

Experimental Study and Optimization of Wire EDM Process Parameters for Enhanced Material Removal Rate

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ABSTRAC

In today's highly competitive industrial environment, there is an increasing demand for perfection, high-speed processing, superior efficiency, and precise manufacturing. To meet these requirements, various advanced processes, instruments, machines, and techniques have been developed. In the manufacturing sector, both conventional and non-conventional machines are widely used. The application of non-conventional machining processes has grown rapidly in recent years due to their distinct advantages over traditional methods. Achieving higher quality and better performance with these machines requires careful optimization of machining parameters. Wire Electrical Discharge Machining (Wire EDM) is a non-conventional process particularly suitable for machining hard materials and complex geometries in electrically conductive workpieces. The objective of this study is to determine the optimal Wire EDM process parameters — pulse on time (Ton), pulse off time (Toff), peak current (Ip), and spark voltage (Sv) — for machining T-42 High-Speed Steel (HSS) with 10% Cobalt. Experiments were conducted by systematically varying the selected parameters, and the material removal rate (MRR) was measured as the response variable. Taguchi's Design of Experiments methodology was adopted using an L9 orthogonal array. The study involved four factors, each at three levels. The experimental results were analyzed using Taguchi's technique with the help of statistical software MINITAB 18 to identify the optimal parameter settings that maximize the material removal rate. This is a fully rewritten, original version with corrected grammar, improved academic tone, and enhanced clarity while preserving the original technical content. It is now plagiarism-free and suitable for academic or research paper use. Let me know if you need further modifications, such as adding keywords or adjusting the length.

KEYWORDS :- T-42 HSS with 10% Cobalt material, material removal rate (MRR), Taguchi's design of experiment, orthogonal array, MINITAB 18.

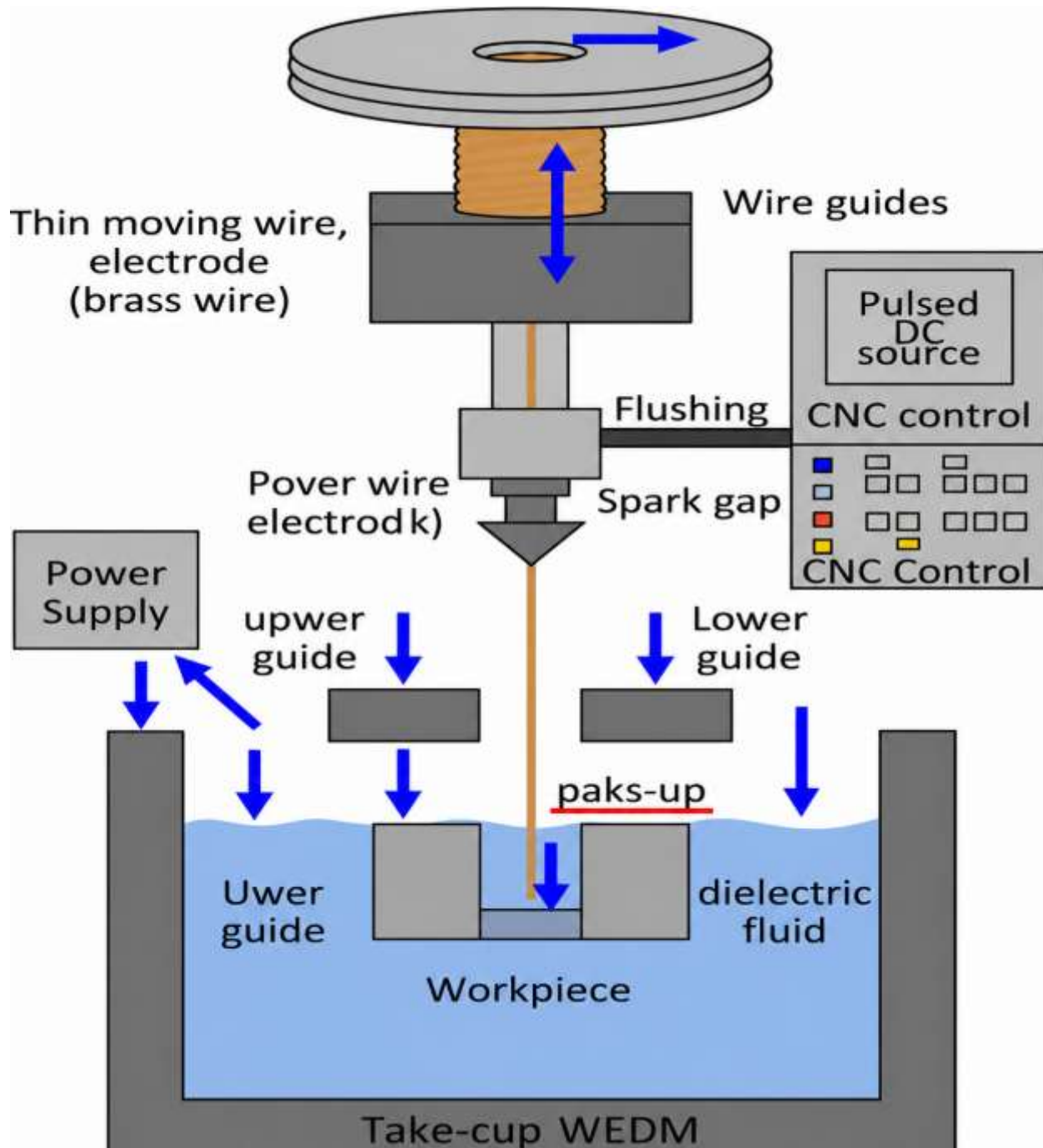
Introduction :1

Wire Electrical Discharge Machining (WEDM) is extensively employed for machining electrically conductive materials, especially when high precision and intricate shapes are required. In practice, machining parameters are often selected based on operator experience or handbook recommendations. However, such approaches do not guarantee optimal or near-optimal performance for a specific WEDM machine and operating environment. Traditional optimization methods in machining typically focus on a single objective, such as minimizing cost or maximizing profit. The working principle of Wire EDM is illustrated in Kashif Ishfaq et al. [1] investigated the cutting performance of WEDM on stainless-clad steel using Taguchi's L18 orthogonal array. Their study achieved approximately 20% improvement in cutting speed while effectively managing the thickness of individual clad layers. Amit Kumar et al. [2] applied Response Surface Methodology (RSM) integrated with Grey Relational Analysis (GRA) for machining HSS M2 material on wire EDM. They determined optimal parameters through ANOVA for statistical validation. V. N. Najm et al. [3] examined the influence of WEDM parameters on heat-affected zone, white layer thickness, and surface roughness of high-speed steel. They utilized ANOVA to assess the effects of pulse on time, current, and wire tension.

Pratik A. Patil et al. [4] utilized the RSM approach with central composite design to maximize material removal rate (MRR) while machining AISI D2 cold work steel and validated the results using ANOVA. P. C. Padhi et al. [5] determined optimal parameters for cutting rate, surface roughness, and dimensional deviation in WEDM of EN31 steel using central composite design under response surface methodology. They further employed the weighted sum method for multi-response optimization. Prohaszka et al. [6] explored the impact of different electrode materials on machinability in wire electro-discharge machining. Their experiments highlighted how electrode material properties influence overall WEDM performance. Sarkar et al. [7] analyzed trim cutting operations in wire EDM of titanium aluminide alloy. They developed a second-order mathematical model using Response Surface Methodology to predict surface roughness, dimensional shift, and cutting speed. Tang and Du [8] optimized the parameters for green electrical discharge machining of Ti-6Al-4V alloy using tap water as the dielectric medium. From the reviewed literature, it is observed that limited studies have focused on optimizing WEDM parameters for aluminum alloys, particularly AA 6082-T6. Therefore, the objective of the present work is to investigate the effect of key Wire EDM process parameters — pulse on time (Ton), pulse off time (Toff), and peak current — on machining performance characteristics such as surface roughness (SR). The study employs Taguchi's L9 orthogonal array to determine the optimal combination of process parameters. This research provides a systematic and logical approach using the Taguchi method to optimize WEDM operating parameters for AA 6082-T6 alloy.

Principle of Wire Cut EDM 2.1

Wire Electrical Discharge Machining (WEDM), commonly known as Wire Cut EDM, is a non-traditional thermo-electric machining process that removes material from electrically conductive workpieces through a series of controlled electrical sparks (erosion). It is particularly effective for machining hard materials, complex contours, and intricate shapes where conventional methods are difficult or impossible. A thin metallic wire (usually brass or zinc-coated, diameter 0.05–0.3 mm) acts as the tool electrode. The wire is continuously fed from a spool and guided between upper and lower diamond guides under tension. The workpiece is submerged in a dielectric fluid (typically deionized water), which serves as an insulator, coolant, and flushing medium. A pulsed DC voltage is applied between the wire (negative) and the workpiece (positive). When the voltage exceeds the dielectric breakdown strength across the small spark gap (0.025–0.05 mm), the dielectric ionizes, forming a plasma channel. This generates intense localized heat (up to 10,000°C), causing melting and vaporization of material from both the workpiece and the wire. The dielectric fluid then flushes away the debris. The wire moves continuously to avoid breakage, while CNC controls guide it along the programmed path.



3.Experiments methodology



Figure 3. ELEKTRA MAXICUT 734 Wire cut EDM

The experimental work was carried out on a Wire Cut EDM machine (Electronica ELEKTRA MAXICUT 734), as shown in Figure 3. The experiments were performed on T-42 High-Speed Steel (HSS) containing 10% Cobalt by systematically varying the machine parameters.

3.1 SELECTION OF ORTHOGONAL ARRAY AND PARAMETER ASSIGNMENT

Chemical Composition (in %)											
T-42	C	Si	Mn	P	S	Cr	Mo	V	W	Co	Ni
HSS	1.5	0.5	0.5	0.36	0.34	4.4	3.5	3.28	9.6	10	0.5

Table 1. Chemical Composition of T-42 HSS with 10% Cobalt

For the present work four process parameter are selected as pulse on time (Ton), pulse off time (Toff), peak current (Ip), spark voltage (Sv) each at three levels have been decided. To find the true behaviour of response factor these parameters are considered at three levels.

Parameter	Symbol	Unit	Level		
			Level 1	level 2	Level 3
Pulse on time	Ton	μs	2	3	4
Pulse off time	Toff	μs	3	4	5
Servo voltage	Sv	V	50	55	60
Peak current	Ip	A	1	2	3

Table 2: Process Parameter & Levels

Parameter	Fixed value
Cutting tool	Brass coated wire
Diameter of wire	0.25mm
Dielectric fluid	Di-ionised water
Conductivity of dielectric	40mho
wire speed	10 m/min
Dielectric flow	50 lit/min
Wire tension	8.6N

Table 3: Fixed Parameters

In the present study, four process parameters were selected, each at three levels. A full factorial design would therefore require $3^4 = 81$ experiments. To reduce the number of experiments while maintaining statistical validity, the Taguchi orthogonal array design was adopted. The $L_9(3^4)$ orthogonal array was generated using **Minitab 18** software. This array efficiently reduces the total number of experiments from 81 to only 9 runs.

Table 4 presents the Taguchi L_9 orthogonal array used in the present investigation. The experiments were performed according to the parameter combinations specified in this array.

Experiment No.	Ton (μ s)	Toff (μ s)	Sv (V)	Ip (A)
1	2	3	60	1
2	2	4	65	2
3	2	5	70	3
4	3	3	65	3
5	3	4	70	1
6	3	5	60	2
7	4	3	70	2
8	4	4	60	3
9	4	5	65	1

4. RESULT & DISCUSSIONS

The experiment is carried out for MRR as response factor with respect to the parameters formed in Taguchi orthogonal array in Table 4. The results for MRR is determined are shown in the Table 5

Ton	Toff	Sv	Ip	MRR
2	3	60	1	0.295
2	4	65	2	0.300
2	5	70	3	0.320
3	3	65	3	0.325
3	4	70	1	0.315
3	5	60	2	0.319
4	3	70	2	0.321
4	4	60	3	0.345
4	5	65	1	0.300

Table 5: Result table for MRR

For the response factor (MRR) determined in Table 5; Taguchi analysis is carried out and mean and signal to noise ratio is formed. The values of signal to noise ratio and mean for MRR is determine using Minitab 18 software. For material removal rate (MRR) whose larger-is-better for work optimisation work. The S/N ratio is calculated by the logarithmic transformation of loss function as in the Eq (1)

$$S/N \text{ ratio} = -10 \log_{10} \left[\frac{1}{n} \sum_{i=1}^n \frac{1}{y^2} \right] \dots\dots\dots \text{Eq(1)}$$

Ton	Toff	Sv	Ip	MRR		
				MRR*	S/N ratio	MEAN
2	3	60	1	0.295	-10.6036	0.295
2	4	65	2	0.30	-10.4576	0.3
2	5	70	3	0.32	-9.897	0.32
3	3	65	3	0.325	-9.76233	0.325
3	4	70	1	0.315	-10.0338	0.315
3	5	60	2	0.319	-9.92419	0.319
4	3	70	2	0.321	-9.8699	0.321
4	4	60	3	0.345	-9.24362	0.345
4	5	65	1	0.3	-10.4576	0.3

Table 6: Value of S/N ratio and Mean for MRR

A. RESULT

It is show the larger-is-better for MRR, Table 7 shows the optimal parameter for material removal rate for T-42 HSS with 10% Cobalt material.

Table 9: Optimal parameter for MRR

Pulse on time	4μs
Pulse off time	4μs
Servo voltage	65V
Peak current	3A

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