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OPTIMIZATION OF WELD BEAD GEOMETRY IN GMAW PROCESS USING RSM BY BOX-BEHNKEN DESIGN

DHARMENDRA KUMAR [1], DR. NEERAJ KUMAR[1], RAVINDRA KUMAR JAIN[1], ARVIND KUMAR SINGH[2]

1. Department of Mechanical Engineering, Suresh Gyan Vihar University, Rajasthan, Jaipur, 302017, India.
2. Department of Mechanical Engineering, JNU Jaipur

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Abstract: Now a day's use of the automatic & robotic system of welding leads a vital role for the fabrication industries in terms of maintaining their quality and productivity. And also helps them to come out from the problems such as lack of skilled welders, health & safety needs. To make more use of these type of system. This is essential to choose the correct method and parameters which would satisfy the required nature of the weld bead. To get a high quality of welding all the various variables should be balanced in a corrective way, so in this paper, we have focused on the high quality of welding all the various variables should be balanced in a corrective way.

Keywords: Weld Bead Geometry, Robotic System

Corresponding Author: DHARMENDRA KUMAR

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INTRODUCTION

Current modern items which have given to the thriving of humankind, owe their expansion and productive execution to welding, which is presently the all-around acknowledged strategy for forever joining metals and making solid structures proficiently and monetarily. Weld rising is logically attempting to enhance the life and to decrease the cost of designing part. Gas metals arc welding (GMAW) covering is lengthily utilized in its reflex mode to get the victor quality stainless steel cladding. Steels by far off are the most widely utilized and welded assets, principally, because of the trueness that they can be mass-created moderately monetarily in gigantic adds up to correct necessity and have an encompassing scope of mechanized properties.

MIG WELDING

MIG welding is for the most part utilized for welding Aluminum and Stainless Steels through inert gas welding. In 2this strategy, the welding is being

Formed between an electrode and the base metal. Where electrode deeds a straightforward wire of minor breadth, which offers the mortar metal and consequently no additional field, is essential. Shielding argon, helium, carbon dioxide, and oxygen are being castoff for close-by the arc to safeguard the dissolved metal from air contaminations like dust, dirt, metal oxides, and so on. These gasses can be castoff both as a lone gas and in a blend of different gasses. At the point when CO2 just is castoff as the protective gas, the system is called CO2 welding. Once in the past, argon and helium were utilized as shielding gasses. By and by CO2 is utilized Panoptic, and oxygen and CO2 are oft various with inert gasses.

CLADDING TECHNIQUE

Rolling: It is being finished by following two techniques viz.
a). Roll is bonding cold. b). Roll is bonding hot.

Extrusion: This procedure is utilized for making tubing.

Continuous brazing: In this procedure, the brazing composite flowed between strips is immersed, as the strips are unendingly warmed and rolled.

Casting: This procedure contains metal being cast by another through the centrifugal process.

Welding: In this procedure, one material is dropped over the other through welding.

Explosive Bonding: Here the blasting activity of a leaf of unstable drives the source metal and covering metal messily and blows them. This procedure was gotten a handle on useable titanium, Nickel stainless clad steel in large plates.

CLAD METAL APPLICATION-

Copper: stainless steel is utilized as a base metal. It is utilized to advance thermal properties of heater and heat exchangers.

Aluminum: Wrought Aluminum (Al-clad) is utilized as source metal. Their utilization includes reflectors, cooking utility, substance hardware, marine application.

Stainless steel: Carbon and alloy steel, aluminum is utilized as the base metal. It is covered for better-quality corrosion resistance of pressing and blending tanks. Its utilization incorporates cooking utensil, auto trim, and chemic method watercraft.

Titanium: Steel is utilized as a soluble base metal. It is utilized as a part of chemic process mechanical assembly.

Silver: There is a various source metal on which silver is covered. It is for the most part utilized for electrical conduction.

MIG VARIABLES

After the productive decision of the wire, a gas which ought to be utilized for the welding drive and the circumstance proper for welding essential is chosen according to our work request of demand. These being is utilized on the ground that these requirements excessively affecting the weld bead. Because of this intention these issues will be upheld out finished a vast range, these limitations ought to be pondered as the preparatory change in any of the welding operation. So the morals are taken out under these conditions. After the productive decision of the wire, gas which must be utilized for the welding drive and the circumstance reasonable for welding basic be chosen according to our work request of demand. These being utilized on the ground that these requirements abundantly affecting the weld character to a better than average degree.

Welding Voltage

It ought to be evidently recognized that the arc length is directly controlled by the voltage setting and in addition, it will a beyond any doubt run is needed to hold the welding soundness at any predetermined current level of welding.

Nozzle to plate distance

NPD mains are an enthusiastic part of proceeding with the bead shape and quality. At the point when the NPD is being to smaller then it will harm the gas nozzle. However, when the NPD is too long, the capability of the shielding gas is affected including with the chances of arc stability. Commonly NPD of the inward distance across approx. 1 to 1.5mm.

Welding speed

The welding rate can be characterized as the direct rate what the welding moves alongside the workpiece. These parameters are in effect essentially expressed in inches or meters per min. Two articulations are being influenced with respect to the welding speed.

If there is any expansion in the thickness of the material, the welding speed must be dropped down.

Higher welding travel speed is being accomplished by utilizing the forehand strategy for welding.

Electrode Stick Out

The separation from bringing down the tip of the contact tube to the tip of the electrode wire is known as electrode stand out. It is an essential parameter for controlling the disintegration rate and bead geometry. They stand out is essentially kept between 5 to 15 mm for the short circuiting transformer and 16 to 25 mm for another sort of metal exchange.

PRESENT WORK

The cladding properties have been essentially impacted by weakening turns out. In this way, control of weakening assumes an essential part in surfacing at whatever point a frail weakening is very required. The in conclusion store organization comes nearer to that of filling material When weakening is very low, and consequently it enhances the erosion safe properties of the cladding .

Reseweldinghers have endeavored to improve weakening of stainless steel cladding utilizing the GMAW procedure. At the same time, it was discovered that the ideal weakening conditions are accomplished, accordingly diminishing the efficiency of this procedure in the event that it is to be utilized for surfacing operations.

High testimony rate in this movement is important for cladding operations, yet it has been built up that statement rate is accomplished with an amalgamation of parameters.

METHODOLOGY

To finish the following targets RSM has been assigned (Response Surface Methodology) strategy that it request the smaller amount of experimentations to be appeared and furthermore it can handle uncompromising variables incorporated in the plan of experimentations. Essential strides for finishing the want destinations are:

Data Collection

Rendering to outline framework established on RSM plan grid. The experimentations will be coordinated on mellow steel plate devouring 304 stainless steel electrodes.

Empirical Modelling

Design of the new observational model (relationship among GMAW reactions and the GMAW parameters) utilizing relapse investigation.

Test for sufficiency of creating a show

Inspection of prototypical centrality, demonstrate terms suggestion utilizing ANOVA investigation. This exact model will oblige in an ideal combination of GMAW parameters.

OPTIMIZATION OF GMAW PARAMETERS

Plan of analyses approach, by utilizing of RSM procedure was found to the best fitting optimization method for contemporary work as placated by the writing overview. I have taken four numeric factors, for example, nozzle to plate distance, open circuit voltage, welding speed and wire feed rate being distinguished for my present work. Plan of trials approach, by utilizing of RSM strategy was found to the best appropriate enhancement method for introducing function as fulfilled by the writing study.

In view of the issue communicated or talked about over the accompanying goals were surrounded

Define the Parametric enhancement of bead geometry parameters,

1. Bead Height
2. Bead Penetration of dot geometry.
3. Bead Width

DESIGN OF EXPERIMENTS

Materials and hardware's utilized

Base material

We are utilizing the Mild steel plates of 8 mm thickness of size 300x 100x 10 mm which were expurgated from the pads utilizing impact Hacksaw after that all squares were utilized as the substrate physical for cladding.

Filler wire

The austenitic stainless steel strong wire of the kind 304 of the distance across 1.2 mm is being utilized as a part of the contemporaneous work. The physical and concoction belonging to the ASS sort 304 are as per the following:

Table 1

Mtrl	C	Mn	S	P	Si	Cu	Ni
%	0.0194	1.7152	0.00085	0.0283	0.2883	0.1732	9.1356

Ti	Cr	Mb	V	Tu	Al	Fe
0.0041	19.2702	0.0777	0.1188	0.037	0.0061	68.922

The composition of base metal plate M.S being used (wt %)

Table 2

Mtrl(MS)	C	Si	Mn	P	S	Ni	Cr	Al	Fe
%	0.134	0.161	0.59	0.025	0.022	0.021	0.044	0.028	Balance

Shielding gas

The shielding gas utilized as a part of this examination was innovatively unadulterated Argon. The shielding gas weight was kept steady and safeguarded at 22Lt/min for each exploratory run.

Experimental Details

To pick up an entire information about dependability of austenitic stainless and steel cladded plates this will be discovered basic to research the accompanying conditions.

Identification, determination, and foundation of scopes of parameters.

To discover ideal welding conditions for welding current, weld globule geometry, weakening, testimony rate and cladding file utilizing RSM strategy.

Evaluation of properties of claddings through smaller scale hardness testing and twist test.

Process parameters varied at three levels

Table 3

Input Parameters	Units	Low(-)	Intermediate	High(+)
NPD(Nozzle to plate distance	Mm	6	10	14
OCV(Open circuit Voltage)	Volts	15	21	27
WS(Welding Speed)	Cm/Min	20	30	40
WFR(Wire Feed Rate)	M/Min	4	8	12

EXPERIMENTAL WORK

In the cutting-edge time of programmed and automated arrangement of welding drives an essential part of the creative businesses as far as keeping up their quality and efficiency. And furthermore, feeds them to turn out from the issues, for example, the absence of gifted welders, wellbeing and security needs. To make more utilization of these sort of framework. This is extremely basic to pick the right technique and parameters which would fulfill the

required idea of the weld globule. To get a high caliber of welding all the different factors ought to be adjusted remedially.

Design of tests

Input factors
Wire feed rate (F),
Open circuit voltage (V),
Welding speed (S)
Nozzle to plate distance (N)

Response parameters
The depth of Penetration(DOP)
Bead Height (BH)
Bead Width(BW)

BOX-BEHNKEN DESIGN
Box– Behnken Designs are experimental designs, designed by George E. P. Box and Donald Behnken in 1960 for response surface methodology.

Table 4

StdOrder	RunOrder	PtType	Blocks	NPD	OCV	WS	WFR
12	1	2	1	1	0	0	0
1	2	2	1	-1	-1	0	0
10	3	2	1	1	1	0	-1
24	4	2	1	0	1	0	1
19	5	2	1	-1	0	1	0
3	6	2	1	-1	1	0	0
21	7	2	1	0	-1	0	-1
20	8	2	1	1	0	1	0
22	9	2	1	0	1	0	-1
5	10	2	1	0	0	-1	-1
18	11	2	1	1	0	-1	0
2	12	2	1	1	-1	0	0
16	13	2	1	0	1	1	0
27	14	0	1	0	0	0	0
6	15	2	1	0	0	1	-1
17	16	2	1	-1	0	-1	-1
9	17	2	1	-1	0	0	-1
13	18	2	1	0	-1	-1	0

14	19	2	1	0	1	-1	0
11	20	2	1	-1	0	0	1
25	21	0	1	0	0	0	0
8	22	2	1	0	0	1	1
4	23	2	1	1	1	0	0
26	24	0	1	0	0	0	0
23	25	2	1	0	-1	0	1
15	26	2	1	0	-1	1	0
7	27	2	1	0	0	-1	1

MEASUREMENT OF WELD BEAD GEOMETRY

Optical profile projector is used for studied of the bead height and depth of penetration. Model METZ-801A of optical profile projector was used for bead penetration measuring.

OPTIMIZATION

The enhancement is a procedure of seedlings for coordination of elements levels which coincidently legitimize the requests of every factor and also reactions. Every reaction being set up with the reasonable model before it gets upgraded. Optimization of a solitary reaction or numerous reactions with coincidently reactions should be possible numerically or graphically.

BOX-BEHNKEN DESIGN SUMMARY

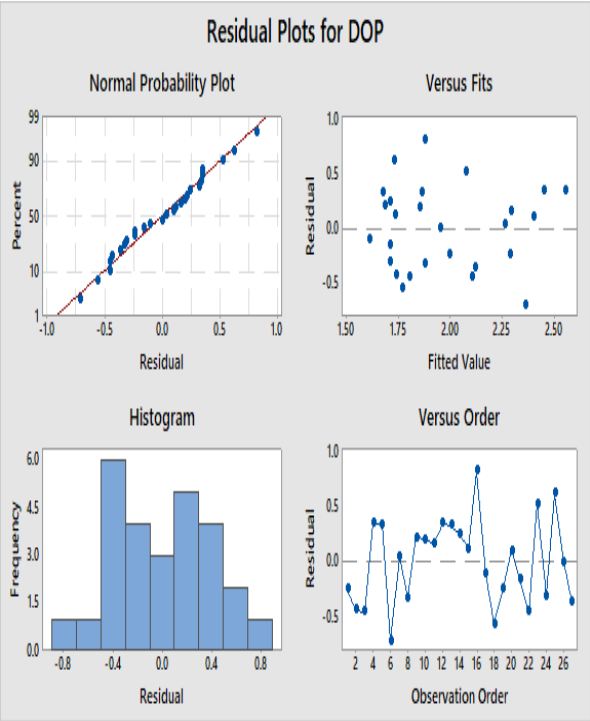
Table 5

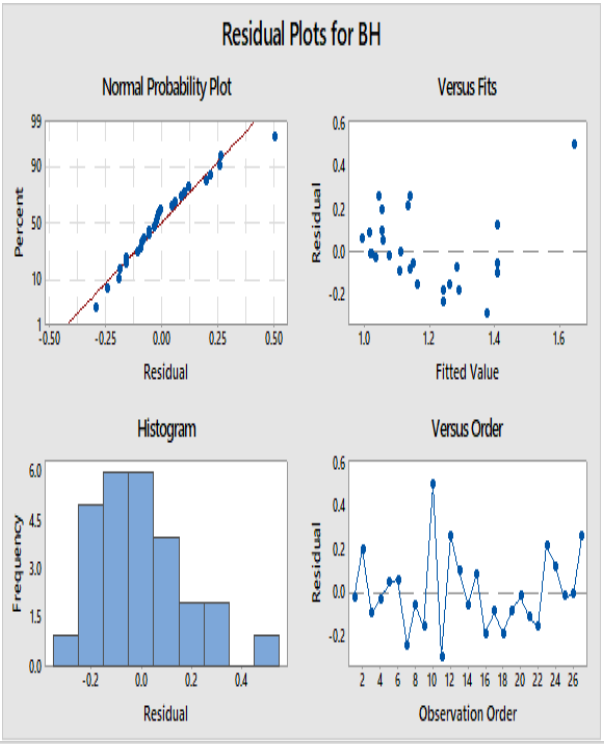
Std Order	Run Order	Pt Type	Blocks	NPD	OCV	WS	WFR	DOP	BH	BW
12	1	2	1	14	21	30	12	2	1	6
1	2	2	1	6	15	30	8	1	1	5
10	3	2	1	14	27	30	4	2	1	6
24	4	2	1	10	27	30	12	3	1	5
19	5	2	1	6	21	40	8	2	1	8
3	6	2	1	6	27	30	8	2	1	6
21	7	2	1	10	15	30	4	2	1	10
20	8	2	1	14	21	40	8	2	1	5
22	9	2	1	10	27	30	4	2	1	8
5	10	2	1	10	21	20	4	2	2	9
18	11	2	1	14	21	20	8	2	1	4
2	12	2	1	14	15	30	8	3	1	10
16	13	2	1	10	27	40	8	2	1	7
27	14	0	1	10	21	30	8	2	1	11
6	15	2	1	10	21	40	4	2	1	10
17	16	2	1	6	21	20	8	3	1	4
9	17	2	1	6	21	30	4	2	1	7
13	18	2	1	10	15	20	8	1	1	8
14	19	2	1	10	27	20	8	2	1	5
11	20	2	1	6	21	30	12	3	1	6
25	21	0	1	10	21	30	8	2	1	5
8	22	2	1	10	21	40	12	1	1	8
4	23	2	1	14	27	30	8	3	1	6
26	24	0	1	10	21	30	8	1	2	4
23	25	2	1	10	15	30	12	2	1	7
15	26	2	1	10	15	40	8	2	1	5
7	27	2	1	10	21	20	12	2	1	7

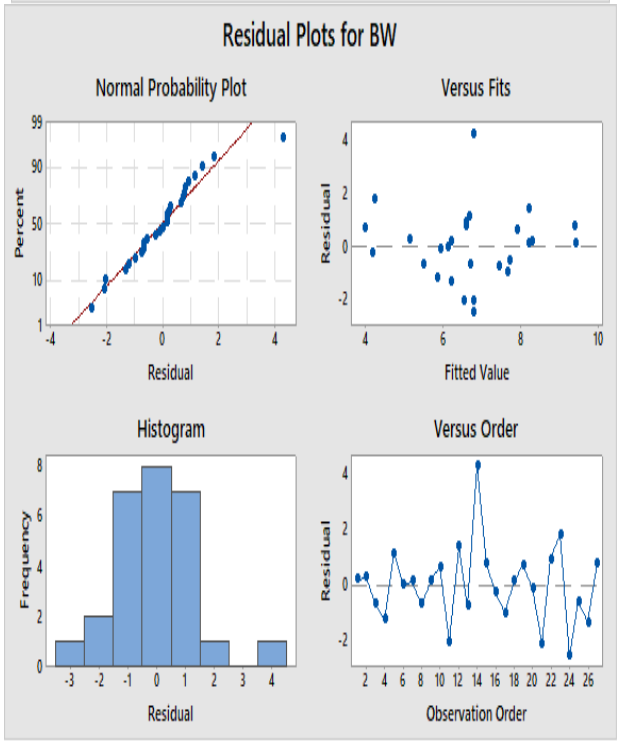
Box-Behnken DesignDesign Summary

Factors:	4	Replicates:	1
Base runs:	27	Total runs:	27
Base blocks:	1	Total blocks:	1

Center points: 3







Response Optimization: BW, BH, DOP

Response	Goal	Lower	Target	Upper	Weight	Importance
BW	Minimum		3.93	11.10	1	1
BH	Minimum		1.00	2.15	1	1
DOP	Maximum	1.2	2.90		1	1

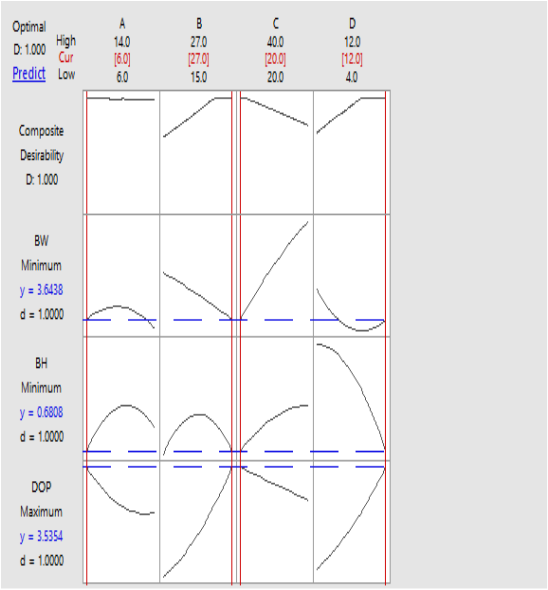
Solution

Solution	A	B	C	D	BW Fit	BH Fit	DOP Fit	Composite Desirability
1	6	27	20	12	3.64376	0.680760	3.53542	1

Multiple Response Prediction

Variable	Setting
A	6
B	27
C	20
D	12

Response	Fit	SE Fit	95% CI	95% PI
BW	3.64	3.14	(-3.20, 10.49)	(-4.51, 11.80)
BH	0.681	0.407	(-0.205, 1.567)	(-0.375, 1.736)
DOP	3.535	0.883	(1.611, 5.459)	(1.244, 5.827)



CONCLUSION

The following conclusions are as follows:

With the increase in wire feed rate, depth of penetration will increase.

When wire feed rate increases, its weld bead rate also increases. In open circuit voltage and nozzle to plate distance but decreases in welding speed.

A three level four-factor full factorial project matrix based on the Box-Behnken Design method can be used for the development of a mathematical model to design of Experiment.

After designing the experiment and performing on this design for optimization of surface response, I found that observation no. 1(where NPD=6, OCV=27, WS=20, and WFR=12) is the best suitable for the Welding of Mild Steel by the use of austenitic stainless steel wire of the kind 304.

Out of the four process variables considered wire feed rate was the most significant and influential factor having the positive effect,

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