**Tabel 1.** Parameter Proses FSW

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| --- | --- | --- | --- | --- |
|  |  |  |  |  |
| **No** | **Kecepatan Rotasi Tool (rpm)** | **Sudut Bahu Cekung (deg.)** | **Sudut Kemiringan Tool (deg.)** | **Kecepatan Pengelasan (mm/min)** |
| 1 | 765 | 2 | 2 | 24 |
| 2 | 765 | 5 | 2,5 | 43 |
| 3 | 765 | 8 | 3 | 65 |
| 4 | 765 | 11 | 3,5 | 90 |
| 5 | 1208 | 2 | 2,5 | 65 |
| 6 | 1208 | 5 | 2 | 90 |
| 7 | 1208 | 8 | 3,5 | 24 |
| 8 | 1208 | 11 | 3 | 43 |
| 9 | 1907 | 2 | 3 | 90 |
| 10 | 1907 | 5 | 3,5 | 65 |
| 11 | 1907 | 8 | 2 | 43 |
| 12 | 1907 | 11 | 2,5 | 24 |
| 13 | 3022 | 2 | 3,5 | 43 |
| 14 | 3022 | 5 | 3 | 24 |
| 15 | 3022 | 8 | 2,5 | 90 |
| 16 | 3022 | 11 | 2 | 65 |