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**Workman et al.**

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(54) **METHOD FOR REPAIRING DEFECTS IN A CONDUCTIVE SUBSTRATE USING WELDING**

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**Related U.S. Application Data**

(63) Continuation-in-part of application No. 10/772,701, filed on Feb. 5, 2004.

(51) **Int. Cl.**  
**B23K 11/00** (2006.01)

(52) **U.S. Cl.** ..... **219/117.1; 228/119**

(58) **Field of Classification Search** ..... **219/117.1; 228/119; 29/402.01, 402.18**

See application file for complete search history.

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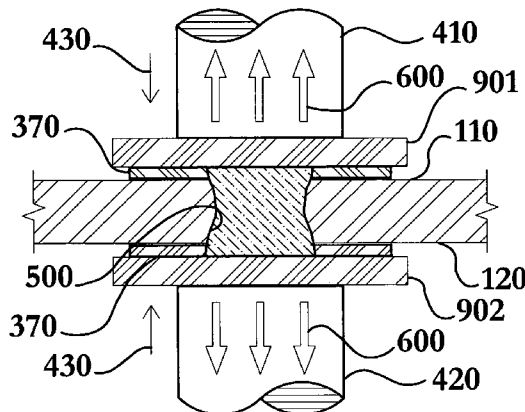
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(57) **ABSTRACT**

A method for repairing defects in a substrate including the steps of placing a consumable filler slug in contact with the substrate in the vicinity of the defect; placing at least one electrically conductive cover sheet in contact with a portion of the consumable filler slug; bringing a first electrode and a second electrode in contact with the at least one cover sheet and applying a force; and transmitting electrical current between the electrodes, thereby resistively heating the at least one cover sheet and conductively heating the consumable slug and a portion of the substrate resulting in coalescence in a substantially liquid pool that fills the defect. The pool is then cooled to solidification under pressure. Alternative embodiments eliminate the need for the conductive cover sheet(s) by utilizing electrodes having increased electrical and thermal resistance. The consumable slug may be formed as a single unit or multiple sections, and may incorporate sacrificial retainers.

**30 Claims, 6 Drawing Sheets**



# US 7,141,754 B2

Page 2

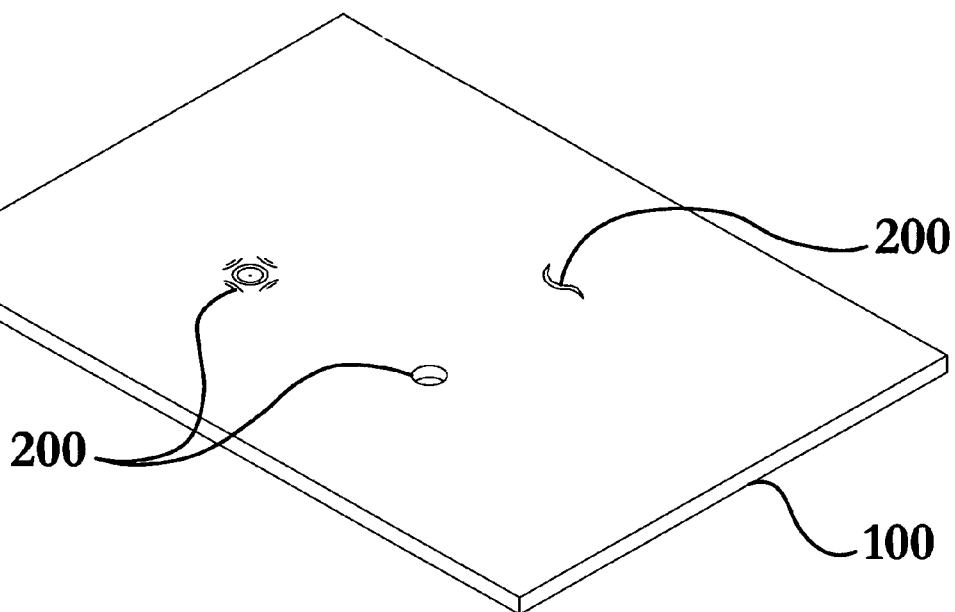
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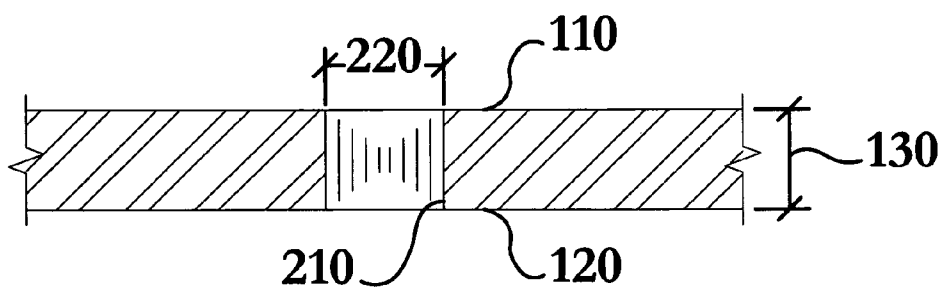
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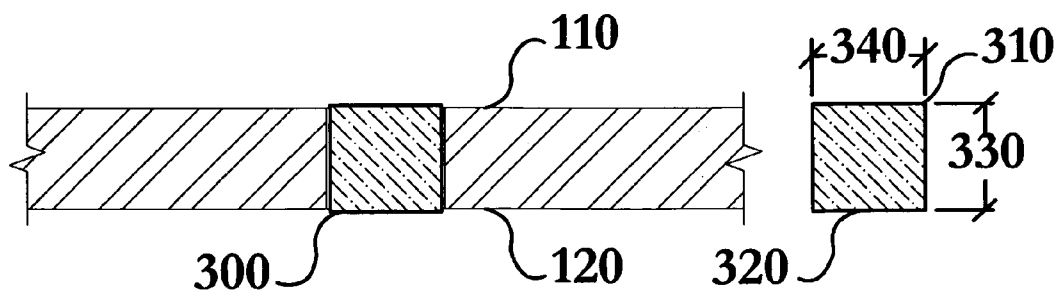
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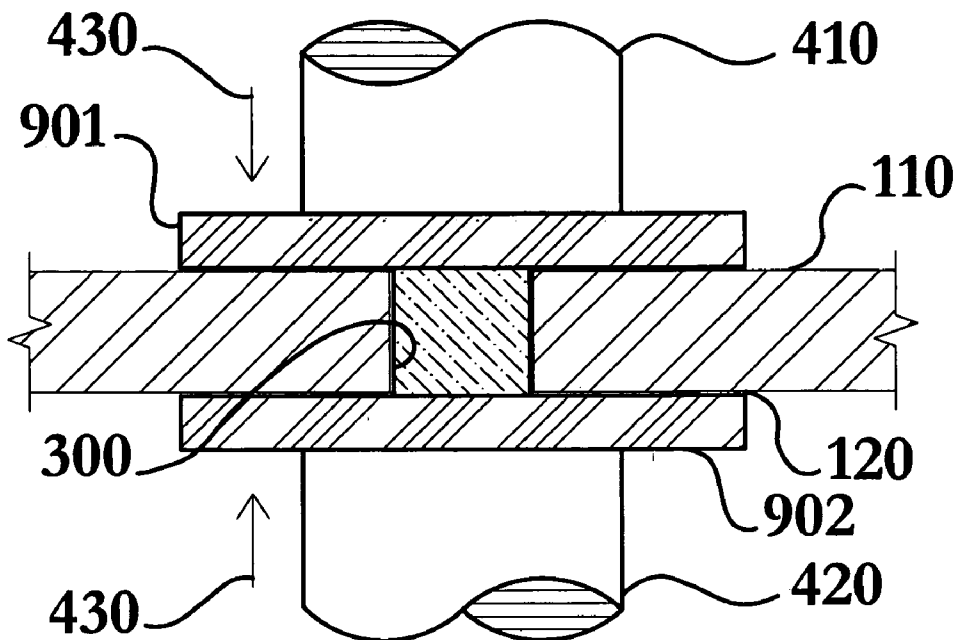
**FIG. 1**



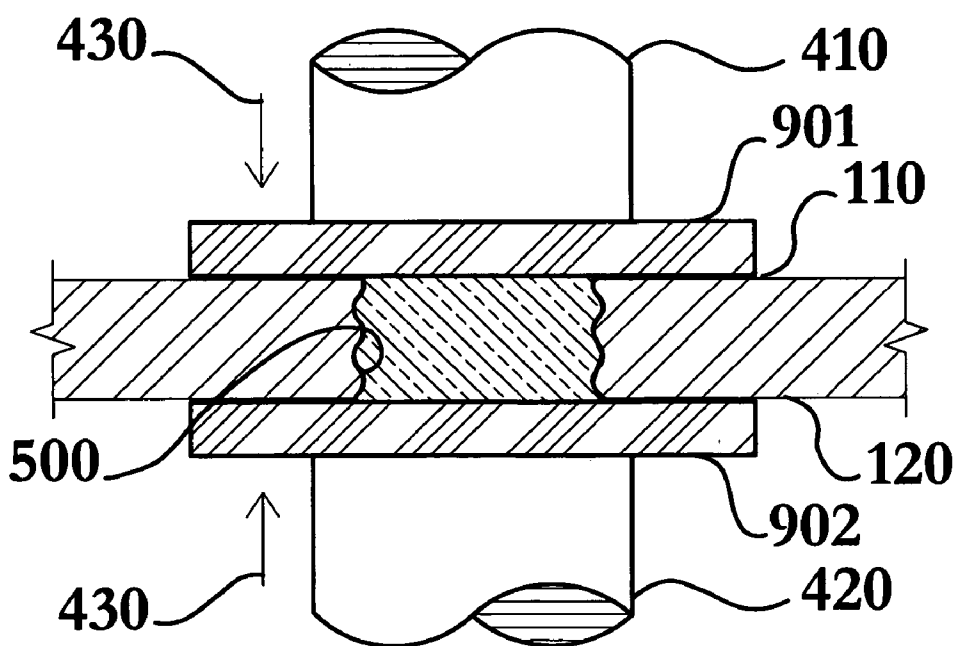
**FIG. 2**



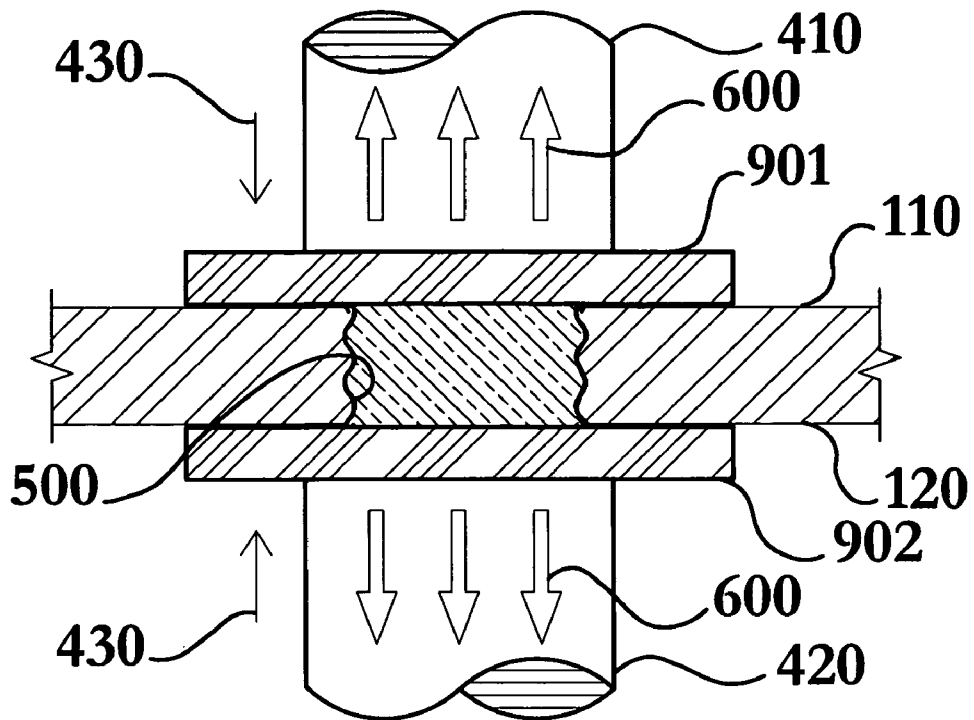
**FIG. 3**



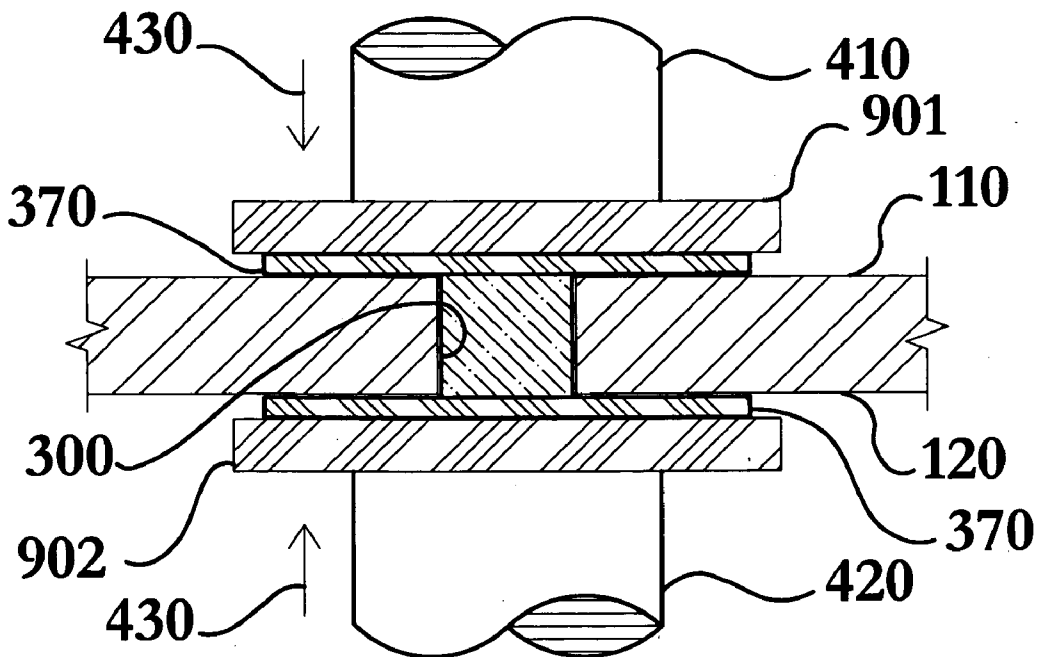
**FIG. 4**



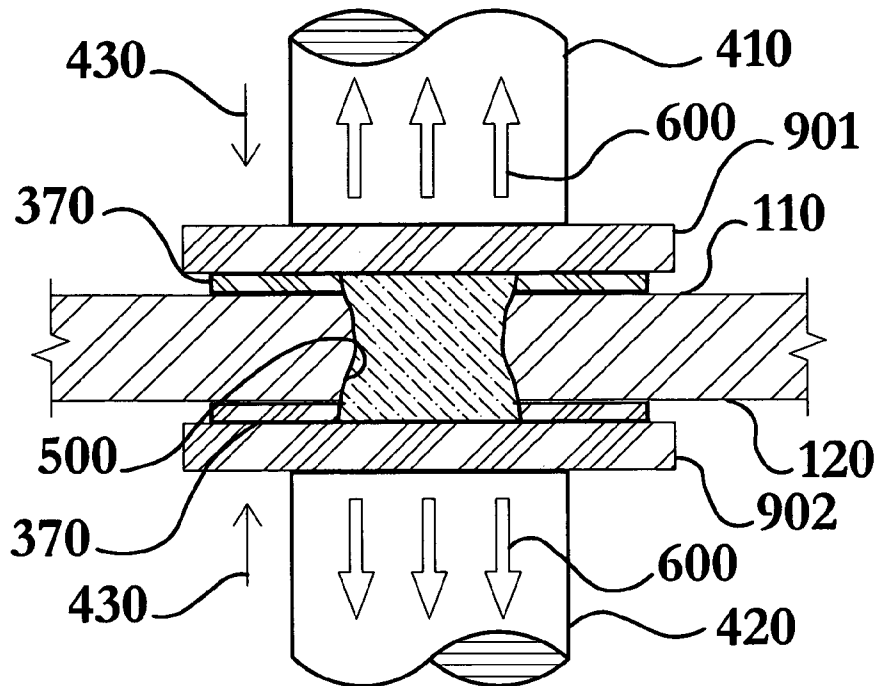
**FIG. 5**



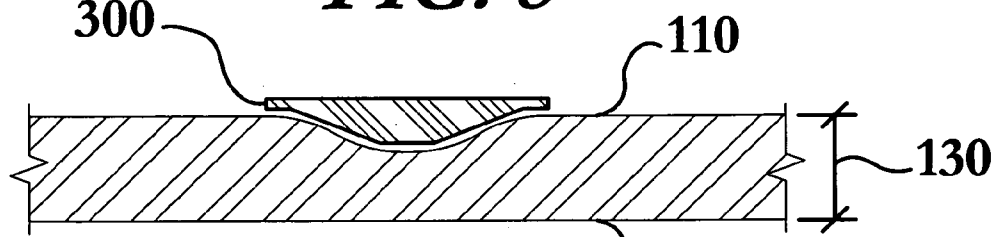
**FIG. 6**



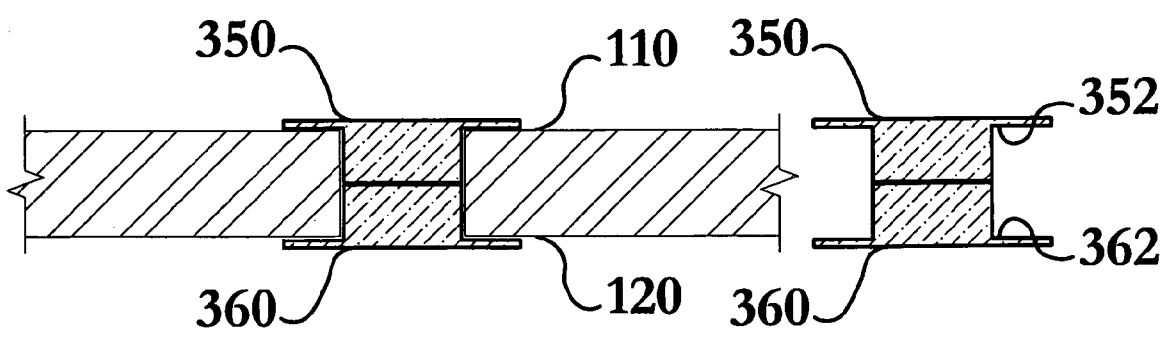
**FIG. 7**



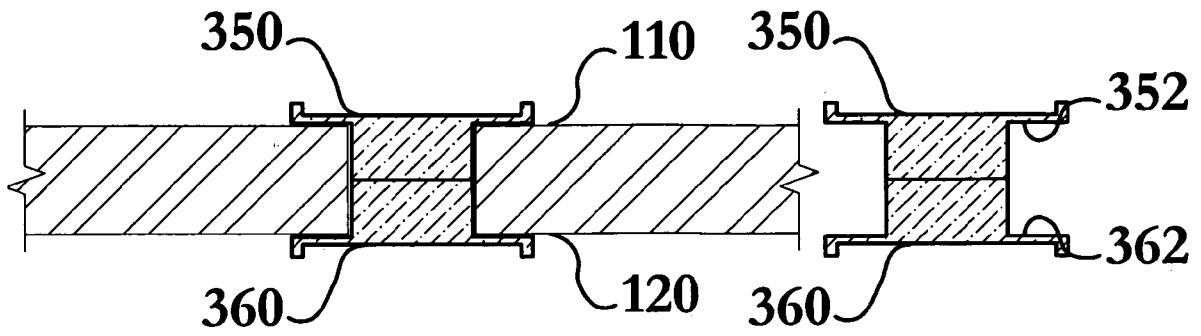
**FIG. 8**



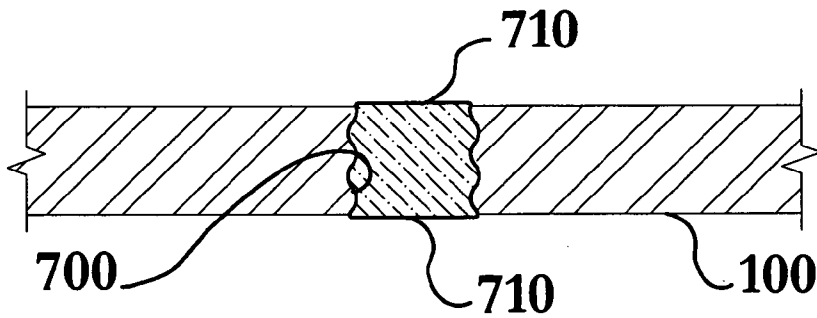
**FIG. 9**



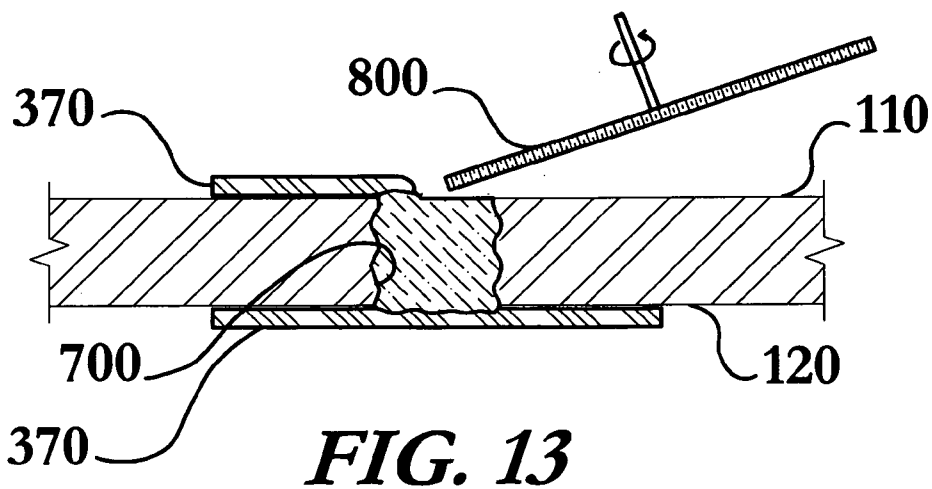
**FIG. 10**



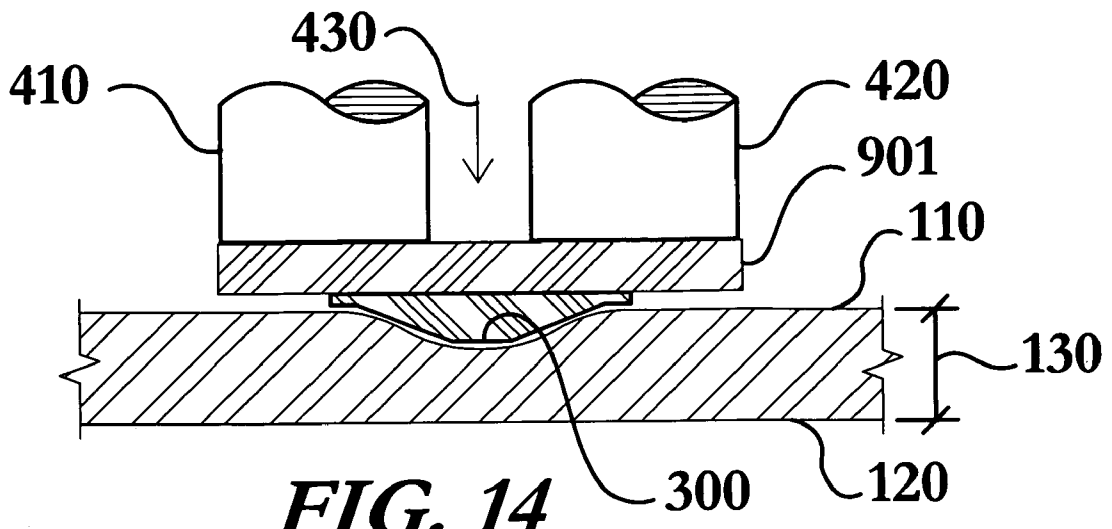
**FIG. 11**



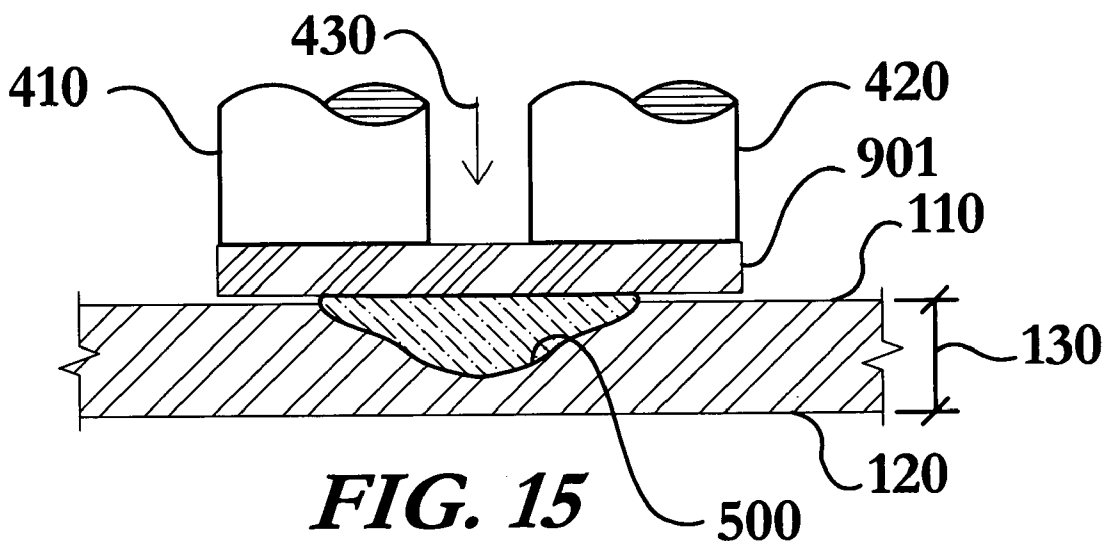
**FIG. 12**



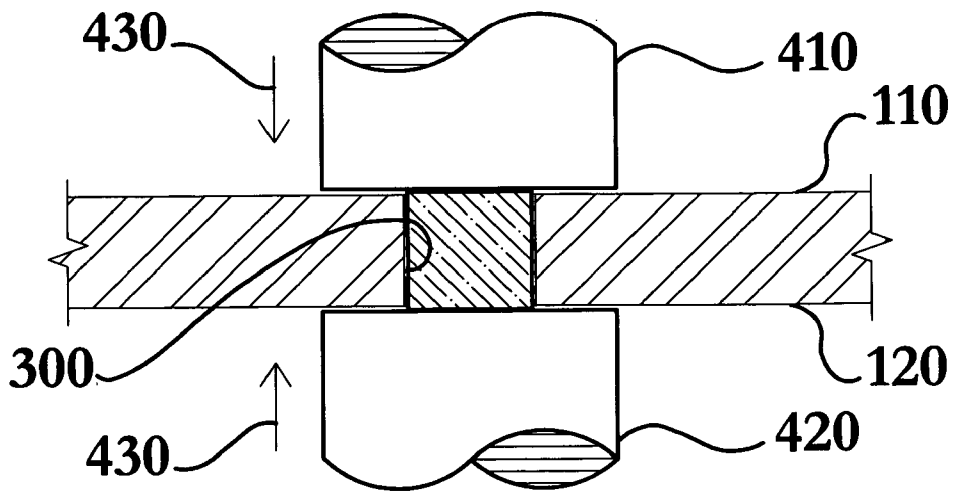
**FIG. 13**



**FIG. 14**



**FIG. 15**



**FIG. 16**



## METHOD FOR REPAIRING DEFECTS IN A CONDUCTIVE SUBSTRATE USING WELDING

### REFERENCE TO RELATED DOCUMENTS

This application is a continuation-in-part of a previous application filed in the United States Patent and Trademark Office on Feb. 5, 2004, titled "Method for Repairing Defects in a Metallic Substrate using Welding," and given Ser. No. 10/772,701, all of which is incorporated here by reference as if completely written herein.

### STATEMENT REGARDING FEDERALLY SPONSORED RESEARCH OR DEVELOPMENT

This invention was not made as part of a federally sponsored research or development project.

### TECHNICAL FIELD

The present invention relates to the field of material defect repair; particularly, to a method and apparatus for repairing material defects in conductive materials utilizing a consumable filler slug, at least one resistively heated electrically-conductive cover sheet, or alternatively electrodes having increased electrical and thermal resistivity, that is resistively heated and provides conductive heating of the weld zone, electrical current, and pressure to the conductively melted weld pool and repair the defect.

### BACKGROUND OF THE INVENTION

Repairing defects in manufactured assemblies costs industries hundreds of millions of dollars each year. In fact, many industries view repairing defects in assemblies constructed of relatively thin metallic sheet materials, and the very high cost of these repairs, as a necessary evil and have invested heavily in preventing such defects rather than identifying more cost effective ways to repair such defects. The aircraft industry is just one of many industries plagued by this problem.

In the aircraft industry, parts are often manufactured to very exacting tolerances. As such, penetrations in aircraft parts are generally not made until after the part is manufactured and meets the predetermined tolerances. Such penetrations may be required for the insertion of bolts, or rivets, or as a means for cooling the part. One can easily appreciate that many of the hundreds of thousands of such penetrations in an aircraft are misplaced during assembly despite even the most exacting quality control measures. Such undesired holes, or material defects, then need to be repaired, while minimizing negative effects to the part. Additionally, the need frequently arises to repair damaged, corroded, or worn holes in parts that have already been in service for a period of time.

The aircraft industry, as well as virtually all industries that experience similar problems, currently relies upon arc welding and friction plug welding to repair such defects. Arc welding repair of relatively thin sheet metallic substrates requires a very skilled welder. Additionally, no matter how skilled the welder, the very nature of arc welding results in a large amount of heat input that is applied asymmetrically over the defect to repair the defect. As such, arc welding repairs have large heat affected zones that can influence mechanical and corrosion performance in the repair area. The large heat affected zone often results in local distortion

of the repaired substrate that then requires post-weld treatment to return the substrate to the desired tolerances. A further limitation to arc welding repairs is the significant amount of pre and post-weld preparation of the defect area required to produce a quality weld and ensure the desired part geometry is produced.

An even greater limitation introduced when using arc welding to repair defects is that the repair weld is often of less than optimal quality and that filler materials must often be used that reduce performance of the component to improve the weldability of the surrounding substrate. This can result in repairs of significantly less strength than the surrounding substrate. For instance, filler metals having very high ductility, but less than desired strength and corrosion properties, are often required to minimize solidification cracking when using arc welding to repair defects in materials that have been in use for a period of time and suffer from reduced ductility. This is particularly true in the aircraft industry where holes often require repair after the aircraft has been in service for several years. In such repairs it is not uncommon that filler metals having strengths of 60% of the strength of the adjoining parent material are required so as to avoid solidification cracking of the weld repair.

As previously mentioned, friction plug welding has also been used to repair defects and holes in manufactured assemblies. Friction plug welding offers some advantages over the previously mentioned arc welding method in that it is a solid state process and produces a narrower heat affected zone. This minimizes the influence on mechanical and corrosion properties of the finished product.

The friction plug welding process has some definite limitations, which are primarily associated with the need to apply and react the mechanical loads associated with this process. Friction welding uses a consumable plug that must be rotated at high rpm and then pressed into a tapered hole to produce the repair. As such, the consumable plug is generally much larger than needed to produce the repair so that the plug can be rigidly gripped to allow the transfer of high speed and large loads. The reaction of the loads induced into the component by the plug typically requires specialized rigid tooling. The friction welding equipment used to produce the weld is typically very large due to the rotational energy that must be applied to the plug and the axial load necessary to force the plug into the tapered hole. An additional limitation of friction plug welding is that it requires line of sight access to the repair area, thereby limiting it to only the most simple repairs. Further, friction plug welding equipment is expensive and less readily available than arc welding or resistance welding equipment.

The parent application of this application, namely Ser. No. 10/772,701; filed on Feb. 5, 2004; titled "Method for Repairing Defects in a Metallic Substrate using Welding;" advances the state of the art by introducing a new resistance welding technique that incorporates a consumable filler slug, and in some embodiments, a sacrificial retainer. The method outlined in the Ser. No. 10/772,701 application dramatically changed how defects are repaired, however some highly conductive materials require additional consideration to coalesce the consumable filler slug and adjacent metallic substrate into a liquid pool via transmission of a reasonable amount of electrical current. The present invention solves the problems encountered in repairing conductive substrates.

Additionally, several of the present inventors invented the conductive heat seam welding method described in U.S. Pat. No. 6,545,244. While conductive heat seam welding has solved countless welding problems, only recently has the

present invention solved many issues surrounding the repair of defects in highly conductive substrates.

The instant invention addresses many of the shortcomings of the prior art and allows for previously unavailable benefits. A method of repairing defects in a substrate that overcomes many of the limitations of the prior art has long been needed. The method of the present invention is designed to reduce the need for a skilled welder to effect repairs, and to result in a repaired substrate having greatly improved material properties, while negating many of the limitations of prior repair techniques. The method accomplishes such improvements by utilizing a relatively low heat input applied over a very short period of time and cooling of the repaired substrate. Additional benefits of the present method arise from the substantially uniform application of heat to the repair region and the fact that it typically requires no special preparation of defects prior to repair. Further, the equipment used to produce the repair is common in many manufacturing facilities and is relatively inexpensive to procure and maintain.

#### SUMMARY OF INVENTION

In its most general configuration, the present invention advances the state of the art with a variety of new capabilities and overcomes many of the shortcomings of prior methods in new and novel ways. In one of the many preferable configurations, the method comprises a method of repairing defects in a conductive substrate using welding. The method comprises, in general, the steps of placing a consumable filler slug in contact with the substrate in the vicinity of the defect; placing at least one electrically conductive cover sheet in contact with at least a portion of the consumable filler slug; bringing a first electrode and a second electrode in contact with the at least one cover sheet and applying a pressure to the consumable filler slug; and transmitting electrical current between the electrodes, thereby resistively heating the at least one cover to a temperature above the melting point of the slug and the substrate. The at least one cover sheet then conductively heats the slug and a portion of the substrate resulting in coalescence in a substantially liquid pool that fills the defect; followed by cooling the substantially liquid pool to solidification under pressure.

The present method does not require the use of at least one electrically conductive cover sheet when appropriately designed electrically and thermally resistive electrodes are used. The use of such electrodes permits the electrodes themselves, to be resistively heated to a temperature above the melting temperature of the substrate and the consumable filler slug. The substrate and the consumable filler slug are then primarily resistively heated by the electrodes until they form a weld pool.

The substrate of the present invention may be formed of any resistance spot weldable substance, but has particular advantages in repairing materials having high electrical conductivity that makes these materials difficult to resistance weld. The method has particular application in repairing aluminum substrates. Substrates may be a single sheet of material having a first surface and a second surface, but this method may perform equally as well on substrates having complex curvature, variable thickness, and heterogeneous compositions.

The present method may repair defects having a wide variety of characteristics, such as tears, voids extending all the way through the substrate, dents, or areas of compression or reduced thickness. The method generally begins with the

placement of the consumable filler slug in contact with the substrate in the vicinity of the defect. The consumable filler slug may be formed in a number of equally effective configurations, such as single units or multiple sections, or conforming or merely roughly approximating the defect. The slug may also take the form of a washer or other configuration that works preferably with the electrodes or achieves desired flow to, or within, the defect.

An embodiment having multiple slug sections is contemplated. In such an embodiment, the consumable filler slug includes a first slug section and a second slug section such that the slug sections are configured to be in contact through the void. The consumable filler slug may be used in conjunction with at least one sacrificial retainer. The sacrificial retainer may be placed on each open end of the void, however, the present method is equally effective utilizing a single sacrificial retainer. A multi-part slug may incorporate exterior retaining lips that act in many ways as a sacrificial retainer.

The consumable filler slug and sacrificial retainer may be formulated to have properties similar, or dissimilar, to the substrate, or be made of the same material as the substrate. This can lead to the repaired area having substantially the same, or markedly different, properties from that of the substrate. For example, the present invention's ability to use consumable filler slugs of virtually any resistance weldable composition creates the ability to augment the strength or corrosion performance of the substrate.

The next step in the method includes bringing the electrodes in contact with the cover sheet(s), or directly in contact with a portion of the slug and/or substrate when cover sheets are not used, and applying a force on the slug. Then, an electrical current is transmitted from the first electrode to the second electrode through the cover sheet(s), when used, the slug, and a portion of the substrate. The current resistively heats the cover sheet(s), or electrodes when cover sheet(s) are not used, to a temperature above the melting temperature of the slug and substrate thereby resulting in the melting of a substantial portion of the slug and a portion of the substrate and coalescence into a substantially liquid pool that fills the defect. The first and second electrodes, or the cover sheet(s), exert a pressure on the substantially liquid pool as it is created and as it solidifies.

It is important to note that the use of a separate distinct cover sheet(s) is not required. For instance, electrodes that are more electrically and thermally resistive than commonly used for resistance spot welding may be used. In such a situation the electrodes themselves heat up past the melting point of the substrate and the consumable filler slug and create a weld pool by conduction.

This method does not require the use of a shielding gas, thereby reducing the cost of repairing defects as well increasing the versatility of the method. Additionally, the incorporation of a sacrificial retainer creates the ability to further seal the substantially liquid pool from the surrounding atmosphere, if desired. In such an embodiment, the sacrificial retainer is placed between the slug and the cover sheet(s) through which the current passes and resistively heats. A portion of the sacrificial retainer coalesces into the pool and a portion of the sacrificial retainer may remain solid and constrains the flow of the pool. In some embodiments the portion of the sacrificial retainer that remains solid may seal the pool from the surrounding atmosphere. The portion of the sacrificial retainer that remains solid, and any portion of the solidified pool, may be removed by finishing processes to bring the level of the repaired defect down to the

5

level of the adjoining substrate. Further, the cover sheet(s) tends to keep the electrodes clean.

With the instant invention, the period of the heat input and the amount of heat input of the present invention is significantly less than that of previous defect repair techniques. Further, the amount of heat that remains in the repaired substrate is significantly less using the method of the present invention, as will be discussed later herein, further reducing distortion and improving performance of the repaired defect.

The substantially liquid pool is then cooled to solidification. The pressure exerted on the substantially liquid pool during solidification reduces contraction stresses during solidification of the pool since the fusion zone remains under compressive loading. This tends to prevent solidification and liquation cracks from forming in the repaired defect. The cooling of the liquid pool is generally accomplished by utilizing water cooled electrodes, but may be accomplished through the use of a number of heat transfer processes. The cooling of the pool, as well as the short period of heat input, produces a repaired substrate containing very little residual heat. The small amount of residual heat in the repaired substrate and rapid cooling of the substantially liquid pool further minimize distortion and significantly improve the performance of the repaired defect.

After obtaining the desired predetermined level of cooling, the electrodes and cover sheet(s) are removed from contact with the slug and the repair is complete. Alternative embodiments may include providing local post-weld heat treatment after producing the repair, but before releasing the welding pressure. Such post-weld heat treatment may resistively heat the repair for a predetermined time to locally produce a predetermined microstructure. Additional embodiments may include additional steps such as a step of removing excess slug material so that the surface of the repaired defect is substantially consistent with the level of the adjoining substrate surface.

Variations, modifications, alternatives, and alterations of the various preferred embodiments, processes, and methods may be used alone or in combination with one another as will become more readily apparent to those with skill in the art with reference to the following detailed description of the preferred embodiments and the accompanying figures and drawings.

#### BRIEF DESCRIPTION OF THE DRAWINGS

Without limiting the scope of the present invention as claimed below and referring now to the drawings and figures:

FIG. 1 shows a substrate having various defect embodiments in elevated perspective view, not to scale;

FIG. 2 shows a partial cross-sectional view of the substrate having a cylindrical void, not to scale;

FIG. 3 shows a partial cross-sectional view of the substrate having a cylindrical void with a consumable filler slug in place, not to scale;

FIG. 4 shows a partial cross-sectional view of the setup of FIG. 3 with the electrodes and electrically conductive cover sheets in place, not to scale;

FIG. 5 shows a partial cross-sectional view of the setup of FIG. 4 having a substantially liquid pool, not to scale;

FIG. 6 shows a partial cross-sectional view of the setup of FIG. 5 with the electrodes removing heat from the cover sheets, pool, and substrate, not to scale;

FIG. 7 shows an embodiment incorporating a plurality of sacrificial retainers in partial cross-sectional view, with the electrodes and cover sheets in place, not to scale;

6

FIG. 8 shows a partial cross-sectional view of the setup of FIG. 7 having a substantially liquid pool, not to scale;

FIG. 9 shows an alternative defect containing a consumable filler slug in partial cross-sectional view, not to scale;

FIG. 10 shows an alternative embodiment of the consumable filler slug having a first slug section and a second slug section, in partial cross-sectional view, not to scale;

FIG. 11 shows an alternative embodiment of the consumable filler slug having a first slug section and a second slug section, in partial cross-sectional view, not to scale;

FIG. 12 shows a repaired defect after removal of the excess consumable filler slug, in partial cross-sectional view, not to scale;

FIG. 13 shows a repaired defect having the repaired surface brought to the level of the surrounding surfaces, in partial cross-sectional view, not to scale;

FIG. 14 shows the embodiment of FIG. 9 in partial cross-sectional view, with the electrodes and cover sheet in place, not to scale;

FIG. 15 shows the embodiment of FIG. 14 in partial cross-sectional view having a substantially liquid weld pool, not to scale; and

FIG. 16 shows a partial cross-sectional view of the setup of FIG. 3 with the electrodes in place, not to scale.

#### DETAILED DESCRIPTION OF THE INVENTION

The method for repairing a defect in a substrate using welding enables a significant advance in the state of the art. The preferred embodiments of the apparatus accomplish this by new and novel methods that are configured in unique and novel ways and which demonstrate previously unavailable but preferred and desirable capabilities. The description set forth below in connection with the drawings is intended merely as a description of the presently preferred embodiments of the invention, and is not intended to represent the only form in which the present invention may be constructed or utilized. The description sets forth the designs, functions, means, and methods of implementing the invention in connection with the illustrated embodiments. It is to be understood, however, that the same or equivalent functions and features may be accomplished by different embodiments that are also intended to be encompassed within the spirit and scope of the invention.

One exemplary embodiment of the method for repairing a defect **200** in a substrate **100** using welding includes the steps of placing a consumable filler slug **300** in contact with the substrate **100** in the vicinity of the defect **200**; placing at least one electrically conductive cover sheet **901** in contact with at least a portion of the consumable filler slug **300**; bringing a first electrode **410** and a second electrode **420** in contact with the at least one cover sheet **901** and applying a pressure to the consumable filler slug **300**; transmitting electrical current from the first electrode **410** to the second electrode **420** through the at least one cover sheet **901** and the consumable filler slug **300** for a period of time such that the at least one cover sheet **901** is thereby resistively heated, which then conductively heats the consumable filler slug **300** and a portion of the substrate **100** resulting in coalescence in a substantially liquid pool **500** that fills the defect **200**; cooling the substantially liquid pool **500** to solidification under the pressure of the first electrode **410** and the second electrode **420**; and removing the at least one cover sheet **901** from contact with the repaired substrate.

An alternative embodiment of the present method for repairing a defect **200** in a substrate **100** using welding

eliminates the use of the at least one electrically conductive cover sheet **901** and utilizes more electrically and thermally resistive electrodes **410**, **420**. The method of this embodiment includes the steps of placing a consumable filler slug **300** in contact with the substrate **100** in the vicinity of the defect **200**; bringing a first electrode **410** and a second electrode **420** in contact with at least a portion of the consumable filler slug **300** and applying a pressure to the consumable filler slug **300**; transmitting electrical current from the first electrode **410** to the second electrode **420** through the consumable filler slug **300** for a period of time such that the electrodes **410**, **420** are resistively heated, which then conductively heat the consumable filler slug **300** and a portion of the substrate **100** resulting in coalescence in a substantially liquid pool **500** that fills the defect **200**; cooling the substantially liquid pool **500** to solidification under the pressure of the first electrode **410** and the second electrode **420**; and removing the at least one cover sheet **901** from contact with the repaired substrate. In this embodiment, illustrated in FIG. 16, the electrodes **410**, **420** incorporate electrically and thermally resistive materials having a higher melting temperature than that of the substrate **100** and the consumable filler slug **300**.

The substrate **100** of the present invention may be formed of any resistance spot weldable substance. The method may be used to repair aluminum, lead, copper, brass, and other alloys; provided that the material to be repaired has a lower melting point than the at least one cover sheet **901**. The at least one cover sheet **901** is typically steel such as SAE 1010/1080, but can include various other cover materials including cobalt, nickel, and stainless steel that melt at temperatures greater than the consumable filler slug **300** and the substrate **100**. The method has particular advantages in repairing aluminum, titanium alloys, and high strength austenitic nickel-chromium-iron alloys and superalloys, but may be used with virtually any material that conducts electricity, including electrically conductive plastics. The method is particularly useful with materials, such as aluminum, that are extremely difficult to resistively heat due to their high level of conductivity. Further, the method greatly reduces the porosity and cracking that is typically associated with resistively welded aluminum, particularly aluminum spot welds. This method reverses the direction of solidification of the weld pool **500** when compared to welds completed using resistance welding.

Utilization of conduction from the outer surface of the substrate **100** results in the solidification of the weld pool **500** from the center outward toward the substrate surfaces **110**, **120**, not from the surfaces inward as with resistance welding. This is easy to recognize by reviewing FIGS. 4, 5, and 6. For example, in FIG. 4 the current passes from the first electrode **410** to the second electrode **420** and is met with great resistance at the first cover sheet **901** and the second cover sheet **902**, or at the electrodes **410**, **420** themselves when cover sheets **901**, **902** are not used, while being met with very little resistance by the conductive substrate **100** and the consumable filler slug **300**. Therefore, the first and second cover sheets **901**, **902**, or the first and second electrodes **410**, **420**, are resistively heated and reach a temperature higher than the melting point of the conductive substrate **100** and the consumable filler slug **300** resulting in coalescence of a portion of the conductive substrate **100** and the consumable filler slug **300** in a weld pool **500**, as seen in FIG. 5. The heat from the resistively heated cover sheets **901**, **902**, or the resistively heated electrodes **410**, **420**, is conductively transferred away from the substrate's first and second surfaces **110**, **120** and toward the middle of

the substrate **100**. Therefore, the weld pool **500** will be highest in temperature at the surfaces **110**, **120** and lowest in temperature at the point farthest from the surfaces **110**, **120**, or the middle of the substrate **100**. Once the cover sheets **901**, **902**, or electrodes **410**, **420**, are no longer resistively heated and the weld pool **500** is allowed to cool it solidifies from the coolest area of the weld pool to the hottest area, in other words, from the middle of the substrate **100** outward toward the surfaces **110**, **120**. Further, the solidification is occurring as the electrodes **410**, **420** are exerting force **430** on the weld pool **500**, ensuring the weld pool **500** remains under compression during solidification, thereby minimizing porosity and cracking. In contrast, resistance welding of the substrate **100** would result in a weld pool **500** that solidifies from the substrates surfaces **110**, **120** toward the middle of the substrate **100**, or center of the fusion zone. Further, the present method can be conducted at much lower currents than typical resistance spot welding. For example, a typical resistance spot weld of 1.5-mm thick aluminum would require 30,000 Amps, whereas a conductive heat weld of the present invention may be produced at approximately 15,000 Amps.

Additionally, the substrate **100** may be configured in any number of ways that facilitate the transfer of current through the defect **200**. The substrate **100** is illustrated in FIG. 1 through FIG. 16 as a single sheet of material having a first surface **110** and a second surface **120**. One with skill in the art will appreciate that this is just one illustrative embodiment and that this method may perform equally as well on substrates **100** of varied geometries including, but not limited too, substrates **100** having complex curvature, variable thickness, and heterogeneous compositions. Further, one with skill in the art will recognize that the shape of the weld pool **500** in FIGS. 5, 6, 8, and 15 is merely schematic in nature and does not represent the actual shape of the weld pool in practice.

The present method may repair defects **200** having a wide variety of characteristics. For instance, the method may be used to repair defects **200** that consist of a tear in the substrate **100**, those that are voids **210** extending all the way through the substrate **100**, dents, or areas of compression or areas of reduced thickness, in the substrate **100**, as seen in FIG. 1, and any number of surface imperfections such as corroded holes, mislocated holes, oversized holes, and holes that are out of round. The method is described herein generally with reference to a defect **200** that is a void **210** extending through the substrate **100** from the first surface **110** to the second surface **120**, as illustrated in FIG. 2, but the method applies equally to a number of other defects **200** referred to herein and others known to those in the field.

As previously expressed, the method generally begins with the placement of the consumable filler slug **300** in contact with the substrate **100** in the vicinity of the defect **200**. The consumable filler slug **300** may be formed in a number of equally effective configurations. For instance, as illustrated in FIG. 3, the consumable filler slug **300** may be a single unit or may be composed of multiple slug sections, as seen in FIG. 10. The consumable filler slug **300** may, but is not required to, substantially conform to the shape and configuration of the defect **200**. For instance, FIG. 9 illustrates an embodiment having a consumable filler slug **300** that substantially conforms to the shape of the dent, or defect **200**. The consumable filler slug **300** of the present embodiment may be formed in any number of alternative shapes. For instance, the filler slug **300** may take the form of a

washer or other configuration that works preferably with the at least one cover sheet **901** or achieves desired flow to, or within, the defect **200**.

Similarly, the consumable filler slug **300** may be configured to substantially conform to the void **210** extending through the substrate **100**, as illustrated in FIG. 3. The void **210** of this particular embodiment is substantially cylindrical in shape having a diameter **220** and a length equal to the thickness **130** of the substrate **100**, as seen in FIG. 2. However, in practice it is common for the void **210** to have a length that is less than the substrate **100** when necking of the material has occurred. This particular embodiment will be referred to throughout for ease of explanation and illustration. Referring again to FIG. 3, an embodiment of the consumable filler slug **300** for such a void **210** is one being substantially cylindrical in shape, having a diameter **340**, and a distal end **310** and a proximal end **320** separated by a length **330**. Typically, the diameter **340** of the consumable filler slug **300** is less than the diameter **220** of the void **210** for ease of installation, but this is not required and a consumable filler slug **300** that necessitates being driven into the defect **200** is anticipated.

An embodiment having multiple slug sections is illustrated in FIG. 10. In this embodiment the consumable filler slug **300** includes a first slug section **350** and a second slug section **360**. The first slug section **350** and the second slug section **360** may, or may not, be in contact through the void **210**. In this particular embodiment the first slug section **350** and the second slug section **360** incorporate retaining lips **352**, **362** to provide the same advantages as the sacrificial retainers **370**, discussed later herein. Further, retaining lips **352**, **362** of FIG. 10 may be formed with upturned edges, as seen in FIG. 11. The upturned retaining lips **352**, **362** of FIG. 11 may be configured to cooperate with the shape of the first and second cover sheets **901**, **902** or the electrodes **410**, **420**. The configuration of FIG. 11 promotes accurate alignment and placement of the consumable filler slugs **350**, **360** and the cover sheets **901**, **902** or electrodes **410**, **420**, and may reduce, or eliminate, the need for non-electrically conductive locating fixtures. Similarly, the at least one cover sheet **901** may be configured to cooperate with the electrodes **410**, **420**. Further, the cover sheets **901**, **902** may be attached to the electrodes **410**, **420** as accessories, or may be built into the electrodes **410**, **420**.

The consumable filler slug **300** may be used in conjunction with at least one sacrificial retainer **370**, as seen in FIG. 7. The embodiments illustrated in FIG. 7 and FIG. 8 utilize a sacrificial retainer **370** on each open end of the void **210**, however the present method is equally effective utilizing a single sacrificial retainer **370**. In a further embodiment the beneficial features of the sacrificial retainer **370** may be incorporated directly into the consumable filler slug **300**, as will be explained later herein.

The consumable filler slug **300** and the sacrificial retainer **370** may be formulated to have properties similar, or dissimilar, to the substrate **100**. In fact, the consumable filler slug **300** and the sacrificial retainer **370** may be the same material as the substrate **100**. This is particularly beneficial in that the repaired defect **700** is no longer limited by the use of a limited number of filler products, as is the case with GTAW welding.

For example, it is widely understood that grain size plays a notable role in both notched and smooth fatigue tests of many titanium alloys. Generally, GTAW repairs of titanium sheet metal result in grains having a diameter between approximately one-half of the metal thickness to the entire thickness, thereby greatly reducing the performance of the

repair. The method of the present invention may be used to produce fine grained structure in the repaired defect and a minimal heat affected zone. In fact, the present method may be used to achieve grain size in the repaired defect that is close to that of the base metal. Such grain size control may be used to greatly enhance the performance of the repaired defect, especially in fatigue. For example, the changes in fatigue strength of TI-6Al-4V at  $10^7$  cycles to failure may vary between 406 MPa and 551 MPa, depending on grain size. This method may be used to control grain size such that the best performance grain size for each alloy may be achieved in the repaired defect.

In yet another example, GTAW welds are generally used to repair defects **200** in 6061 aluminum. In this situation a 4043 aluminum filler is used. The deposited weld metal in the defect **200**, a misplaced rivet hole in this example, generally has a yield strength of 10,500 psi and an ultimate strength of 21,000 psi. The present method may use a consumable filler slug **300** of 6061 aluminum, which after repair and heat treatment can achieve a yield strength of 39,000 psi and an ultimate strength of 45,000 psi, an improvement of almost a factor of 4 for the yield strength and more than doubling the ultimate strength.

A further example of the benefits of this invention is illustrated in nickel-based and cobalt alloys that have been in service and require repair of a defect **200**. Repairing the defect **200** in such a material generally requires the use of a filler metal having high ductility because of elongation of the base material during its life which tends to promote solidification cracking of repairs. For instance the strength of an overaged high strength austenitic nickel-chromium-iron alloy part can be approximately 180,000 psi, but the part will generally have very low ductility. Therefore, repairing a defect **200** in such a material may require the use of a lower strength alloy having high ductility to reduce the likelihood of cracking, but a strength of only 100,000 psi. Such ductility problems are eliminated by the present invention, in part due to the fact that the substantially liquid pool **500** is kept under constant compressive loading, as will be discussed later herein.

Still further, the present invention's ability to use consumable filler slugs **300** of virtually any composition creates the ability to augment the strength of the substrate **100**. This ability is desired in a number of industries. For instance, in many industries the thickness of sheet metal parts is determined by the allowable stress at a particular load connection point, such as a rivet or bolt hole. If the strength of the material could be locally augmented in the vicinity of the rivet or bolt hole, then the thickness of the remainder of the part may be reduced. In high temperature applications, such as the combustor of a jet engine, it would be advantageous to place a material with better corrosion and oxidation resistance at higher temperatures in only those areas subjected to particularly high loading, while constructing the bulk of the combustor from less expensive materials. As such, the present method may be used to create engineered surfaces designed to accept the higher temperatures in particular areas. This may be accomplished by using the method of the present invention to essentially line a bolt or rivet hole in one substrate with a material having better corrosion or oxidation resistance characteristics.

The next step in the method includes bringing a first electrode **410** and a second electrode **420** in contact with the at least one electrically conductive cover sheet **901** and applying a pressure, or force **430**, to the consumable filler slug **300**, as seen in FIG. 4. Alternatively, in one particular embodiment the at least one electrically conductive cover

sheet **901** is eliminated and the first electrode **410** and/or the second electrode **420** contact a portion of the consumable filler slug **300**, as seen in FIG. **16**. Then, an electrical current is transmitted from the first electrode **410** to the second electrode **420** through the consumable filler slug **300**, potentially a portion of the substrate **100**, and in some embodiments the at least one cover sheet **901** for a period of time, thereby resistively heating the at least one cover sheet **901**, or the electrodes **410**, **420**, and conductively heating the more electrically conductive consumable filler slug **300** and the substrate **100**. The heat generated in the at least one cover sheet **901** or the electrodes **410**, **420** is conductively transferred to consumable filler slug **300** and substrate **100** results in the melting of a substantial portion of the consumable filler slug **300** and a portion of the substrate **100**, resulting in coalescence into a substantially liquid pool **500** that fills the defect **200**, illustrated in FIG. **5**. The first and second electrodes **410**, **420**, or the at least one cover sheet **901**, exert a pressure on the substantially liquid pool **500** as it is created and as it solidifies.

The embodiment in which the at least one electrically conductive cover sheet **900** is eliminated has advantages in certain situations. For example, elimination of the at least one cover sheet **900**, as seen in FIG. **16**, simplifies the welding process, reduce part count, and eliminates a source of variability. In this embodiment electrodes **410**, **420** that are more resistive than those that would be normally selected for proper resistance welding are used. By substituting a more resistive electrode material such as a Resistance Welding Manufacturers Association (RWMA) Class 10, 11, 12, 13, 14, or other similar material, in place of the typical RWMA Class 1 material it is possible to eliminate the need for the at least one cover sheet **900** when repairing highly electrically conductive substrates **100** such as aluminum alloys, coppers, and brasses.

The use of more electrically and thermally resistive electrode materials on a highly electrically and thermally conductive sheet metal resistance spot or seam welding application defies conventional wisdom since pure copper or RWMA Class 1 material is typically recommended by the RWMA Handbook and American Welding Society (AWS) Handbook. Class 10–14 materials do not work for traditional spot or seam welding because in such processes the weld nugget is grows from the inside to the outside, or the middle of the substrate **100** to the surfaces **110**, **120**. For such traditional spot or seam welding the melting of the substrate **100** all of the way to the outer surface is avoided. By using Class 1 material, the outer surfaces have less heat build up and the electrodes are more effectively cooled. Conversely, with the present method the weld nugget grows from the exterior surfaces **110**, **120** of the substrate **100** to the middle of the substrate **100**. The electrically and thermally resistive electrodes **410**, **420** of the present embodiment are generally constructed of between approximately 55% and approximately 100% Tungsten and between approximately 45% and approximately 1% Copper, or 100% Molybdenum. Those with materials engineering experience will recognize that numerous other electrically and thermally resistive materials may be used for the electrodes **410**, **420** including tungsten based materials made using high temperature powder metallurgy techniques and tungsten-copper press-sinter-infiltrated materials normally with the tungsten content ranging from 50% to 90% by weight, just to name a few.

Unlike other repair techniques, the thermal cycle of the present method is so rapid that oxidation is not an issue. As such, this method does not require the use of a shielding gas, thereby reducing the cost of repairing defects **200** as well as

increasing the versatility of the method. Additionally, the at least one cover sheet **901** helps minimize tip sticking and pickup on the welding electrode, thereby lengthening the electrode tip life. For instance, the substantially liquid pool **500** illustrated in FIG. **8** is sealed from the surrounding atmosphere by the sacrificial retainers **370** and the cover sheets **901**, **902** in approximately  $\frac{1}{100}$  second. In such an embodiment the sacrificial retainer **370** is placed between the consumable filler slug **300** and the first cover sheet **901** through which the current passes and resistively heats. A portion of the sacrificial retainer **370** coalesces into the pool **500** and a portion of the sacrificial retainer **370** remains solid and constrains the flow of the pool **500** and seals the pool **500** from the surrounding atmosphere. The portion of the sacrificial retainer **370** that remains solid, and any portion of the solidified pool, may be removed by finishing processes to bring the level of the repaired defect down to the level of the adjoining substrate **100**, as seen in FIG. **13**.

In yet another embodiment the method is performed such that the electrical current is substantially uniformly transmitted from the first electrode **410** to the second electrode **420**. Such uniform transmission results in substantially symmetric resistive heating of the at least one cover sheet **901** or the electrodes **410**, **420**, and substantially symmetric conductive heating of the consumable filler slug **300** and a portion of the substrate **100** and substantially uniform heating of the defect **200**, unlike previous defect **200** repair techniques having non-symmetric thermal profiles around the defect **200** during repair and solidification. The application of nearly uniform heat around the entire perimeter of the defect **200** substantially eliminates distortion. Repairs made using GTAW welds generally require extensive rework to return the repaired substrate **100** to the original tolerances.

Additionally, the period of the heat input and the amount of heat input of the present invention is significantly less than that of previous defect repair techniques. For example, the present method may utilize a heat input of roughly 15,000 joules to repair most defects, whereas commonly used GTAW weld repair produces approximately 23,400 joules of heat input, over fifty percent more than the present invention. Further, the amount of heat that remains in the repaired substrate **100** is significantly less using the method of the present invention, as will be discussed later herein, further reducing distortion and improving performance of the repaired defect **700**.

The substantially liquid pool **500** is then cooled to solidification. The pressure exerted on the substantially liquid pool **500**, during solidification ensures that tensile stress is reduced during solidification of the pool **500** since the fusion zone remains under compressive loading. This tends to prevent solidification cracks from forming in the repaired defect **700**. The liquid pool **500** is generally allowed to air cool, however the cooling of the liquid pool **500** may be accomplished by utilizing water cooled electrodes for the first and second electrode **410**, **420** or through the use of a number of heat transfer processes, as illustrated by the heat transfer flow arrows **600** in FIG. **6** and FIG. **8**. The cooling of the pool **500**, as well as the short period of heat input, produces a repaired substrate **100** containing very little residual heat. For example, the previously discussed sample produced using this method had approximately 150 joules of residual heat almost immediately after being subjected to 15,000 joules. Conversely, the sample repaired using GTAW welding had roughly one hundred percent of the input 23,400 joules remaining in the substrate **100** upon completion of the repair. One embodiment of the present method is specifically directed to producing a repaired substrate **100**

13

having less than approximately 1–5% of the heat input actually remaining in the repaired substrate **100** upon completion of the repair.

The small amount of residual heat in the repaired substrate **100** and rapid cooling of the substantially liquid pool **500** further minimize distortion and significantly improve the performance of the repaired defect **700**. For instance, the rapid cooling of the liquid pool **500** under pressure can significantly reduce the grain size in the resulting repaired substrate **100**. These benefits are particularly beneficial in the repair of titanium because the process greatly reduces, or eliminates, the formation of alpha case in the titanium, which is highly undesirable in fatigue sensitive applications. In yet another embodiment of this invention, the amount of cooling applied to the pool **500** is varied as the pool **500** solidifies to achieve a desired predetermined property. For instance, the varied cooling may be tuned to obtain a preferred grain size in the repaired substrate **100**. Additionally, the cooling rate may be set for a preferred cooling rate of the material of the substrate **100**.

After obtaining the desired predetermined level of cooling, the first electrode **410** and the second electrode **420** are removed from contact with the consumable filler slug **300** and the repair is complete, as seen in FIG. **12**. Alternative embodiments may include additional steps such as a step of removing excess consumable filler slug **300** material with a material processing device **800**, such as a grinder, so that the surface **710** of the repaired defect **700** is substantially consistent with the level of the adjoining substrate **100** surface, illustrated in FIG. **13**. Removal of excess consumable filler slug **300** material is often desired as it may serve as an indicator that the entire defect **200** has been repaired.

Numerous alterations, modifications, and variations of the preferred embodiments disclosed herein will be apparent to those skilled in the art and they are all anticipated and contemplated to be within the spirit and scope of the instant invention. For example, although specific embodiments have been described in detail, those with skill in the art will understand that the preceding embodiments and variations can be modified to incorporate various types of substitute and or additional or alternative materials, relative arrangement of elements, and dimensional configurations. Accordingly, even though only few variations of the present invention are described herein, it is to be understood that the practice of such additional modifications and variations and the equivalents thereof, are within the spirit and scope of the invention as defined in the following claims. The corresponding structures, materials, acts, and equivalents of all means or step plus function elements in the claims below are intended to include any structure, material, or acts for performing the functions in combination with other claimed elements as specifically claimed.

We claim:

**1.** A method for repairing a defect in a conductive substrate using welding, the substrate having a first surface and a second surface, the method comprising:

- a) placing a consumable filler slug in contact with the defect;
- b) applying a sacrificial retainer in contact with at least a portion of the consumable filler slug;
- c) placing at least one electrically conductive cover sheet in contact with at least a portion of the sacrificial retainer, the cover sheet having a melting temperature higher than that of the conductive substrate, the consumable filler slug, and the sacrificial retainer;
- d) placing a first electrode and a second electrode in contact with the at least one cover sheet and transmit-

14

ting electrical current from the first electrode to the second electrode for a period, thereby resistively heating the at least one cover sheet and conductively heating a portion of the sacrificial retainer, a portion of the consumable filler slug, and a portion of the substrate resulting in coalescence in a substantially liquid pool that substantially fills the defect, the first electrode and the second electrode applying pressure to the substantially liquid pool;

- e) cooling the substantially liquid pool to solidification under the pressure of the first electrode and the second electrode producing a repaired substrate; and
- f) removing the at least one cover sheet from the repaired substrate.

**2.** The method of claim **1**, further including the step of applying a sacrificial retainer between the consumable filler slug and the resistively heated at least one cover sheet, wherein the resistively heated at least one cover sheet conductively heats a portion of the sacrificial retainer, the consumable filler slug, and the substrate resulting in coalescence of a portion of the sacrificial retainer into the pool.

**3.** The method of claim **1**, wherein the defect is a void extending from the substrate first surface to the substrate second surface.

**4.** The method of claim **3**, wherein the consumable filler slug includes a first slug section and a second slug section, the first slug section having a retaining lip configured to be in contact with the substrate first surface and the second slug section having a retaining lip configured to be in contact with the substrate second surface such that as the at least one electrically conductive cover sheet conductively heats the first slug section and the second slug section a portion of each retaining lip coalesces into the pool.

**5.** The method of claim **1**, further including the step of applying a first electrically conductive cover sheet and a first sacrificial retainer between the consumable filler slug and the first electrode and applying a second electrically conductive cover sheet and a second sacrificial retainer between the consumable filler slug and the second electrode, wherein the void is substantially cylindrical in shape, having a diameter and a volume, and the consumable filler slug is substantially cylindrical having a diameter smaller than the diameter of the void, a volume, and a distal end and a proximal end whereby the consumable filler slug is configured to be received by the void, such that current passes and resistively heats the first and second electrically conductive cover sheets thereby conductively heating the first sacrificial retainer, the consumable filler slug, a portion of the substrate, and the second sacrificial retainer resulting in the coalescence of the consumable filler slug, a portion of the substrate, and a portion of the sacrificial retainers into the weld pool.

**6.** The method of claim **5**, wherein the electrical current is substantially uniformly transmitted from the first electrode to the second electrode thereby substantially symmetrically resistively heating the first and second electrically conductive cover sheets thereby substantially symmetrically conductively heating the consumable filler slug, the first and second sacrificial retainers, and the substrate and substantially uniformly heating the defect.

**7.** The method of claim **1**, wherein the period of transmitting electrical current from the first electrode to the second electrode is less than approximately 3 seconds.

**8.** The method of claim **1**, wherein less than approximately 5% of the heat input to the at least one conductive cover sheet by the transmission of current from the first



15

electrode to the second electrode remains in the repaired substrate upon removal of the first electrode and the second electrode.

9. The method of claim 1, wherein the amount of cooling applied to the pool is varied as the pool solidifies to achieve a desired predetermined property.

10. The method of claim 9, wherein the substrate is metallic and the desired predetermined property is a preferred grain size.

11. The method of claim 1, wherein the consumable filler slug is composed of the same material as the substrate.

12. The method of claim 1, wherein the repaired substrate is substantially free of distortion.

13. The method of claim 1, wherein the repaired substrate is substantially free of solidification cracks.

14. A method for repairing a defect in a conductive substrate using welding, the substrate having a first surface and a second surface, wherein the defect is a void extending from the substrate first surface to the substrate second surface, the method comprising:

- a) placing a consumable filler slug in contact with the void;
- b) placing a first electrode and a second electrode in contact with a portion of the consumable filler slug and transmitting electrical current from the first electrode to the second electrode for a period, the first electrode and the second electrode incorporating an electrically and thermally resistive material having a melting temperature higher than that of the conductive substrate and the consumable filler slug, such that the electrodes are resistively heated to a temperature above the melting point of the conductive substrate and the consumable filler slug thereby conductively heating a portion of the consumable filler slug and a portion of the substrate resulting in coalescence in a substantially liquid pool that substantially fills the void while the first electrode and the second electrode apply a pressure to the substantially liquid pool, wherein the consumable filler slug includes a first slug section and a second slug section, the first slug section having a retaining lip configured to be in contact with the substrate first surface and the second slug section having a retaining lip configured to be in contact with the substrate second surface such that as the first electrode and the second electrode conductively heat the first slug section and the second slug section portion of each retaining lip coalesces into the pool; and
- c) cooling the substantially liquid pool to solidification under the pressure of the first electrode and the second electrode producing a repaired substrate.

15. The method of claim 14, further including the step of applying a sacrificial retainer between the consumable filler slug and either the first electrode or the second electrode, wherein the resistively heated first and second electrodes conductively heat a portion of the sacrificial retainer, the consumable filler slug, and the substrate resulting in coalescence of a portion of the sacrificial retainer into the pool.

16. The method of claim 14, wherein the first electrode and the second electrode include at least approximately fifty percent tungsten by weight.

17. The method of claim 14, wherein the period of transmitting electrical current from the first electrode to the second electrode is less than approximately 3 seconds.

18. The method of claim 14, wherein less than approximately 5% of the heat generated by the transmission of current from the first electrode to the second electrode

16

remains in the repaired substrate upon removal of the first electrode and the second electrode.

19. The method of claim 14, wherein the amount of cooling applied to the pool is varied as the pool solidifies to achieve a desired predetermined property.

20. The method of claim 19, wherein the substrate is metallic and the desired predetermined property is a preferred grain size.

21. The method of claim 14, wherein the consumable filler slug is composed of the same material as the substrate.

22. The method of claim 14, wherein the repaired substrate is substantially free of solidification cracks.

23. A welding arrangement for performing repairs, comprising:

- a) a conductive substrate having a first surface and a second surface and a defect;
- b) a consumable filler slug in the defect thereby forming a weld zone;
- c) at least one sacrificial retainer in contact with a portion of the consumable filler slug;
- d) at least one resistively heated electrically conductive cover sheet:
  - 1) having a higher melting temperature than a melting temperature of the conductive substrate, the consumable filler slug, and the sacrificial retainer,
  - 2) placed in contact with at least a portion of the sacrificial retainer, and
  - 3) conductively heating the weld zone to weld the consumable filler slug, a portion of the sacrificial retainer, and a portion of the conductive substrate together thereby filling the defect;
- e) a first electrode placed in contact with the at least one cover sheet;
- f) a second electrode positioned and aligned with the first electrode to heat resistively the at least one cover sheet with an electrical current for a period with subsequent conductive heating of the weld zone to produce sufficient heat to weld the consumable filler slug, a portion of the sacrificial retainer, and a portion of the conductive substrate together; and
- g) a force producing device for applying a force to the weld zone so as to produce a compressive force on the weld zone during the conductive heating of the weld zone.

24. The welding arrangement of claim 23, wherein the conductive substrate and the consumable filler slug are substantially the same material composition.

25. The welding arrangement of claim 24, wherein the material composition is substantially an aluminum composition.

26. The welding arrangement of claim 23, wherein the defect is a void extending from the substrate first surface to the substrate second surface.

27. The welding arrangement of claim 23, further including a first electrically conductive cover sheet and a first sacrificial retainer between the consumable filler slug and the first electrode and a second electrically conductive cover sheet and a second sacrificial retainer between the consumable filler slug and the second electrode, wherein the void is substantially cylindrical in shape, having a diameter and a volume, and the consumable filler slug is substantially cylindrical having a diameter smaller than the diameter of the void, a volume, and a distal end and a proximal end whereby the consumable filler slug is configured to be received by the void, such that current passes and resistively heats the first and second electrically conductive cover sheets thereby conductively heating the first sacrificial



**17**

retainer, the consumable filler slug, a portion of the substrate, and the second sacrificial retainer resulting in the coalescence of the consumable filler slug, a portion of the substrate, and a portion of the sacrificial retainers into the weld pool and a portion of the retainers remains solid and constraining flow of the weld pool and sealing the weld pool from a surrounding atmosphere.

**28.** The welding arrangement of claim **23**, wherein the period of transmitting electrical current from the first electrode to the second electrode is less than approximately 3 seconds.

**18**

**29.** The welding arrangement of claim **23**, wherein less than approximately 5% of the heat input to the at least one conductive cover sheet by the transmission of current from the first electrode to the second electrode remains in the repaired substrate upon removal of the first electrode and the second electrode.

**30.** The welding arrangement of claim **23**, wherein the consumable filler slug is composed of the same material as the substrate.

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