Question: Can the exchanging of marital vows suffice for alālah?

Answer: The Ulamā have unequivocally stated that when a man gives he's wife three alāqs at one time or in one sitting, then it will be arām for him to get married to her for a second time until she does not get married to someone else first. Intercourse is a pre-requisite for this second marriage, therefore the mere exchanging of marital vows will not be sufficient. In this case, there is no other option besides alālah.

Fatawa Darul Ulūm Zakariyyā, Vol. 4, Pg. 120-122

And Allāh knows best