**Tabel 1.** Parameter Eksperimen OA Taguchi

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **No. Spc** | **Kecepatan rotasi tool (N) rpm** | **Sudut Bahu Cekung (SB)°** | **Sudut Kemiringan Tool (SK)°** | **Kecepatan Pengelasan (KP) mm/m** | **Hasil FSW** |
| 1. | 765 | 2 | 2 | 24 | *Accepted* |
| 2. | 765 | 5 | 2.5 | 43 | *Reject* |
| 3. | 765 | 8 | 3 | 65 | *Reject* |
| 4. | 765 | 11 | 3 | 90 | *Accepted* |
| 5. | 1208 | 2 | 2.5 | 65 | *Accepted* |
| 6. | 1208 | 5 | 2 | 90 | *Accepted* |
| 7. | 1208 | 8 | 3.5 | 24 | *Reject* |
| 8. | 1208 | 11 | 3 | 43 | *Accepted* |
| 9. | 1907 | 2 | 3 | 90 | *Accepted* |
| 10. | 1907 | 5 | 3.5 | 65 | *Reject* |
| 11. | 1907 | 8 | 2 | 43 | *Accepted* |
| 12. | 1907 | 11 | 2.5 | 24 | *Reject* |
| 13. | 3022 | 2 | 3.5 | 43 | *Reject* |
| 14. | 3022 | 5 | 3 | 24 | *Accepted* |
| 15. | 3022 | 8 | 2.5 | 90 | *Reject* |
| 16. | 3022 | 11 | 2 | 65 | *Reject* |