	.02	.02	.02

TABLE A7 WEDGE TEST DATA - SEA COAST EXPOSURE - 2024 - T3 BARE/2024 - T3 BARE

FPL BONDING SYSTEM

ADHESIVE SYSTEM: FPL Etch - BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 29 March, 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
C1	0.008	1.89	.15	.15	.15	.15	.15	.20	.30	.30	.40	.50	0.50	(1)
C2	0.009	1.93	.05	.08	.10	.10	.10	.20	.30	.30	.40	.40	0.40	(1)
C3	0.010	1.88	.05	.10	.13	.90	1.10	1.40	1.40	1.40	1.50	1.50	1.50	(2)
C4	0.008	1.88	.12	.12	.15	.25	.45	.60	.60	.60	.60	.60	0.60	(1)
C5	0.007	1.91	.11	.11	.15	.90	1.10	1.30	1.30	1.40	1.50	1.50	1.50	(2)
C6	0.009	1.88	.12	.13	.16	.16	.35	.50	.50	.50	.50	.50	0.50	(3)
C7	0.009	1.90	.15	.15	.15	.25	.35	.35	.35	.35	.35	.50	0.50	(3)
C8	0.009	1.93	.12	.12	.12	.15	.15	.20	.20	.20	.30	.30	0.30	(1)
C9	0.008	1.93	.08	.12	.15	.20	.75	1.00	1.00	1.00	1.00	1.00	1.00	(2)
C10	0.007	1.96	.10	.10	.10	.15	.80	.85	.90	.90	.90	.90	0.90	(2)
C11	0.009	1.93	.12	.12	.20	.30	.35	.60	.60	.60	.60	.60	0.60	(1)
C12	0.009	1.83	.18	Discontinued										
Average			.11	.12	.14	.32	.51	.65	.68	.69	.73	.75	0.75	0.77
Range			.05	.08	.10	.10	.10	.20	.20	.20	.30	.30	0.30	0.30
			.18	.15	.20	.90	1.10	1.40	1.40	1.40	1.50	1.50	1.50	1.60

- (1) Failure mode was 40 to 60 percent adhesive failure.
 (2) Failure mode was 80 to 100 percent adhesive failure.
 (3) Failure mode was 20 to 40 percent adhesive failure.

TABLE A8

WEDGE TEST DATA - SEA COAST EXPOSURE - 2024 - T3 BARE/2024 - T3 BARE

WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0 - 1.5 Volt Phosphoric Acid Anodize/A1444B Paste Adhesive

EXPOSURE STARTED: 1 June, 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
01	0.010	2.07	0.11	0.55	0.80	0.90	1.00	1.00	1.00	1.10	1.20	1.35	1.35	1.50 (1)
02	0.009	2.06	0.10	0.50	0.75	0.85	0.90	0.90	0.90	1.00	1.00	1.00	1.00	1.05 (1)
03	0.008	2.50	0.02	0.02	0.02	0.02	0.15	0.22	0.22	0.30	0.30	0.30	0.30	0.55 (1)
04	0.009	2.17	0.10	0.60	0.70	0.75	0.80	0.80	0.80	0.80	0.90	0.90	0.90	0.90 (1)
05	0.010	2.15	0.05	0.95	1.00	1.10	1.10	1.10	1.10	1.10	1.20	1.20	1.20	1.20 (1)
06	0.005	2.06	0.05	0.05	0.20	0.20	0.20	0.20	0.20	0.30	0.30	0.35	0.35	0.45 (1)
07	0.010	2.02	0.07	0.70	0.75	0.80	0.80	0.90	0.95	1.00	1.00	1.10	1.10	1.10 (1)
08	0.011	2.07	0.08	0.08	0.10	0.20	0.20	0.20	0.20	0.20	0.45	0.55	0.55	0.55 (1)
09	0.010	2.00	0.11	0.11	0.15	0.20	0.20	0.20	0.20	0.20	0.30	0.55	0.60	0.60 (1)
010	0.003	2.12	0.10	0.10	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15 (2)
011	0.009	2.11	0.08	0.55	0.95	1.05	1.45	1.60	1.60	1.80	1.80	1.90	1.90	2.20 (1)
012	0.009	2.12	0.15	0.15	0.50	0.60	0.65	0.80	0.90	1.10	1.20	1.50	1.65	2.20 (1)
Average			0.085	0.36	0.51	0.59	0.63	0.67	0.68	0.76	0.82	0.91	0.94	1.06
Range			0.02	.02	0.02	0.02	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15
			0.15	.95	1.00	1.10	1.45	1.60	1.60	1.80	1.80	1.90	1.90	2.20

(1) Failure mode was 90 to 100 percent adhesive failure.

(2) Failure mode was 90 percent cohesive failure.

TABLE A9 WEDGE TEST DATA - SEA COAST EXPOSURE - 2024 - T3 BARE/2024 - T3 BARE

ADHESIVE SYSTEM: 10-15 Volt Phosphoric Acid Anodize/BR-127 Primer/FM73 Mat Adhesive
 EXPOSURE SYSTEM: PABST SYSTEM
 EXPOSURE STARTED: 29 March, 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
K1	0.008	2.13	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02
K2	0.008	2.08	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02
K3	0.008	2.05	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
K4	0.008	2.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03
K5	0.006	2.10	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03
K6	0.004	2.08	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02
K7	0.005	2.11	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02	0.02
K8	0.005	2.16	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
K9	0.006	2.10	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
K10	0.007	2.10	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
K11	0.005	2.12	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
K12	0.007	2.08	0.0	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED
Average			0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01
Range			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03

TABLE A10 WEDGE TEST DATA - SEA COAST EXPOSURE - 7075 - T6 BARE/7075 - T6 BARE

FPL BONDING SYSTEM

ADHESIVE SYSTEM: FPL Etch - BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 29 March, 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
D1	0.009	1.96	0.12	0.20	0.65	1.00	1.00	1.40	1.40	1.40	1.40	1.40	1.40	(2)
D2	0.010	1.98	0.14	0.65	1.40	2.35	2.75	3.50	3.50	3.60	3.60	3.60	3.60	(2)
D3	0.010	1.97	0.10	0.78	1.80	3.10	4.00	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	(2)
D4	0.010	1.98	0.09	0.82	1.35	1.80	1.80	1.80	1.80	1.80	1.80	1.80	1.80	(2)
D5	0.010	1.98	0.08	0.08	0.75	1.45	1.80	2.10	2.10	2.10	2.10	2.10	2.10	(2)
D6	0.008	1.93	0.13	0.65	1.20	1.50	1.65	1.70	1.70	1.75	1.75	1.75	1.75	(2)
D7	0.010	1.92	0.14	0.14	1.45	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	(2)
D8	0.010	1.96	0.15	0.15	1.55	1.55	2.10	2.30	2.30	2.30	2.30	2.30	2.30	(2)
D9	0.010	1.91	0.13	0.83	1.35	1.65	1.75	2.00	2.00	2.00	2.00	2.00	2.00	(2)
D10	0.010	1.98	0.08	0.68	1.70	2.20	2.40	2.40	2.40	2.40	2.40	2.40	2.40	(2)
D11	0.009	1.96	0.11	1.08	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	(2)
D12	0.008	2.00	0.05	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	(2)
Average(1)			0.11	0.55	1.20	1.84	2.13	2.35	2.35	2.36	2.36	2.37	2.37	2.38
Range			0.05	0.08	0.65	1.00	1.00	1.40	1.40	1.40	1.40	1.40	1.40	1.40
			0.15	1.08	1.80	3.10	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00

(1) Average Values Include Values For Specimen D3.

(2) Failure mode was 100 percent adhesive failure.

TABLE A11 WEDGE TEST DATA - SEA COAST EXPOSURE - 7075-T6 BARE/7075-T6 BARE

WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0 - 1.5 Volt Phosphoric Acid Anodize/A1444B Paste Adhesive

EXPOSURE STARTED: 1 June, 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
P1	0.009	2.51	0.0	0.55	1.10	1.20	1.40	1.40	1.40	1.40	1.40	1.40	1.40	(1)
P2	0.011	2.15	0.02	1.15	1.80	2.00	2.00	2.20	2.20	2.20	2.20	2.20	2.20	(1)
P3	0.011	2.19	0.0	1.10	1.45	1.60	1.65	1.65	1.65	1.70	1.70	1.70	1.70	(1)
P4	0.010	2.17	0.07	1.00	1.65	2.20	2.20	2.20	2.20	2.20	2.20	2.20	2.20	(1)
P5	0.010	2.43	0.0	0.95	1.30	1.55	1.55	1.55	1.55	1.60	1.60	1.60	1.60	(1)
P6	0.009	2.25	0.0	1.20	1.75	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	(1)
P7	0.010	2.25	0.0	0.50	1.30	1.60	1.60	1.90	1.90	1.90	2.00	2.00	2.00	(1)
P8	0.010	2.21	0.10	1.25	1.85	2.15	2.15	2.15	2.15	2.15	2.15	2.15	2.15	(1)
P9	0.010	2.11	0.08	0.90	1.40	1.40	1.40	1.80	1.80	1.90	1.90	2.00	2.00	(1)
P10	0.011	2.38	0.0	0.95	1.20	1.50	1.50	1.70	1.70	1.70	1.70	1.70	1.70	(1)
P11	0.011	2.66	0.0	0.85	1.50	1.80	1.80	1.80	1.80	1.80	1.80	1.80	1.80	(1)
P12	0.012	2.38	0.0	1.15	1.50	1.90	1.90	1.90	1.90	2.00	2.00	2.00	2.00	(1)
Average			0.024	0.96	1.48	1.74	1.85	1.85	1.85	1.88	1.89	1.90	1.90	(1)
Range			0.0	0.50	1.10	1.20	1.40	1.40	1.40	1.40	1.40	1.40	1.40	(1)
			0.10	1.25	1.85	2.20	2.20	2.20	2.20	2.20	2.20	2.20	2.20	(1)

(1) Failure mode was 100 percent adhesive failure.

TABLE A12 WEDGE TEST DATA - SEA COAST EXPOSURE - 7075-T6 BARE/7075-T6 BARE

PABST SYSTEM

ADHESIVE SYSTEM: 10-15 Volt Phosphoric Acid Anodize/BR127 Primer/FM 73 Mat Adhesive

EXPOSURE STARTED: 29 March, 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
L1	0.005	2.16	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L2	0.007	2.10	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L3	0.008	2.08	0.0	0.0	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05
L4	0.007	2.07	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L5	0.003	2.14	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L6	0.005	2.16	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L7	0.008	2.15	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L8	0.008	2.13	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L9	0.006	2.13	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L10	0.002	2.14	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.04
L11	0.006	2.13	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L12	0.006	2.11	0.0	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED	DISCONTINUED
Average			0.0	0.0	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.01
Range			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			0.04	0.04	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05

TABLE A13 WEDGE TEST DATA - SALT FOG EXPOSURE - 2024-T3 ALCLAD/7075-T6 BAREFPL BONDING SYSTEM

ADHESIVE SYSTEM: FPL Etch/BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 4 May 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)								
			Exposure Time (Days)								
			1	4	8	15	30	50	60	90	
A 13	(1)	2.01	0.05	0.72	0.82	0.82	0.85	0.92	0.92	0.92	(2)
A 14	(1)	1.96	0.08	0.18	0.21	0.38	0.55	0.70	0.70	0.70	(2)
A 15	(1)	2.01	0.10	0.21	0.23	0.25	0.35	0.45	0.45	0.55	(2)
A 16	(1)	1.96	0.11	0.18	0.25	0.05	0.25	0.40	0.40	0.45	(2)
A 17	(1)	1.89	0.17	0.25	0.25	0.25	0.32	0.52	0.55	0.60	(2)
A 18	(1)	1.85	0.21	0.24	0.31	0.32	0.40	0.60	0.60	0.65	(2)
Average			0.12	0.30	0.35	0.38	0.45	0.60	0.60	0.65	
Range {			0.05	0.18	0.21	0.25	0.25	0.40	0.40	0.45	
			0.21	0.72	0.82	0.82	0.85	0.92	0.92	0.92	

(1) Bondline thickness ranged from 0.006-inch to 0.010-inch.

(2) 100 percent adhesive failure along the 2024-T3 alclad surface.

TABLE A14 WEDGE TEST DATA - SALT FOG EXPOSURE - 2024-T3 ALCLAD/7075-T6 BARE
WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0-1.5 Volt Phosphoric Acid Anodize/Al444B Paste Adhesive Cured at 250-260 F for 2 1/2 Hours

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
M 13	0.008	2.10	0.06	0.15	0.15	0.75	2.20	3.10	3.90	(1)
M 14	0.007	2.08	0.15	0.20	0.27	0.35	0.45	2.70	2.70	(1)
M 15	0.007	2.11	0.10	0.15	0.37	0.45	2.20	2.50	2.70	(1)
M 16	0.008	2.00	0.0	0.05	0.20	0.20	2.10	2.70	2.80	(1)
M 17	0.009	2.12	0.13	0.13	0.25	0.25	0.35	2.80	2.80	(1)
M 18	0.009	2.06	0.11	0.15	0.25	0.50	2.10	2.90	4.00	(1)
Average			0.09	0.14	0.25	0.42	1.56	2.78	3.15	
Range {			0.0	0.05	0.20	0.20	0.35	2.50	2.70	
			0.15	0.20	0.37	0.75	2.20	3.10	4.00	

(1) 100 percent adhesive failure along the 2024-T3 alclad surface.

TABLE A15 WEDGE TEST DATA - SALT FOG EXPOSURE - 2024-T3 ALCLAD/7075-T6 BARE
PABST SYSTEM

ADHESIVE SYSTEM: 10-15 Volt Phosphoric Acid Anodize/BR-127 Primer/FM 73 Mat Adhesive

EXPOSURE STARTED: 4 May 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	8	15	30	50	60	90
I 13	(1)	2.04	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 14	(1)	2.09	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 15	(1)	2.14	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 16	(1)	2.08	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 17	(1)	2.08	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 18	(1)	2.12	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Average			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Range {										

(1) Bondline thickness ranged from 0.005 to 0.009 inch.

TABLE A16 WEDGE TEST DATA - SALT FOG EXPOSURE-2024-T3 BARE/7075-T6 BARE
FPL BONDING SYSTEM

ADHESIVE SYSTEM: FPL Etch /BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 4 May 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	8	15	30	50	60	90
B 13	(1)	1.93	0.12	0.15	0.22	0.26	0.35	0.45	0.50	0.65
B 14	(1)	2.02	0.05	0.13	0.16	0.17	0.25	0.30	0.30	0.30
B 15	(1)	1.99	0.12	0.17	0.21	0.23	0.30	0.30	0.30	0.40
B 16	(1)	2.00	0.09	0.18	0.25	0.26	0.38	0.55	0.60	0.60
B 17	(1)	1.97	0.06	0.13	0.18	0.22	0.50	0.60	0.65	0.65
B 18	(1)	1.95	0.09	0.17	0.18	0.23	0.30	0.55	0.65	0.65
Average			0.09	0.16	0.20	0.23	0.35	0.46	0.50	0.54
Range {			0.06	0.13	0.16	0.17	0.25	0.30	0.30	0.30
			0.12	0.18	0.25	0.26	0.50	0.60	0.65	0.65

(1) Bondline thickness ranged from 0.006 inch to 0.010 inch.

(2) 100 percent adhesive failure with more than 80 percent occurring along the 2024-T3 bare.

TABLE A17 WEDGE TEST DATA - SALT FOG EXPOSURE - 2024-T3 BARE/7075-T6 BARE

WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0-1.5 Volt Phosphoric Acid Anodize/Al444B Paste Adhesive Cured at 270-290 F for 1 Hour

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
N 13	0.013	2.56	0.0	0.0	0.0	1.15	1.30	1.30	1.40	1.40
N 14	0.013	2.16	0.10	0.10	0.85	1.60	1.80	1.80	1.80	1.80
N 15	0.013	2.71	0.0	0.0	0.0	0.02	0.05	0.10	1.50	1.50
N 16	0.013	2.42	0.0	0.0	0.0	0.0	1.10	1.30	1.30	1.30
N 17	0.013	2.26	0.0	0.0	0.80	0.80	0.95	1.10	1.30	1.30
N 18	0.016	2.81	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Average			0.02	0.02	0.28	0.60	0.87	0.93	1.21	1.21
Range {			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			0.10	0.10	0.85	1.60	1.80	1.80	1.80	1.80

(1) 100 percent adhesive failure along the 2024-T3 bare surface.

TABLE A18 WEDGE TEST DATA - SALT FOG EXPOSURE - 2024-T3 BARE/7075-T6 BARE

PABST SYSTEM

ADHESIVE SYSTEM: 10-15 Volt Phosphoric Acid Anodize/BR-127 Primer/FM 73 Mat Adhesive

EXPOSURE STARTED: 4 May 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	8	15	30	50	60	90
J 13	(1)	2.19	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J 14	(1)	2.26	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J 15	(1)	2.29	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J 16	(1)	2.14	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J 17	(1)	2.13	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J 18	(1)	2.13	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Average			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Range {										

(1) Bondline thickness ranged from 0.005 to 0.009 inch.

TABLE A19 WEDGE TEST DATA - SALT FOG EXPOSURE - 2024-T3 BARE/2024-T3 BARE
FPL BONDING SYSTEM

ADHESIVE SYSTEM: FPL Etch/BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 4 May 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	8	15	30	50	60	90
C 13	(1)	1.90	0.07	0.13	0.16	0.16	0.22	0.40	0.55	0.60 (2)
C 14	(1)	1.91	0.08	0.13	0.17	0.19	0.20	0.35	0.43	0.50 (2)
C 15	(1)	1.92	0.12	0.20	0.21	0.24	0.25	0.35	0.35	0.45 (2)
C 16	(1)	1.92	0.09	0.13	0.17	0.19	0.20	0.30	0.35	0.50 (2)
C 17	(1)	1.89	0.12	0.17	0.21	0.23	0.30	0.40	0.50	0.60 (2)
C 18	(1)	1.87	0.12	0.16	0.22	0.25	0.40	0.55	0.55	0.65 (2)
Average			0.10	0.15	0.19	0.21	0.26	0.39	0.46	0.55
Range {			0.07	0.13	0.16	0.16	0.20	0.30	0.35	0.45
			0.12	0.20	0.22	0.25	0.40	0.55	0.55	0.65

(1) Bondline thickness ranged from 0.006 inch to 0.010 inch.

(2) 100 percent adhesive failure.

TABLE A20 WEDGE TEST DATA - SALT FOG EXPOSURE - 2024-T3 BARE/2024-T3 BARE
WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0-1.5 Volt Phosphoric Acid Anodize/Al444B Paste Adhesive Cured at 250-260 F For 2-1/2 Hours

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
O 13	0.009	2.10	0.14	0.15	0.28	0.30	0.35	0.45	0.45	0.50 (1)
O 14	0.008	2.08	0.08	0.15	0.27	0.30	0.30	0.55	0.55	0.60 (1)
O 15	0.009	2.14	0.03	0.05	0.15	0.20	0.35	0.50	0.50	0.50 (1)
O 16	0.008	2.08	0.15	0.15	0.20	0.20	0.30	0.45	0.45	0.50 (1)
O 17	0.008	2.04	0.06	0.10	0.18	0.18	0.20	0.30	0.30	0.40 (1)
O 18	0.008	2.05	0.08	0.15	0.18	0.18	0.20	0.50	0.50	0.50 (1)
Average			0.09	0.13	0.21	0.23	0.28	0.46	0.46	0.50
Range {			0.03	0.05	0.15	0.18	0.20	0.30	0.30	0.40
			0.15	0.15	0.28	0.30	0.35	0.55	0.55	0.60

(1) 90 to 95 percent cohesive failure.

TABLE A21 WEDGE TEST DATA - SALT FOG EXPOSURE - 2024-T3 BARE/2024-T3 BARE
PABST SYSTEM

ADHESIVE SYSTEM: 10-15 Volt Phosphoric Acid Anodize/BR-127 Primer/FM 73 Mat Adhesive

EXPOSURE STARTED: 4 May 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	8	15	30	50	60	90
K13	(1)	2.13	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
K14	(1)	2.14	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
K15	(1)	2.10	0.0	0.0	0.0	0.0	0.05	0.05	0.05	0.05
K16	(1)	2.12	0.0	0.0	0.0	0.0	0.06	0.06	0.06	0.06
K17	(1)	2.11	0.0	0.02	0.02	0.02	0.02	0.02	0.02	0.02
K18	(1)	2.10	0.0	0.03	0.03	0.03	0.03	0.03	0.03	0.03
Average			0.0	0.01	0.01	0.01	0.03	0.03	0.03	0.03
Range {				0.0	0.0	0.0	0.0	0.0	0.0	0.0
				0.03	0.03	0.03	0.06	0.06	0.06	0.06

(1) Bondline thickness ranged from 0.005 to 0.009 inch.

TABLE A22 WEDGE TEST DATA - SALT FOG EXPOSURE - 7075-T6 BARE/7075-T6 BARE
FPL BONDING SYSTEM

ADHESIVE SYSTEM: FPL Etch/BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 4 May 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)								
			Exposure Time (Days)								
			1	4	8	15	30	50	60	90	
D13	(1)	2.00	0.08	0.15	0.20	0.20	0.20	0.25	0.30	0.45	(2)
D14	(1)	2.04	0.08	0.13	0.18	0.30	0.30	0.30	0.30	0.30	(2)
D15	(1)	2.04	0.07	0.08	0.17	0.18	0.20	0.30	0.30	0.35	(2)
D16	(1)	2.03	0.10	0.20	0.21	0.23	0.23	0.25	0.25	0.30	(2)
D17	(1)	1.98	0.13	0.15	0.15	0.23	0.25	0.35	0.35	0.45	(2)
D18	(1)	2.08	0.06	0.10	0.21	0.21	0.21	0.25	0.25	0.25	(2)
Average			0.09	0.14	0.18	0.23	0.23	0.28	0.29	0.35	
Range {			0.06	0.08	0.12	0.18	0.20	0.25	0.25	0.25	
			0.13	0.20	0.21	0.30	0.30	0.35	0.35	0.45	

(1) Bondline thickness ranged from 0.006-inch to 0.010-inch.

(2) 100 percent adhesive failure.

TABLE A23 WEDGE TEST DATA - SALT FOG EXPOSURE - 7075-T6 BARE/7075-T6 BARE
WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0 - 1.5 Volt Phosphoric Acid Anodize/A1444B Paste Adhesive Cured
at 270-290°F for 1 Hour

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
P13	0.013	2.52	0.0	0.05	0.05	0.45	1.40	1.40	1.40	1.40 (1)
P14	0.011	2.15	0.12	0.15	0.35	0.65	1.50	1.70	1.70	1.70 (1)
P15	0.009	2.15	0.08	0.12	0.15	0.15	0.90	1.55	1.55	1.60 (1)
P16	0.010	2.14	0.08	0.10	0.35	0.80	0.90	0.90	0.90	0.90 (1)
P17	0.013	2.81	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
P18	0.014	2.36	0.0	0.0	0.0	0.0	0.0	0.40	1.10	1.10 (1)
Average			0.05	0.06	0.15	0.34	0.78	0.99	1.10	1.11
Range {			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			0.12	0.15	0.35	0.80	1.50	1.70	1.70	1.70

(1) 100 percent adhesive failure.

TABLE A24 WEDGE TEST DATA - SALT FOG EXPOSURE - 7075-T6 BARE/7075-T6 BARE
PABST SYSTEM

ADHESIVE SYSTEM: 10-15 Volt Phosphoric Acid Anodize/BR-127 Primer/FM 73 Mat Adhesive

EXPOSURE STARTED: 4 May 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	8	15	30	50	60	90
L13	(1)	2.15	0.0	0.0	0.0	0.0	0.10	0.10	0.10	0.10
L14	(1)	2.18	0.0	0.0	0.0	0.0	0.05	0.05	0.05	0.05
L15	(1)	2.18	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L16	(1)	2.16	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L17	(1)	2.11	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L18	(1)	2.13	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Average			0.0	0.0	0.0	0.0	0.03	0.03	0.03	0.03
Range {			—	—	—	—	0.0	0.0	0.0	0.0
			—	—	—	—	0.10	0.10	0.10	0.10

(1) Bondline thickness ranged from 0.005 to 0.009 inch

TABLE A25 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 2024-T3
ALCLAD/7075-T6 BARE-FPL BONDING SYSTEM

ADHESIVE SYSTEM: FPL Etch/BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
A25	0.008	2.02	0.10	0.12	0.17	0.15	0.15	0.15	0.15	0.30
A26	0.007	2.03	0.12	0.17	0.18	0.18	0.18	0.18	0.18	0.25
A27	0.009	1.98	0.13	0.18	0.21	0.21	0.21	0.21	0.21	0.29
A28	0.009	1.95	0.14	0.17	0.20	0.21	0.21	0.21	0.21	0.28
A29	0.008	1.98	0.09	0.10	0.12	0.12	0.12	0.12	0.12	0.21
A30	0.008	1.98	0.13	0.16	0.18	0.18	0.18	0.18	0.18	0.25
Average			0.11	0.15	0.17	0.17	0.17	0.17	0.17	0.26
Range {			0.09	0.10	0.12	0.12	0.12	0.12	0.12	0.21
			0.14	0.18	0.21	0.21	0.21	0.21	0.21	0.30

TABLE A26 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 2024-T3
ALCLAD/7075-T6 BARE-WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0-1.5 Volt Phosphoric Acid Anodize/A-1444B Paste Adhesive Cured at 250-260°F for 2-1/2 Hours

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
M25	0.007	2.38	0.0	0.05	0.06	0.15	0.15	0.15	0.15	0.35
M26	0.008	2.13	0.0	0.13	0.16	0.20	0.25	0.25	0.25	0.38
M27	0.010	2.38	0.0	0.0	0.0	0.0	0.08	0.08	0.08	0.27
M28	0.010	2.22	0.0	0.07	0.08	0.10	0.10	0.13	0.13	0.36
M29	0.009	2.28	0.02	0.15	0.15	0.15	0.20	0.20	0.20	0.47
M30	0.007	2.10	0.15	0.21	0.27	0.30	0.38	0.40	0.40	0.68
Average			0.03	0.10	0.12	0.15	0.19	0.20	0.20	0.42
Range {			0.0	0.0	0.0	0.08	0.08	0.08	0.08	0.27
			0.15	0.21	0.27	0.30	0.38	0.40	0.40	0.68

TABLE A27 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 2024-T3
ALCLAD/7075-T6 BARE - PABST SYSTEM

ADHESIVE SYSTEM: 10-15 Volt Phosphoric Acid Anodize/BR-127 Primer/FM 73 Mat Adhesive

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
I 25	0.008	2.10	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
I 26	0.009	2.15	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.06
I 27	0.010	2.11	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.05
I 28	0.010	2.08	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.05
I 29	0.009	2.12	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.05
I 30	0.007	2.11	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Average			0.01	0.01	0.01	0.01	0.01	0.01	0.01	0.04
Range {			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.06

TABLE A28 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 2024-T3
BARE/7075-T6 BARE - FPL BONDING SYSTEM

ADHESIVE SYSTEM: FPL Etch/BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
B 25	0.009	2.00	0.12	0.12	0.14	0.14	0.14	0.14	0.14	0.21
B 26	0.008	1.99	0.15	0.15	0.21	0.21	0.21	0.21	0.21	0.27
B 27	0.010	1.99	0.12	0.14	0.16	0.17	0.17	0.17	0.17	0.28
B 28	0.010	2.00	0.11	0.11	0.16	0.16	0.18	0.18	0.18	0.27
B 29	0.010	1.98	0.11	0.12	0.16	0.16	0.17	0.17	0.17	0.24
B 30	0.006	1.99	0.12	0.13	0.17	0.17	0.18	0.18	0.18	0.23
Average			0.12	0.13	0.17	0.17	0.18	0.18	0.18	0.25
Range {			0.11	0.11	0.14	0.14	0.14	0.14	0.14	0.21
			0.15	0.15	0.21	0.21	0.21	0.21	0.21	0.28

TABLE A29 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 2024-T3
BARE/7075-T6 BARE - WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0-1.5 Volt Phosphoric Acid Anodize/Al444B Paste Adhesive cured at 270-290 F for 1 Hour.

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
N 25	0.008	2.25	0.10	0.12	0.13	0.13	0.15	0.15	0.15	0.42
N 26	0.015	2.58	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.08
N 27	0.017	2.62	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.04
N 28	0.018	2.48	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.10
N29	0.019	2.16	0.0	0.08	0.08	0.08	0.09	0.09	0.09	0.22
N 30	0.012	2.28	0.0	0.06	0.06	0.06	0.07	0.07	0.07	0.18
Average			0.02	0.04	0.05	0.05	0.05	0.05	0.05	0.17
Range {			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.04
			0.10	0.12	0.13	0.13	0.15	0.15	0.15	0.42

TABLE A30 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 2024-T3
BARE/7075-T6 BARE - PABST SYSTEM

ADHESIVE SYSTEM: 10-15 Volt Phosphoric Acid Anodize/BR-127 Primer/FM 73 Mat Adhesive

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
J 25	0.004	2.12	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.03
J 26	0.006	2.09	0.0	0.0	0.0	0.0	0.06	0.06	0.06	0.06
J 27	0.007	2.12	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
J 28	0.007	2.14	0.0	0.0	0.0	0.0	0.05	0.05	0.05	0.08
J 29	0.006	2.16	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.07
J 30	0.006	2.11	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Average			0.0	0.0	0.0	0.0	0.02	0.02	0.02	0.04
Range {			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			0.0	0.0	0.0	0.0	0.06	0.06	0.06	0.08

TABLE A31 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 2024-T3
BARE/2024-T3 BARE - FPL BONDING SYSTEM

ADHESIVE SYSTEM: FPL Etch /BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
C 25	0.007	2.01	0.06	0.06	0.11	0.13	0.13	0.13	0.13	0.18
C 26	0.008	1.90	0.16	0.16	0.17	0.17	0.17	0.17	0.17	0.27
C 27	0.009	1.94	0.09	0.09	0.11	0.13	0.13	0.13	0.13	0.20
C 28	0.009	1.90	0.15	0.16	0.18	0.18	0.20	0.20	0.20	0.26
C 29	0.008	1.93	0.12	0.12	0.13	0.13	0.15	0.15	0.15	0.25
C 30	0.009	1.97	0.10	0.11	0.14	0.15	0.15	0.15	0.15	0.22
Average			0.11	0.11	0.14	0.15	0.16	0.16	0.16	0.23
Range {			0.06	0.06	0.11	0.13	0.13	0.13	0.13	0.18
			0.16	0.16	0.18	0.18	0.20	0.20	0.20	0.27

TABLE A32 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 2024-T3
BARE/2024-T3 BARE - WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0-1.5 Volt Phosphoric Acid Anodize/Al444B Paste Adhesive Cured at 250-260F for 2-1/2 Hours

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
O 25	0.004	2.51	0.0	0.02	0.03	0.03	0.15	0.15	0.15	0.30
O 26	0.012	2.49	0.0	0.0	0.0	0.0	0.05	0.05	0.05	0.18
O 27	0.011	2.56	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.14
O 28	0.013	2.52	0.0	0.0	0.0	0.0	0.05	0.05	0.05	0.27
O 29	0.011	2.44	0.07	0.07	0.07	0.10	0.10	0.10	0.10	0.20
O 30	0.010	2.55	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.20
Average			0.0	0.02	0.02	0.02	0.06	0.06	0.06	0.22
Range {			0.01	0.0	0.0	0.0	0.0	0.0	0.0	0.14
			0.07	0.07	0.07	0.10	0.15	0.15	0.15	0.30

TABLE A33 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 2024-T3
BARE/2024-T3 BARE PABST SYSTEM

ADHESIVE SYSTEM: 10-15 Volt Phosphoric Acid Anodize/BR-127 Primer/FM 73 Mat Adhesive

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
K 25	0.005	2.13	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
K 26	0.006	2.12	0.06	0.06	0.06	0.06	0.06	0.06	0.06	0.06
K 27	0.006	2.12	0.03	0.10	0.10	0.10	0.10	0.10	0.10	0.10
K 28	0.007	2.12	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
K 29	0.008	2.05	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
K 30	0.006	2.22	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Average			0.02	0.03	0.03	0.03	0.03	0.03	0.03	0.03
Range {			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			0.06	0.10	0.10	0.10	0.10	0.10	0.10	0.10

TABLE A34 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 7075-T6
BARE/7075-T6 BARE - FPL BONDING SYSTEM

ADHESIVE SYSTEM: FPL Etch/BR-127 Primer/FM 123-2 Mat Adhesive

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
D 25	0.010	2.00	0.10	0.11	0.13	0.13	0.13	0.13	0.13	0.16
D 26	0.007	2.01	0.03	0.08	0.12	0.12	0.12	0.12	0.12	0.16
D 27	0.009	1.99	0.13	0.13	0.13	0.13	0.13	0.13	0.13	0.16
D 28	0.010	1.95	0.12	0.12	0.13	0.13	0.13	0.13	0.13	0.16
D 29	0.009	2.02	0.0	0.05	0.07	0.08	0.08	0.08	0.08	0.10
D 30	0.010	1.97	0.11	0.14	0.15	0.15	0.15	0.15	0.15	0.16
Average			0.08	0.11	0.12	0.12	0.12	0.12	0.12	0.15
Range {			0.0	0.05	0.07	0.08	0.08	0.08	0.08	0.10
			0.11	0.14	0.15	0.15	0.15	0.15	0.15	0.16

TABLE A35 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 7075-T6
BARE/7075-T6 BARE - WELDBOND SYSTEM

ADHESIVE SYSTEM: 1.0-1.5 Volt Phosphoric Acid Anodize/Al444B Paste Adhesive Cured at 270-290 F For 1 Hour

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
P 25	0.010	2.39	0.0	0.0	0.0	0.0	0.03	0.03	0.03	0.18
P 26	0.013	2.34	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.11
P 27	0.010	2.43	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.10
P 28	0.011	2.73	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.06
P 29	0.010	2.48	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.11
P 30	0.009	2.81	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
Average			0.0	0.0	0.0	0.0	0.005	0.005	0.005	0.09
Range {			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			0.0	0.0	0.0	0.0	0.03	0.03	0.03	0.18

TABLE A36 WEDGE TEST DATA - 95-100% RELATIVE HUMIDITY EXPOSURE - 7075-T6
BARE/7075-T6 BARE - PABST SYSTEM

ADHESIVE SYSTEM: 10-15 Volt Phosphoric Acid Anodize/BR-127 Primer/FM 73 Mat Adhesive

EXPOSURE STARTED: 12 June 1978

Specimen Code	Bondline Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)							
			Exposure Time (Days)							
			1	4	11	15	30	45	60	90
L 25	0.006	2.18	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.06
L 26	0.006	2.06	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.05
L 27	0.008	2.10	0.02	0.05	0.05	0.05	0.05	0.05	0.05	0.05
L 28	0.009	2.13	0.0	0.05	0.0	0.0	0.0	0.0	0.0	0.05
L 29	0.008	2.17	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
L 30	0.007	2.13	0.0	0.05	0.05	0.05	0.08	0.08	0.08	0.08
Average			0.0	0.03	0.03	0.03	0.03	0.03	0.03	0.05
Range {			0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0
			0.02	0.05	0.05	0.05	0.08	0.08	0.08	0.08

TABLE A37

WEDGE TEST DATA - SEA COAST EXPOSURE - 2024-T3 ALCLAD/7075-T6 BARE

WELDBOND SYSTEM WITH PRIMER BR-127

ADHESIVE SYSTEM:

1.0-1.5 Volt Phosphoric Acid Anodize/BR-127/A1444B

EXPOSURE STARTED:

1 February 1979

Specimen Code	Bond Line Thickness (Inch)	Initial Crack Length (Inch)	Wedge Crack Growth (Inch)											
			Exposure Time (Months)											
			1	2	3	4	5	6	7	8	9	10	11	12
C1	0.005	2.30	0.20	0.20	0.20	0.20	0.20	0.20						
C2	0.005	2.27	0.02	0.02	0.02	0.02	0.02	0.02						
C3	0.006	2.32	0.0	0.0	0.0	0.0	0.0	0.0						
C4	0.005	2.36	0.0	0.0	0.0	0.02	0.02	0.02						
C5	0.005	2.26	0.04	0.04	0.04	0.04	0.04	0.04						
C6	0.006	2.28	0.0	0.0	0.0	0.0	0.0	0.0						
C7	0.009	2.27	0.0	0.0	0.0	0.0	0.0	0.0						
C8	0.004	2.28	0.0	0.09	0.09	0.09	0.09	0.09						
C9	0.005	2.30	0.0	0.05	0.05	0.05	0.05	0.05						
C10	0.006	2.55	0.0	0.0	0.0	0.0	0.0	0.0						
Average			0.03	0.04	0.04	0.04	0.04	0.04						
Range			0.0	0.0	0.0	0.0	0.0	0.0						
			0.20	0.20	0.20	0.20	0.20	0.20						

WEDGE TEST DATA - SALT FOG EXPOSURE - 2024-T3 ALCLAD/7075-T6 BARE

WELDBOND SYSTEM WITH PRIMER BR-127

ADHESIVE SYSTEM: 1.0-1.5 Volt Phosphoric Acid Anodize/BR-127/A1444B

EXPOSURE STARTED: 10 October 1978

[illegible]

(1) Discontinued and split open to show 100 percent cohesive failure.

WEDGE TEST DATA FOR WELDBOND SPECIMENS WITH WELDS - 2024 - T3 ALCLAD/

ADHESIVE SYSTEM:

1.1.0 - 1.5 Volt Phosphoric Acid Anodize/A144B Paste Adhesive With One Spot Weld Centered 3 Inches From End of Specimen

EXPOSURE STARTED: 9 January 1979 in 5% Salt Fog at 95F

[illegible]

(1) Specimen was removed after four months and pried open. Thirty percent interface corrosion was observed on the 2024-T3 alclad surface in addition to the 100 percent adhesive failure along this surface.